

Garant**GARANT Master TM plain shank thread mill with countersink 1.5×D, TiAlN, M: M8****Order data**

Order number	139656 M8
GTIN	4062406240950
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**

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

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

Through-coolant: yes

No. of teeth Z: 4

Thread pitch: 1.25 mm

Nominal Ø D_C: 6.4 mm

Shank length L_S: 40 mm

Overall length L: 75 mm

Shank $\varnothing D_s$: 10 mm
 maximum countersink $\varnothing D_1$: 8.5 mm

Technical description

Number of clamping slots	4
No. of teeth Z	4
Through-coolant	yes
Thread pitch	1.25 mm
Feed f_z in steel < 750 N/mm ²	0.06 mm
Thread depth	16 mm
Thread size	M8
Shank $\varnothing D_s$	10 mm
Programming value for countersink l_1	14.1 mm
Overall length L	75 mm
Thread $\varnothing$	8 mm
Shank length L_s	40 mm
maximum countersink $\varnothing D_1$	8.5 mm
Nominal $\varnothing D_c$	6.4 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