

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, MF: 8X0,75



Order data

Order number	139683 8X0,75
GTIN	4045197958013
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. 139683 + 129100 HB**

Order **HE** shank: with **No. 139683 + 129100 HE**

Through-coolant: yes

No. of teeth Z: 4

Thread pitch: 0.75 mm

Nominal $\varnothing D_c$: 6.8 mm

Flute length L_c : 20.63 mm

Shank length L_s : 40 mm

Overall length L: 75 mm

Shank $\varnothing D_s$: 10 mm

Technical description

Shank $\varnothing D_s$	10 mm
Thread depth	16 mm
Feed f_z in steel $< 750 \text{ N/mm}^2$	0.06 mm
No. of teeth Z	4
Through-coolant	yes
Thread pitch	0.75 mm
Number of clamping slots	4
Overall length L	75 mm
Shank length L_s	40 mm
Thread size	M8x0.75
Nominal $\varnothing D_c$	6.8 mm
Flute length L_c	20.63 mm
Programming value for countersink L_1	21.48 mm
Neck $\varnothing D_1$	8.5 mm
Coating	TiAlN
Thread type	MF
Thread type	MF-LH
Flank angle	60°
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA to h6
Application for type of drilling	up to 2xD for blind holes
Application for type of drilling	up to 2.5xD for through holes
Spacing of the cutters	unequal spacing
Countersink angle	90°
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 HE	129100 HE
Shank grinding Type HB	129100 HB