

Garant**GARANT Master TM plain shank thread mill with countersink 2×D, AlTiN, G: G1/8****Order data**

Order number	139716 G1/8
GTIN	4067263126911
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.**
- **The latest generation of AlTiN-based HiPIMS coating.**
- **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). **Suitable for internal and external threads.**

Note:

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

Order **HB** shank: with **No. 139716 + 129100 HB**.

Order **HE** shank: with **No. 139716 + 129100 HE**.

Technical description

Programming value for countersink L ₁	22.57 mm
For use with external threads	up to 2×D for bolt threads

Thread size	G1/8
Flute length L_c	19.5 mm
Nominal $\varnothing D_c$	8.1 mm
Number of clamping slots	4
Neck $\varnothing D_1$	11 mm
Threads per inch	28
Shank $\varnothing D_s$	12 mm
Thread pitch	0.907 mm
Series	Master TM
Shank length L_s	47 mm
Thread depth	19.5 mm
Application for type of drilling	up to 2×D for through holes
Application for type of drilling	up to 2×D for blind holes
No. of teeth Z	4
Feed f_z in steel < 750 N/mm ²	0.075 mm
Overall length L	82 mm
Coating	AlTiN
Thread type	G
Thread type	BSP
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Spacing of the cutters	unequal spacing
Countersink angle	90 degrees
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter

User data

	Suitability	V _c	ISO code
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 ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	130 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	80 m/min	P
Steel < 50 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 ²	suitable	82 m/min	M
INOX > 900 N/mm ²	suitable	75 m/min	M
Ti > 850 N/mm ²	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