

Garant
Drill thread milling cutter 1.5×D, TiAlN, M: M6

Order data

Order number	139511 M6
GTIN	4062406393137
Item class	11J

Description
Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions). **Incorporating a** countersink profile for a 90° countersink. A stronger core diameter, two narrow geometrically optimised chip flutes and a special drill point result in good chip formation and low cutting pressure. **Internal coolant feed.**

Advantage:

Drilling, countersinking and thread milling all with a single tool!

Thread pitch: 1 mm

Cutting edge Ø D_C: 4.85 mm

Cutter length l_c: 10.7 mm

Shank length L_s: 36 mm

Overall length L: 62 mm

Shank Ø D_s: 8 mm

Technical description

maximum countersink Ø D ₁	6.3 mm
Overall length L	62 mm
Thread depth	7.3
Shank Ø D _s	8 mm
Shank length L _s	36 mm
Thread pitch	1 mm
Cutter length l _c	10.7 mm

Thread size	M6
Width of groove e_1	1 mm
Feed f_z in cast aluminium	0.05 mm
Number of clamping slots	2
Cutting edge $\varnothing D_c$	4.85 mm
Programming value for countersink L_1	11.6 mm
Coating	TiAlN
Thread type	M-LH
Thread type	M
Flank angle	60 degrees
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA with h6
Number of cutting edges Z	2
Through-coolant	yes
Application for type of drilling	up to $1.5 \times D$ for blind holes and through holes
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	without
Internal/external application	Internal
Type of product	thread milling cutter