

Garant**GARANT Master TM plain shank thread mill, TiAlN, NPT: 1/4-18****Order data**

Order number	139729 1/4-18
GTIN	4062406058166
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**
- **Increased number of cutting edges**
- **New coating for optimum wear resistance**
- **Corrected thread profile for avoidance of profile distortions**

Application:

Tapered pipe threads (NPT) to ANSI B1.20.1, for threads with sealants.

Note:

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

Form **HB**: order with **No. 139729 + 129100 HB**

Form **HE**: order with **No. 139729 + 129100 HE**

No. of teeth Z: 6

Threads per inch: 18

Nominal Ø D_C: 9.11 mm

Flute length L_C: 13.39 mm

Shank length L_S: 40 mm

Overall length L: 75 mm

Shank Ø D_S: 10 mm

Technical description

Shank length L_s	40 mm
Threads per inch	18
Shank $\varnothing D_s$	10 mm
Overall length L	75 mm
Number of clamping slots	6
Thread pitch	1.411 mm
Thread $\varnothing$	13.62 mm
No. of teeth Z	6
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.1
Flute length L_c	13.39 mm
Thread size	1/4-18 NPT
Nominal $\varnothing D_c$	9.11 mm
Series	GARANT Master TM
Coating	TiAlN
Thread type	NPT
Flank angle	60 degrees
Tool material	solid carbide
Standard	ANSI B 1.20.1
Taper ratio	1:16
Shank	DIN 6535 HA with h6
Through-coolant	yes
Application for type of drilling	for blind hole and through hole
Spacing of the cutters	unequal spacing
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter

