

Garant

GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, UNF: 10-32



Order data

Order number	139728 10-32
GTIN	4062406058289
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: 32

Nominal $\varnothing D_c$: 3.81 mm

Flute length L_c : 9.1 mm

Shank length L_s : 36 mm

Overall length L: 58 mm

Shank $\varnothing D_s$: 6 mm

Technical description

Programming value for countersink l_1	10.74 mm
Shank $\varnothing D_s$	6 mm
Overall length L	58 mm
maximum countersink $\varnothing D_1$	5.5 mm
Shank length L_s	36 mm
Thread \varnothing	4.83 mm
No. of teeth Z	4
Number of clamping slots	4
Thread type	UNF
Thread type	UNF-LH
Thread pitch	0.794 mm
Full profile	yes
Threads per inch	32
Flute length L_c	9.1 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.04
Thread size	10-32 UNF
Nominal $\varnothing D_c$	3.81 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