

Garant
End cutting thread mill 2.5×D, TiAlN, M: M6

Order data

Order number	139521 M6
GTIN	4062406565688
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: 1 mm

Cutting edge Ø D_C: 4.6 mm

Cutter length l_C: 2.8 mm

Overhang L₁: 17.6 mm

Shank length L_S: 36.4 mm

Overall length L: 57 mm

Technical description

Overall length L	57 mm
maximum countersink Ø D ₁	3.36 mm
Thread depth	15
Thread size	M6
Number of clamping slots	4
Thread pitch	1 mm

Shank length L_s	36.4 mm
Shank $\varnothing D_s$	6 mm
Feed f_z in steel < 65 HRC	0.01 mm
Cutter length l_c	2.8 mm
Programming radius	2.27 mm
Overhang L_1	17.6 mm
Cutting edge $\varnothing D_c$	4.6 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 2.5×D 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