

**Garant****GARANT Master TM plain shank thread mill with countersink 2×D, AlTiN, UNC: 10-24****Order data**

Order number	139733 10-24
GTIN	4067263126935
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 **UNC unified coarse threads** ASME-B1.1.

**Note:**

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

Order **HB** shank: with **No. 139733 + 129100 HB**

Order **HE** shank: with **No. 139733 + 129100 HE**

**Technical description**

No. of teeth Z	4
Threads per inch	24
Flute length L <sub>c</sub>	10.02 mm

Shank $\varnothing D_s$	6 mm
Thread $\varnothing$	4.83 mm
Number of clamping slots	4
Programming value for countersink $L_1$	10.91 mm
Thread size	10-24 UNC
Thread type	UNC
Thread type	UNC-LH
Nominal $\varnothing D_c$	3.55 mm
Thread pitch	1.058 mm
Overall length $L$	58 mm
Shank length $L_s$	36 mm
Neck $\varnothing D_1$	5.75 mm
Feed $f_z$ in steel $< 750 \text{ N/mm}^2$	0.03 mm
Series	Master TM
Coating	AlTiN
Flank angle	60 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Cutting direction	right-hand
Application for type of drilling	up to $2 \times D$ for through holes
Application for type of drilling	up to $2 \times D$ for blind holes
Spacing of the cutters	unequal spacing
Countersink angle	90 degrees
Shank tolerance	h6
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 <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 < 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 <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