

Micrometer Stop-Countersink Units

The Micrometer Micro Stop-Countersink Unit was invented and patented (USP 3028774) by Severance Tool for the aircraft industry to allow precise depth control countersinking and deburring. These units ensure perpendicular alignment with the workpiece and easy to adjust exact depth control in increments of .001". They feature hardened and ground spindles supported by ball bearings, bronze sleeves, or needle bearings, and thrust bearings, and a lock nut to maintain "preset" depth dimensions. Overhang is at a minimum making it possible to work in close quarters.

These units are still widely used in Aircraft manufacturing and maintenance, in sheet metal part production areas, and have found wide use in Transportation, electronic, medical, defense, and telecommunications where precise depth control countersinking is required. Used in hand drills, drill presses, mills, lathes, etc. Bases can be modified for special applications or contours. See "NEW" high speed roller bearing units RSC-24 & RSC-36.



Recommended Maximum Cutter	Unit Shank Dia.	Standard Outside Dia.	Overall Length Retracted	Overall Length Extended	Length of Stroke	Internal Thread	Severance Tool Name	EDP Order Number
7/16"	1/4"	7/8"	3.243"	3.544"	.180	1/4"-28	SC-14	21220
3/4"	1/4"	1-1/16"	3.265"	3.513"	.180	1/4"-28	SC-24	21221
3/4"	1/4"	1-1/16"	3.265"	3.513"	.180	1/4"-28	RSC-24	21227
3/4"	3/8"	1-1/16"	3.310"	3.521"	.180	3/8"-24	SC-36	21222
3/4"	3/8"	1-1/16"	3.310"	3.521"	.180	3/8"-24	RSC-36	21228
1-1/4"	1/2"	1-3/4"	4.270"	4.715"	.280	7/16"-20	SC-47	21223
1-1/4"	3/8"	1-3/4"	4.700"	5.185"	.280	3/8"-24	SC-57	21224



**Special
Override
Micro-Stop
Countersink
Units
Available
by
Application**

Non-Marking Nylon Foot



Maximum Cutting Diameter With Foot	Part Number	EDP Number
7/16"	SC-14-11	21245
5/8"	SC-24-11	21264
5/8"	SC-36-11	21264
1-1/4"	SC-47-11	21302
1-1/4"	SC-57-11	21302

**Special units and cutters
can be made to fit
customers applications**

A Severance Precision Stop Countersink Unit is designed for hand power-tool and drill-press use.

This unit converts your drill-press into a precision countersinking unit, giving you identical countersinks on parts of various thicknesses.



#2 Morse Taper Adapter for SC-47 Unit

Part No.	EDP No.
FM-4-MT	34238

If adapter is ordered at the same time as SC-47 UNIT, unit will be provided with a whistle notch.



Chatter-Free® Stop-Countersinks Cutters

Also known as Aircraft style Stop-Countersinks. These tools feature our patented 4 flute Chatter-Free® flute design for smooth finishes, fast production, and quick chip removal. These precision ground tools are made from High Speed Steel or Carbide and may be factory resharpened many times for long useful tool life. Also available with special pilot sizes, angles, forms, and no pilots upon request.

