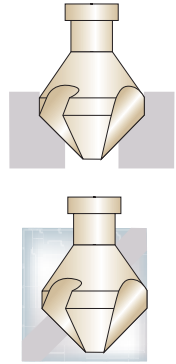
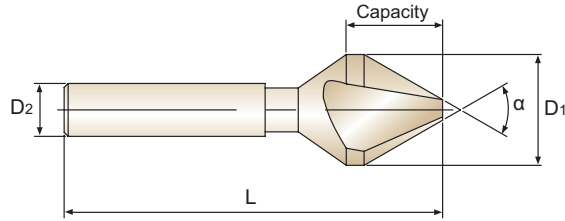


**HSS & HSSCo8, THREE FLUTE COUNTERSINKS (60°)**

- 🇩🇪 **HSS, DREISCHNEIDEN KEGELSENKER (60°)**
- 🇫🇷 **FRAISE HSS À CHANFREINER 3 DENTS (60°)**
- 🇮🇹 **SVASATORI A TRE TAGLIENTI - HSS (60°)**

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

- ▶ Selbstzentrierend
- ▶ Besonders geeignet zum 90° Ansenken für Senkkopfschrauben
- ▶ Manueller Einsatz möglich
- ▶ Zum Entgraten von Längs- und Profilkanten
- ▶ Arbeitet ohne Vibration



**DIN 334 C**  P.440

Unit : mm

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

▶ TiN & TiCN coating are available on your request.

Cutter Dia. Tolerance(mm)	Shank Dia. Tolerance(mm)	Point Angle Tolerance(°)
±0.05	h9	+0/-1

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○							○	○	○	◎	○	○	○	○	○	
ISO	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	○	○	○	○	○	○	○													



**C1136, C3136, C1139,  
C3139, C1132, C3132** SERIES

**3 FLUTE COUNTERSINKS**

RPM = rev./min.  
FEED = mm/rev.

	ISO	VDI 3323	Material Description	Vc (m/min)	Feed(mm/rev)									
					5.0	10.0	15.0	20.0	25.0	30.0	40.0	50.0		
DREAM DRILLS -GENERAL	P	1	Non-alloy steel	20	0.12-0.16	0.16-0.20	0.20-0.23	0.23-0.26	0.26-0.29	0.29-0.33	0.33-0.37	0.37-0.41		
		2		20	0.12-0.16	0.16-0.20	0.20-0.23	0.23-0.26	0.26-0.29	0.29-0.33	0.33-0.37	0.37-0.41		
		3		13	0.10-0.14	0.14-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35	0.35-0.39		
		4		10	0.06-0.10	0.10-0.14	0.14-0.17	0.17-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35		
		5		10	0.06-0.10	0.10-0.14	0.14-0.17	0.17-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35		
		DREAM DRILLS -FLAT BOTTOM	6	Low alloy steel										
		DREAM DRILLS -INOX	7											
		DREAM DRILLS -ALU	8											
		DREAM DRILLS -ALU	9											
		DREAM DRILLS -ALU	10		High alloyed steel, and tool steel									
		DREAM DRILLS -CFRP	11											
DREAM DRILLS -CFRP	M	12	Stainless steel	6	0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.10	0.10-0.12	0.10-0.12	0.12-0.15	0.12-0.15		
		13		5	0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.10	0.10-0.12	0.10-0.12	0.12-0.15	0.12-0.15		
		14		4	0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.10	0.10-0.12	0.10-0.12	0.12-0.15	0.12-0.15		
DREAM DRILLS for HIGH HARDENED STEELS	K	15	Grey cast iron	22	0.09-0.11	0.11-0.13	0.13-0.16	0.16-0.19	0.19-0.22	0.22-0.25	0.25-0.28	0.28-0.32		
		16		17	0.08-0.10	0.10-0.12	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31		
		17	Nodular cast iron	17	0.09-0.11	0.11-0.13	0.13-0.16	0.16-0.19	0.19-0.22	0.22-0.25	0.25-0.28	0.28-0.32		
		18		15	0.08-0.10	0.10-0.12	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31		
		19		Malleable cast iron	17	0.09-0.11	0.11-0.13	0.13-0.16	0.16-0.19	0.19-0.22	0.22-0.25	0.25-0.28	0.28-0.32	
20	15	0.08-0.10	0.10-0.12		0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31				
HPD DRILLS	N	21	Aluminum- wrought alloy	42	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35	0.35-0.40	0.40-0.45		
		22		42	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35	0.35-0.40	0.40-0.45		
GOLD-P DRILLS		23	Aluminum-cast, alloyed	39	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35	0.35-0.40	0.40-0.45		
		24		37	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.28	0.28-0.32	0.32-0.37	0.37-0.42		
SUPER-GP DRILLS		25		Copper and Copper Alloys (Bronze / Brass)	35	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.27	0.27-0.31	0.31-0.35	0.35-0.40	0.40-0.45	
		26			28	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.28	0.28-0.32	0.32-0.37	0.37-0.42	
STRAIGHT SHANK DRILLS		27	Non Metallic Materials	25	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.28	0.28-0.32	0.32-0.37	0.37-0.42		
		28		15	0.12-0.15	0.15-0.18	0.18-0.21	0.21-0.24	0.24-0.28	0.28-0.32	0.32-0.37	0.37-0.42		
TAPER SHANK DRILLS		29												
NC- SPOTTING DRILLS		S	30	Heat Resistant Super Alloys										
	31													
32														
33														
CENTER DRILLS	34													
	35													
SPADE DRILLS	36	Titanium Alloys												
	37													
REAMERS	H	38	Hardened steel											
		39												
COUNTER SINKS		40		Chilled Cast Iron										
		41			Hardened Cast Iron									

