

## Garant

### Single tooth thread mill 3×D, TiAlN, M: M8



#### Order data

Order number	139615 M8
GTIN	4045197585868
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: 1.25 mm

Nominal  $\varnothing D_c$ : 6.5 mm

maximum insertion depth  $L_c$ : 24 mm

Shank length  $L_s$ : 36 mm

Overall length L: 65 mm

Shank  $\varnothing D_s$ : 8 mm

#### Technical description

No. of teeth Z	5
maximum insertion depth $L_c$	24 mm
Thread pitch	1.25 mm

Feed $f_z$ in steel < 1400 N/mm <sup>2</sup>	0.04 mm
Number of clamping slots	5
Shank $\varnothing D_s$	8 mm
Overall length L	65 mm
Feed $f_z$ in CRP	0.08 mm
Shank length $L_s$	36 mm
Through-coolant	yes
Thread depth	24 mm
Thread size	M8
Nominal $\varnothing D_c$	6.5 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