

## Garant

### GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, MF: 8X1



#### Order data

Order number	139683 8X1
GTIN	4045197958020
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**

#### Technical description

Overall length L	75 mm
Shank Ø D <sub>s</sub>	10 mm
Number of clamping slots	4
Thread pitch	1 mm
Thread depth	20.5 mm

Through-coolant	yes
No. of teeth Z	4
Feed $f_z$ in steel < 750 N/mm <sup>2</sup>	0.06 mm
Shank length $L_s$	40 mm
Thread size	M8×1
Nominal $\varnothing D_c$	6.6 mm
Flute length $L_c$	20.5 mm
Programming value for countersink $L_1$	21.45 mm
Neck $\varnothing D_1$	8.5 mm
Coating	TiAlN
Thread type	MF
Thread type	MF-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
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 <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 HB	129100 HB
Shank grinding Type HE	129100 HE