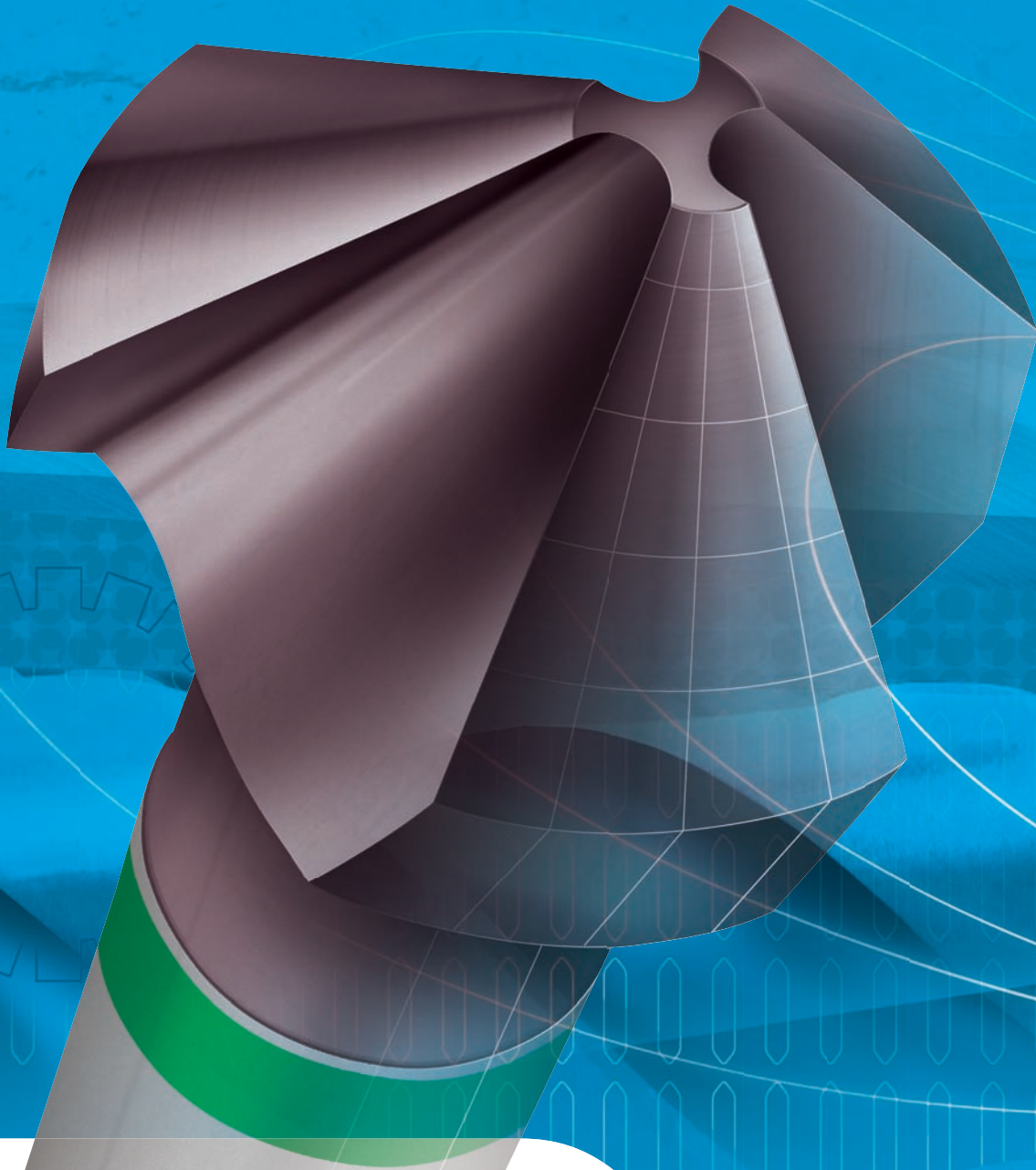


COUNTERSINKS



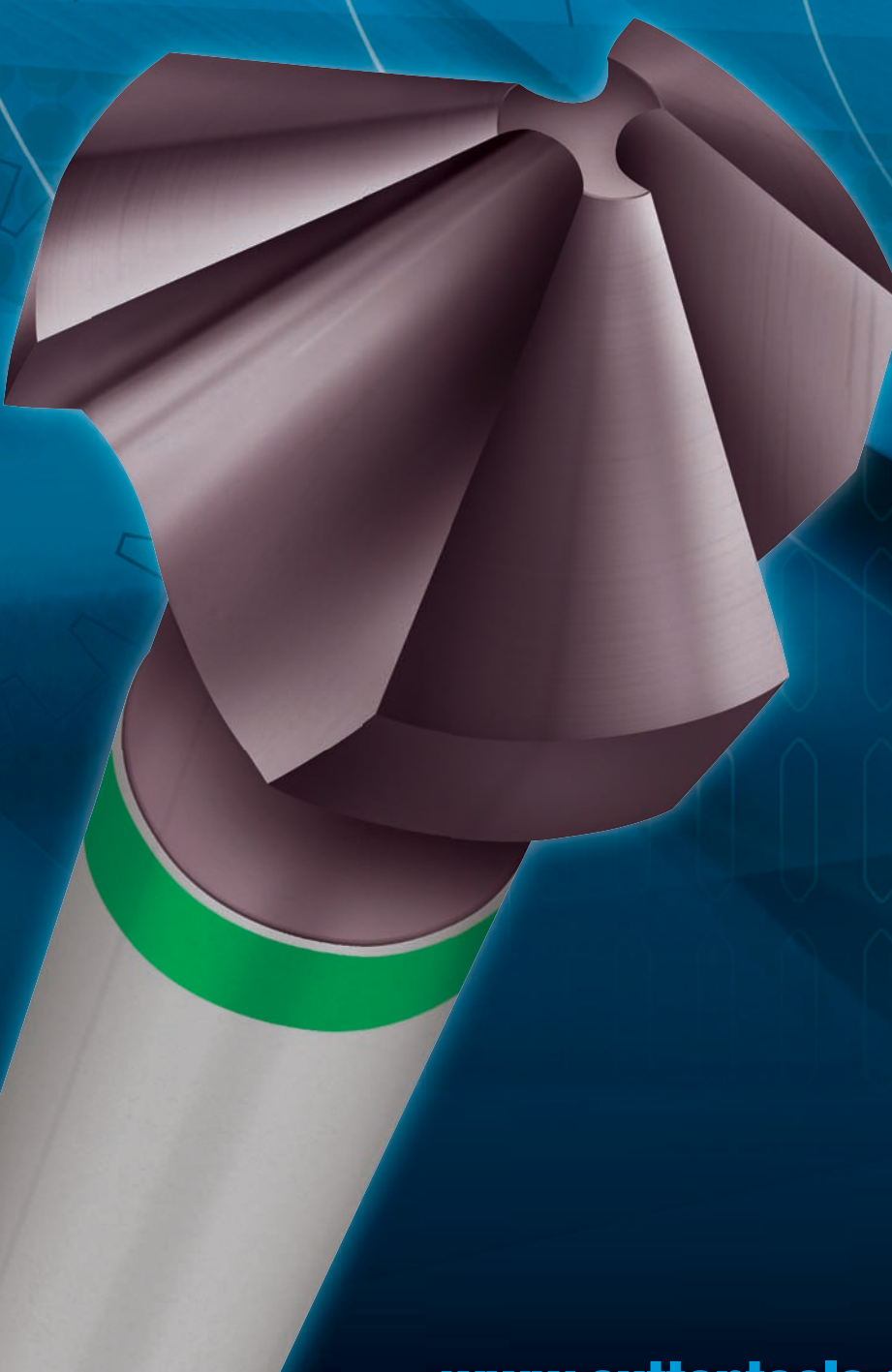
Countersinks

Smooth Cutting, perfect chamfering

- Counterbores
- Cross Hole
- Single Flute
- Three Flute

**smooth cutting...
perfect chamfering**

COUNTERSINKS



Product Code: C108

This new generation of countersink applies the three most important areas for optimal tool life in its design. Constant rake angle along the entire cutting face, latest developments in coating & superior tool material.

