

Garant
GARANT Master TM plain shank thread mill, AlTiN, NPT: 1/4-18

Order data

Order number	139739 1/4-18
GTIN	4067263129349
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:

Tapered pipe threads (NPT) to ANSI B1.20.1, for threads with sealants.

Note:

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

Order **HB** shank: with **No. 139739 + 129100 HB**.

Order **HE** shank: with **No. 139739 + 129100 HE**.

Technical description

Feed f_z in steel $< 750 \text{ N/mm}^2$	0.1 mm
Number of clamping slots	6
Shank $\varnothing D_s$	10 mm
Nominal $\varnothing D_c$	9.11 mm
No. of teeth Z	6

Thread pitch	1.411 mm
Flute length L_c	13.39 mm
Overall length L	75 mm
Thread \varnothing	13.62 mm
Threads per inch	18
Thread size	1/4-18 NPT
Shank length L_s	49 mm
Series	Master TM
Coating	AlTiN
Thread type	NPT
Flank angle	60 degrees
Tool material	Solid carbide
Standard	ANSI B 1.20.1
Taper ratio	1:16
Shank	DIN 6535 HA to h6
Through-coolant	yes
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
Spacing of the cutters	unequal spacing
Cutting direction	right-hand
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 ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	130 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	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 ²	suitable	82 m/min	M
INOX > 900 N/mm ²	suitable	75 m/min	M
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	suitable		

Services

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