

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, AlTiN, MF: 8X1



Order data

Order number	139687 8X1
GTIN	4067263128847
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.

Note:

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

Order **HB** shank: with **No. 139687 + 129100 HB**

Order **HE** shank: with **No. 139687 + 129100 HE**

Technical description

Thread size	M8×1
Nominal $\varnothing D_c$	6.6 mm
Overall length L	75 mm
Through-coolant	yes

Programming value for countersink L_1	21.45 mm
Flute length L_c	20.5 mm
Neck $\varnothing D_1$	9 mm
No. of teeth Z	4
Thread depth	20.5 mm
Number of clamping slots	4
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.06 mm
Shank length L_s	40 mm
Shank $\varnothing D_s$	10 mm
Thread pitch	1 mm
Coating	AlTiN
Thread type	MF
Thread type	MF-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
Countersink angle	90 degrees
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