



## Plain shank thread mill with countersinking step 2×D, TiAlN, UNC: 5/16-18



### Order data

Order number	139725 5/16-18
GTIN	4045197366719
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: 18

Hole  $\varnothing$  d<sub>1</sub>: 6.22 mm

Shank length L<sub>s</sub>: 40 mm

Overall length L<sub>tot</sub>: 74 mm

Shank  $\varnothing$ : 10 mm

maximum countersink  $\varnothing$  d<sub>3</sub>: 8.2 mm

### Technical description

No. of teeth Z	3
Threads per inch	18

Thread pitch	1.411 mm
Programming value for countersink $l_1$	17.1 mm
Hole $\varnothing d_1$	6.22 mm
Feed $f_z$ in steel < 1100 N/mm <sup>2</sup>	0.025 mm
maximum countersink $\varnothing d_3$	8.2 mm
Number of clamping slots	3
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	UNC
Thread type	UNC-LH
Thread size	5/16-18
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