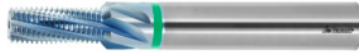


Garant**GARANT Master TM plain shank thread mill with countersink 2×D, TiAlN, UNF: 5/16-24****Order data**

Order number	139728 5/16-24
GTIN	4062406058302
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.**
- **Corrected thread profile for avoidance of profile distortions.**
- **increased number of cutting edges**
- **new coating for optimum wear resistance**

Advantage:

Incorporating a countersink profile for a 90° countersink and thread milling in a single operation.

Application:

For **UNF unified fine threads** ASME-B1.1.

Note:

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

Form **HB**: order with **No. 139728 + 129100 HB**

Form **HE**: order with **No. 139728 + 129100 HE**

Thread type: UNF

Thread type: UNF-LH

No. of teeth Z: 4

Threads per inch: 24

Nominal Ø D_c: 6.5 mm

Flute length L_c: 16.36 mm

Shank length L_s: 40 mm

Overall length L: 75 mm

Shank Ø D_s: 10 mm

Technical description

Shank Ø D _s	10 mm
Shank length L _s	40 mm
Overall length L	75 mm
Threads per inch	24
Thread type	UNF
Thread type	UNF-LH
No. of teeth Z	4
Thread pitch	1.058 mm
Number of clamping slots	4
Thread Ø	7.94 mm
Flute length L _c	16.36 mm
Feed f _z in steel < 750 N/mm ²	0.07 mm
Thread size	5/16-24 UNF
Nominal Ø D _c	6.5 mm
Programming value for countersink L ₁	17.33 mm
Neck Ø D ₁	8.5 mm
Series	Master TM
Coating	TiAlN
Flank angle	60 °
Tool material	solid carbide
Shank	DIN 6535 HA with h6
Through-coolant	yes
Cutting direction	right-hand
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

Countersink angle	90 °
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
Services**

Suitable

Shank grinding Type HB

129100 HB

Shank grinding Type HE

129100 HE