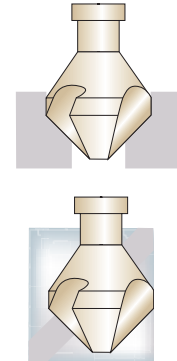
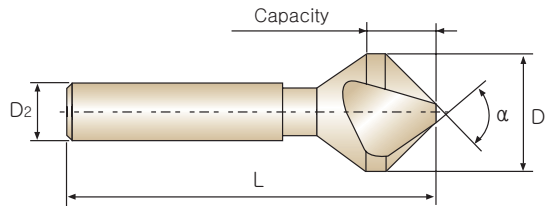


HSS & HSSCo8, THREE FLUTE COUNTERSINKS (90°)

- HSS, DREISCHNEIDEN KEGELSENKER (90°)
- FRAISE HSS À CHANFREINER 3 DENTS (90°)
- SVASATORI A TRE TAGLIENTI - HSS (90°)

- ▶ Self-centering(3 flutes).
- ▶ Designed for 90°capscrews 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



Unit : mm

EDP No. (uncoating)		Point Angle α	Cutter Diameter D1	Shank Diameter D2	Overall Length L(± 1)	Capacity min/max
HSSCo8	HSS					
C1139043	C3139043	90°	4.3	4	40	1.3 - 4.3
C1139050	C3139050	90°	5.0	4	40	1.5 - 5.0
C1139060	C3139060	90°	6.0	5	45	1.5 - 6.0
C1139063	C3139063	90°	6.3	5	45	1.5 - 6.3
C1139070	C3139070	90°	7.0	6	50	1.8 - 7.0
C1139080	C3139080	90°	8.0	6	50	2.0 - 8.0
C1139083	C3139083	90°	8.3	6	50	2.0 - 8.3
C1139100	C3139100	90°	10.0	6	50	2.5 - 10.0
C1139104	C3139104	90°	10.4	6	50	2.5 - 10.4
C1139115	C3139115	90°	11.5	8	56	2.8 - 11.5
C1139124	C3139124	90°	12.4	8	56	2.8 - 12.4
C1139150	C3139150	90°	15.0	10	60	3.2 - 15.0
C1139165	C3139165	90°	16.5	10	60	3.2 - 16.5
C1139190	C3139190	90°	19.0	10	63	3.5 - 19.0
C1139205	C3139205	90°	20.5	10	63	3.5 - 20.5
C1139230	C3139230	90°	23.0	10	67	3.8 - 23.0
C1139250	C3139250	90°	25.0	10	67	3.8 - 25.0
C1139300	C3139300	90°	30.0	12	71	4.2 - 30.0
C1139310	C3139310	90°	31.0	12	71	4.2 - 31.0

▶ 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 Material Description	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	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 Material Description	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												
			DREAM DRILLS -INOX	7	Low alloy steel										
				8											
				9											
				DREAM DRILLS -ALU		10	High alloyed steel, and tool steel								
						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			
DREAM DRILLS -MQL	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			
		GENERAL CARBIDE DRILLS	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		
			MULTI-1 DRILLS		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	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		
STRAIGHT SHANK DRILLS			26	Copper and Copper Alloys (Bronze / Brass)	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		
		27	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	Non Metallic Materials												
30															
NC- SPOTTING DRILLS	S	31	Heat Resistant Super Alloys												
		32													
		33													
		CENTER DRILLS		34											
				35											
SPADE DRILLS		36	Titanium Alloys												
		37													
REAMERS	H	38	Hardened steel												
		39													
		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

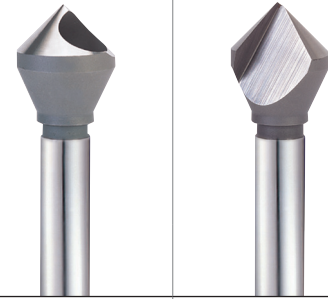
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SURFACE TREATMENT

Bright

HSS & HSSCo8
COUNTERSINKS

For Deburring, Chamfering and Countersinking



Please visit
globalyg1.com/mat
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		Ferritic	130		○	○
20	Malleable cast iron	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		

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



⊙	⊙	⊙	1
⊙	⊙	⊙	2
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