

**Garant**
**GARANT Master TM plain shank thread mill 2×D, TiAlN, MF: 3X0,35**

**Order data**

Order number	139665 3X0,35
GTIN	4045197955470
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  $\geq 4 \times 0.5$**

**Note:**

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

Order **HB** shank: with **No. 139665 + 129100 HB**.

Order **HE** shank: with **No. 139665 + 129100 HE**.

Through-coolant: no

No. of teeth Z: 4

Thread pitch: 0.35 mm

Nominal  $\varnothing D_c$ : 2.45 mm

Flute length  $L_c$ : 6.13 mm

Shank length  $L_s$ : 36 mm

Overall length L: 58 mm

Shank  $\varnothing D_s$ : 6 mm

**Technical description**

Feed $f_z$ in steel $< 750 \text{ N/mm}^2$	0.01 mm
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Thread depth	6 mm
No. of teeth Z	4
Number of clamping slots	4
Overall length L	58 mm
Shank length L <sub>s</sub>	36 mm
Thread pitch	0.35 mm
Shank Ø D <sub>s</sub>	6 mm
Through-coolant	no
Thread size	M3×0.35
Nominal Ø D <sub>c</sub>	2.45 mm
Flute length L <sub>c</sub>	6.13 mm
Coating	TiAlN
Thread type	MF
Thread type	MF-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×D for through holes
Spacing of the cutters	unequal spacing
Colour ring	green
Internal/external application	Indvendig
Series	Master TM
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 < 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 <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 HE	129100 HE
Shank grinding Type HB	129100 HB