

Garant
GARANT Master TM plain shank thread mill, TiAlN, NPT: 3/8-18

Order data

Order number	139729 3/8-18
GTIN	4062406058173
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.**

Application:

Tapered pipe threads (NPT) to ANSI B1.20.1, for threads with sealants.

Note:

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

Form **HB**: order with **No. 139729 + 129100 HB**

Form **HE**: order with **No. 139729 + 129100 HE**

No. of teeth Z: 6

Threads per inch: 18

Nominal $\varnothing D_c$: 11.11 mm

Flute length L_c : 13.38 mm

Shank length L_s : 45 mm

Overall length L: 82 mm

Shank $\varnothing D_s$: 12 mm

Technical description

Threads per inch	18
Thread pitch	1.411 mm
Shank length L_s	45 mm
Thread \varnothing	17.06 mm
Number of clamping slots	6
Shank $\varnothing D_s$	12 mm
Overall length L	82 mm
No. of teeth Z	6
Feed f_z in steel < 750 N/mm ²	0.11 mm
Flute length L_c	13.38 mm
Thread size	3/8-18 NPT
Nominal $\varnothing D_c$	11.11 mm
Series	Master TM
Coating	TiAlN
Thread type	NPT
Flank angle	60 °
Tool material	solid carbide
Standard	ANSI B 1.20.1
Taper ratio	1:16
Shank	DIN 6535 HA with h6
Through-coolant	yes
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
Spacing of the cutters	unequal spacing
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
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/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 < 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 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

