

Garant

Single tooth thread mill 2×D, TiAlN, M: M1,8



Order data

Order number	139610 M1,8
GTIN	4045197533883
Item class	11J

Description

Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions). Very sturdy **single-tooth** thread mill, **highly suitable especially for GRP, CRP, and graphite**. Also suitable for **Ti-based and Ni-based alloys** and **hardened steels up to 63 HRC**.

Advantage:

Significantly less radial pressure than with multi-tooth thread mills.

Note:

Single-tooth thread mill **exclusively for milling internal threads. The tapping hole (and where necessary the countersinking) has to be prepared beforehand!**

Through-coolant: no

No. of teeth Z: 4

Thread pitch: 0.35 mm

Nominal $\varnothing D_c$: 1.35 mm

Shank length L_s : 18 mm

Overall length L: 32 mm

Shank $\varnothing D_s$: 3 mm

No. of teeth Z: 4

Technical description

Feed f_z in steel < 1400 N/mm ²	0.01 mm
No. of teeth Z	4
maximum insertion depth L_c	4 mm
Number of clamping slots	4
Thread pitch	0.35 mm

Shank $\varnothing D_s$	3 mm
Overall length L	32 mm
Feed f_z in CRP	0.02 mm
Shank length L_s	18 mm
Through-coolant	no
Thread depth	3.6 mm
Thread size	M1.8
Nominal $\varnothing D_c$	1.35 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
Application for type of drilling	up to 2xD for blind holes and through holes
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter