

Garant

GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, UNF: 1/2-20



Order data

Order number	139728 1/2-20
GTIN	4062406058333
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**

Advantage:

Incorporating a countersink profile for a 90° countersink and thread milling in a single operation.

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. 139728 + 129100 HB**

Form **HE**: order with **No. 139728 + 129100 HE**

Thread type: UNF

Thread type: UNF-LH

No. of teeth Z: 6

Threads per inch: 20

Nominal $\varnothing D_c$: 10.9 mm

Flute length L_c : 25.99 mm

Shank length L_s : 45 mm

Overall length L: 94 mm

Shank $\varnothing D_s$: 14 mm

Technical description

Programming value for countersink l_1	27.14 mm
Overall length L	94 mm
Shank $\varnothing D_s$	14 mm
Thread pitch	1.27 mm
No. of teeth Z	6
Thread type	UNF
Thread type	UNF-LH
Thread \varnothing	12.7 mm
maximum countersink $\varnothing D_1$	13.2 mm
Full profile	yes
Threads per inch	20
Number of clamping slots	6
Shank length L_s	45 mm
Flute length L_c	25.99 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.1
Thread size	1/2-20 UNF
Nominal $\varnothing D_c$	10.9 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 $2 \times D$ 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