



4-Flute Chatter-Free® Econo-Sinks®

Severance Econo-Sinks® features a Chatter-Free®, four-flute design. Econo-Sinks® are designed with four staggered cutting teeth arranged to insure free chip flow and rapid Chatter-Free® cutting. You will find the Econo-Sinks® give you better finishes, higher production, and more economic value than a single flute tool. Ideal on a wide range of materials including non-ferrous and other stringy materials and cast iron. Other diameters and angles available upon

Request High Speed Steel

| Head Dia. | Shank Dia. | Overall Length | Shank Length | Centerline Angle | | 30° | 41° | 45° | 50° | 55° | 60° |
|-----------|------------|----------------|--------------|------------------|--------------|--------------|--------------|--------------|--------------|-------|------|
| | | | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | | |
| 1/8" | 1/8" | 1-5/8" | 1-5/8" | ES-1/8 | 00970 | 00991 | 01012 | 01033 | 01054 | 01075 | |
| 3/16" | 3/16" | 1-1/2" | 1-1/2" | ES-3/16 | 00971 | 00992 | 01013 | 01034 | 01055 | 01076 | |
| 1/4" | 3/16" | 1-1/2" | 3/4" | ES-1/4 | 00972 | 00993 | 01014 | 01035 | 01056 | 01077 | |
| 5/16" | 1/4" | 1-3/4" | 7/8" | ES-5/16 | 00973 | 00994 | 01015 | 01036 | 01057 | 01078 | |
| 3/8" | 1/4" | 1-3/4" | 7/8" | ES-3/8 | 00974 | 00995 | 01016 | 01037 | 01058 | 01079 | |
| 1/2" | 3/8" | 2-1/8" | 1-1/8" | ES-1/2 | 00976 | 00997 | 01018 | 01039 | 01060 | 01081 | |
| 1/2" | 1/4" | 2-1/8" | 1-1/8" | ES-1/2-1/4 | 00977 | 00998 | 01019 | 01040 | 01061 | 01082 | |
| 5/8" | 3/8" | 2-3/8" | 1-1/8" | ES-5/8 | 00978 | 00999 | 01020 | 01041 | 01062 | 01083 | |
| 5/8" | 1/4" | 2-3/8" | 1-1/8" | ES-5/8-1/4 | 00979 | 01000 | 01021 | 01042 | 01063 | 01084 | |
| 3/4" | 1/2" | 2-11/16" | 1-5/16" | ES-3/4 | 00980 | 01001 | 01022 | 01043 | 01064 | 01085 | |
| 7/8" | 1/2" | 2-13/16" | 1-5/16" | ES-7/8 | 00982 | 01003 | 01024 | 01045 | 01066 | 01087 | |
| 1" | 1/2" | 2-13/16" | 1-5/16" | ES-1 | 00983 | 01004 | 01025 | 01046 | 01067 | 01088 | |
| 1-1/4" | 3/4" | 3-3/8" | 1-5/8" | ES-1-1/4 | 00984 | 01005 | 01026 | 01047 | 01068 | 01089 | |
| 1-1/2" | 3/4" | 3-1/2" | 1-5/8" | ES-1-1/2 | 00985 | 01006 | 01027 | 01048 | 01069 | 01090 | |
| 1-3/4" | 1" | 4-1/4" | 2-1/8" | ES-1-3/4 | 00987 | 01008 | 01029 | 01050 | 01071 | 01092 | |
| 2" | 1" | 4-3/8" | 2-1/8" | ES-2 | 00988 | 01009 | 01030 | 01051 | 01072 | 01093 | |
| 2-1/2" | 1" | 4-3/4" | 2-1/8" | ES-2-1/2 | 00989 | 01010 | 01031 | 01052 | 01073 | 01094 | |
| 3" | 1" | 5" | 2-1/8" | ES-3 | 00990 | 01011 | 01032 | 01053 | 01074 | 01095 | |

Carbide

| Head Dia. | Shank Dia. | Overall Length | Shank Length | Centerline Angle | | 30° | 41° | 45° | 50° | 55° | 60° |
|-----------|------------|----------------|--------------|------------------|--------------|--------------|--------------|--------------|--------------|-------|------|
| | | | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | | |
| 1/8" | 1/8" | 1-1/2" | 1-1/2" | ES-1/8-W | 01120 | 01135 | 01150 | 01165 | 01180 | 01195 | |
| 1/4" | 3/16" | 1-1/2" | 1-3/16" | ES-1/4-W | 01121 | 01136 | 01151 | 01166 | 01181 | 01196 | |
| 3/8" | 1/4" | 2-1/4" | 1-3/4" | ES-3/8-W | 01122 | 01137 | 01152 | 01167 | 01182 | 01197 | |
| 1/2" | 3/8" | 2-1/4" | 1-3/4" | ES-1/2-W | 01125 | 01140 | 01155 | 01170 | 01185 | 01200 | |
| 5/8" | 3/8" | 2-5/8" | 2" | ES-5/8-W | 01126 | 01141 | 01156 | 01171 | 01186 | 01201 | |
| 3/4" | 1/2" | 2-3/4" | 2" | ES-3/4-W | 01127 | 01142 | 01157 | 01172 | 01187 | 01202 | |
| 1" | 1/2" | 3" | 2" | ES-1-W | 01128 | 01143 | 01158 | 01173 | 01188 | 01203 | |



4-Flute Chatter-Free® Double Ended Econo-Sinks®

Severance 4-Flute chatter-free™ countersinks feature a 2+2 staggered cutting flute design. This tool provides lots of chip clearance and is ideal for non-ferrous materials including aluminum and plastics.

