Garant

GARANT Master TM plain shank thread mill, AlTiN, G: G1/4

Order data

Order number	139706 G1/4
GTIN	4067263128908
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.**
· **The latest generation of AlTiN-based HIPIMS coating.**
· **Corrected thread profile for avoidance of profile distortions.**
Application:
For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connections). **Suitable for internal and external threads.**
Note:
HB and HE shanks are available at the same price as HA.
Order **HB** shank: with **No. 139706 + 129100 HB**.
Order **HE** shank: with **No. 139706 + 129100 HE**.

Technical description

Application for type of drilling	up to 2×D for through holes
Application for type of drilling	up to 2×D for blind holes
Feed f_z in steel < 750 N/mm^2	0.1 mm
Thread depth	27.41 mm

Thread size	G1/4
Series	Master TM
Number of clamping slots	6
Shank length L_s	42.3 mm
Thread pitch	1.337 mm
Flute length L_c	27.41 mm
Threads per inch	19
For use with external threads	up to 2×D for bolt threads
Shank ∅ D_s	10 mm
Nominal ∅ D_C	9.95 mm
Overall length L	82 mm
No. of teeth Z	6
Coating	AlTiN
Thread type	BSP
Thread type	G
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Spacing of the cutters	unequal spacing
Colour ring	green
Internal/external application	Internal and external
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/mm²	suitable	140 m/min	P
Steel < 750 N/mm²	suitable	130 m/min	P
Steel < 900 N/mm²	suitable	120 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	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/mm²	suitable	82 m/min	M
INOX > 900 N/mm²	suitable	75 m/min	M
Ti > 850 N/mm²	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