

# Countersinks

## Style 1001, 1003 • Single-Flute and Three-Flute Countersink

DRILLING

### FEATURES

ANSI SIZES  
HSS SUBSTRATE  
GENERAL PURPOSE  
STEAM OXIDE  
SHANK

### APPLICATIONS

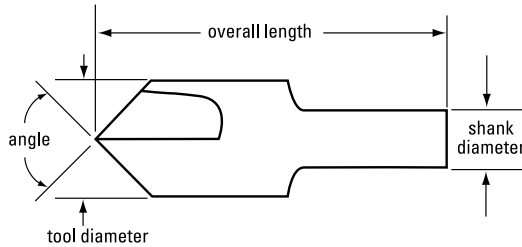
CARBON STEEL  
CAST IRON



Style 1001 Single-Flute



Style 1003 Three-Flute



Operating parameters on page 23

See page 89 for sets.

HOLE FINISHING

### Style 1001 • Single-Flute

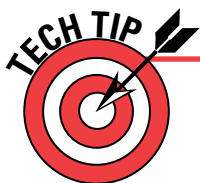
Fraction	Tool Diameter		Shank Diameter	Overall Length	Order Number						
	Decimal	Metric			in	mm	60° Angle	82° Angle	90° Angle	100° Angle	120° Angle
1/4	.2500	6.35	.188	4.76	1.500	38.10	C46101	C46102	C46103	C46104	C46106
3/8	.3750	9.53	.250	6.35	1.750	44.45	C46107	C46108	C46109	C46110	C46112
1/2	.5000	12.70	.250	6.35	2.000	50.80	C46113	C46114	C46115	C46116	C46118
5/8	.6250	15.88	.375	9.53	2.250	57.15	C46119	C46120	C46121	C46122	C46123
3/4	.7500	19.05	.500	12.70	2.625	66.68	C46124	C46125	C46126	C46127	C46129
1	1.0000	25.40	.500	12.70	2.750	69.85	C46130	C46131	C46132	C46133	C46135
1-1/4	1.2500	31.75	.500	12.70	2.750	69.85	C46136	C46137	C46138	-	-
1-1/2	1.5000	38.10	.750	19.05	2.875	73.03	C46141	C46139	C46140	-	-
2	2.0000	50.80	.750	19.05	3.250	82.55	C46142	-	C46143	-	-

THREADING

### Style 1003 • Three-Flute

Fraction	Tool Diameter		Shank Diameter	Overall Length	Order Number						
	Decimal	Metric			in	mm	60° Angle	82° Angle	90° Angle	100° Angle	120° Angle
1/4	.2500	6.35	.188	4.76	1.500	38.10	C46150	C46151	C46152	C46153	C46155
3/8	.3750	9.53	.250	6.35	1.750	44.45	C46156	C46157	C46158	C46159	C46161
1/2	.5000	12.70	.250	6.35	2.000	50.80	C46162	C46163	C46164	C46165	C46167
5/8	.6250	15.88	.375	9.53	2.250	57.15	C46168	C46169	C46170	C46171	C46173
3/4	.7500	19.05	.500	12.70	2.625	66.68	C46174	C46175	C46176	C46177	C46179
1	1.0000	25.40	.500	12.70	2.750	69.85	C46180	C46181	C46182	C46183	C46185
1-1/4	1.2500	31.75	.500	12.70	2.750	69.85	C46186	C46187	C46188	-	-
1-1/2	1.5000	38.10	.750	19.05	2.875	73.03	C46189	C46190	C46191	-	-
2	2.0000	50.80	.750	19.05	3.250	82.55	-	-	C46192	-	-

MILLING



### Using Countersinks

- The pre-drilled hole for countersinking should not be less than 10% of the countersink diameter.
- Use single-flute countersinks for smaller holes; multi-flute tools countersink much larger holes.
- Run countersinks at 50% to 66% of recommended drill speeds.

OTHER TOOLS

