Smooth cutting...

Perfect chamfering

Features
- Constant flute rake along entire cutting face
- Axial and radial adjusted relief
- Higher dimensional precision
- Improved and sharper cutting edge
- Cobalt grade high speed steel

Benefits
- Chatter-free countersinking and deburring
- Longer lasting
- Excellent chip flow

DIN335 90° COUNTERSINKS

AUSTRALIAN MADE

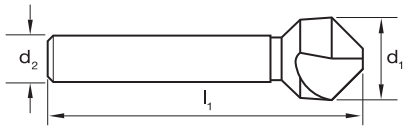
suttontools
world class cutting tools

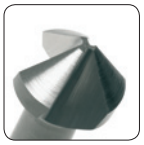
Countersinks 3 Flute, 90°

suttontools

- Deburring
- 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

DIN 335





	C107	C108
Catalogue Code	C107	C108
Discount Group	A1106	A1108
Material	HSS Co	HSS Co
Surface Finish	Brt	TiAlN
Colour Ring & Application	N	UNI
Geometry	-	-
Point Type	90°	90°
Shank Tolerance	h9	h9

Size Ref.	d_1	Screw Head	l_1	d_2	Pieces	Item #	Item #
0430	4.3	M2	40	4		C107 0430	C108 0430
0530	5.3	M2.5	40	4		C107 0530	C108 0530
0630	6.3	M3	45	5		C107 0630	C108 0630
0730	7.3	M3.5	50	6		C107 0730	C108 0730
0800	8.0		50	6		C107 0800	C108 0800
0840	8.4	M4	50	6		C107 0840	C108 0840
0940	9.4	M5	50	6		C107 0940	C108 0940
1000	10.0		50	6		C107 1000	C108 1000
1040	10.4		50	6		C107 1040	C108 1040
1150	11.5	M6	56	8		C107 1150	C108 1150
1240	12.4		56	8		C107 1240	C108 1240
1340	13.4		56	8		C107 1340	C108 1340
1500	15.0		60	10		C107 1500	C108 1500
1650	16.5	M8	60	10		C107 1650	C108 1650
1900	19.0	M10	63	10		C107 1900	C108 1900
2050	20.5		63	10		C107 2050	C108 2050
2300	23.0		67	10		C107 2300	C108 2300
2500	25.0		67	10		C107 2500	C108 2500
3000	30.0		71	12		C107 3000	C108 3000
3100	31.0		71	12		C107 3100	C108 3100
					C107		
					C108		
0004			6.3. 10.4. 16.5 & 20.5		4	C107 0004	C108 0004

LEGEND

n = rev. per minute
v_c = cutting speed (m/min)
f = feed (mm/rev)
v_f = feed rate (mm/min)
z = no. cutting edges

FORMULAS

$n = (v_c \times 1000) / (Ø \times \pi)$
$v_c = (Ø \times \pi \times n) / 1000$
$v_f = f \times n$

Feed Table (f) (mm/rev)

Countersink Ø	Feed Number 1	2	3	4
4.3–6.3	0.04	0.06	0.09	0.13
7.3–8.4	0.05	0.08	0.13	0.16
9.4–10.4	0.06	0.09	0.14	0.17
11.5–13.4	0.06	0.1	0.15	0.19
15–16.5	0.07	0.11	0.17	0.21
19–20.5	0.08	0.13	0.18	0.23
23–25	0.09	0.15	0.21	0.26
30–40	0.12	0.17	0.24	0.30

Notes: For calculating revolutions per minute, apply hole diameter
For calculating feed, apply large end diameter

ISO	VDI 3323	Material		Condition	HB	N/mm²	Vc	Feed #	Vc	Feed #
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	36	3	44	3
	2		~ 0.45 %C	A	190	640	30	3	36	3
	3			QT	250	840	30	2	36	2
	4		~ 0.75 %C	A	270	910	30	2	36	2
	5			QT	300	1010	14	1	16	1
	6	Steel - Low alloy & cast < 5% of alloying elements		A	180	610	30	2	36	2
	7			QT	275	930	18	2	22	2
	8			QT	300	1010	14	1	16	1
	9			QT	350	1180	-	-	10	1
	10	Steel - High alloy, cast & tool		A	200	680	14	1	16	1
	11			HT	325	1100	-	-	10	1
	12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680	10	1	12	1
	13		Martensitic	QT	240	810	-	-	10	1
M	14.1	Stainless Steel	Austenitic	AH	180	610	12	2	14	2
	14.2		Duplex		250	840	10	1	12	1
	14.3		Precipitation Hardening		250	840	10	1	12	1
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610	24	2	28	2
	16		Pearlitic		260	880	24	2	28	2
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570	20	2	25	2
	18		Pearlitic		250	840	20	2	25	2
	19	Cast Iron - Malleable	Ferritic		130	460	20	2	25	2
	20		Pearlitic		230	780	20	2	25	2
N	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210	48	4	58	4
	22		Heat Treatable	AH	100	360	48	4	58	4
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270	36	4	44	4
	24		Heat Treatable	AH	90	320	36	4	44	4
	25	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460	30	4	44	4
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390	78	2	94	2
	27		Brass (CuZn, CuSnZn)		90	320	48	2	58	2
	28		Bronze (CuSn)		100	360	60	2	72	2
	29	Non-metallic - Thermosetting & fiber-reinforced plastics					30	4	44	4
S	31	High temp. alloys	Fe based	A	200	680	5	2	8	2
	32			AH	280	950	4	2	5	2
	33		Ni / Co based	A	250	840	5	2	8	2
	34			AH	350	1180	-	-	5	2
	35			C	320	1080	-	-	5	2
	36	Titanium & Ti alloys	CP Titanium		400 MPa		8	3	10	3
	37.1		Alpha alloys		860 MPa		7	3	9	3
	37.2		Alpha / Beta alloys	A	960 MPa		7	3	9	3
	37.3			AH	1170 MPa		-	-	8	2
	37.4		Beta alloys	A	830 MPa		7	3	9	3
	37.5			AH	1400 MPa		-	-	8	2
H	40	Cast Iron	Chilled	C	400	1350	24	2	28	2

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