



CATALOG NO. 101

Severance®

High Speed Steel and Carbide CUTTING TOOLS

Precision Finishing

Chatterless Design



Severance® Tool Industries Inc. Saginaw, Michigan 989-777-5500

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Specialty Tools

Whirly-Gig® Handle

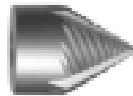
The Severance Whirly-Gig® Handle is designed for fast efficient part deburring. A wide range of standard Severance deburring tools can be quickly interchanged for performing and finishing a variety of hand deburring operations.

How does the Severance Whirly-Gig® Handle work?

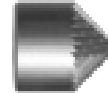


Severance has a wide variety of deburring tools to fit the Whirly-Gig® Handle

Inside Deburring Tools



IC-5/8-30



ID-5/8-45

Hole Radius Tool



HR-10

Aircraft Style Stop Countersinks



SC-7-41-.093



3N1-QC-1/2-30

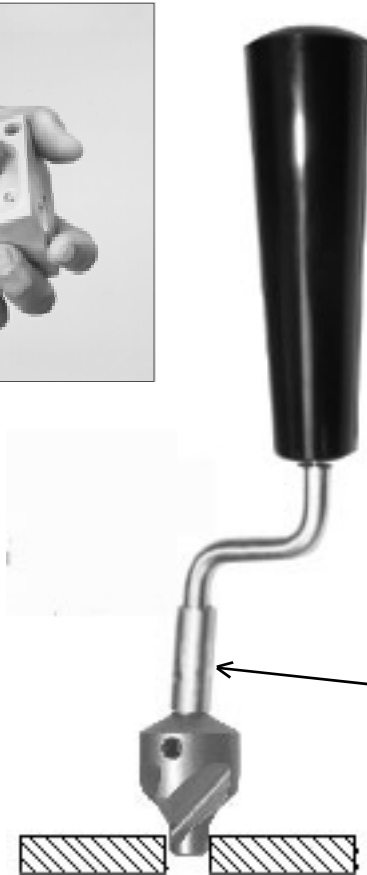
Double Ended Countersink



CK-1/4-41-DE

Whirly-Gig® Handle Accessories

Tools	EDP#
Whirly-Gig® Handle	34266
Whirly-Gig® Extension	34267
Whirly-Gig® Holder-1/4	34273
Whirly-Gig® Set #344	34268
Whirly-Gig® Set #345	34271
Whirly-Gig® Set #346	34272



Whirly-Gig® Extension



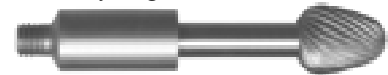
EDP# 34267

End removes for adapting to female 1/4-28 threaded parts, other adapters available for larger thread sizes.

Threaded Arbor



Whirly-Gig® 1/4" Shank Holder



Holds 1/4" shank tools



Whirly-Gig® Sets

Whirly-Gig® Set #344 EDP# 34268

1 Whirly-Gig® Handle
1 Whirly-Gig® Extension
1 ID-5/8-30
1 ID-5/8-45
1 SC-7-41-.093
1 SC-7-45-.093
1 HR-10
1 Threaded Arbor

Whirly-Gig® Set #345 EDP# 34271

1 Whirly-Gig® Handle
1 Whirly-Gig® Holder-1/4
1 CK-1/4-45-DE
1 3N1-QC-1/2-45
1 Hex Wrench

Whirly-Gig® Set #346 EDP# 34272

1 Whirly-Gig® Handle
1 Whirly-Gig® Holder-1/4
1 CK-1/4-45-DE
1 CK-1/4-41-DE
1 3N1-QC-1/2-45
1 3N1-QC-3/8-45
1 IC-5/8-30
1 HR-10
1 Hex Wrench
1 Threaded Arbor

Mini-Scraper™

High Speed Steel triangular shaped scraper, ideal for removing burrs and sharp edges. Special ground surface, three sharp edges, and no teeth. High Speed Steel heat treated for durable use.

Shipped in a convenient storage tube. Should be in every Machinists tool box.

NEW!!

