

Garant**GARANT Master TM plain shank thread mill 2xD, TiAlN, G: G1/4****Order data**

Order number	139705 G1/4
GTIN	4045197957702
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**

Application:

For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connections).

Note:

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

Form **HB**: order with **No. 139705 + 129100 HB**

Form **HE**: order with **No. 139705 + 129100 HE**

No. of teeth Z: 6

Drilling depth for blind and through holes: 2.0xD

Thread pitch: 1.337 mm

Threads per inch: 19

Nominal Ø D_c: 9.95 mm

Flute length L_c: 27.41 mm

Shank length L_s: 40 mm

Technical description

Thread size	G1/4
Flute length L_c	27.41 mm
Thread pitch	1.337 mm
Number of clamping slots	6
Overall length L	82 mm
Drilling depth for blind and through holes	2.0xD
Threads per inch	19
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.1 mm
Thread depth	19.9 mm
Shank length L_s	40 mm
Shank $\varnothing D_s$	10 mm
No. of teeth Z	6
Series	GARANT Master TM
Nominal $\varnothing D_c$	9.95 mm
Coating	TiAlN
Thread type	G
Thread type	G-LH
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Application for type of drilling	up to 2xD for blind holes and through holes
Spacing of the cutters	unequal spacing
Colour ring	green
Internal/external application	Indvendig
Type of product	thread milling cutter

Services

129100 HB

Shank grinding Type HB	
Shank grinding Type HE	129100 HE