- De-burring
- Countersinking / Counterboring screw holes
- Chamfering of tapping holes
- For use in machine applications

Features

- 5% Cobalt grade High Speed Steel
- TiAlN Futura coated
- Constant flute rake along entire cutting face
- Axial and radial adjusted relief
- Higher dimensional precision
- Improved and sharper cutting edge

Benefits

- Chatter-free countersinking and de-burring
- Longer lasting
- Excellent chip flow

www.suttontools.com.au



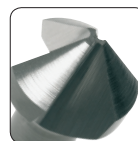
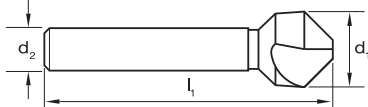
	Countersink Three Flute, 90° N		Countersink Three Flute, 90° UNI		Countersink Three Flute, 90°		Countersink Three Flute, 90°		Countersink Single Flute, 90°		Countersink Single Flute, 90°		Deburring C-Sink Cross Hole, 90°		Deburring C-Sink Cross Hole, 90°		Countersink	
Page	138	138	139	139	140	140	141	141	141	141	141	141	141	141	141	141	142	142
Catalogue Code	C107	C108	C105	C106	C103	C104	C101	C102	C100									
Material	HSS Co		HSS		HSS		HSS		HSS Co									
Surface Finish	Brt	TiAlN	Brt	TiN	Brt	TiN	Brt	TiN	Brt									
Colour Ring & Application	N	UNI	Machine Use		Hand Held		Deburring											
Standard	DIN 335				-												DIN 373	
Depth of Cut	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Shank Tolerance	h9	h9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	h6

Material	HB	N/mm ²	% Elong.															
1.0 Steels																		
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	○	●	●	●	●	●	●	●	●	●	●	●	●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
1.3 Plain carbon, low allowed	<300	>350 <850	20	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
1.7 Hardened Steel 45-50 Rc	<550		<12		○													
1.8 Hardened Steel 50-62 Rc	<700		<12															
2.0 Stainless Steels																		
2.1 Free machining	<250	<850	25	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
2.2 Austenitic	<250	<850	20	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○
2.3 Ferritic + martensitic	<250	<850	20	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
3.0 Cast Irons																		
3.1 Lamellar graphite (Grey soft)	<150	<500	10	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
4.0 Titaniums																		
4.1 Pure Titanium	<250	<850	20	○	○													
4.2 Titanium alloys	>250	>850	20	○	○													
5.0 Nickels																		
5.1 Nickel alloys	<250	<850	25	○	○													
5.2 Nickel alloys	>250	>850	25	○	○													
6.0 Coppers																		
6.1 Pure Copper (electrolytic Cu)	<120	<400	12	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○
6.3 Long chip Brass, Bronze	<200	<700	12	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
7.0 Aluminiums																		
7.1 Aluminium unalloyed	<100	<350	15	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○
7.2 Magnesium unalloyed	<150	<350	15	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	●	●	○	●	○	●	○	●	○	●	○	●	○	●	○
7.5 Al Alloyed > 10% Si	-	<400	N	○	●													
7.6 Magnesium alloys	-	<400	N	○	○													
8.0 Plastics																		
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○

Countersinks Three Flute, 90°



- De-burring
- Countersinking / Counterboring screw holes
- For Countersunk screws acc. to DIN 963, 964, 965, 966, 7513, 7516
- For Countersunk screws acc. to ISO 2009, 2010, 7046-1, 7046-2, 7047
- Chamfering of tapping holes
- For use in machine applications. Type N - For non-ferrous, Type UNI - For difficult to machine materials



