



## Plain shank thread mill with countersinking step 2×D, TiAlN, UNC: 5/8-11



### Order data

|              |               |
|--------------|---------------|
| Order number | 139725 5/8-11 |
| GTIN         | 4045197366757 |
| 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: 4

Threads per inch: 11

Hole  $\varnothing d_1$ : 12.5 mm

Shank length  $L_s$ : 48 mm

Overall length  $L_{tot}$ : 102 mm

Shank  $\varnothing$ : 18 mm

maximum countersink  $\varnothing d_3$ : 16.2 mm

### Technical description

|                                       |          |
|---------------------------------------|----------|
| Thread pitch                          | 2.309 mm |
| maximum countersink $\varnothing d_3$ | 16.2 mm  |

|   |   |
|---|---|
| No. of teeth Z  | 4   |
| Number of clamping slots                              | 4   |
| Programming value for countersink I <sub>1</sub>      | 35 mm                                       |
| Feed f <sub>z</sub> in steel < 1100 N/mm <sup>2</sup> | 0.055 mm                                    |
| Threads per inch                                      | 11  |
| Hole Ø d <sub>1</sub>                                 | 12.5 mm                                     |
| Shank Ø   | 18 mm                                       |
| Overall length L <sub>tot</sub>                       | 102 mm                                      |
| Shank length L <sub>s</sub>                           | 48 mm                                       |
| Hole Ø  | 12.5 mm                                     |
| Full profile  | yes   |
| Thread depth  | 31.76 mm                                    |
| Thread type   | UNC   |
| Thread type   | UNC-LH                                      |
| Thread size   | 5/8-11                                      |
| 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 2×D for blind holes and through holes |
| Countersink angle                                     | 90 degrees                                  |
| Shank tolerance                                       | h6  |
| Colour ring   | green                                       |
| Internal/external application                         | Internal                                    |