High Speed Steel

Head Dia.	Pilot Dia.	Thread Dia.	Overall Length	Centerline Angle					
				39°		41°		45°	
				Included Angle	78°	82°	90°	100°	120°
Severance Name	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number
3/8"	3/32 (.0938)	1/4"-28	1-5/32"	SC-6	15340	15485	15629	15774	15919
3/8"	#40 (.0980)	1/4"-28	1-5/32"	SC-6	15341	15486	15630	15775	15920
3/8"	1/8 (.1250)	1/4"-28	1-5/32"	SC-6	15342	15487	15631	15776	15921
3/8"	#30 (.1285)	1/4"-28	1-5/32"	SC-6	15343	15488	15632	15777	15922
3/8"	5/32 (.1562)	1/4"-28	1-5/32"	SC-6	15345	15489	15634	15779	15924
3/8"	#21 (.1590)	1/4"-28	1-5/32"	SC-6	15346	15490	15635	15780	15925
3/8"	3/16 (.1875)	1/4"-28	1-5/32"	SC-6	15347	15491	15636	15781	15926
3/8"	#10 (.1935)	1/4"-28	1-5/32"	SC-6	15348	15492	15637	15782	15927
7/16"	3/32 (.0938)	1/4"-28	1-5/32"	SC-7	15350	15494	15639	15784	15929
7/16"	#40 (.0980)	1/4"-28	1-5/32"	SC-7	15351	15495	15640	15785	15930
7/16"	1/8 (.1250)	1/4"-28	1-5/32"	SC-7	15352	15496	15641	15786	15931
7/16"	#30 (.1285)	1/4"-28	1-5/32"	SC-7	15353	15497	15642	15787	15932
7/16"	5/32 (.1562)	1/4"-28	1-5/32"	SC-7	15355	15499	15644	15789	15934
7/16"	#21 (.1590)	1/4"-28	1-5/32"	SC-7	15356	15500	15645	15790	15935
7/16"	3/16 (.1875)	1/4"-28	1-5/32"	SC-7	15357	15501	15646	15791	15936
7/16"	#10 (.1935)	1/4"-28	1-5/32"	SC-7	15358	15502	15647	15792	15937
1/2"	3/32 (.0938)	1/4"-28	1-5/32"	SC-8	15360	15504	15649	15794	15939
1/2"	#40 (.0980)	1/4"-28	1-5/32"	SC-8	15361	15505	15650	15795	15940
1/2"	1/8 (.1250)	1/4"-28	1-5/32"	SC-8	15362	15506	15651	15796	15941
1/2"	#30 (.1285)	1/4"-28	1-5/32"	SC-8	15363	15507	15652	15797	15942
1/2"	5/32 (.1562)	1/4"-28	1-5/32"	SC-8	15364	15508	15653	15798	15943
1/2"	#21 (.1590)	1/4"-28	1-5/32"	SC-8	15366	15510	15655	15800	15945
1/2"	3/16 (.1875)	1/4"-28	1-5/32"	SC-8	15367	15511	15656	15801	15946
1/2"	#10 (.1935)	1/4"-28	1-5/32"	SC-8	15368	15512	15657	15802	15947
1/2"	7/32 (.2187)	1/4"-28	1-5/32"	SC-8	15369	15513	15658	15803	15948
1/2"	1/4 (.2500)	1/4"-28	1-5/32"	SC-8	15370	15514	15659	15804	15949
5/8"	1/8 (.1250)	1/4"-28	1-5/32"	SC-10	15372	15516	15661	15806	15951
5/8"	#30 (.1285)	1/4"-28	1-5/32"	SC-10	15373	15517	15662	15807	15952
5/8"	5/32 (.1562)	1/4"-28	1-5/32"	SC-10	15374	15518	15663	15808	15953
5/8"	#21 (.1590)	1/4"-28	1-5/32"	SC-10	15375	15519	15664	15809	15954
5/8"	3/16 (.1875)	1/4"-28	1-5/32"	SC-10	15376	15520	15665	15810	15955
5/8"	#10 (.1935)	1/4"-28	1-5/32"	SC-10	15378	15522	15667	15812	15957
5/8"	7/32 (.2187)	1/4"-28	1-5/32"	SC-10	15379	15523	15668	15813	15958
5/8"	1/4 (.2500)	1/4"-28	1-5/32"	SC-10	15380	15524	15669	15814	15959
5/8"	5/16 (.3125)	1/4"-28	1-5/32"	SC-10	15381	15525	15670	15815	15960
5/8"	3/8 (.3750)	1/4"-28	1-5/32"	SC-10	15382	15526	15671	15816	15961
3/4"	5/32 (.1562)	1/4"-28	1-3/16"	SC-12	15384	15528	15673	15818	15963
3/4"	#21 (.1590)	1/4"-28	1-3/16"	SC-12	15385	15529	15674	15819	15964
3/4"	3/16 (.1875)	1/4"-28	1-3/16"	SC-12	15386	15530	15675	15820	15965
3/4"	#10 (.1935)	1/4"-28	1-3/16"	SC-12	15387	15531	15676	15821	15966
3/4"	7/32 (.2187)	1/4"-28	1-3/16"	SC-12	15389	15533	15678	15823	15968
3/4"	1/4 (.2500)	1/4"-28	1-3/16"	SC-12	15390	15534	15679	15824	15969
3/4"	"F" (.2570)	1/4"-28	1-3/16"	SC-12	15391	15535	15680	15825	15970
3/4"	5/16 (.3125)	1/4"-28	1-3/16"	SC-12	15392	15536	15681	15826	15971
3/4"	3/8 (.3750)	1/4"-28	1-3/16"	SC-12	15393	15537	15682	15827	15972
3/4"	5/32 (.1562)	3/8"-24	1-3/16"	S3-12	15395	15539	15684	15829	15974
3/4"	#21 (.1590)	3/8"-24	1-3/16"	S3-12	15396	15540	15685	15830	15975

