



## Plain shank thread mill with countersinking step 2×D, TiAlN, UNF: 5/16-24



### Order data

Order number	139726 5/16-24
GTIN	4045197366788
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: 24

Hole  $\varnothing d_1$ : 6.22 mm

Shank length  $L_s$ : 40 mm

Overall length  $L_{tot}$ : 74 mm

Shank  $\varnothing$ : 10 mm

maximum countersink  $\varnothing d_3$ : 8.2 mm

### Technical description

Feed $f_z$ in steel < 1100 N/mm <sup>2</sup>	0.03 mm
Hole $\varnothing d_1$	6.22 mm

Number of clamping slots	3
No. of teeth Z	3
Programming value for countersink $l_1$	17.2 mm
maximum countersink $\varnothing d_3$	8.2 mm
Threads per inch	24
Thread pitch	1.058 mm
Shank $\varnothing$	10 mm
Overall length $L_{tot}$	74 mm
Shank length $L_s$	40 mm
Hole $\varnothing$	6.22 mm
Full profile	yes
Thread depth	15.88 mm
Thread type	UNF
Thread type	UNF-LH
Thread size	5/16-24
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