

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, MF: 6X0,75



Order data

Order number	139683 6X0,75
GTIN	4045197958006
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: 4

Thread pitch: 0.75 mm

Nominal $\varnothing D_c$: 4.9 mm

Shank length L_s : 36 mm

Overall length L: 68 mm

Shank $\varnothing D_s$: 8 mm

maximum countersink $\varnothing D_1$: 6.5 mm

Technical description

Overall length L	68 mm
No. of teeth Z	4
maximum countersink $\varnothing D_1$	6.5 mm
Shank $\varnothing D_s$	8 mm
Through-coolant	yes
Number of clamping slots	4
Thread depth	12 mm
Programming value for countersink l_1	16.18 mm
Feed f_z in steel < 750 N/mm ²	0.05 mm
Thread pitch	0.75 mm
Shank length L_s	36 mm
Thread size	M6×0.75
Nominal $\varnothing D_c$	4.9 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 HE	129100 HE
Shank grinding Type HB	129100 HB