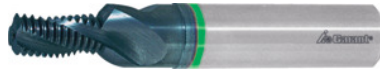




## Plain shank thread mill 1.5×D, TiAlN, M: M4



### Order data

Order number	139655 M4
GTIN	4045197082015
Item class	11J

### Description

#### Version:

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

**Shaft incorporates** a countersinking step for a 90° counterbore.

#### Advantage:

**Countersinking and thread milling in one operation!**

#### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 139653 and 139654 (2×D).**

Through-coolant: no

No. of teeth Z: 3

Thread pitch: 0.7 mm

Hole  $\varnothing d_1$ : 3.14 mm

Shank length  $L_s$ : 36 mm

Overall length  $L_{tot}$ : 47 mm

Shank  $\varnothing$ : 6 mm

maximum countersink  $\varnothing d_3$ : 4.5 mm

### Technical description

Thread pitch	0.7 mm
Programming value for countersink $l_1$	6.5 mm
Number of clamping slots	3
No. of teeth Z	3
Hole $\varnothing d_1$	3.14 mm

Feed $f_z$ in steel < 1100 N/mm <sup>2</sup>	0.01 mm
maximum countersink $\varnothing d_3$	4.5 mm
Shank $\varnothing$	6 mm
Overall length $L_{tot}$	47 mm
Shank length $L_s$	36 mm
Through-coolant	no
Hole $\varnothing$	3.14 mm
Full profile	yes
Thread depth	6 mm
Thread size	4
Coating	TiAlN
Thread type	M
Thread type	M-LH
Flank angle	60 degrees
Tool material	Solid carbide
Thread standard	DIN 13
Skaft	DIN 6535 HA with h6
Application for type of drilling	up to 1.5xD for blind holes and through holes
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	green