

GARANT Master TM plain shank thread mill, AlTiN, G: G3/8



Order data

Order number	139706 G3/8
GTIN	4067263128915
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

Number of clamping slots	6
Nominal Ø D _c	13.95 mm
Threads per inch	19
No. of teeth Z	6

For use with external threads	up to 2×D for bolt threads		
Thread size	G3/8		
Series	Master TM		
Thread depth	34.09 mm		
Feed f_z in steel < 750 N/mm ²	0.11 mm		
Shank Ø D _s	14 mm		
Flute length L _c	34.09 mm		
Thread pitch	1.337 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		
Shank length L _s	45.9 mm		
Overall length L	94 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	\mathbf{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	Р
Steel < 750 N/mm ²	suitable	130 m/min	Р
Steel < 900 N/mm ²	suitable	120 m/min	Р
Steel < 1100 N/mm ²	suitable	90 m/min	Р
Steel < 1400 N/mm ²	suitable	80 m/min	Р
Steel < 50 HRC	suitable only under restricted conditions	45 m/min	Н
TOOLOX 33	suitable	85 m/min	Н
TOOLOX 44	suitable	50 m/min	Н
INOX < 900 N/mm ²	suitable	82 m/min	М
INOX > 900 N/mm ²	suitable	75 m/min	М
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 Services	suitable		

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE