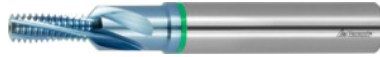


## Garant

### GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, MF: 8X0,75



#### Order data

|              |               |
|--------------|---------------|
| Order number | 139682 8X0,75 |
| GTIN         | 4045197957917 |
| 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: 4

Thread pitch: 0.75 mm

Nominal  $\varnothing D_C$ : 6.8 mm

Shank length  $L_s$ : 40 mm

Overall length L: 75 mm

Shank  $\varnothing D_s$ : 10 mm

maximum countersink  $\varnothing D_1$ : 8.5 mm

## Technical description

|   |   |
|---|---|
| Thread pitch                                | 0.75 mm                                     |
| Overall length L                            | 75 mm                                       |
| Thread depth                                | 16 mm                                       |
| maximum countersink $\varnothing D_1$       | 8.5 mm                                      |
| Shank $\varnothing D_s$                     | 10 mm                                       |
| Programming value for countersink $l_1$     | 16.98 mm                                    |
| No. of teeth Z                              | 4   |
| Shank length $L_s$                          | 40 mm                                       |
| Through-coolant                             | yes   |
| Number of clamping slots                    | 4   |
| Feed $f_z$ in steel < 750 N/mm <sup>2</sup> | 0.06 mm                                     |
| Thread size                                 | M8x0.75                                     |
| Nominal $\varnothing D_c$                   | 6.8 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 2xD 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 |
|------------------------|-----------|

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|