Catalogue Code				C107	C108	
Discount Group				A1106	A1108	
Material				HSS Co	HSS Co	
Surface Finish				Brt	TIAIN	
Colour Ring & Application				N	UNI	
Geometry				-	-	
Point Type				90°	90°	
Shank Tolerance				h9	h9	
d ₁	Screw Head	l ₁	d ₂	Pieces	Item #	Item #
4.3	M2	40	4		C107 0430	C108 0430
5.3	M2.5	40	4		C107 0530	C108 0530
6.3	M3	45	5		C107 0630	C108 0630
7.3	M3.5	50	6		C107 0730	C108 0730
8		50	6		C107 0800	C108 0800
8.4	M4	50	6		C107 0840	C108 0840
9.4	M5	50	6		C107 0940	C108 0940
10		50	6		C107 1000	C108 1000
10.4		50	6		C107 1040	C108 1040
11.5	M6	56	8		C107 1150	C108 1150
12.4		56	8		C107 1240	C108 1240
13.4		56	8		C107 1340	C108 1340
15		60	10		C107 1500	C108 1500
16.5	M8	60	10		C107 1650	C108 1650
19	M10	63	10		C107 1900	C108 1900
20.5		63	10		C107 2050	C108 2050
23		67	10		C107 2300	C108 2300
25		67	10		C107 2500	C108 2500
30		71	12		C107 3000	C108 3000
31		71	12		C107 3100	C108 3100

SETS

Contents:

4 Piece	6.3, 10.4, 16.5, 20.5	4	C107 0004	C108 0004
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C107

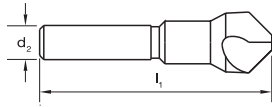


C108

Countersinks Three Flute, 90°



- Countersinking tool
- For machine use
- For use on most materials including plastics, non-ferrous & ferrous metals



Catalogue Code				C105	C106
Discount Group				A1106	A1108
Material				HSS	HSS
Surface Finish				Brt	TIN
Colour Ring & Application				N	Tough Materials
Geometry				-	-
Point Type				90°	90°
Shank Tolerance				-	-
d_1	Range	l_1	d_2	Pieces	Item #
Three Flute (Countersinking)					
TF901	4-10mm	43	1/4		C105 0901
TF902	4-14mm	48	1/4		C105 0902
TF903	5-20mm	67	1/2		C105 0903
TF904	6-28mm	72	1/2		C105 0904
TF905	6-37mm	89	1/2		C105 0905
SETS Contents:					
STF-1	4-28mm				C105 STF1
Three Flute (Countersinking)	TF901, TF902, TF903, TF904	4			
STF-1T	4-28mm				C106 STF1T
Three Flute (Countersinking)	TF901, TF902, TF903, TF904	4			



STF-1

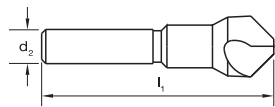


STF-1T

Deburring Countersinks Cross Hole, 90°



- Deburring tool
- Smooth cutting action



Catalogue Code						C101	C102	
Discount Group						A1106	A1108	
Material						HSS	HSS	
Surface Finish						Brt	TIN	
Colour Ring & Application						N	Tough Materials	
Geometry						-	-	
Point Type						90°	90°	
Shank Tolerance						-	-	
Code	Range	l_1	d_2	Weldon	Pieces	Item #	Item #	
Cross Hole (Deburring)								
CH901	3-6mm	45	1/4	DB-8		C101 0901	C102 0901	
CH902	4-10mm	43	1/4	DB-14		C101 0902	C102 0902	
CH903	5-13mm	48	1/4	DB-18		C101 0903	C102 0903	
CH904	8-20mm	67	1/2	DB-26		C101 0904	C102 0904	
CH905	14-28mm	72	1/2	DB-36		C101 0905	C102 0905	
CH906	13-37mm	89	1/2	DB-48		C101 0906	C102 0906	
SETS								
Contents:								
SC-1	3-28mm						C101 SC1	
Cross Hole (Deburring)	CH901, CH902, CH903, CH904, CH905				5			
SC-1T	3-28mm							C102 SC1T
Cross Hole (Deburring)	CH901, CH902, CH903, CH904, CH905				5			

