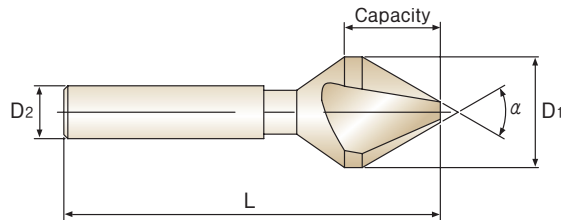


HSS, THREE FLUTE COUNTERSINKS (60°)

HSS, DREISCHNEIDEN KEGELSENKER (60°)

- ▶ Self-centering(3 flutes)
- ▶ For deburring, chamfering and countersinking
- ▶ Hand using
- ▶ Longitudinal chamfers and contouring
- ▶ Works without vibrations

- ▶ Selbstzentrierend
- ▶ Zum Entgraten, Abfasen und Senkkopfschrauben
- ▶ Manueller Einsatz möglich
- ▶ Zum Entgraten von Längs- und Profilkanten
- ▶ Arbeitet ohne Vibration


**DIN
334C**

Unit : mm

EDP No. (uncoating)		Angle	Nominal Diameter	Shank Diameter	Overall Length	Capacity
HSSCo8	HSS	α (-1°)	D1	D2	L(±1)	min/max
C1136063	C3136063	60°	6.3	5	45	1.6~6.3
C1136080	C3136080	60°	8	6	50	2.0~8.0
C1136100	C3136100	60°	10	6	50	2.5~10.0
C1136125	C3136125	60°	12.5	8	56	3.2~12.5
C1136160	C3136160	60°	16	10	63	4.0~16.0
C1136200	C3136200	60°	20	10	67	5.0~20.0
C1136250	C3136250	60°	25	10	71	6.3~25.0

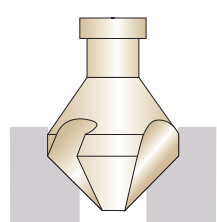
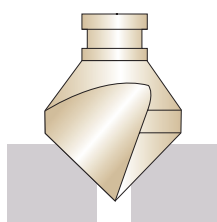
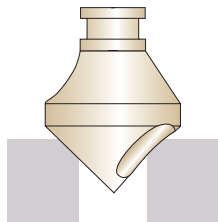
▶ TiN & TiCN coating are available on your request.

Nominal Dia Tolerance(mm)	Shank Dia. Tolerance(mm)
±0.05	h9



COUNTERSINKS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN



Material	V	S			V	S			V	S		
		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30
STEELS ≤ 500N/mm ²	35-45	0.20	0.22	0.24	35-45	0.20	0.22	0.24	17-22	0.30	0.32	0.36
STEELS 500~800N/mm ²	20-30	0.14	0.17	0.20	20-30	0.14	0.17	0.20	10-15	0.28	0.30	0.31
STEELS 800~1000N/mm ²	15-20	0.11	0.12	0.14	15-20	0.11	0.12	0.14	8-12	0.24	0.26	0.28
STEELS-STAINLESS STEEL 1000~1300N/mm ²	12-15	0.10	0.12	0.15	12-15	0.10	0.12	0.15	6-8	0.20	0.20	0.22
STAINLESS STEELS	6-8	0.07	0.08	0.09	6-8	0.07	0.08	0.09	4-6	0.08	0.09	0.10
CAST IRON	20-40	0.15	0.24	0.28	20-40	0.15	0.24	0.28	15-25	0.13	0.19	0.24
ALUMINUM	50-60	0.22	0.25	0.27	50-60	0.22	0.25	0.27	35-45	0.27	0.30	0.35
BRASS-BRONZE	30-40	0.23	0.25	0.28	30-40	0.23	0.25	0.28	20-30	0.30	0.30	0.31
COPPER	20-30	0.22	0.25	0.27	20-30	0.22	0.25	0.27	10-15	0.29	0.30	0.31
PLASTICS	50-100	0.50	0.60	0.65	50-100	0.50	0.60	0.65	35-70	0.40	0.45	0.50

V : Cutting Speed(mm/min)

S : Feed per Revolution(mm/rev)