H.S.S.
Mini-Scraper™

Aprox. Overall Length	Cut Length	Severance Tool Name	EDP Order Number
6-1/2"	2"	Mini-Scraper™	20300

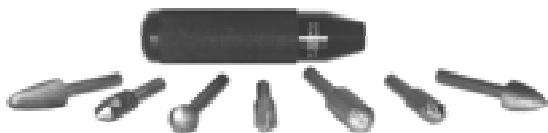


Speedy Handle™

The Severance Speed Handle™ is designed for fast efficient part deburring. A wide range of standard Severance 1/4" deburring and chamfering tools can be quickly interchanged for performing and finishing a variety of hand deburring operations.



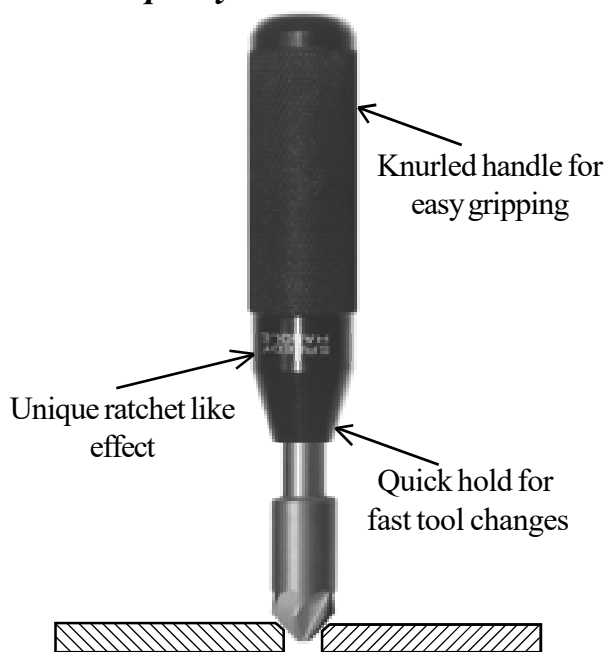
Able to take a variety of 1/4" shank standard and special tools.



Tools	EDP#
Speedy Handle™	34269



How Does The Severance Speedy Handle™ Work?



Speedy Handle™ Set 349

EDP# 34270	
Speedy Handle™	
IIB	Ball Shaped Midget Mill®
ICS-5/8-45	Inside Chamfering Mill
ES-5/8-45-1/4	Four Flute Countersink

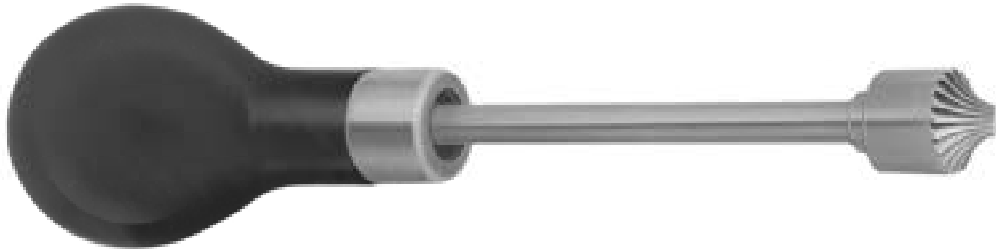


Hole Radius Deburring Cutters

Rounds hole edges often an improvement over the chamfer. The multi-flute design keeps cutter centered in hole. May be used manually, mounted on a handle (see comfy grip handles below), just a twist of the wrist easily removes burrs safely from holes already sized. Also, can be shank-mounted and chucked in a machine (see shanks on pages 78-80). Safer than ordinary deburring tools. May be reground many times. Shanks and handles sold separately

