

### Quick Change Countersink System

Severance Tool introduces the new 3N1-QC<sup>TM</sup> Quick Change Countersink System. Featuring standard shanks in 4",6", and 8" over all lengths, this system is designed to allow quick change of the countersink head for fast tool changes while maintaining dimensional integrity. The quick change head has a positive lock up on a ground taper and with a threaded lock, tool changes are fast and simple. All 3N1-QC<sup>TM</sup> threaded countersinks are factory resharpenable.

#### free<sup>™</sup> countersink ... to perform two or all three of the steps in a spot-drillcountersink and edge chamfer operations. Once you have established a tool in a chuck, you can leave the shank in place and quickly change out the dull 3N1® head with a sharp 3N1®, fast change over. On thin material, such as (1) illustration (2) below, drilling could be optional. Long Shank Allows For Easy Reach Benefits of a 3N1-QC<sup>TM</sup> Drill Point Countersink Around Fixtures Or Into Cavities Sizes 3/8" to 3/4" countersink dia. (.041" to .312" drillpoint) Chatterfree flute design Threaded End For Use With Shank inhibits resonant vibration For Quick Change And Minimum (3) Setup Change. 4-Flute design is twice as Drilling fast as 2-flute drillsinks (2) Excellent rigidity, no offset Drillpoint design eliminates Spot Drilling & Perfect or wobbling when spot drilling risk of point breaking off in Countersinking the work 6 Centerline angles available - 30, 41, 45, 50, 60 7/ 7/ 7/ Save steps, setup, production time, and lower scrap rates with a

Save steps, setup, production time, and lower scrap rates with a Severance 3N1-QC<sup>™</sup> Spotting tool. Specifically designed to give a true start spot and an accurate countersink chamfer on your part.

# **3N1-QC<sup>™</sup>Drill Point Countersinks**

		Centerline Angle 30°				50°	60°
Overall	Thread	Severance	Order	Order	Order	Order	120° Order Number
							01840
				0-0			01841 01842
							01842
							01843
	Overall Length 1-5/32" 1-5/32" 1-5/32" 1-5/32" 1-13/16"	Length Size   1-5/32" 1/4"-28   1-5/32" 1/4"-28   1-5/32" 1/4"-28   1-5/32" 1/4"-28   1-5/32" 1/4"-28	Overall Length Included Angle   1-5/32" 1/4"-28 Severance   1-5/32" 1/4"-28 3N1-QC-3/8   1-5/32" 1/4"-28 3N1-QC-7/16   1-5/32" 1/4"-28 3N1-QC-1/2   1-5/32" 1/4"-28 3N1-QC-5/8	Included Angle 60°   Overall Length Thread Size Severance Name Order Number   1-5/32" 1/4"-28 3N1-QC-3/8 01800   1-5/32" 1/4"-28 3N1-QC-7/16 01801   1-5/32" 1/4"-28 3N1-QC-1/2 01802   1-5/32" 1/4"-28 3N1-QC-7/16 01802   1-5/32" 1/4"-28 3N1-QC-1/2 01802	Included Angle 60° 82°   Overall Length Thread Size Severance Name Order Number Order Number   1-5/32" 1/4"-28 3N1-QC-3/8 01800 01810   1-5/32" 1/4"-28 3N1-QC-7/16 01801 01811   1-5/32" 1/4"-28 3N1-QC-1/2 01802 01812   1-5/32" 1/4"-28 3N1-QC-1/2 01802 01812   1-5/32" 1/4"-28 3N1-QC-5/8 01803 01813	Included Angle 60° 82° 90°   Overall Length Thread Size Severance Name Order Number Order Number Order Number   1-5/32" 1/4"-28 3N1-QC-3/8 01800 01810 01820   1-5/32" 1/4"-28 3N1-QC-7/16 01801 01811 01821   1-5/32" 1/4"-28 3N1-QC-7/2 01802 01812 01822   1-5/32" 1/4"-28 3N1-QC-5/8 01803 01813 01823	Included Angle 60° 82° 90° 100°   Overall Length Thread Size Severance Name Order Number Number

Note: When Ordering 3N1-QC<sup>™</sup> Make Sure To Specify Angle, Example (3N1-QC-3/8-45)

## Shanks for 3N1-QC<sup>TM</sup> Cutters

**High Speed Steel** 

3N1-QC<sup>™</sup> Quick Change Drill Point Countersink

Patent Pending

How Does a  $3N1-QC^{TM}$  Work?

Severance has developed a unique tool which combines the functions of a

drill point starter and true countersink in a quick change tool. A conven-

tional thin-web drill point is blended into two flutes of a four-flute chatter-

	Thread Size	Shank Frac.	Dia. Dec.	Overall Length	Shoulder Dia.	Severance Shank Name	EDP Order Number
Spot Drill	1/4"-28	1/4"	.250	3-1/2"	7/16"	FM-2 Shank	34235
Countersink	1/4"-28	1/2"	.500	6"	1/2"	QMS-2x6 Shank	34239
Quick Change	1/4"-28	1/2"	.500	8"	1/2"	QMS-2x8 Shank	34240
~ 0	3/8"-24	1/4"	.250	3-1/2"	9/16"	FM-3 Shank	34236
The $3N1-OC^{TM}$ System	3/8"-24	5/8"	.625	6"	5/8"	QMS-3x6 Shank	34241
	3/8"-24	5/8"	.625	8"	5/8"	QMS-3x6 Shank	34242



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# For Assistance, Contact Your Local Dealer:

Severance Tool Ind. Inc. reserves the right that all prices and

tools are subject to change or correction without notice.