

Garant
GARANT Diabolo solid carbide end cutting thread mill 2.5×D, TiAlN, M: M8

Order data

Order number	139524 M8
GTIN	4067263118015
Item class	11J

Description
Version:

Tool for **combined production** of bore, chamfer and thread **in a single work step**. Pre-drilling is no longer required. The innovative centre cutting edge geometry makes this tool a specialist in thread production in **hardened and hard-to-machine materials**. The **TiAlN high-performance coating** ensures the longest possible **tool life**, especially in hardened steels **up to 63 HRC**. All tools have left-hand cutting and are suitable for **right-hand and left-hand threads**.

Note:

HB and HE shanks are available at the same price as HA.

Order **HB** shank: with **No. 139524 + 129100 HB**.

Order **HE** shank: with **No. 139524 + 129100 HE**.

Always use with cooling lubricant emulsion. (Fat content minimum 8%). In the case of steels **>45 HRC**: can only be used with **compressed air!** Can also be used for thread size MF10×1.25.

Technical description

Overall length L	72 mm
Thread depth	20
Shank $\varnothing D_s$	10 mm
Programming radius	3.04 mm
Shank length L_s	45.1 mm
Thread pitch	1.25 mm
Cutting edge $\varnothing D_c$	6.2 mm
Number of clamping slots	4

Overhang L_1	22 mm
Feed f_z in steel < 65 HRC	0.01 mm
Neck $\varnothing D_1$	4.66 mm
Thread size	M8
Cutter length l_c	3.5 mm
Through-coolant	yes
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
Number of cutting edges Z	4
Application for type of drilling	up to 2.5×D for through holes
Application for type of drilling	up to 2×D for blind holes
Countersink angle	90 degrees
Cutting direction	left-hand
Shank tolerance	h6
Colour ring	without
Internal/external application	Internal
Type of product	Drill thread milling cutters

User data

	Suitability	V_c	ISO code
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
Steel < 55 HRC	suitable	45 m/min	H
Steel < 60 HRC	suitable	40 m/min	H

Steel < 65 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable	45 m/min	S
wet maximum	suitable		
Air Services	suitable		

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE