

Garant
GARANT Master TM plain shank thread mill 2×D, TiAlN, M: M3

Order data

Order number	139640 M3
GTIN	4045197955463
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.**

Through-coolant feed \geq M4

Note:

HB and HE shanks are available at the same price as HA.

Order **HB** shank: with **No. 139640 + 129100 HB**.

Order **HE** shank: with **No. 139640 + 129100 HE**.

Through-coolant: no

No. of teeth Z: 4

Thread pitch: 0.5 mm

Nominal $\varnothing D_c$: 2.33 mm

Flute length L_c : 6.25 mm

Shank length L_s : 36 mm

Overall length L: 58 mm

Shank $\varnothing D_s$: 6 mm

Technical description

Number of clamping slots	4
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No. of teeth Z	4
Shank length L _s	36 mm
Thread depth	6 mm
Feed f _z in steel < 750 N/mm ²	0.01 mm
Shank Ø D _s	6 mm
Overall length L	58 mm
Through-coolant	no
Thread pitch	0.5 mm
Thread size	M3
Nominal Ø D _c	2.33 mm
Flute length L _c	6.25 mm
Coating	TiAlN
Thread type	M-LH
Thread type	M
Flank angle	60°
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×D for through holes
Spacing of the cutters	unequal spacing
Shank tolerance	h6
Colour ring	green
Internal/external application	Indvendig
Series	Master TM
Type of product	thread milling cutter

User data

	Suitability	V _c	ISO code
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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 < 55 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