

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

Order data

Order number	139682 10X1
GTIN	4045197957931
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. 139682 + 129100 HB**

Form **HE**: order with **No. 139682 + 129100 HE**

Form **HB**: order with **No. 139683 + 129100 HB**

Form **HE**: order with **No. 139683 + 129100 HE**

Order **HB** shank: with **No. 139682 + 129100 HB**

Order **HE** shank: with **No. 139682 + 129100 HE**

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 1 mm

Nominal $\varnothing D_C$: 8.5 mm

Shank length L_s : 45 mm

Overall length L: 82 mm

Shank $\varnothing D_s$: 12 mm

maximum countersink $\varnothing D_1$: 10.5 mm

Technical description

Shank length L_s	45 mm
Programming value for countersink l_1	21.5 mm
No. of teeth Z	6
Thread pitch	1 mm
Number of clamping slots	6
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.075 mm
maximum countersink $\varnothing D_1$	10.5 mm
Overall length L	82 mm
Shank $\varnothing D_s$	12 mm
Through-coolant	yes
Thread depth	20 mm
Thread size	M10×1
Nominal $\varnothing D_c$	8.5 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
Countersink angle	90 degrees
Colour ring	green
Internal/external application	Internal
Series	GARANT Master TM

Type of product	thread milling cutter
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Services

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