

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, M: M10



Order data

Order number	139654 M10
GTIN	4045197957856
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**

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Form **HE**: order with **No. 139654 + 129100 HE**.

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 1.5 mm

Nominal $\varnothing D_c$: 8.1 mm

Shank length L_s : 45 mm

Overall length L: 92 mm

Shank $\varnothing D_s$: 12 mm
 maximum countersink $\varnothing D_1$: 10.5 mm

Technical description

Number of clamping slots	6
Through-coolant	yes
Programming value for countersink l_1	27.45 mm
Thread pitch	1.5 mm
Shank $\varnothing D_s$	12 mm
Overall length L	92 mm
No. of teeth Z	6
maximum countersink $\varnothing D_1$	10.5 mm
Feed f_z in steel < 750 N/mm ²	0.075 mm
Thread depth	20 mm
Shank length L_s	45 mm
Thread size	M10
Nominal $\varnothing D_c$	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 2.5×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