



## Plain shank thread mill with countersinking step 2×D, TiAlN, UNF: 1/4-28



### Order data

Order number	139726 1/4-28
GTIN	4045197366771
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 **UNF unified fine threads** ASME-B1.1.

#### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 139728.**

Countersink angle: 90 degrees

Thread type: UNF

Thread type: UNF-LH

No. of teeth Z: 3

Threads per inch: 28

Hole  $\varnothing$   $d_1$ : 4.7 mm

Shank length  $L_s$ : 36 mm

Overall length  $L_{tot}$ : 62 mm

Shank  $\varnothing$ : 8 mm

maximum countersink  $\varnothing$   $d_3$ : 6.6 mm

### Technical description

Threads per inch	28
maximum countersink $\varnothing$ $d_3$	6.6 mm

Hole $\varnothing d_1$	4.7 mm
Number of clamping slots	3
Feed $f_z$ in steel < 1100 N/mm <sup>2</sup>	0.02 mm
Programming value for countersink $l_1$	14.8 mm
Thread pitch	0.907 mm
No. of teeth Z	3
Shank $\varnothing$	8 mm
Overall length $L_{tot}$	62 mm
Shank length $L_s$	36 mm
Hole $\varnothing$	4.7 mm
Full profile	yes
Thread depth	12.7 mm
Thread type	UNF
Thread type	UNF-LH
Thread size	1/4-28
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