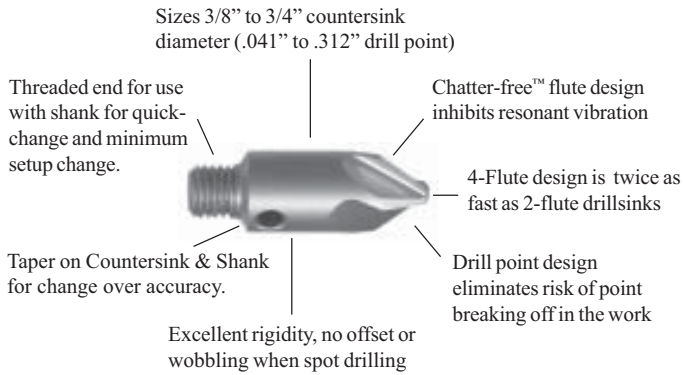


3N1-QC™ Quick Change Countersink System

Patent Pending

Benefits of a 3N1-QC™ Drill Point Countersink



Save steps, setup, production time, and lower scrap rates with a Severance 3N1-QC™ Spotting tool. Specifically designed to give a true start spot and an accurate countersink chamfer on your part.

Quick Change Countersink System


Severance Tool introduces the new 3N1-QC™ Quick Change Countersink System. Featuring standard shanks in 4", 6", and 8" over all lengths, this system is designed to allow quick change of the countersink head for fast tool changes while maintaining dimensional integrity. The quick-change head has a positive lock up on a 60° seat angle and with a threaded lock, tool changes are fast and simple. All 3N1-QC™ threaded countersinks are factory resharpenable.

High Speed Steel

Head Dia.	Overall Length	Drill Point Dia.	Thread Size	Centerline Angle					
				30°	41°	45°	50°	60°	
				Included Angle 60°	82°	90°	100°	120°	
				Severance Name	Order Number	Order Number	Order Number	Order Number	Order Number
3/8"	1-5/32"	.141"	1/4"-28	3N1-QC-3/8	01800	01810	01820	01830	01840
7/16"	1-5/32"	.188"	1/4"-28	3N1-QC-7/16	01801	01811	01821	01831	01841
1/2"	1-5/32"	.219"	1/4"-28	3N1-QC-1/2	01802	01812	01822	01832	01842
5/8"	1-5/32"	.25"	1/4"-28	3N1-QC-5/8	01803	01813	01823	01833	01843
3/4"	1-13/16"	.313"	3/8"-24	3N1-QC-3/4	01804	01814	01824	01834	01844

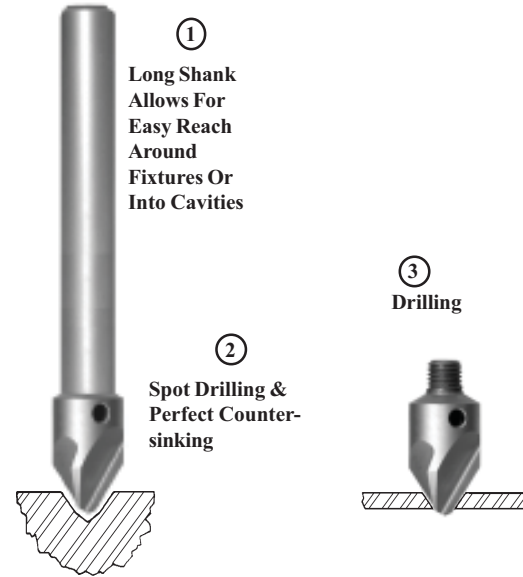
Note: When Ordering 3N1-QC™ Make Sure To Specify Angle, Example (3N1-QC-3/8-45)

Shanks for 3N1-QC™ Cutters



Thread Size	Shank		Overall Length	Shoulder Dia.	Severance Shank Name	EDP Order Number
	Frac.	Dia. Dec.				
1/4"-28	1/4"	.250	4"	7/16"	FM-2 Shank	34235
1/4"-28	1/2"	.500	6"	1/2"	FM-2x6 Shank	34239
1/4"-28	1/2"	.500	8"	1/2"	FM-2x8 Shank	34240
3/8"-24	1/4"	.250	4"	9/16"	FM-3 Shank	34236
3/8"-24	5/8"	.625	6"	5/8"	FM-3x6 Shank	34241
3/8"-24	5/8"	.625	8"	5/8"	FM-3x8 Shank	34242

See pages 78-80 for other available shank styles and sizes.



How Does a 3N1-QC™ Work?

Severance has developed a unique tool, which combines the functions of a drill point starter and true countersink in a quick-change tool. A conventional thin-web drill point is blended into two flutes of a four-flute chatter-free™ countersink ... to perform two or all three of the steps in a spot-drill-countersink and edge chamfer operations. Once you have established a tool in a chuck, you can leave the shank in place and quickly change out the dull 3N1® head with a sharp 3N1®, fast change over. On thin material, such as above, drilling could be optional.