

Garant

Single tooth thread mill 3×D, TiAlN, M: M6



Order data

Order number	139615 M6
GTIN	4045197585851
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**.

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: no

No. of teeth Z: 4

Thread pitch: 1 mm

Nominal $\varnothing D_c$: 4.6 mm

maximum insertion depth L_c : 18 mm

Shank length L_s : 36 mm

Overall length L: 59 mm

Shank $\varnothing D_s$: 6 mm

Technical description

maximum insertion depth L_c	18 mm
Thread pitch	1 mm
Number of clamping slots	4

No. of teeth Z	4
Feed f_z in steel < 1400 N/mm ²	0.035 mm
Shank $\varnothing D_s$	6 mm
Overall length L	59 mm
Feed f_z in CRP	0.06 mm
Shank length L_s	36 mm
Through-coolant	no
Thread depth	18 mm
Thread size	M6
Nominal $\varnothing D_c$	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
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