

Garant
GARANT Master TM plain shank thread mill with countersink 1.5×D, TiAlN, M: M12

Order data

Order number	139656 M12
GTIN	4062406240974
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**

Advantage:

Incorporating a countersink profile for a 90° countersink and thread milling in a single operation.

Note:

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

Form **HB**: order with **No. 139656 + 129100 HB**

Form **HE**: order with **No. 139656 + 129100 HE**

Form **HB**: order with **No. 139653 + 129100 HB**

Form **HE**: order with **No. 139653 + 129100 HE**

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Form **HE**: order with **No. 139654 + 129100 HE**.

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 1.75 mm

Nominal Ø D_C: 9.8 mm

Shank length L_S: 45 mm

Overall length L: 94 mm

Shank $\varnothing D_s$: 14 mm
maximum countersink $\varnothing D_1$: 12.5 mm

Technical description

Programming value for countersink l_1	19.7 mm
No. of teeth Z	6
Thread pitch	1.75 mm
Number of clamping slots	6
Shank $\varnothing D_s$	14 mm
Thread $\varnothing$	12 mm
Overall length L	94 mm
Thread depth	24 mm
Shank length L_s	45 mm
Thread size	M12
maximum countersink $\varnothing D_1$	12.5 mm
Feed f_z in steel < 750 N/mm ²	0.09 mm
Through-coolant	yes
Nominal $\varnothing D_c$	9.8 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 1.5×D for blind holes and through holes
Spacing of the cutters	unequal spacing
Countersink angle	90 degrees
Shank tolerance	h6

Colour ring	green
Internal/external application	Internal
Series	GARANT Master TM
Type of product	thread milling cutter

Services

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