



High Speed Steel

AC-Adjustable Countersinks

Severance AC Countersinks are designed out of high speed steel as an economical means of combining drilling and countersinking into a continuous operation. They are well adapted to a wide range of applications, and can be used for countersinking wood or light metals, such as mild steel, magnesium, brass and die cast, and for some plastics.

They can be used with any standard twist drill in sizes as indicated, so they need not be discarded if the drill breaks or is used up. They can be positioned at any point along the fluted section of a drill and work best if adjusted to start countersinking when the drilling has been completed.

The cutting teeth are arranged to give a shearing cut, to produce a seat free from chatter and to avoid corkscrew jamming.

These Tools can be factory resharpened many times for cost efficiency. See pages 89-90 for more details.

Drill not included.

C'Sink Body Dia.	Drill Size	Overall Length	Centerline Angle		
			Included Angle	41°	45°
			82°	82°	90°
			Severance Name	Order Number	Order Number
3/8"	1/8" (.1250)	1"	6-AC-2	03572	03622
3/8"	29 (.1360)	1"	6-AC-29	03573	03623
3/8"	28 (.1405)	1"	6-AC-28	03574	03624
3/8"	25 (.1495)	1"	6-AC-25	03575	03625
3/8"	21 (.1590)	1"	6-AC-21	03576	03626
3/8"	19 (.1660)	1"	6-AC-19	03577	03627
1/2"	16 (.1770)	1-1/8"	8-AC-16	03579	03629
1/2"	14 (.1820)	1-1/8"	8-AC-14	03580	03630
1/2"	3/16" (.1875)	1-1/8"	8-AC-3/16	03578	03628
1/2"	10 (.1935)	1-1/8"	8-AC-10	03582	03632
1/2"	7 (.2010)	1-1/8"	8-AC-7	03583	03633
1/2"	7/32" (.2188)	1-1/8"	8-AC-7/32	03581	03631
5/8"	3 (.2130)	1-1/8"	10-AC-3	03586	03636
5/8"	7/32" (.2188)	1-1/8"	10-AC-7/32	03584	03634
5/8"	2 (.2210)	1-1/8"	10-AC-2	03587	03637
5/8"	D (.2460)	1-1/8"	10-AC-D	03590	03640
5/8"	1/4" (.2500)	1-1/8"	10-AC-4	03585	03635
5/8"	F (.2570)	1-1/8"	10-AC-F	03603	03604
5/8"	I (.2720)	1-1/8"	10-AC-I	03591	03641
5/8"	9/32" (.2813)	1-1/8"	10-AC-9/32	03588	03638
5/8"	5/16" (.3125)	1-1/8"	10-AC-5/16	03589	03639
7/8"	Q (.3320)	1-1/2"	14-AC-Q	03592	03642
7/8"	R (.3390)	1-1/2"	14-AC-R	03593	03643
7/8"	S (.3480)	1-1/2"	14-AC-S	03594	03644
7/8"	U (.3680)	1-1/2"	14-AC-U	03596	03646
7/8"	3/8" (.3750)	1-1/2"	14-AC-3/8	03595	03645
7/8"	25/64" (.3906)	1-1/2"	14-AC-25/64	03597	03647
1-1/8"	27/64" (.4219)	1-3/4"	18-AC-27/64	03598	03648
1-1/8"	7/16" (.4375)	1-3/4"	18-AC-7/16	03599	03649
1-1/8"	29/64" (.4531)	1-3/4"	18-AC-29/64	03600	03650
1-1/8"	31/64" (.4844)	1-3/4"	18-AC-31/64	03602	03652
1-1/8"	1/2" (.5000)	1-3/4"	18-AC-1/2	03601	03651

Special Adjustable Countersinks

Special diameters, drill sizes, flute configurations, and angles are available as specials. This Adjustable countersink is designed for non-ferrous materials such as aluminum and magnesium.



REF. # 55381