



Plain shank thread mill with countersinking step 2×D, TiAlN, UNC: 1/2-13



Order data

Order number	139725 1/2-13
GTIN	4045197366740
Item class	11J

Description

Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions).

Incorporating a **countersink profile** for a 90° countersink.

Advantage:

Countersinking and thread milling in one operation!

Application:

For **UNC unified coarse threads** ASME-B1.1.

Note:

NEW GENERATION AVAILABLE!

Recommended successor product is No. 139723.

Countersink angle: 90 degrees

Thread type: UNC

Thread type: UNC-LH

No. of teeth Z: 3

Threads per inch: 13

Hole $\varnothing d_1$: 9.38 mm

Shank length L_s : 45 mm

Overall length L_{tot} : 89 mm

Shank \varnothing : 14 mm

maximum countersink $\varnothing d_3$: 13 mm

Technical description

Hole $\varnothing d_1$	9.38 mm
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maximum countersink $\varnothing d_3$	13 mm
Thread pitch	1.954 mm
Threads per inch	13
No. of teeth Z	3
Programming value for countersink l_1	27.8 mm
Number of clamping slots	3
Feed f_z in steel < 1100 N/mm ²	0.05 mm
Shank \varnothing	14 mm
Overall length L_{tot}	89 mm
Shank length L_s	45 mm
Hole \varnothing	9.38 mm
Full profile	yes
Thread depth	25.4 mm
Thread type	UNC
Thread type	UNC-LH
Thread size	1/2-13
Coating	TiAlN
Flank angle	60 degrees
Tool material	Solid carbide
Skaft	DIN 6535 HA with h6
Through-coolant	yes
Application for type of drilling	up to 2xD for blind holes and through holes
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal

