

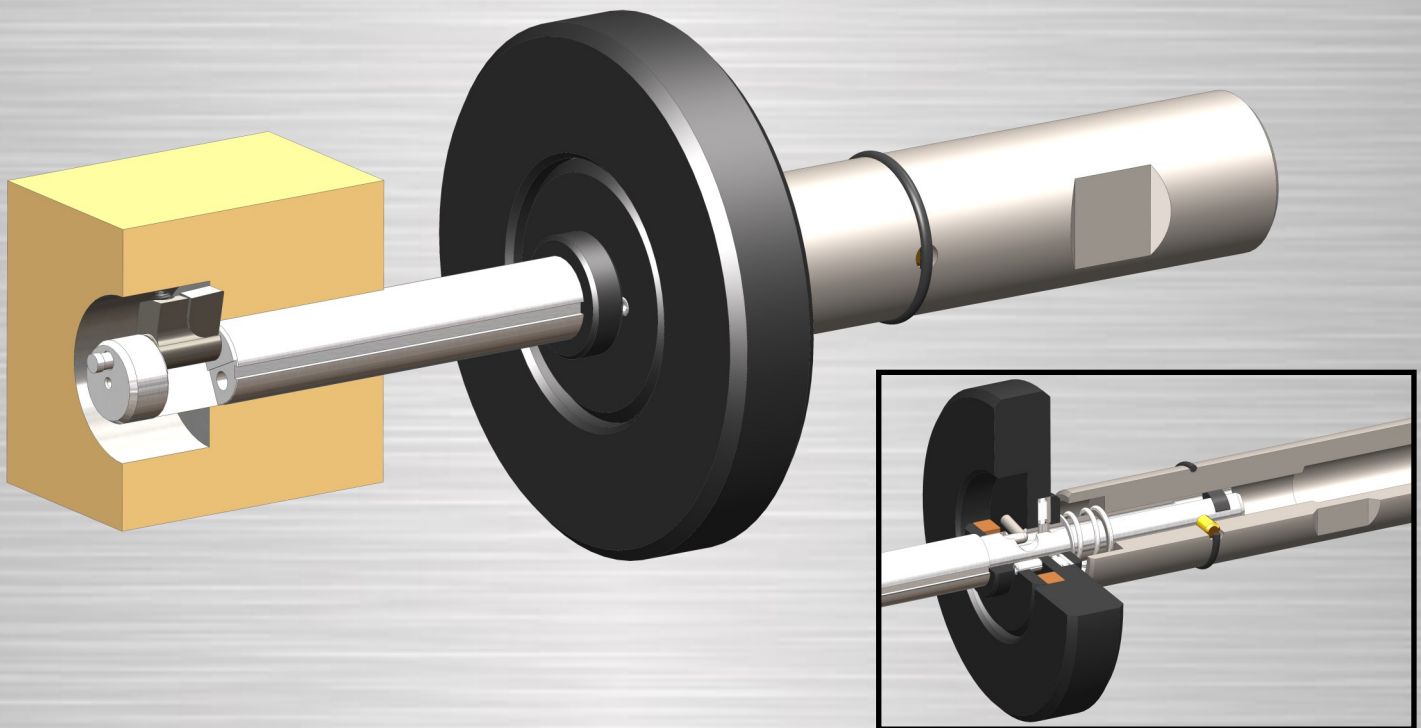
STEINERTM

INGENIOUS CUTTING TOOLS

Stocked Flywheel Autofacer®

THE WORLD LEADER IN

AUTOMATIC BACK BORING SOLUTIONS



Advantages:

