



Plain shank thread mill 2xD, TiAlN, G: G1/4



Order data

Order number	139707 G1/4
GTIN	4062406225605
Item class	12J

Description

Version:

Corrected thread profile for milling **exact internal or external Whitworth pipe threads**, (ensure stable clamping conditions).

Application:

For Whitworth parallel pipe threads DIN-ISO 228/1 (threads that do not form a seal within the connections). **Suitable for internal and external threads.**

Technical description

Overall length L	75 mm
Thread depth	28 mm
Shank $\varnothing D_s$	10 mm
No. of teeth Z	4
Thread pitch	1.337 mm
Shank length L_s	40 mm
Threads per inch	19
Nominal $\varnothing D_c$	9.9 mm
Flute length L_c	28 mm
Thread size	G1/4
Application for type of drilling	up to 2xD for blind holes
Application for type of drilling	up to 2xD for through holes

Number of clamping slots	4
Feed f_z in steel < 900 N/mm ²	0.04 mm
Coating	TiAlN
Thread type	G
Thread type	BSP
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA to h6
Through-coolant	yes
Colour ring	green
Internal/external application	Internal and external
Type of product	thread milling cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	220 m/min	N
Aluminium (short chipping)	suitable	220 m/min	N
Alu > 10% Si	suitable	170 m/min	N
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	80 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	60 m/min	S
GG(G)	suitable	120 m/min	K
CuZn	suitable	180 m/min	N

Uni	suitable
wet maximum	suitable
Services	
Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE