

GARANT Master TM plain shank thread mill with countersink 2×D, TiAIN, 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 Ø D_c: 8.5 mm

Shank length L_s: 45 mm

Overall length L: 82 mm

Shank Ø D_s: 12 mm

maximum countersink Ø D₁: 10.5 mm

Technical description

Programming value for countersink I₁ 21.5 mm No. of teeth Z 6 Thread pitch 1 mm Number of clamping slots 6 Feed f₂, in steel < 750 N/mm² 0.075 mm maximum countersink Ø D₁ 10.5 mm Overall length L 82 mm Shank Ø D₂ 12 mm Through-coolant yes Thread depth 20 mm Thread size M10×1 Nominal Ø D₂ 8.5 mm Coating TiAIN Thread type MF Thread type MF-LH Flank angle 60 degrees Tool material Solid carbide Thread standard DIN 13 Shank DIN 635 HA to h6 Application for type of drilling holes and through holes Spacing of the cutters unequal spacing Countersink angle 90 degrees Colour ring green Internal/external application Internal	Shank length L₅	45 mm
Thread pitch 1 mm Number of clamping slots 6 Feed f₂ in steel < 750 N/mm² 0.075 mm maximum countersink Ø D₁ 10.5 mm Overall length L 82 mm Shank Ø D₃ 12 mm Through-coolant yes Thread depth 20 mm Thread size M10×1 Nominal Ø Dc 8.5 mm Coating TiAIN 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 Spacing of the cutters unequal spacing Countersink angle 90 degrees Colour ring green Internal/external application Internal	Programming value for countersink I ₁	21.5 mm
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Feed f₂ in steel < 750 N/mm² maximum countersink Ø D₁ Overall length L Shank Ø D₂ Through-coolant Thread depth Thread size M10×1 Nominal Ø D₂ Coating TiAlN Thread type MF Thread type MF Thread sype MF-LH Flank angle Tool material Solid carbide Thread standard DIN 13 Shank DIN 6535 HA to h6 Application for type of drilling Countersink angle Countersink angle Gountersink angle Flank angle Gountersink angle Spacing of the cutters unequal spacing Countersink angle Gountersink angle Flour ing green Internal/external application	Thread pitch	1 mm
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Through-coolant Thread depth 20 mm Thread size M10×1 Nominal Ø Dc 8.5 mm Coating TiAIN 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 Spacing of the cutters unequal spacing Countersink angle Golderes Colour ring Internal/external application Internal	Overall length L	82 mm
Thread depth Thread size M10×1 Nominal Ø Dc 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 Application for type of drilling Countersink angle Countersink angle Colour ring Internal/external application Internal	Shank Ø D _s	12 mm
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Nominal Ø Dc8.5 mmCoatingTiAINThread typeMFThread typeMF-LHFlank angle60 degreesTool materialSolid carbideThread standardDIN 13ShankDIN 6535 HA to h6Application for type of drillingup to 2×D for blind holes and through holesSpacing of the cuttersunequal spacingCountersink angle90 degreesColour ringgreenInternal/external applicationInternal	Thread depth	20 mm
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Thread standard Shank DIN 6535 HA to h6 Application for type of drilling Spacing of the cutters Countersink angle Colour ring Internal/external application DIN 13 DIN 6535 HA to h6 up to 2×D for blind holes and through holes unequal spacing 90 degrees Internal Internal	Flank angle	60 degrees
Shank Application for type of drilling Spacing of the cutters Countersink angle Colour ring Internal/external application DIN 6535 HA to h6 up to 2×D for blind holes unequal spacing unequal spacing 90 degrees Internal	Tool material	Solid carbide
Application for type of drilling Spacing of the cutters Countersink angle Colour ring Internal/external application up to 2×D for blind holes unequal spacing 90 degrees green	Thread standard	DIN 13
Application for type of drilling Spacing of the cutters Countersink angle Colour ring Internal/external application holes and through holes unequal spacing 90 degrees green Internal	Shank	DIN 6535 HA to h6
Countersink angle90 degreesColour ringgreenInternal/external applicationInternal	Application for type of drilling	·
Colour ring green Internal/external application Internal	Spacing of the cutters	unequal spacing
Internal/external application Internal	Countersink angle	90 degrees
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Series GARANT Master TM	Internal/external application	Internal
	Series	GARANT Master TM

Type of product	thread milling cutter
Services	
Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE