

Garant

GARANT Master TM plain shank thread mill with countersink 2.5×D, TiAlN, M: M4



Order data

Order number	139654 M4
GTIN	4045197956903
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. 139654 + 129100 HB**.

Order **HE** shank: with **No. 139654 + 129100 HE**.

Through-coolant: yes

No. of teeth Z: 4

Thread pitch: 0.7 mm

Nominal $\varnothing D_c$: 3.1 mm

Flute length L_c : 10.15 mm

Shank length L_s : 36 mm

Overall length L: 58 mm

Shank $\varnothing D_s$: 6 mm

Technical description

No. of teeth Z	4
Thread depth	8 mm
Shank length L_s	36 mm
Thread pitch	0.7 mm
Overall length L	58 mm
Through-coolant	yes
Shank $\varnothing D_s$	6 mm
Feed f_z in steel < 750 N/mm ²	0.02 mm
Number of clamping slots	4
Thread size	M4
Nominal $\varnothing D_c$	3.1 mm
Flute length L_c	10.15 mm
Programming value for countersink L_1	10.85 mm
Neck $\varnothing D_1$	4.5 mm
Coating	TiAlN
Thread type	M
Thread type	M-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 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°
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
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