

Garant**GARANT Master TM plain shank thread mill with countersink 2.5×D, AlTiN, M: M10****Order data**

Order number	139664 M10
GTIN	4067263128496
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.**
- **Latest-generation 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.

Note:

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

Order **HB** shank: with **No. 139664 + 129100 HB**.

Order **HE** shank: with **No. 139664 + 129100 HE**.

Technical description

Overall length L	92 mm
No. of teeth Z	6
Through-coolant	yes
Programming value for countersink L ₁	27.45 mm

Thread pitch	1.5 mm
Shank Ø D _s	12 mm
Number of clamping slots	6
Feed f _z in steel < 750 N/mm ²	0.075 mm
Thread depth	26.25 mm
Thread size	M10
Neck Ø D ₁	11 mm
Flute length L _c	26.25 mm
Nominal Ø D _c	8.1 mm
Shank length L _s	49.4 mm
Thread profile	Full profile
Coating	AlTiN
Thread type	M-LH
Thread type	M
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×D for blind holes
Application for type of drilling	up to 2.5×D for through 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

	Suitability	V_c	ISO code
Alu plastics	suitable	200 m/min	N
Aluminium (short chipping)	suitable	190 m/min	N
Alu > 10% 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 HB	129100 HB
Shank grinding Type HE	129100 HE