



**High Speed Steel
COUNTER SINKS 90° WITH
PARALLEL SHANKS AND
SOLID PILOTS**

Specifications Conform to :
IS 5693 - 1988
ISO 4205 - 1977
DIN 1866 - 1975
Dimensions in mm



Diameter z9	Dia.of Shank h9	Cutting Edge Length	Over all Length
10.0	8.0	18	80
11.0	8.0	18	80
12.0	8.0	18	80
12.5	8.0	18	80
13.0	12.5	22	100
14.0	12.5	22	100
15	12.5	22	100
16	12.5	22	100
17	12.5	22	100
18	12.5	22	100
19	12.5	22	100
20	12.5	22	100

Pilot Diameter: To be specified to suit pilot hole diameter when ordering. (minimum possible pilot diameter is equal to 1/3rd of counter sink diameter) Tolerance on pilot diameter is e8

A cutter with teeth on conical cutting faces, integral with a parallel shank, designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.

ADDISON **High Speed Steel COUNTER SINKS 60°, 90° AND 120° WITH PARALLEL SHANK**

Specifications Conform to :
 IS 13304 - 1992
 ISO 3294 - 1975
 BS 328 : Part 5 : 1983
 Dimensions in mm



Nominal Size	Small Dia.	Overall Length		Body Length		Shank Dia. h ₉
		$\alpha = 60^\circ$	$\alpha = 90^\circ \& 120^\circ$	$\alpha = 60^\circ$	$\alpha = 90^\circ \& 120^\circ$	
8.0	1.6	48	44	-	-	8
10.0	2.0	50	46	18	14	8
12.5	2.5	52	48	20	16	8
16.0	3.2	60	56	24	20	10
20.0	4.0	64	60	28	24	10
25.0	7.0	69	65	33	29	10

A cutter with teeth on the conical cutting faces, integral with a parallel shank designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.

R.H. cutting with straight teeth shall be supplied unless otherwise specified.

ADDISON **High Speed Steel COUNTER SINKS 60°, 90° AND 120° WITH MORSE TAPER SHANK**

Specifications Conform to :
 IS 13303 - 1992
 ISO 3293 - 1975
 BS 328 : Part 5 : 1983
 Dimensions in mm



Nominal size	Small Dia.	Overall Length		Body Length		Morse Taper No.
		$\alpha=60^\circ$	$\alpha=90^\circ\&120^\circ$	$\alpha=60^\circ$	$\alpha=90^\circ \& 120^\circ$	
16.0	3.2	97	93	24	20	1
20.0	4.0	120	116	28	24	2
25.0	7.0	125	121	33	29	2
31.5	9.0	132	124	40	32	2
40.0	12.5	160	150	45	35	3
50.0	16.0	165	153	50	38	3
63.0	20.0	200	185	58	43	4
80.0	25.0	215	196	73	54	4

A cutter with teeth on conical cutting faces, integral with a Morse Taper Shank designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.

R.H. cutting with straight teeth shall be supplied unless otherwise specified.

ADDISON **High Speed Steel COUNTER SINKS WITH TAPER SHANKS** Specifications Conform to : BSS 122 : Part 2 : 1964 Dimensions in Inches
Included Angle 60° or 90°

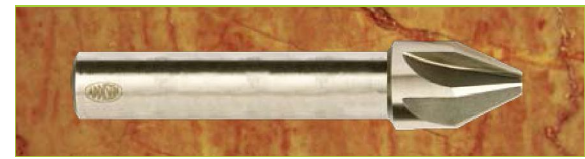


Body Diameter	Overall length	Small Diameter	Morse Taper No.
1/2	3.1/2	5/32	1
5/8	3.5/8	3/16	1
3/4	4.1/4	1/4	2
7/8	4.1/4	9/32	2
1	4.3/8	5/16	2
1.1/8	4.1/2	3/8	2
1.1/4	5.3/8	13/32	3
1.3/8	5.3/8	7/16	3
1.1/2	5.1/2	1/2	3
1.3/4	6.3/4	9/16	4
2	7	21/32	4
2.1/4	7.1/4	3/4	4
2.1/2	7.3/4	13/16	4
2.3/4	8	7/8	4
3	8.1/4	1	4

Tolerance on Body dia:
 Sizes upto and incl. 1" = - 0.001" / - 0.003"
 Over 1" = - 0.002" / - 0.005"
 RH Cutting with straight flutes shall be supplied unless otherwise specified.

ADDISON **High Speed Steel COUNTER SINKS 60°** Specifications Conform to : DIN 334 - 1979 Dimensions in mm

Form 'A' - Straight Shank



Nominal Size	Shank dia.	Small end dia.	Overall Length	Body Length
8.0	-	-	50	-
12.5	8	2.0	50	18
16.0	10	3.2	60	24
20.0	10	5.0	63	27

Form 'B' - Morse Taper Shank

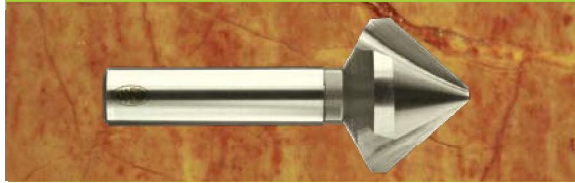


Nominal Size	Small end dia.	Overall Length	Body Length	Morse TaperNo.
16.0	3.2	100	24	1
25.0	7.0	125	33	2
31.5	9.0	132	40	2
40.0	12.0	160	45	3
50.0	16.0	170	50	3
63.0	20.0	200	58	4
80.0	25.0	215	73	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified.

ADDISON **High Speed Steel COUNTER SINKS 60°** Specifications Conform to : DIN 334 - 1979 Dimensions in mm.

Form 'C' - Straight Shank with 3 cutting edges



Nominal Size	Shank dia.	Small end dia.	Overall Length	Body Length
6.3	5	1.6	45	6.3
8.0	6	2.0	50	8.0
12.5	8	3.2	56	11.2
16.0	10	4.0	63	14.0
20.0	10	5.0	67	17.0
25.0	10	6.3	71	20.0

Form 'D' - Morse Taper Shank 3 cutting edges



Nominal Size	Small end dia	Overall Length	Body Length	Morse Taper No.
16.0	4.0	90	14.0	1
20.0	5.0	106	17.0	2
25.0	6.3	112	20.0	2
31.5	10.0	118	22.4	2
40.0	12.5	150	28.0	3
50.0	16.0	160	35.5	3
63.0	20.0	190	42.5	4
80.0	25.0	200	53.0	4

R.H. cutting with straight teeth shall be supplied unless otherwise specified.

ADDISON **High Speed Steel COUNTER SINKS 90°** Specifications Conform to : DIN 335 - 1979 Dimensions in mm.

Form 'A' - Straight Shank



Nominal Size	Shank dia	Small end dia	Overall Length	Body Length
8.0	-	-	48	-
12.5	8	2	48	16
16.0	10	3.2	56	20
20.0	10	5	60	24

Form 'B' - Morse Taper Shank



Nominal Size	Small end dia	Overall Length	Body Length	Morse Taper No.
16.0	3.2	95	20	1
25.0	7.0	118	26	2
31.5	9.0	122	30	2
40.0	12.0	150	35	3
50.0	16.0	155	38	3
63.0	20.0	185	43	4
80.0	25.0	196	54	4

R.H. cutting with straight teeth shall be supplied unless otherwise specified.



**High Speed Steel
COUNTER SINKS 90°**

Specifications Conform to :
DIN 335 - 1979
Dimensions in mm.

Form 'C' - Straight Shank with 3 cutting edges



Nominal Size	Shank Dia.	Small End Dia.	Overall Length	Body Length
4.3	4	1.3	40	3.5
5.0	4	1.5	40	4.0
5.3	4	1.5	40	4.0
5.8	5	1.5	45	4.5
6.0	5	1.5	45	4.5
6.3	5	1.5	45	5.0
7.0	6	1.8	50	5.0
7.3	6	1.8	50	5.6
8.0	6	2.0	50	5.6
8.3	6	2.0	50	6.0
9.4	6	2.2	50	6.7
10.0	6	2.5	50	7.1
10.4	6	2.5	50	7.1

Nominal Size	Shank Dia.	Small End Dia.	Overall Length	Body Length
11.5	8	2.8	56	7.5
12.4	8	2.8	56	8.0
13.4	8	2.9	56	8.5
15.0	10	3.2	60	9.0
16.5	10	3.2	60	10.0
19.0	10	3.5	63	11.2
20.5	10	3.5	63	12.5
23.0	10	3.8	67	13.2
25.0	10	3.8	67	15.0
26.0	10	3.8	67	15.0
28.0	12	4.0	71	16.0
30.0	12	4.2	71	18.0
31.0	12	4.2	71	18.0

R.H. Cutting with straight teeth shall be supplied unless otherwise specified

Form 'D' - Morse Taper Shank with 3 cutting edges



Nominal Size	Small End dia.	Overall Length	Body Length	Morse Taper No.
15.0	3.2	85	9.0	1
16.5	3.2	85	10.0	1
19.0	3.5	100	11.2	2
20.5	3.5	100	12.5	2
23.0	3.8	106	13.2	2
25.0	3.8	106	15.0	2
26.0	3.8	106	15.0	2
28.0	4.0	112	16.0	2

Nominal Size	Small End dia.	Overall Length	Body Length	Morse Taper No.
30	4.2	112	18.0	2
31	4.2	112	18.0	2
34	4.5	118	19.0	2
37	4.8	118	21.2	2
40	10.0	140	20.0	3
50	14.0	150	23.6	3
63	16.0	180	28.0	4
80	22.0	190	35.5	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified