

Garant
GARANT Master TM plain shank thread mill 2.5×D, TiAlN, M: M6

Order data

Order number	139641 M6
GTIN	4062406240844
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.**

Through-coolant feed \geq M4

Note:

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

Order **HB** shank: with **No. 136941 + 129100 HB**.

Order **HE** shank: with **No. 136941 + 129100 HE**.

Technical description

Shank $\varnothing D_s$	6 mm
No. of teeth Z	4
Thread depth	15.47 mm
Shank length L_s	36 mm
Number of clamping slots	4
Thread \varnothing	6 mm

Thread pitch	1 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.05 mm
Thread size	M6
Overall length L	64 mm
Through-coolant	yes
Nominal $\varnothing D_c$	4.7 mm
Flute length L_c	15.47 mm
Coating	TiAlN
Thread type	M
Thread type	M-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 $2 \times D$ for blind holes
Application for type of drilling	up to $2.5 \times D$ for through holes
Spacing of the cutters	unequal spacing
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Series	Master TM
Type of product	thread milling cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	200 m/min	N
Aluminium (short chipping)	suitable	190 m/min	N
Alu $> 10\% \text{ Si}$	suitable	160 m/min	N

Steel < 500 N/mm ²	suitable	125 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	Suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P
INOX < 900 N/mm ²	suitable	75 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable	45 m/min	S
GG(G)	suitable	105 m/min	K
CuZn	suitable	175 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	Suitable		

Services

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