High Speed Steel

Use For Nominal Hole Size	Cutting Dia.	Cutting Length	Radius	Nose Dia.	Overall Length	Internal Thread	Severance Tool Name	EDP Order Number
3/32"	3/16"	1/16"	3/32"	0.046	7/8"	1/4"-28	HR-1	25140
1/8"	9/32"	3/32"	1/8"	0.063	7/8"	1/4"-28	HR-2	25141
3/16"	3/8"	1/8"	3/16"	0.093	7/8"	1/4"-28	HR-3	25142
1/4"	9/16"	3/16"	1/4"	1/8"	3/4"	1/4"-28	HR-5	25143
5/16"	5/8"	1/4"	5/16"	3/16"	3/4"	1/4"-28	HR-10	25144
3/8"	3/4"	1/4"	3/8"	1/4"	3/4"	1/4"-28	HR-15	25145
7/16"-1/2"	1"	3/8"	3/8"	5/16"	3/4"	5/16"-24	HR-20	25146
9/16"-5/8"	1-1/8"	1/4"	1/2"	3/8"	5/8"	5/16"-24	HR-25	25147
3/4"	1-3/8"	3/8"	9/16"	7/16"	3/4"	3/8"-24	HR-30	25148
7/8"-1"	1-1/2"	3/8"	5/8"	9/16"	11/16"	3/8"-24	HR-35	25149
1-3/8"	2"	1/2"	1"	1"	3/4"	3/8"-24	HR-40	25150
1-5/8"-1-3/4"	2-1/2"	5/8"	1-1/4"	1-1/8"	1"	1/2"-20	HR-45	25151
2"	2-3/4"	3/4"	1-3/8"	1-1/2"	1-1/8"	1/2"-20	HR-50	25152



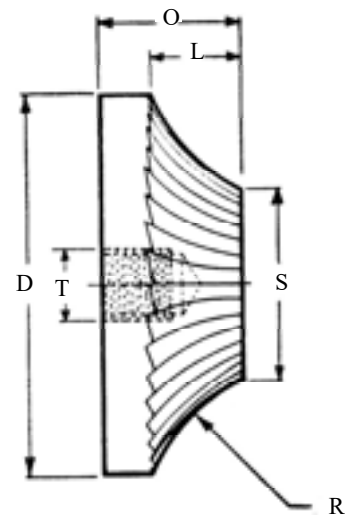
Threaded

Handles

Fits This Rad. Dbr. Ctr	Severance Tool Name	EDP Order Number
HR-1	H-100	34260
HR-2	H-100	34260
HR-3	H-100	34260
HR-5	H-100	34260
HR-10	H-100	34260
HR-15	H-100	34260
HR-20	H-110	34261
HR-25	H-110	34261
HR-30	H-121	34262
HR-35	H-121	34262
HR-40	H-121	34262
HR-45	H-131	34263
HR-50	H-131	34263

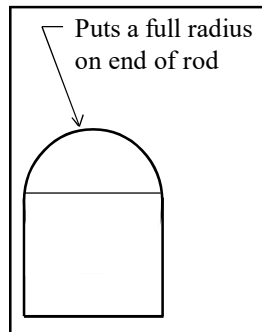


Handles generally used with radius deburr tools.
For other shanks, see pages 78-80.



Rod End Forming Cutters

These cutters are used to form rounded ends on rods, wire, parts, etc. They perform well on many "Space Age" materials, as well as on the more common metals, plastics, etc. SPECIALS – Rod-End Forming Cutters may be obtained to produce various radii, straight chamfers, etc. Send sketch of desired form and sample of part, if feasible.



High Speed Steel

For Rod Diameter	Radius Formed	Body Dia.	Shank Dia.	Overall Length	Severance Tool Name	EDP Order Number
1/32"	1/64"	1/4"	1/4"	1-1/2"	RFC-0	28630
1/16"	1/32"	5/16"	1/4"	1-3/4"	RFC-1	28631
3/32"	3/64"	3/8"	1/4"	1-3/4"	RFC-1-1/2	28632
1/8"	1/16"	1/2"	3/8"	2-1/8"	RFC-2	28633
3/16"	3/32"	1/2"	3/8"	2-1/8"	RFC-3	28634
1/4"	1/8"	3/4"	1/2"	2-11/16"	RFC-4	28635
5/16"	5/32"	3/4"	1/2"	2-11/16"	RFC-5	28636
3/8"	3/16"	3/4"	1/2"	2-11/16"	RFC-6	28637
7/16"	7/32"	1"	1/2"	2-13/16"	RFC-7	28638
1/2"	1/4"	1"	1/2"	2-13/16"	RFC-8	28639
9/16"	9/32"	1"	1/2"	2-13/16"	RFC-9	28640
5/8"	5/16"	1-1/4"	3/4"	3-3/8"	RFC-10	28641
3/4"	3/8"	1-1/2"	3/4"	3-1/2"	RFC-12	28642
7/8"	7/16"	1-3/4"	1"	4-1/4"	RFC-14	28643
1"	1/2"	2"	1"	4-3/8"	RFC-16	28644

