

## Garant

### GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, M: M8



#### Order data

Order number	139654 M8
GTIN	4045197957849
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.**
- **New coating for optimum wear resistance.**
- **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. 139654 + 129100 HB**.

Order **HE** shank: with **No. 139654 + 129100 HE**.

#### Technical description

Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.06 mm
Through-coolant	yes
Number of clamping slots	4
Shank $\varnothing D_s$	10 mm

Thread depth	20.63 mm
Thread pitch	1.25 mm
Overall length L	75 mm
No. of teeth Z	4
Shank length L <sub>s</sub>	40 mm
Thread size	M8
Nominal Ø D <sub>c</sub>	6.4 mm
Flute length L <sub>c</sub>	20.63 mm
Programming value for countersink L <sub>1</sub>	21.68 mm
Neck Ø D <sub>1</sub>	8.5 mm
Coating	TiAlN
Thread type	M
Thread type	M-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×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	Indvendig
Series	Master TM
Type of product	thread milling cutter

## User data

	Suitability	V <sub>c</sub>	ISO code
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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 <sup>2</sup>	suitable	125 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	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 HE	129100 HE
Shank grinding Type HB	129100 HB