

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, MF: 12X1,5



Order data

Order number	139683 12X1,5
GTIN	4045197958068
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:

HB and HE shanks are available at the same price as HA.

Order **HB** shank: with **No. 139683 + 129100 HB**

Order **HE** shank: with **No. 139683 + 129100 HE**

Through-coolant: yes

No. of teeth Z: 6

Thread pitch: 1.5 mm

Nominal $\varnothing D_c$: 10 mm

Shank length L_s : 45 mm

Overall length L: 94 mm

Shank $\varnothing D_s$: 14 mm

maximum countersink $\varnothing D_1$: 12.5 mm

Technical description

Number of clamping slots	6
No. of teeth Z	6
maximum countersink $\varnothing D_1$	12.5 mm
Shank $\varnothing D_s$	14 mm
Shank length L_s	45 mm
Overall length L	94 mm
Programming value for countersink l_1	32 mm
Thread pitch	1.5 mm
Feed f_z in steel < 750 N/mm ²	0.09 mm
Thread depth	24 mm
Through-coolant	yes
Thread size	M12×1.5
Nominal $\varnothing D_c$	10 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 2.5×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

Services

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