

Garant**GARANT Master TM plain shank thread mill 2xD, TiAlN, UNF: 5/8-18****Order data**

Order number	139727 5/8-18
GTIN	4062406058098
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: 6

Threads per inch: 18

Nominal Ø D_C: 11.95 mm

Flute length L_C: 33.09 mm

Shank length L_S: 45 mm

Overall length L: 92 mm

Shank Ø D_S: 12 mm

Technical description

Shank length L_s	45 mm
Number of clamping slots	6
Thread type	UNF
Thread type	UNF-LH
Threads per inch	18
Shank $\varnothing D_s$	12 mm
Thread pitch	1.411 mm
No. of teeth Z	6
Thread $\varnothing$	15.86 mm
Overall length L	92 mm
Full profile	yes
Flute length L_c	33.09 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.11
Thread size	5/8-18 UNF
Nominal $\varnothing D_c$	11.95 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