

**Garant**
**GARANT Master TM plain shank thread mill, AlTiN, G: G1/8**

**Order data**

Order number	139706 G1/8
GTIN	4067263128892
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.**

**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. 139706 + 129100 HB**.

Order **HE** shank: with **No. 139706 + 129100 HE**.

**Technical description**

Shank length $L_s$	37.7 mm
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×D for through holes
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.075 mm

Shank $\varnothing D_s$	8 mm
For use with external threads	up to $2 \times D$ for bolt threads
Thread pitch	0.907 mm
Flute length $L_c$	19.5 mm
Threads per inch	28
Thread size	G1/8
Series	Master TM
Number of clamping slots	4
Thread depth	19.5 mm
Nominal $\varnothing D_c$	7.95 mm
No. of teeth Z	4
Overall length L	68 mm
Coating	AlTiN
Thread type	BSP
Thread type	G
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Spacing of the cutters	unequal spacing
Colour ring	green
Internal/external application	Internal and external
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