See Page 36 for Outside Chamfer Mills to put a angle on the end of a rod

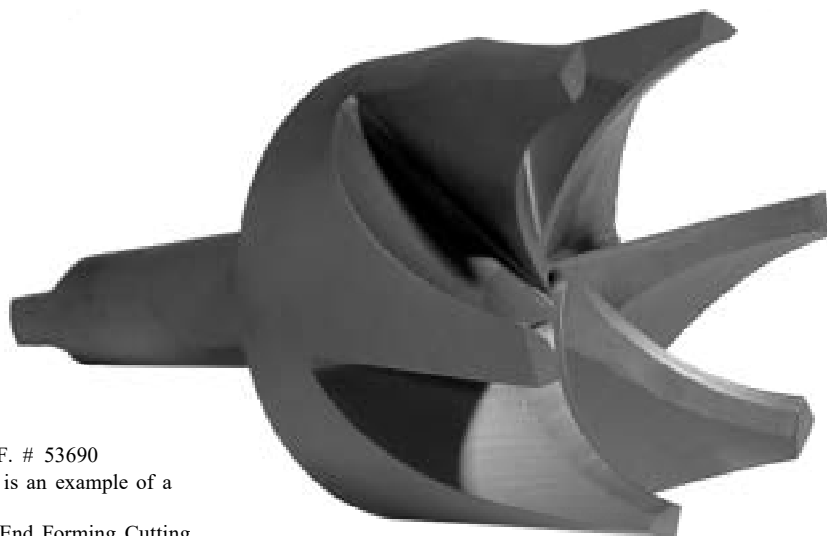
Special Rod End Forming Cutters

Special diameters, Radii, flutes, and angles available.



REF. # 55361

Severance can make special hollow mills to fit customer applications.

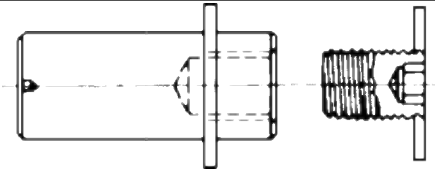
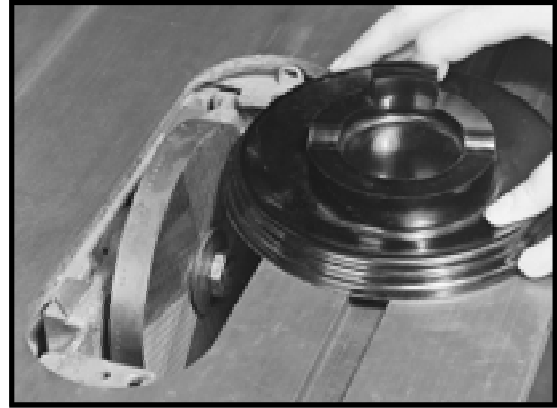


REF. # 53690

Here is an example of a large Rod End Forming Cutting.

Disc Cutters

Severance Disc Cutters are used to replace sanding discs, snagging wheels and milling cutters on deburring applications. Unless otherwise specified, all double-face disc cutters are furnished with reversible faces. That is, only one side rotates in the cutting direction. Other disc sizes, pitches or mounting designs can be made up as specials. Severance applications engineers can recommend disc designs suitable for your type of power tool, speeds available and mounting requirements.



For shanks and arbors, see pages 78-80.