Chatter-Free™ Stop-Countersinks Cutters continued....



High Speed Steel

Head Dia.	Pilot Dia.	Thread Dia.	Overall Length	Centerline Angle					
				39°		41°		45°	
				Included Angle	78°	82°	90°	100°	120°
				Severance Name	Order Number	Order Number	Order Number	Order Number	Order Number
3/4"	3/16 (.1875)	3/8"-24	1-3/16"	S3-12	15397	15541	15686	15831	15976
3/4"	#10 (.1935)	3/8"-24	1-3/16"	S3-12	15398	15542	15687	15832	15977
3/4"	7/32 (.2187)	3/8"-24	1-3/16"	S3-12	15400	15544	15689	15834	15979
3/4"	1/4 (.2500)	3/8"-24	1-3/16"	S3-12	15401	15545	15690	15835	15980
3/4"	"F" (.2570)	3/8"-24	1-3/16"	S3-12	15402	15546	15691	15836	15981
3/4"	5/16 (.3125)	3/8"-24	1-3/16"	S3-12	15403	15547	15692	15837	15982
3/4"	3/8 (.3750)	3/8"-24	1-3/16"	S3-12	15404	15548	15693	15838	15983
1-1/4"	3/16 (.1875)	7/16"-20	1-3/8"	SC-20	15406	15550	15695	15840	15985
1-1/4"	#10 (.1935)	7/16"-20	1-3/8"	SC-20	15407	15551	15696	15841	15986
1-1/4"	7/32 (.2187)	7/16"-20	1-3/8"	SC-20	15408	15552	15697	15842	15987
1-1/4"	1/4 (.2500)	7/16"-20	1-3/8"	SC-20	15409	15553	15698	15843	15988
1-1/4"	"F" (.2570)	7/16"-20	1-3/8"	SC-20	15411	15555	15700	15845	15990
1-1/4"	5/16 (.3125)	7/16"-20	1-3/8"	SC-20	15412	15556	15701	15846	15991
1-1/4"	3/8 (.3750)	7/16"-20	1-3/8"	SC-20	15413	15557	15702	15847	15992
1-1/4"	1/2 (.5000)	7/16"-20	1-3/8"	SC-20	15414	15558	15703	15848	15993



