

Garant
Drill thread milling cutter 1.5×D, TiAlN, M: M8

Order data

Order number	139511 M8
GTIN	4062406393144
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: 1.25 mm

Cutting edge $\varnothing D_c$: 6.45 mm

Cutter length l_c : 13.6 mm

Shank length L_s : 40 mm

Overall length L: 74 mm

Shank $\varnothing D_s$: 10 mm

Technical description

Number of clamping slots	2
Overall length L	74 mm
Shank $\varnothing D_s$	10 mm
Thread size	M8
Thread pitch	1.25 mm
maximum countersink $\varnothing D_1$	9 mm
Thread depth	12

Feed f_z in cast aluminium	0.065 mm
Width of groove e_1	1.25 mm
Shank length L_s	40 mm
Cutter length l_c	13.6 mm
Cutting edge $\varnothing D_c$	6.45 mm
Programming value for countersink L_1	14.8 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