

**Garant**
**GARANT Master TM plain shank thread mill 2×D, TiAlN, MF: 10X1,25**

**Order data**

Order number	139665 10X1,25
GTIN	4045197957627
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**

**Through-coolant feed  $\geq 4 \times 0.5$**

**Note:**

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

Form **HB**: order with **No. 139665 + 129100 HB**

Form **HE**: order with **No. 139665 + 129100 HE**

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 1.25 mm

Nominal  $\varnothing D_c$ : 7.95 mm

maximum insertion depth  $L_1$ : 20.63 mm

Shank length  $L_s$ : 36 mm

Overall length L: 68 mm

Shank  $\varnothing D_s$ : 8 mm

**Technical description**

No. of teeth Z	6
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Thread depth	20 mm
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.075 mm
Through-coolant	yes
Thread pitch	1.25 mm
Number of clamping slots	6
Shank $\varnothing D_s$	8 mm
Shank length $L_s$	36 mm
Overall length L	68 mm
maximum insertion depth $L_1$	20.63 mm
Thread size	M10×1.25
Nominal $\varnothing D_c$	7.95 mm
Coating	TiAlN
Thread type	MF
Thread type	MF-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
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

