

**Garant**
**GARANT Master TM plain shank thread mill 2×D, TiAlN, UNF: 3/8-24**

**Order data**

Order number	139727 3/8-24
GTIN	4062406058135
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.**
- **Corrected thread profile for avoidance of profile distortions.**
- **increased number of cutting edges.**
- **new coating for optimum wear resistance.**

**Application:**

For **UNF unified fine threads** ASME-B1.1.

**Note:**

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

Form **HB**: order with **No. 139727 + 129100 HB**

Form **HE**: order with **No. 139727 + 129100 HE**

Thread type: UNF

Thread type: UNF-LH

No. of teeth Z: 4

Threads per inch: 24

Nominal  $\varnothing D_c$ : 7.95 mm

Flute length  $L_c$ : 19.54 mm

Shank length  $L_s$ : 36 mm

Overall length L: 68 mm

Shank  $\varnothing D_s$ : 8 mm

**Technical description**

Thread Ø	9.53 mm
Thread type	UNF
Thread type	UNF-LH
Overall length L	68 mm
Threads per inch	24
Shank Ø D <sub>s</sub>	8 mm
No. of teeth Z	4
Shank length L <sub>s</sub>	36 mm
Number of clamping slots	4
Thread pitch	1.058 mm
Flute length L <sub>c</sub>	19.54 mm
Feed f <sub>z</sub> in steel < 750 N/mm <sup>2</sup>	0.08 mm
Thread size	3/8-24 UNF
Nominal Ø D <sub>c</sub>	7.95 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 <sub>c</sub>	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 <sup>2</sup>	Suitable	140 m/min	P
Steel < 750 N/mm <sup>2</sup>	Suitable	130 m/min	P
Steel < 900 N/mm <sup>2</sup>	Suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	Suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	Suitable	82 m/min	M
INOX > 900 N/mm <sup>2</sup>	Suitable	75 m/min	M
Ti > 850 N/mm <sup>2</sup>	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

