

Garant**GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, UNC: 1/4-20****Order data**

Order number	139723 1/4-20
GTIN	4062406058203
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.

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. 139723 + 129100 HB**

Form **HE**: order with **No. 139723 + 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: 68 mm

Shank Ø D_s: 8 mm

Technical description

Threads per inch	20
Thread pitch	1.27 mm
Number of clamping slots	4
Thread Ø	6.35 mm
Thread type	UNC
Thread type	UNC-LH
maximum countersink Ø D ₁	6.85 mm
Full profile	yes
Overall length L	68 mm
Shank length L _s	36 mm
No. of teeth Z	4
Shank Ø D _s	8 mm
Programming value for countersink l ₁	14.36 mm
Flute length L _c	13.29 mm
Feed f _z in steel < 750 N/mm ²	0.05
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

Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter