

GARANT Master TM plain shank thread mill with countersink 2×D, TiAIN, 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 Ø D₁: 8.5 mm

Technical description

Overall length L 75 mm Thread depth 16 mm maximum countersink Ø D₁ 8.5 mm Shank Ø D₀ 10 mm Programming value for countersink I₁ 16.98 mm No. of teeth Z 4 Shank length L₂ 40 mm Through-coolant yes Number of clamping slots 4 Feed f₂ in steel < 750 N/mm² 0.06 mm Thread size M8×0.75 Nominal Ø D₀ 6.8 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 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	Thread pitch	0.75 mm
maximum countersink \oslash D18.5 mmShank \oslash D210 mmProgramming value for countersink I116.98 mmNo. of teeth Z4Shank length L240 mmThrough-coolantyesNumber of clamping slots4Feed f_{z} in steel < 750 N/mm²	Overall length L	75 mm
Shank Ø D₀ 10 mm Programming value for countersink I₁ 16.98 mm No. of teeth Z 4 Shank length L₀ 40 mm Through-coolant yes Number of clamping slots 4 Feed f₂ in steel < 750 N/mm²	Thread depth	16 mm
Programming value for countersink I, No. of teeth Z Shank length L, Through-coolant Number of clamping slots Feed f, in steel < 750 N/mm² Nominal Ø Dc Coating TiAlN Thread type MF Thread type MF Thread standard Solid carbide Thread standard Shank DIN 6535 HA to h6 Application for type of drilling Spacing of the cutters Countersink angle Countersink angle Goundersink angle Countersink angle Goundersink angle Internal	maximum countersink Ø D₁	8.5 mm
No. of teeth Z Shank length L₂ Shank length L₂ Through-coolant Shank length L₂ Number of clamping slots Ves Shumber of clamping slots Feed f₂ in steel < 750 N/mm² O.06 mm Thread size M8×0.75 Nominal Ø D₂ Solid Garbide Thread type MF Thread type MF-LH Flank angle Solid carbide Thread standard Solid Carbide Thread standard Thread standard 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 Solodegrees Colour ring General Internal	Shank Ø D _s	10 mm
Shank length L₃ 40 mm Through-coolant yes Number of clamping slots 4 Feed f₂ in steel < 750 N/mm²	Programming value for countersink I ₁	16.98 mm
Through-coolant yes Number of clamping slots 4 Feed f₂ in steel < 750 N/mm²	No. of teeth Z	4
Number of clamping slots 4 Feed f₂ in steel < 750 N/mm²	Shank length L _s	40 mm
Feed f _z in steel < 750 N/mm² Thread size M8×0.75 Nominal Ø D _C 6.8 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 Golour ring green Internal/external application	Through-coolant	yes
Thread size Nominal Ø Dc 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 Application for type of drilling Countersink angle Countersink angle Gunternal/external application M8×0.75 6.8 mm TiAlN TiAlN DIN 6535 MF-LH Solid carbide DIN 13 Shank DIN 6535 HA to h6 Pup to 2×D for blind holes and through holes Flacing Guntersink angle 90 degrees Colour ring green Internal/external application	Number of clamping slots	4
Nominal Ø Dc 6.8 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 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	Feed f_z in steel < 750 N/mm ²	0.06 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 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	Thread size	M8×0.75
Thread type Thread type MF 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 Spacing of the cutters Countersink angle Countersink angle Golour ring Internal/external application MF MF MF MF MF MF MF MF MF M	Nominal Ø D _c	6.8 mm
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	Coating	TiAIN
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Tool material Solid carbide Thread standard DIN 13 Shank DIN 6535 HA to h6 Application for type of drilling Application for type of drilling Spacing of the cutters Countersink angle Colour ring Internal/external application Solid carbide DIN 13 DIN 6535 HA to h6 up to 2×D for blind holes and through holes unequal spacing 90 degrees Internal	Thread type	MF-LH
Thread standard DIN 13 Shank DIN 6535 HA to h6 Application for type of drilling Application for type of drilling Spacing of the cutters Unequal spacing Countersink angle Solour ring Internal/external application DIN 13 DIN 13 DIN 13 DIN 13 Application 13 Up to 2×D for blind holes and through holes Unequal spacing 90 degrees 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 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	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 angle 90 degrees Colour ring green Internal/external application Internal	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
	Colour ring	green
Series GARANT Master TM	Internal/external application	Internal
	Series	GARANT Master TM

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