

## Micrometer Stop-Countersink Units

The Micrometer Micro Stop-Countersink Unit was invented and patented (USP 3028774) by Severance Tool for the aircraft industry to allow precise depth control countersinking and deburring. These units ensure perpendicular alignment with the workpiece and easy to adjust exact depth control in increments of .001". They feature hardened and ground spindles supported by ball bearings, bronze sleeves, or needle bearings, and thrust bearings, and a lock nut to maintain "preset" depth dimensions. Overhang is at a minimum making it possible to work in close quarters.

These units are still widely used in Aircraft manufacturing and maintenance, in sheet metal part production areas, and have found wide use in Transportation, electronic, medical, defense, and telecommunications where precise depth control countersinking is required. Used in hand drills, drill presses, mills, lathes, etc. Bases can be modified for special applications or contours. See "NEW" high speed roller bearing units RSC-24 & RSC-36.



Recommended Maximum Cutter	Unit Shank Dia.	Standard Outside Dia.	Overall Length Retracted	Overall Length Extended	Length of Stroke	Internal Thread	Severance Tool Name	EDP Order Number
7/16"	1/4"	7/8"	3.243"	3.544"	.180	1/4"-28	SC-14	21220
3/4"	1/4"	1-1/16"	3.265"	3.513"	.180	1/4"-28	SC-24	21221
3/4"	1/4"	1-1/16"	3.265"	3.513"	.180	1/4"-28	RSC-24	21227
3/4"	3/8"	1-1/16"	3.310"	3.521"	.180	3/8"-24	SC-36	21222
3/4"	3/8"	1-1/16"	3.310"	3.521"	.180	3/8"-24	RSC-36	21228
1-1/4"	1/2"	1-3/4"	4.270"	4.715"	.280	7/16"-20	SC-47	21223
1-1/4"	3/8"	1-3/4"	4.700"	5.185"	.280	3/8"-24	SC-57	21224



**Special Override Micro-Stop Countersink Units Available by Application**

Non-Marking Nylon Foot	Maximum Cutting Diameter With Foot	Part Number	EDP Number
	7/16"	SC-14-11	21245
	5/8"	SC-24-11	21264
	5/8"	SC-36-11	21264
	1-1/4"	SC-47-11	21302

**Special units and cutters can be made to fit customers applications**

**A Severance Precision Stop Countersink Unit is designed for hand power-tool and drill-press use.**  
**This unit converts your drill-press into a precision countersinking unit, giving you identical countersinks on parts of various thicknesses.**



**#2 Morse Taper Adapter for SC-47 Unit**

Part No.	EDP No.
FM-4-MT	34238

If adapter is ordered at the same time as SC-47 UNIT, unit will be provided with a whistle notch.