Carbide

Head Dia.	Pilot Dia.	Thread Dia.	Overall Length	Centerline Angle					
				39°		41°		45°	
				Included Angle	78°	82°	90°	100°	120°
				Severance Name	Order Number	Order Number	Order Number	Order Number	Order Number
3/8"	3/32 (.0938)	1/4"-28	1-5/32"	SC-6-W	13840	13985	14129	14274	14419
3/8"	#40 (.0980)	1/4"-28	1-5/32"	SC-6-W	13841	13986	14130	14275	14420
3/8"	1/8 (.1250)	1/4"-28	1-5/32"	SC-6-W	13842	13987	14131	14276	14421
3/8"	#30 (.1285)	1/4"-28	1-5/32"	SC-6-W	13843	13988	14132	14277	14422
3/8"	5/32 (.1562)	1/4"-28	1-5/32"	SC-6-W	13845	13989	14134	14279	14424
3/8"	#21 (.1590)	1/4"-28	1-5/32"	SC-6-W	13846	13990	14135	14280	14425
3/8"	3/16 (.1875)	1/4"-28	1-5/32"	SC-6-W	13847	13991	14136	14281	14426
3/8"	#10 (.1935)	1/4"-28	1-5/32"	SC-6-W	13848	13992	14137	14282	14427
7/16"	3/32 (.0938)	1/4"-28	1-5/32"	SC-7-W	13850	13994	14139	14284	14429
7/16"	#40 (.0980)	1/4"-28	1-5/32"	SC-7-W	13851	13995	14140	14285	14430
7/16"	1/8 (.1250)	1/4"-28	1-5/32"	SC-7-W	13852	13996	14141	14286	14431
7/16"	#30 (.1285)	1/4"-28	1-5/32"	SC-7-W	13853	13997	14142	14287	14432
7/16"	5/32 (.1562)	1/4"-28	1-5/32"	SC-7-W	13855	13999	14144	14289	14434
7/16"	#21 (.1590)	1/4"-28	1-5/32"	SC-7-W	13856	14000	14145	14290	14435
7/16"	3/16 (.1875)	1/4"-28	1-5/32"	SC-7-W	13857	14001	14146	14291	14436
7/16"	#10 (.1935)	1/4"-28	1-5/32"	SC-7-W	13858	14002	14147	14292	14437
1/2"	3/32 (.0938)	1/4"-28	1-5/32"	SC-8-W	13860	14004	14149	14294	14439
1/2"	#40 (.0980)	1/4"-28	1-5/32"	SC-8-W	13861	14005	14150	14295	14440
1/2"	1/8 (.1250)	1/4"-28	1-5/32"	SC-8-W	13862	14006	14151	14296	14441
1/2"	#30 (.1285)	1/4"-28	1-5/32"	SC-8-W	13863	14007	14152	14297	14442
1/2"	5/32 (.1562)	1/4"-28	1-5/32"	SC-8-W	13864	14008	14153	14298	14443
1/2"	#21 (.1590)	1/4"-28	1-5/32"	SC-8-W	13866	14010	14155	14300	14445
1/2"	3/16 (.1875)	1/4"-28	1-5/32"	SC-8-W	13867	14011	14156	14301	14446
1/2"	#10 (.1935)	1/4"-28	1-5/32"	SC-8-W	13868	14012	14157	14302	14447
1/2"	7/32 (.2187)	1/4"-28	1-5/32"	SC-8-W	13869	14013	14158	14303	14448
1/2"	1/4 (.2500)	1/4"-28	1-5/32"	SC-8-W	13870	14014	14159	14304	14449
5/8"	1/8 (.1250)	1/4"-28	1-5/32"	SC-10-W	13872	14016	14161	14306	14451
5/8"	#30 (.1285)	1/4"-28	1-5/32"	SC-10-W	13873	14017	14162	14307	14452
5/8"	5/32 (.1562)	1/4"-28	1-5/32"	SC-10-W	13874	14018	14163	14308	14453
5/8"	#21 (.1590)	1/4"-28	1-5/32"	SC-10-W	13875	14019	14164	14309	14454
5/8"	3/16 (.1875)	1/4"-28	1-5/32"	SC-10-W	13876	14020	14165	14310	14455
5/8"	#10 (.1935)	1/4"-28	1-5/32"	SC-10-W	13878	14022	14167	14312	14457

See more sizes page 67

Chatter-Free™ Stop-Countersinks Cutters continued....