High Speed Steel

| Head Dia. | Overall Length | Centerline Angle | | 30° | 41° | 45° | 50° | 55° | 60° |
|-----------|----------------|------------------|--------------|--------------|--------------|--------------|--------------|--------------|------|
| | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | Order Number | |
| 1/8" | 1-1/2" | ES-1/8-DE | 01204 | 01212 | 01220 | 01228 | 01236 | 01244 | |
| 3/16" | 1-7/8" | ES-3/16-DE | 01205 | 01213 | 01221 | 01229 | 01237 | 01245 | |
| 1/4" | 2" | ES-1/4-DE | 01206 | 01214 | 01222 | 01230 | 01238 | 01246 | |
| 5/16" | 2-1/8" | ES-5/16-DE | 01207 | 01215 | 01223 | 01231 | 01239 | 01247 | |
| 3/8" | 2-1/2" | ES-3/8-DE | 01208 | 01216 | 01224 | 01232 | 01240 | 01248 | |
| 1/2" | 3" | ES-1/2-DE | 01209 | 01217 | 01225 | 01233 | 01241 | 01249 | |
| 5/8" | 3 -1/4" | ES-5/8-DE | 01210 | 01218 | 01226 | 01234 | 01242 | 01250 | |
| 3/4" | 3 -1/2" | ES-3/4-DE | 01211 | 01219 | 01227 | 01235 | 01243 | 01251 | |

Carbide

| Head Dia. | Overall Length | Centerline Angle | | 30° | 41° | 45° | 50° | 55° | 60° |
|-----------|----------------|------------------|--------------|--------------|--------------|--------------|--------------|--------------|------|
| | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | Order Number | |
| 1/8" | 1-1/2" | ES-1/8-W-DE | 01252 | 01260 | 01268 | 01276 | 01284 | 01292 | |
| 3/16" | 2" | ES-3/16-W-DE | 01253 | 01261 | 01269 | 01277 | 01285 | 01293 | |
| 1/4" | 2" | ES-1/4-W-DE | 01254 | 01262 | 01270 | 01278 | 01286 | 01294 | |
| 5/16" | 2-1/8" | ES-5/16-W-DE | 01255 | 01263 | 01271 | 01279 | 01287 | 01295 | |
| 3/8" | 2-1/2" | ES-3/8-W-DE | 01256 | 01264 | 01272 | 01280 | 01288 | 01296 | |
| 1/2" | 3" | ES-1/2-W-DE | 01257 | 01265 | 01273 | 01281 | 01289 | 01297 | |
| 5/8" | 3 -1/4" | ES-5/8-W-DE | 01258 | 01266 | 01274 | 01282 | 01290 | 01298 | |
| 3/4" | 3-1/2" | ES-3/4-W-DE | 01259 | 01267 | 01275 | 01283 | 01291 | 01299 | |



Single Flute Double Ended Countersinks

Severance Single Flute Countersinks features our positive shear cutting edge. Single flutes are ideal for non-rigid machining applications, or for machines with less than precision spindles.

High Speed Steel

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|-----------|----------------|------------------|--------------|--------------|--------------|--------------|--------------|--------------|------|
| | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | Order Number | |
| 1/8" | 1-1/2" | 1/8-SF-DE | 00536 | 00544 | 00552 | 00560 | 00568 | 00576 | |
| 3/16" | 1-7/8" | 3/16-SF-DE | 00537 | 00545 | 00553 | 00561 | 00569 | 00577 | |
| 1/4" | 2" | 1/4-SF-DE | 00538 | 00546 | 00554 | 00562 | 00570 | 00578 | |
| 5/16" | 2-1/8" | 5/16-SF-DE | 00539 | 00547 | 00555 | 00563 | 00571 | 00579 | |
| 3/8" | 2-1/2" | 3/8-SF-DE | 00540 | 00548 | 00556 | 00564 | 00572 | 00580 | |
| 1/2" | 3" | 1/2-SF-DE | 00541 | 00549 | 00557 | 00565 | 00573 | 00581 | |
| 5/8" | 3 -1/4" | 5/8-SF-DE | 00542 | 00550 | 00558 | 00566 | 00574 | 00582 | |
| 3/4" | 3-1/2" | 3/4-SF-DE | 00543 | 00551 | 00559 | 00567 | 00575 | 00583 | |

Carbide

| Head Dia. | Overall Length | Centerline Angle | | 30° | 41° | 45° | 50° | 55° | 60° |
|-----------|----------------|------------------|--------------|--------------|--------------|--------------|--------------|--------------|------|
| | | Included Angle | | 60° | 82° | 90° | 100° | 110° | 120° |
| | | Severance Name | Order Number | Order Number | Order Number | Order Number | Order Number | Order Number | |
| 1/8" | 1-1/2" | 1/8-SF-W-DE | 00600 | 00609 | 00617 | 00625 | 00633 | 00641 | |
| 3/16" | 2" | 3/16-SF-W-DE | 00601 | 00610 | 00618 | 00626 | 00634 | 00642 | |
| 1/4" | 2" | 1/4-SF-W-DE | 00602 | 00611 | 00619 | 00627 | 00635 | 00643 | |
| 5/16" | 2-1/8" | 5/16-SF-W-DE | 00603 | 00612 | 00620 | 00628 | 00636 | 00644 | |
| 3/8" | 2-1/2" | 3/8-SF-W-DE | 00604 | 00613 | 00621 | 00629 | 00637 | 00645 | |
| 1/2" | 3" | 1/2-SF-W-DE | 00605 | 00614 | 00622 | 00630 | 00638 | 00646 | |
| 5/8" | 3-1/4" | 5/8-SF-W-DE | 00606 | 00615 | 00623 | 00631 | 00639 | 00647 | |
| 3/4" | 3-1/2" | 3/4-SF-W-DE | 00607 | 00616 | 00624 | 00632 | 00640 | 00648 | |