

Garant
GARANT Master TM plain shank thread mill 2xD, TiAlN, UNC: 1/4-20

Order data

Order number	139722 1/4-20
GTIN	4062406057930
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 **UNC unified coarse threads** ASME-B1.1.

Note:

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

Form **HB**: order with **No. 139722 + 129100 HB**

Form **HE**: order with **No. 139722 + 129100 HE**

Thread type: UNC

Thread type: UNC-LH

No. of teeth Z: 4

Threads per inch: 20

Nominal Ø D_C: 4.7 mm

Flute length L_C: 13.29 mm

Shank length L_S: 36 mm

Overall length L: 64 mm

Shank Ø D_S: 6 mm

Technical description

Thread pitch	1.27 mm
No. of teeth Z	4
Thread type	UNC
Thread type	UNC-LH
Thread Ø	6.35 mm
Number of clamping slots	4
Threads per inch	20
Shank length L _s	36 mm
Overall length L	64 mm
Shank Ø D _s	6 mm
Flute length L _c	13.29 mm
Feed f _z in steel < 750 N/mm ²	0.05 mm
Thread size	1/4-20 UNC
Nominal Ø D _c	4.7 mm
Series	GARANT Master TM
Coating	TiAlN
Flank angle	60 degrees
Tool material	solid carbide
Shank	DIN 6535 HA with h6
Through-coolant	yes
Cutting direction	right-hand
Application for type of drilling	up to 2xD for blind holes and through holes
Spacing of the cutters	unequal spacing
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter

