

**Garant**
**GARANT Master TM plain shank thread mill 2×D, TiAlN, G: G1**

**Order data**

Order number	139705 G1
GTIN	4045197957740
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: 1.5×D

Thread pitch: 2.309 mm

Threads per inch: 11

Nominal Ø D<sub>c</sub>: 19.95 mm

Flute length L<sub>c</sub>: 51.95 mm

Shank length L<sub>s</sub>: 50 mm

**Technical description**

Thread pitch	2.309 mm
Overall length L	120 mm
Flute length $L_c$	51.95 mm
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.17 mm
Shank $\varnothing D_s$	20 mm
Thread depth	39.9 mm
Drilling depth for blind and through holes	1.5×D
Thread size	G1
Number of clamping slots	6
Shank length $L_s$	50 mm
Threads per inch	11
No. of teeth Z	6
Series	GARANT Master TM
Nominal $\varnothing D_c$	19.95 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 2×D 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