High Speed Steel

Dia.	Thickness	Use Arbor (See page 79)	Center Bore Dia.	Cut Number
3"	3/8"	SH-3, SH-4	3/4"	7
4"	1/2"	SH-3, SH-4	3/4"	7
5"	5/8"	SH-5	1-1/8"	8
6"	3/4"	SH-6	1-5/8"	10
8"	7/8"	SH-8	1-7/8"	12

High Speed Steel Single Face

Severance Tool Name	EDP Order Number
DISC-3-SF	17360
DISC-4-SF	17361
DISC-5-SF	17362
DISC-6-SF	17363
DISC-8-SF	17364

High Speed Steel Double Face

Severance Tool Name	EDP Order Number
DISC-3-DF	17370
DISC-4-DF	17371
DISC-5-DF	17372
DISC-6-DF	17373
DISC-8-DF	17374

Edge Deburring Cutters

Replaces laborious hand filing, scraping, grinding, etc. Severance Edging Cutters are made to deburr one face of an edge or both faces simultaneously. They are furnished with two cutting members having cutting teeth opposed and set for right hand rotation. Opposite ends of each member have faces ground to the same 75° angle with C/L without cutting teeth. By reversing one member, the safe face will act as a guide opposing the cutting member, and may be positioned to give more or less depth of cut as required.



High Speed Steel

1/4" shank w/ 3/8" mounting diameter.

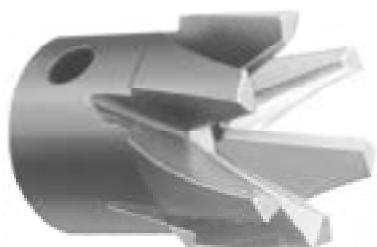
Description	Cutter Dia.	Cutter Centerline Angle	Hole Dia.	Arbor Dia.	Overall Length	Severance Tool Name	EDP Order Number
Complete tool	3/4"	75°	3/8"	3/8"	4"	EG-750	17420
Complete tool	1"	75°	3/8"	3/8"	4"	EG-1000	17425

Extra or Replacement Parts

Arbor, fits both sizes				3/8"	4"	EG-750-3	17430
750F - Front cutter	3/4"	75°	3/8"		3/4"	EG-750-LC	17431
750B - Back cutter	3/4"	75°	3/8"		3/4"	EG-750-RC	17432
1000F - Front cutter	1"	75°	3/8"		7/8"	EG-1000-LC	17433
1000B - Back cutter	1"	75°	3/8"		7/8"	EG-1000-RC	17434
Socket head set screws (2 required for each cutter)					3/16"	6-32 X 1/4"	17435



ED-1

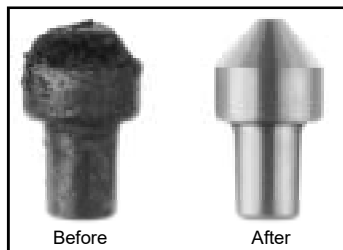


EDE-2



ED-T2

See Special Forms Page 65-66



High Speed Steel

Threaded Style Electrode Forming Cutter

Shape Centerline Angle	Dia. of Flat Nose Cutting Insert And Comb. Stop	Severance Tool Name	EDP Order Number
30°	3/16"	ED-1	17470
30°	1/8"	ED-2	17471

High Speed Steel

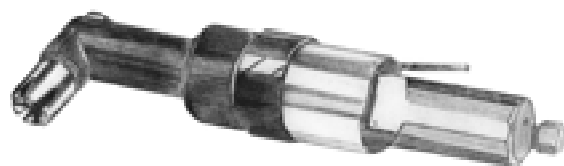
Extended Style Electrode Forming Cutter

Shape Centerline Angle	Dia. of Flat Nose Cutting Insert And Comb. Stop	Severance Tool Name	EDP Order Number
30°	1/8"	EDE-1	17490
30°	3/16"	EDE-2	17491
30°	1/4"	EDE-3	17492
5/16 Radius	1/4"	EDE-6	17493

High Speed Steel

Flush Style Electrode Forming Cutter

Shape Centerline Angle	Dia. of Flat Nose Cutting Insert And Comb. Stop	Severance Tool Name	EDP Order Number
Reform No. 1 Pointed Tips	3/16"	ED-T1	17530
Reform No. 2 Pointed Tips	1/4"	ED-T2	17531



Air tools not included with cutters

