

Garant

GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, MF: 14X1,5



Order data

Order number	139682 14X1,5
GTIN	4045197957979
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: 1.5 mm

Nominal $\varnothing D_C$: 12 mm

Shank length L_s : 48 mm

Overall length L: 106 mm

Shank $\varnothing D_s$: 16 mm

maximum countersink $\varnothing D_1$: 14.5 mm

Technical description

Overall length L	106 mm
Shank $\varnothing D_s$	16 mm
Feed f_z in steel < 750 N/mm ²	0.1 mm
Through-coolant	yes
Thread pitch	1.5 mm
maximum countersink $\varnothing D_1$	14.5 mm
No. of teeth Z	6
Thread depth	28 mm
Shank length L_s	48 mm
Number of clamping slots	6
Programming value for countersink l_1	30.5 mm
Thread size	M14×1.5
Nominal $\varnothing D_c$	12 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 HE	129100 HE
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Shank grinding Type HB	129100 HB
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