SELECTION GUIDE



SERIES

C1109  
C3109

C1119  
C3119

STANDARD

-

-

POINT ANGLE

90°

90°

SIZE MIN

D10.0

D10.0

SIZE MAX

D50.0

D50.0

PAGE

434

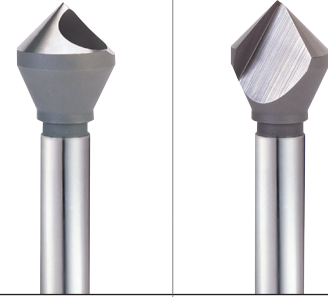
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SURFACE TREATMENT

Bright

# HSS & HSSCo8 COUNTERSINKS

For Deburring, Chamfering and Countersinking



Please visit  
[globalyg1.com/mat](http://globalyg1.com/mat)  
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.439

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc		
P	1	Non-alloy steel	About 0.15% C Annealed	125		○	○
	2		About 0.45% C Annealed	190	13	○	○
	3		About 0.45% C Quenched & Tempered	250	25	○	○
	4		About 0.75% C Annealed	270	28	○	○
	5		About 0.75% C Quenched & Tempered	300	32	○	○
	6	Low alloy steel	Annealed	180	10		
	7		Quenched & Tempered	275	29		
	8		Quenched & Tempered	300	32		
	9		Quenched & Tempered	350	38		
	10		High alloyed steel, and tool steel	Annealed	200	15	
	11	Quenched & Tempered		325	35		
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15	○	○
	13		Martensitic Quenched & Tempered	240	23	○	○
	14	Austenitic	180	10	○	○	
K	15	Grey cast iron	Pearlitic / ferritic	180	10	○	○
	16		Pearlitic (Martensitic)	260	26	○	○
	17	Nodular cast iron	Ferritic	160	3	○	○
	18		Pearlitic	250	25	○	○
	19	Malleable cast iron	Ferritic	130		○	○
20	Pearlitic		230	21	○	○	
N	21	Aluminum-wrought alloy	Not Curable	60		○	○
	22		Curable Hardened	100		○	○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		○	○
	24		≤ 12% Si, Curable Hardened	90		○	○
	25		> 12% Si, Not Curable	130		○	○
	26		Copper and Copper Alloys	Cutting Alloys, PB>1%	110		○
	27	(Bronze / Brass)	CuZn, CuSnZn (Brass)	90		○	○
	28		CuSn, lead-free copper and electrolytic copper	100		○	○
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				
	30		Rubber, Wood, etc.				
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15		
	32		Cured	280	30		
	33		Annealed	250	25		
	34		Ni or Co Based Cured	350	38		
	35	Cast	320	34			
	36	Titanium Alloys	Pure Titanium	400 Rm			
	37		Alpha + Beta Alloys Hardened	1050 Rm			
H	38	Hardened steel	Hardened	550	55		
	39		Hardened	630	60		
	40	Chilled Cast Iron	Cast	400	42		
	41	Hardened Cast Iron	Hardened	550	55		

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

C1136 C3136	C1139 C3139	C1132 C3132
DIN334C	DIN335C	-
60°	90°	120°
D6.3	D4.3	D8.0
D25.0	D31.0	D25.0
<b>436</b>	<b>437</b>	<b>438</b>
Bright		



⊙	⊙	⊙	1
⊙	⊙	⊙	2
○	○	○	3
○	○	○	4
○	○	○	5
			6 P
			7
			8
			9
			10
			11
○	○	○	12 M
○	○	○	13
○	○	○	14
⊙	⊙	⊙	15 K
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○	○	○	17
○	○	○	18
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