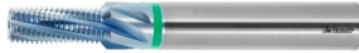


Garant**GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, UNF: 1/4-28****Order data**

Order number	139728 1/4-28
GTIN	4062406058296
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: 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: 68 mm

Shank Ø D_s: 8 mm

Technical description

Thread Ø	6.35 mm
Overall length L	68 mm
Shank Ø D _s	8 mm
No. of teeth Z	4
Shank length L _s	36 mm
Threads per inch	28
Number of clamping slots	4
Full profile	yes
Programming value for countersink l _i	14 mm
maximum countersink Ø D ₁	6.85 mm
Thread pitch	0.907 mm
Thread type	UNF
Thread type	UNF-LH
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

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