

Garant
GARANT Master TM plain shank thread mill 2×D, TiAlN, UNC: 1/2-13

Order data

| | |
|--------------|---------------|
| Order number | 139722 1/2-13 |
| GTIN | 4062406057978 |
| 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.**

Application:

For **UNC unified coarse threads** ASME-B1.1.

Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 139722 + 129100 HB**

Form **HE**: order with **No. 139722 + 129100 HE**

Thread type: UNC

Thread type: UNC-LH

No. of teeth Z: 6

Threads per inch: 13

Nominal $\varnothing D_c$: 9.95 mm

Flute length L_c : 26.31 mm

Shank length L_s : 40 mm

Overall length L: 82 mm

Shank $\varnothing D_s$: 10 mm

Technical description

| | |
|--|-----------------------------|
| Thread pitch | 1.954 mm |
| Thread type | UNC |
| Thread type | UNC-LH |
| No. of teeth Z | 6 |
| Thread Ø | 12.7 mm |
| Overall length L | 82 mm |
| Number of clamping slots | 6 |
| Shank length L _s | 40 mm |
| Threads per inch | 13 |
| Shank Ø D _s | 10 mm |
| Flute length L _c | 26.31 mm |
| Feed f _z in steel < 750 N/mm ² | 0.09 mm |
| Thread size | 1/2-13 UNC |
| Nominal Ø D _c | 9.95 mm |
| Series | Master TM |
| Coating | TiAlN |
| Flank angle | 60 ° |
| Tool material | solid carbide |
| Shank | DIN 6535 HA with h6 |
| Through-coolant | yes |
| Cutting direction | right-hand |
| Application for type of drilling | up to 2×D for blind holes |
| Application for type of drilling | up to 2×D for through holes |
| Spacing of the cutters | unequal spacing |
| 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 |