Carbide

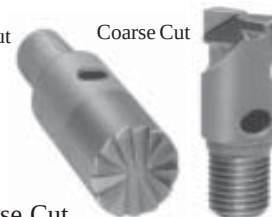
Head Dia.	Pilot Dia.	Thread Dia.	Overall Length	Centerline Angle		39°		41°		45°		50°		60°	
				Included Angle		78°		82°		90°		100°		120°	
				Severance Name	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number	Order Number
5/8"	7/32 (.2187)	1/4"-28	1-5/32"	SC-10-W	13879	14023	14168	14023	14168	14023	14168	14023	14168	14023	14168
5/8"	1/4 (.2500)	1/4"-28	1-5/32"	SC-10-W	13880	14024	14169	14024	14169	14024	14169	14024	14169	14024	14169
5/8"	5/16 (.3125)	1/4"-28	1-5/32"	SC-10-W	13881	14025	14170	14025	14170	14025	14170	14025	14170	14025	14170
5/8"	3/8 (.3750)	1/4"-28	1-5/32"	SC-10-W	13882	14026	14171	14026	14171	14026	14171	14026	14171	14026	14171
3/4"	5/32 (.1562)	3/8"-24	1-3/16"	S3-12-W	13895	14039	14184	14039	14184	14039	14184	14039	14184	14039	14184
3/4"	#21 (.1590)	3/8"-24	1-3/16"	S3-12-W	13896	14040	14185	14040	14185	14040	14185	14040	14185	14040	14185
3/4"	3/16 (.1875)	3/8"-24	1-3/16"	S3-12-W	13897	14041	14186	14041	14186	14041	14186	14041	14186	14041	14186
3/4"	#10 (.1935)	3/8"-24	1-3/16"	S3-12-W	13898	14042	14187	14042	14187	14042	14187	14042	14187	14042	14187
3/4"	7/32 (.2187)	3/8"-24	1-3/16"	S3-12-W	13900	14044	14189	14044	14189	14044	14189	14044	14189	14044	14189
3/4"	1/4 (.2500)	3/8"-24	1-3/16"	S3-12-W	13901	14045	14190	14045	14190	14045	14190	14045	14190	14045	14190
3/4"	"F" (.2570)	3/8"-24	1-3/16"	S3-12-W	13902	14046	14191	14046	14191	14046	14191	14046	14191	14046	14191
3/4"	5/16 (.3125)	3/8"-24	1-3/16"	S3-12-W	13903	14047	14192	14047	14192	14047	14192	14047	14192	14047	14192
3/4"	3/8 (.3750)	3/8"-24	1-3/16"	S3-12-W	13904	14048	14193	14048	14193	14048	14193	14048	14193	14048	14193

Aircraft Style Rivet Shavers

Severance Rivet Shavers are used with Micro-Stop units. These end-cutting tools are designed to cut rivet heads, etc., flush to the surrounding surface. They are available in two series, multi-flute for fine finishing and two-flute for fast material removal.

Fine Cut

Coarse Cut



Carbide Fine Cut

Tool Dia.	Overall Length	Thread Size
5/16"	27/32"	1/4"-28
3/8"	27/32"	1/4"-28
7/16"	27/32"	1/4"-28
1/2"	27/32"	1/4"-28
9/16"	27/32"	1/4"-28
5/8"	27/32"	1/4"-28
3/4"	31/32"	3/8"-24
7/8"	31/32"	3/8"-24
1"	31/32"	3/8"-24

Number of Flutes	Severance Tool Name	EDP Order Number
14	RS-11	28480
14	RS-12	28481
14	RS-13	28482
14	RS-14	28483
16	RS-15	28484
16	RS-16	28485
18	RS-37	28486
24	RS-38	28487
24	RS-39	28488

Carbide Coarse Cut

Number of Flutes	Severance Tool Name	EDP Order Number
2	RS-21	28490
2	RS-22	28491
2	RS-23	28492
2	RS-24	28493
2	RS-25	28494
2	RS-26	28495
2	RS-47	28496
2	RS-48	28497
2	RS-49	28498

See pages
41 and 80
for handles



Special Stop-Countersinks and Units

Special diameters, pilots, flutes, and threads available on the stop countersinks. Special Units can be made like this vacuum unit pictured here.



REF. # 55370