



## The Original 6-Flute Chatterless-Countersinks™

Developed by Severance Tool, the flutes of the 6-flute Chatterless-Countersinks™ are designed with staggered cutting angles to eliminate the harmonics that cause chatter in conventional tools. Our tools feature a positive shearing action, are designed to take heavy cuts and produce exceptionally smooth seats. These six fluted countersinks give long service life because the cutting load is distributed over six cutting edges.

Use them in your milling machine, drill press, screw machine, lathes, automatics, special machines, feed units, and hand tools. See also page 53-54 for our CNC-K™ Chatterless-Countersinks™ for CNC lathes and Machining Centers. Our countersinks may be factory resharpened many times, see pages 89-90.

Available in a wide range of standard angles and sizes, or submit your request for special angles, diameters, double angles, pilots, or radii to our Engineering Dept.

### High Speed Steel

**We're The Originators! We've Been "Copied" But Not Surpassed.**

| 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 | Order Number |       |       |       |       |
| 1/8"           | 1/8"         | 1-5/8"         | 1-5/8"       | CK-1/8           | 02370        | 02390        | 02410 | 02430 | 02450 | 02470 |
| 3/16"          | 3/16"        | 1-1/2"         | 1-1/2"       | CK-3/16          | 02371        | 02391        | 02411 | 02431 | 02451 | 02471 |
| 1/4"           | 3/16"        | 1-1/2"         | 3/4"         | CK-1/4           | 02372        | 02392        | 02412 | 02432 | 02452 | 02472 |
| 5/16"          | 1/4"         | 1-3/4"         | 7/8"         | CK-5/16          | 02373        | 02393        | 02413 | 02433 | 02453 | 02473 |
| 3/8"           | 1/4"         | 1-3/4"         | 7/8"         | CK-3/8           | 02374        | 02394        | 02414 | 02434 | 02454 | 02474 |
| 1/2"           | 3/8"         | 2-1/8"         | 1-1/8"       | CK-1/2           | 02375        | 02395        | 02415 | 02435 | 02455 | 02475 |
| 1/2"           | 1/4"         | 2-1/8"         | 1-1/8"       | CK-1/2-1/4       | 02376        | 02396        | 02416 | 02436 | 02456 | 02476 |
| 5/8"           | 3/8"         | 2-3/8"         | 1-1/8"       | CK-5/8           | 02377        | 02397        | 02417 | 02437 | 02457 | 02477 |
| 5/8"           | 1/4"         | 2-3/8"         | 1-1/8"       | CK-5/8-1/4       | 02378        | 02398        | 02418 | 02438 | 02458 | 02478 |
| 3/4"           | 1/2"         | 2-11/16"       | 1-5/16"      | CK-3/4           | 02379        | 02399        | 02419 | 02439 | 02459 | 02479 |
| 7/8"           | 1/2"         | 2-13/16"       | 1-5/16"      | CK-7/8           | 02380        | 02400        | 02420 | 02440 | 02460 | 02480 |
| 1"             | 1/2"         | 2-13/16"       | 1-5/16"      | CK-1             | 02381        | 02401        | 02421 | 02441 | 02461 | 02481 |
| 1-1/4"         | 3/4"         | 3-3/8"         | 1-5/8"       | CK-1-1/4         | 02382        | 02402        | 02422 | 02442 | 02462 | 02482 |
| 1-1/2"         | 3/4"         | 3-1/2"         | 1-5/8"       | CK-1-1/2         | 02383        | 02403        | 02423 | 02443 | 02463 | 02483 |
| 1-3/4"         | 1"           | 4-1/4"         | 2-1/8"       | CK-1-3/4         | 02384        | 02404        | 02424 | 02444 | 02464 | 02484 |
| 2"             | 1"           | 4-3/8"         | 2-1/8"       | CK-2             | 02385        | 02405        | 02425 | 02445 | 02465 | 02485 |
| 2-1/2"         | 1"           | 4-3/4"         | 2-1/8"       | CK-2-1/2         | 02386        | 02406        | 02426 | 02446 | 02466 | 02486 |
| 3"             | 1"           | 5"             | 2-1/8"       | CK-3             | 02387        | 02407        | 02427 | 02447 | 02467 | 02487 |

### 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 | Order Number |       |       |       |       |
| 1/8"           | 1/8"         | 1-1/2"         | 1-1/2"       | CK-1/8-W         | 02520        | 02540        | 02560 | 02580 | 02600 | 02620 |
| 3/16"          | 3/16"        | 1-1/2"         | 1-1/2"       | CK-3/16-W        | 02521        | 02541        | 02561 | 02581 | 02601 | 02621 |
| 1/4"           | 3/16"        | 1-1/2"         | 3/4"         | CK-1/4-W         | 02522        | 02542        | 02562 | 02582 | 02602 | 02622 |
| 5/16"          | 1/4"         | 2-1/4"         | 7/8"         | CK-5/16-W        | 02523        | 02543        | 02563 | 02583 | 02603 | 02623 |
| 3/8"           | 1/4"         | 2-1/4"         | 7/8"         | CK-3/8-W         | 02524        | 02544        | 02564 | 02584 | 02604 | 02624 |
| 1/2"           | 3/8"         | 2-1/4"         | 1-1/8"       | CK-1/2-W         | 02525        | 02545        | 02565 | 02585 | 02605 | 02625 |
| 1/2"           | 1/4"         | 2-1/4"         | 1-1/8"       | CK-1/2-W-1/4     | 02526        | 02546        | 02566 | 02586 | 02606 | 02626 |
| 5/8"           | 3/8"         | 2-3/8"         | 1-1/8"       | CK-5/8-W         | 02527        | 02547        | 02567 | 02587 | 02607 | 02627 |
| 5/8"           | 1/4"         | 2-3/8"         | 1-1/8"       | CK-5/8-W-1/4     | 02528        | 02548        | 02568 | 02588 | 02608 | 02628 |
| 3/4"           | 1/2"         | 2-11/16"       | 1-5/16"      | CK-3/4-W         | 02529        | 02549        | 02569 | 02589 | 02609 | 02629 |
| 7/8"           | 1/2"         | 2-13/16"       | 1-5/16"      | CK-7/8-W         | 02530        | 02550        | 02570 | 02590 | 02610 | 02630 |
| 1"             | 1/2"         | 2-13/16"       | 1-5/16"      | CK-1-W           | 02531        | 02551        | 02571 | 02591 | 02611 | 02631 |
| 1-1/4"         | 3/4"         | 3-3/8"         | 1-5/8"       | CK-1-1/4-W       | 02532        | 02552        | 02572 | 02592 | 02612 | 02632 |
| 1-1/2"         | 3/4"         | 3-1/2"         | 1-5/8"       | CK-1-1/2-W       | 02533        | 02553        | 02573 | 02593 | 02613 | 02633 |
| 1-3/4"         | 1"           | 4-1/4"         | 2-1/8"       | CK-1-3/4-W       | 02534        | 02554        | 02574 | 02594 | 02614 | 02634 |
| 2"             | 1"           | 4-3/8"         | 2-1/8"       | CK-2-W           | 02535        | 02555        | 02575 | 02595 | 02615 | 02635 |