



Plain shank thread mill 2xD, TiAlN, M: M3



Order data

Order number	139651 M3
GTIN	4045197773616
Item class	12J

Description

Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions).

Through-coolant: no

No. of teeth Z: 2

Thread pitch: 0.5 mm

Nominal $\varnothing D_C$: 2.4 mm

Flute length L_C : 6.25 mm

Shank length L_S : 28 mm

Overall length L: 42 mm

Shank $\varnothing D_S$: 4 mm

Technical description

Shank length L_S	28 mm
No. of teeth Z	2
Thread pitch	0.5 mm
Number of clamping slots	2
Overall length L	42 mm
Shank $\varnothing D_S$	4 mm
Feed f_z in steel < 900 N/mm ²	0.01 mm
Through-coolant	no
Thread depth	6 mm

Thread size	M3
Nominal $\varnothing D_c$	2.4 mm
Flute length L_c	6.25 mm
Coating	TiAlN
Thread type	M
Thread type	M-LH
Flank angle	60°
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA with h6
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×D for through holes
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	220 m/min	N
Aluminium (short chipping)	suitable	220 m/min	N
Alu > 10% Si	suitable	170 m/min	N
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	80 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M

Ti > 850 N/mm ²	suitable only under restricted conditions	60 m/min	S
GG(G)	suitable	120 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
wet maximum	suitable		