

Edge of Arlington Saw & Tool, Inc.

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Item #55122, Amana Tool Carbide-Tipped 82 Degree Countersink with Slow Spiral Stepped Drill, #6 & #8 Screws 25/64 Dia x 5/32 Drill Dia x 5/16 Round Shank **\$34.69**

Thank you for shopping with us! Available in a wide variety of sizes, complete with slow spiral HSS M2 DIN 338 fully ground stepped drill bit. #5 Screw for Hard Wood #6 Screw for Soft Wood Excellent for Drilling: Natural Woods Man-Made Boards MDF Chipboard Plywood Aluminum/Non-Ferrous Aluminum Composite Material (ACM) Composites Composite Decking Materials High Density Polyethylene (HDPE) Acrylic Warning: When drilling aluminum/non-ferrous materials, for optimal results and extended tool life use lubricant or air cooling. Make sure the material is fixed and drill is stable during drilling. **CNC Countersink** Drilling countersinks with these bits on the CNC machine is a great way to save time and have your pieces look great every time! With the adjustable depth drill bit you can adjust for whatever size material you're working with. Best used with a drilling toolpath, utilizing the peck drill option at .25" per pass with a .125" retract height. For best results run at 3,000 RPM with a 30 IPM (Inches Per Minute) plunge rate. No feed rate needs to be set with these as they only move up and down with the Z axis, not side to side. If your software doesn't allow a 0 feed rate, you can enter 1 IPM in the feed rate as a placeholder. For countersinks with 1/4" round shank, use 1/4" spring collet. For countersinks with 5/16" round shank, use 7-8mm spring collet. For countersinks with 3/8" round shank, use 9-10mm spring collet.

SPECIFICATIONS	
Manufacturer	Amana Tool
Diameter	25/64 in
Cut Height, Length, or Width	3/4 in
Replacement Parts	Drill #630-012; Set Screw #67083
Diameter (D1)	5/32 in
Diameter (D2)	7/64 in
Length	1 3/4 in
Overall Length	3 in

SPECIFICATIONS

Screw Size	Softwood #8; Hardwood #6
Shank	5/16 in