

**Garant**
**GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, G: G1/16**

**Order data**

Order number	139715 G1/16
GTIN	4045197956934
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.

**Application:**

For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connections).

**Note:**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 139715 + 129100 HB**

Form **HE**: order with **No. 139715 + 129100 HE**

No. of teeth Z: 4

Thread pitch: 0.91 mm

Threads per inch: 28

Nominal  $\varnothing D_c$ : 6.2 mm

Shank length  $L_s$ : 40 mm

Overall length L: 75 mm

Shank  $\varnothing D_s$ : 10 mm

## Technical description

Programming value for countersink $l_1$	16.92 mm
No. of teeth Z	4
Thread size	G1/16
Number of clamping slots	4
Shank length $L_s$	40 mm
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.06 mm
maximum countersink $\varnothing D_1$	8.3 mm
Threads per inch	28
Thread pitch	0.91 mm
Overall length L	75 mm
Thread depth	12.4 mm
Shank $\varnothing D_s$	10 mm
Series	GARANT Master TM
Nominal $\varnothing D_c$	6.2 mm
Coating	TiAlN
Thread type	G
Thread type	G-LH
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
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	Indvendig

Type of product	thread milling cutter
-----------------	-----------------------

---

**Services**

Shank grinding Type HE	129100 HE
------------------------	-----------

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