

Garant

Single tooth thread mill 3×D, TiAlN, M: M12



Order data

Order number	139615 M12
GTIN	4045197585882
Item class	11J

Description

Version:

Corrected thread profile for milling **exact internal threads**, (ensure stable clamping conditions). Very sturdy **single-tooth** thread mills, **highly suitable especially for GRP, CRP and graphite**. Also suitable for **Ti-based and Ni-based alloys** and **hardened steels up to 58 HRC**. **Internal coolant feed.**

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!**

Because of the tooth profile only the thread nominal \varnothing (= size) with the corresponding thread pitch (see table) may be generated.

Through-coolant: yes

No. of teeth Z: 5

Thread pitch: 1.75 mm

Nominal $\varnothing D_c$: 9.9 mm

Shank length L_s : 40 mm

Overall length L: 82 mm

Shank $\varnothing D_s$: 10 mm

No. of teeth Z: 5

Technical description

maximum insertion depth L_c	37.7 mm
Thread pitch	1.75 mm
No. of teeth Z	5

Feed f_z in steel < 1400 N/mm ²	0.08 mm
Number of clamping slots	5
Shank $\varnothing D_s$	10 mm
Overall length L	82 mm
Feed f_z in CRP	0.16 mm
Shank length L_s	40 mm
Through-coolant	yes
Thread depth	36 mm
Thread size	M12
Nominal $\varnothing D_c$	9.9 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 3×D for blind holes and through holes
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter