

Garant
GARANT Master TM plain shank thread mill 2×D, TiAlN, M: M20

Order data

Order number	139640 M20
GTIN	4045197957542
Item class	11D

Description
Version:

Solid carbide thread mills **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**

Through-coolant feed \geq M4

Note:

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

Form **HB**: order with **No. 139640 / 136941 + 129100 HB**

Form **HE**: order with **No. 139640 / 136941 + 129100 HE**.

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 2.5 mm

Nominal $\varnothing D_c$: 13.95 mm

maximum insertion depth L_1 : 41.25 mm

Shank length L_s : 45 mm

Overall length L: 102 mm

Shank $\varnothing D_s$: 14 mm

Technical description

No. of teeth Z	6
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Shank length L_s	45 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.13 mm
Through-coolant	yes
Overall length L	102 mm
Shank $\varnothing D_s$	14 mm
Number of clamping slots	6
maximum insertion depth L_1	41.25 mm
Thread pitch	2.5 mm
Thread depth	40 mm
Thread size	M20
Nominal $\varnothing D_c$	13.95 mm
Coating	TiAlN
Thread type	M-LH
Thread type	M
Flank angle	60 degrees
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA to h6
Application for type of drilling	up to $2 \times D$ for blind holes and through holes
Spacing of the cutters	unequal spacing
Shank tolerance	h6
Colour ring	green
Internal/external application	Indvendig
Series	GARANT Master TM
Type of product	thread milling cutter

Services

Shank grinding Type HE	129100 HE
	129100 HB

Shank grinding Type HB
