

## Garant

### GARANT Master TM plain shank thread mill with countersink 1.5×D, TiAlN, M: M6



#### Order data

Order number	139656 M6
GTIN	4062406240943
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. 139656 + 129100 HB**.

Order **HE** shank: with **No. 139656 + 129100 HE**.

#### Technical description

Thread depth	9.47 mm
Number of clamping slots	4
Overall length L	68 mm
No. of teeth Z	4

Through-coolant	yes
Thread Ø	6 mm
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.05 mm
Shank length $L_s$	36 mm
Thread pitch	1 mm
Shank Ø $D_s$	8 mm
Thread size	M6
Nominal Ø $D_c$	4.7 mm
Flute length $L_c$	9.47 mm
Programming value for countersink $L_1$	10.37 mm
Neck Ø $D_1$	6.5 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 1.5×D for through holes
Application for type of drilling	up to 1.5×D for blind holes
Spacing of the cutters	unequal spacing
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Series	Master TM
Type of product	thread milling cutter

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Alu plastics	suitable	220 m/min	N
Aluminium (short chipping)	suitable	220 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	45 m/min	H
TOOLOX 33	suitable	85 m/min	H
TOOLOX 44	suitable	50 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	82 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	75 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	50 m/min	S
GG(G)	suitable	120 m/min	K
CuZn	suitable	200 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

## Services

Shank grinding Type HB

129100 HB

Shank grinding Type HE

129100 HE