

**Garant**
**GARANT Master TM plain shank thread mill 2.5×D, TiAlN, M: M8**

**Order data**

Order number	139641 M8
GTIN	4062406240851
Item class	11D

**Description**
**Version:**

Solid carbide thread milling cutters **with irregular cutting edge spacing and an increased number of cutting edges**. Due to the **irregular cutting edge spacing** they achieve **very smooth running** and **long tool life**.

**Newly developed universal geometry** and **high-performance coating** for use across a wide spectrum of materials.

- **Significantly reduced vibration due to irregular cutting edge spacing**
- **Increased number of cutting edges**
- **New coating for optimum wear resistance**
- **Corrected thread profile for avoidance of profile distortions**

**Through-coolant feed  $\geq$  M4**

**Note:**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 139640 / 136941 + 129100 HB**

Form **HE**: order with **No. 139640 / 136941 + 129100 HE**.

Through-coolant: yes

No. of teeth Z: 4

Thread pitch: 1.25 mm

Nominal  $\varnothing D_c$ : 5.95 mm

maximum insertion depth  $L_1$ : 20.58 mm

Shank length  $L_s$ : 36 mm

Overall length L: 68 mm

Shank  $\varnothing D_s$ : 6 mm

**Technical description**

Thread depth	16 mm
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Through-coolant	yes
Overall length L	68 mm
No. of teeth Z	4
Thread pitch	1.25 mm
Number of clamping slots	4
Shank length L <sub>s</sub>	36 mm
maximum insertion depth L <sub>1</sub>	20.58 mm
Shank Ø D <sub>s</sub>	6 mm
Thread size	M8
Feed f <sub>z</sub> in steel < 750 N/mm <sup>2</sup>	0.06 mm
Thread Ø	8 mm
Nominal Ø D <sub>c</sub>	5.95 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 to h6
Application for type of drilling	up to 2.5×D for blind holes and through holes
Spacing of the cutters	unequal spacing
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Series	GARANT Master TM
Type of product	thread milling cutter

## Services

129100 HB

Shank grinding Type HB

Shank grinding Type HE

129100 HE