

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, M: M6



Order data

Order number	139654 M6
GTIN	4045197957832
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: 4

Thread pitch: 1 mm

Nominal $\varnothing D_c$: 4.7 mm

Shank length L_s : 36 mm

Overall length L: 68 mm

Shank $\varnothing D_s$: 8 mm
 maximum countersink $\varnothing D_1$: 6.5 mm

Technical description

Through-coolant	yes
Number of clamping slots	4
Feed f_z in steel < 750 N/mm ²	0.05 mm
Shank length L_s	36 mm
No. of teeth Z	4
maximum countersink $\varnothing D_1$	6.5 mm
Programming value for countersink l_1	16.4 mm
Overall length L	68 mm
Shank $\varnothing D_s$	8 mm
Thread pitch	1 mm
Thread depth	12 mm
Thread size	M6
Nominal $\varnothing D_c$	4.7 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 2.5xD 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 HB	129100 HB
Shank grinding Type HE	129100 HE