

**Garant**
**End cutting thread mill 2.5×D, TiAlN, M: M4**

**Order data**

Order number	139521 M4
GTIN	4062406565664
Item class	11J

**Description**
**Version:**

Tool for **combined production** of bore, chamfer and thread **in a single operation**. No more pre-drilling required. The innovative centre cutting edge geometry makes this tool a specialist in thread production in **hardened and hard-to-machine materials**. The **TiAlN high-performance coating** achieves a top **tool life**, especially in hardened steels **up to 67 HRC**. All tools are left-hand cutting and suitable for **right-hand and left-hand threads**.

**Note:**

**Always use with cooling lubricant emulsion.** (Fat content minimum 8%). In the case of steels **>45 HRC**: can only be used with **compressed air!**

Thread pitch: 0.7 mm

Cutting edge  $\varnothing D_c$ : 3.1 mm

Cutter length  $l_c$ : 2.2 mm

Overhang  $L_1$ : 11.2 mm

Shank length  $L_s$ : 41.5 mm

Overall length  $L$ : 57 mm

**Technical description**

Thread size	M4
maximum countersink $\varnothing D_1$	2.18 mm
Overall length $L$	57 mm
Shank $\varnothing D_s$	6 mm
Thread pitch	0.7 mm
Number of clamping slots	4

Thread depth	10
Shank length $L_s$	41.5 mm
Feed $f_z$ in steel < 65 HRC	0.01 mm
Cutter length $l_c$	2.2 mm
Programming radius	1.53 mm
Overhang $L_1$	11.2 mm
Cutting edge $\varnothing D_c$	3.1 mm
Coating	TiAlN
Thread type	M
Thread type	M-LH
Flank angle	60 degrees
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA with h6
Number of cutting edges Z	4
Through-coolant	yes
Application for type of drilling	up to 2.5xD for blind holes and through holes
Countersink angle	90 degrees
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	without
Internal/external application	Internal
Type of product	thread milling cutter