



## Plain shank thread mill with countersinking step 2×D, TiAlN, UNC: 1/4-20



### Order data

|              |               |
|--------------|---------------|
| Order number | 139725 1/4-20 |
| GTIN         | 4045197366702 |
| 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: 20

Hole  $\varnothing$  d<sub>1</sub>: 4.7 mm

Shank length L<sub>s</sub>: 36 mm

Overall length L<sub>tot</sub>: 62 mm

Shank  $\varnothing$ : 8 mm

maximum countersink  $\varnothing$  d<sub>3</sub>: 6.6 mm

### Technical description

|                  |    |
|------------------|----|
| Threads per inch | 20 |
| No. of teeth Z   | 3  |

|  |   |
|--|---|
| Thread pitch                                 | 1.27 mm                                     |
| Number of clamping slots                     | 3   |
| Feed $f_z$ in steel < 1100 N/mm <sup>2</sup> | 0.018 mm                                    |
| maximum countersink $\varnothing d_3$        | 6.6 mm                                      |
| Hole $\varnothing d_1$                       | 4.7 mm                                      |
| Programming value for countersink $l_1$      | 15.4 mm                                     |
| 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                                  | UNC   |
| Thread type                                  | UNC-LH                                      |
| Thread size                                  | 1/4-20                                      |
| 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                                    |