

Garant**GARANT Master TM plain shank thread mill 2xD, TiAlN, UNF: 1/4-28****Order data**

Order number	139727 1/4-28
GTIN	4062406058043
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**
- **Corrected thread profile for avoidance of profile distortions**
- **increased number of cutting edges.**
- **new coating for optimum wear resistance.**

Application:

For **UNF unified fine threads** ASME-B1.1.

Note:

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

Form **HB**: order with **No. 139727 + 129100 HB**

Form **HE**: order with **No. 139727 + 129100 HE**

Spacing of the cutters: unequal spacing

Thread type: UNF

Thread type: UNF-LH

No. of teeth Z: 4

Threads per inch: 28

Nominal Ø D_C: 5.1 mm

Flute length L_C: 13.12 mm

Shank length L_S: 36 mm

Overall length L: 64 mm

Shank Ø D_S: 6 mm

Technical description

Shank Ø D _s	6 mm
Thread type	UNF
Thread type	UNF-LH
Thread Ø	6.35 mm
Full profile	yes
Thread pitch	0.907 mm
Number of clamping slots	4
No. of teeth Z	4
Overall length L	64 mm
Shank length L _s	36 mm
Threads per inch	28
Flute length L _c	13.12 mm
Feed f _z in steel < 750 N/mm ²	0.05
Thread size	1/4-28 UNF
Nominal Ø D _c	5.1 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