ඨ Hoffmann Group

Garant

GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, M: M10

Order data

Order number	139653 M10
GTIN	4045197957788
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**
Advantage:
Incorporating a countersink profile for a 90° countersink and thread milling in a single operation.
Note:
Form HB and HE supplied at the same price as HA.
Form **HB**: order with **No. 139656 + 129100 HB**
Form **HE**: order with **No. 139656 + 129100 HE**
Form **HB**: order with **No. 139653 + 129100 HB**
Form **HE**: order with **No. 139653 + 129100 HE**
Form **HB**: order with **No. 139654 + 129100 HB**
Form **HE**: order with **No. 139654 + 129100 HE**.
Through-coolant: yes
No. of teeth Z: 6
Thread pitch: 1.5 mm
Nominal Ø D_C: 8.1 mm
Shank length L_s: 45 mm
Overall length L: 82 mm

Shank Ø D_s: 12 mm
maximum countersink Ø D_1: 10.5 mm

Technical description

Number of clamping slots	6
Thread pitch	1.5 mm
Overall length L	82 mm
Feed f_z in steel < 750 N/mm^2	0.075 mm
maximum countersink Ø D_1	10.5 mm
Through-coolant	yes
Programming value for countersink l_1	21.45 mm
Shank Ø D_s	12 mm
Shank length L_s	45 mm
No. of teeth Z	6
Thread depth	20 mm
Thread size	M10
Nominal Ø D_C	8.1 mm
Coating	TiAlN
Thread type	M
Thread type	M-LH
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×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	Indvendig
Series	GARANT Master TM
Type of product	thread milling cutter

Services

Shank grinding Type HE	129100 HE
Shank grinding Type HB	129100 HB