

Garant

GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, G: G1/4



Order data

Order number	139715 G1/4
GTIN	4045197958105
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: 6

Thread pitch: 1.337 mm

Threads per inch: 19

Nominal $\varnothing D_c$: 11 mm

Shank length L_s : 45 mm

Overall length L: 94 mm

Shank $\varnothing D_s$: 14 mm

Technical description

Number of clamping slots	6
Feed f_z in steel < 750 N/mm ²	0.1 mm
maximum countersink $\varnothing D_1$	13.7 mm
No. of teeth Z	6
Thread pitch	1.337 mm
Thread depth	22 mm
Overall length L	94 mm
Programming value for countersink l_1	28.76 mm
Shank $\varnothing D_s$	14 mm
Threads per inch	19
Thread size	G1/4
Shank length L_s	45 mm
Series	GARANT Master TM
Nominal $\varnothing D_c$	11 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
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Services

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