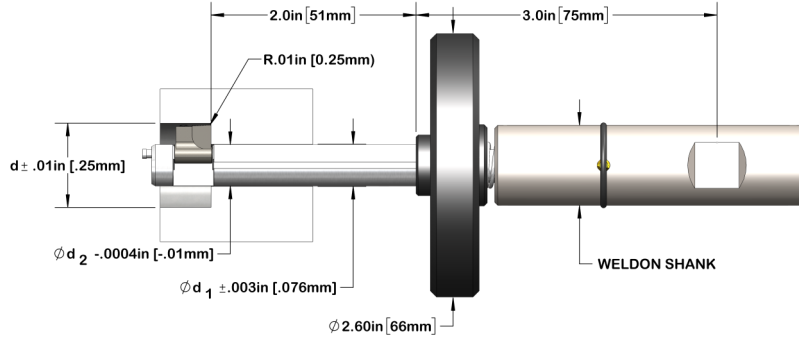
- **Inch & Metric Weldon Shanks available.**
- **Fully supported in pilot hole during cutting.**
- **Utilizes machine spindle inertia to open/close.**
- **Shear pin design protects the tool investment, workpiece and machine spindle.**



**OEM of the
Autofacer®
Since 1968**

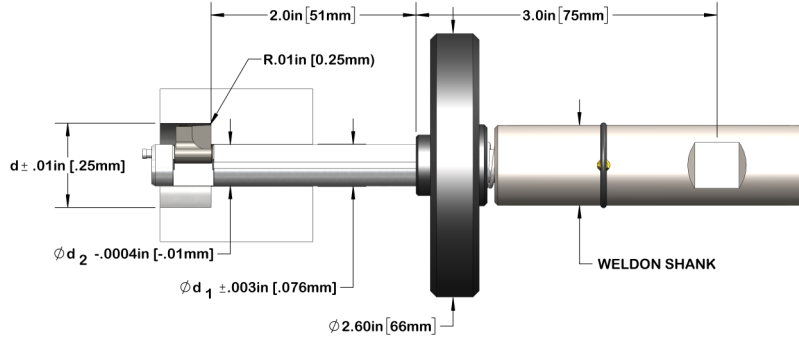


Counterbore Ø | 9.5mm (0.375in) - 15.5mm (0.610in)



Counterbore		Pilot Hole		Autofacer		Order Number					
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N			
9.5	0.374	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-9.50M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
10.0	0.394	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-10.00M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
10.5	0.413	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-10.50M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
11.0	0.433	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-11.00M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
11.0	0.433	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-11.00M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		11.5	0.453	6.5	0.256	6.4	0.251		Ø20mm	AF25-6.50M	CB25-11.50M
				6.5	0.256	6.4	0.251		Ø0.75in	AF25-6.50	
7.0	0.276			6.9	0.270	Ø20mm	AF25-7.00M				
7.0	0.276			6.9	0.270	Ø0.75in	AF25-7.00				
11.5	0.453	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-11.50M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-11.50M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
12.0	0.472	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-12.00M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
12.0	0.472	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-12.00M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-12.00M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
12.5	0.492	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-12.50M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
12.5	0.492	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-12.50M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-12.50M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
13.0	0.512	6.5	0.256	6.4	0.251	Ø20mm	AF25-6.50M	CB25-13.00M			
		6.5	0.256	6.4	0.251	Ø0.75in	AF25-6.50				
		7.0	0.276	6.9	0.270	Ø20mm	AF25-7.00M				
		7.0	0.276	6.9	0.270	Ø0.75in	AF25-7.00				
13.0	0.512	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-13.00M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-13.00M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
13.5	0.531	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-13.50M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-13.50M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
14.0	0.551	7.5	0.295	7.4	0.290	Ø20mm	AF28-7.50M	CB28-14.00M			
		7.5	0.295	7.4	0.290	Ø0.75in	AF28-7.50				
		8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M		CB31-14.00M		
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M						
8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50						
14.0	0.551	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-14.00M			
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00				
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M		CB38-14.00M		
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50				
10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M						
10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00						
14.5	0.571	8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M	CB31-14.50M			
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
		8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M				
		8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50				
14.5	0.571	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-14.50M			
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00				
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M		CB38-14.50M		
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50				
10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M						
10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00						
15.0	0.591	8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M	CB31-15.00M			
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
		8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M				
		8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50				
15.0	0.591	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-15.00M			
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00				
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M		CB38-15.00M		
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50				
10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M						
10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00						
15.5	0.610	8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M	CB31-15.50M			
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00				
		8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M				
		8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50				
15.5	0.610	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-15.50M			
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00				
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M		CB38-15.50M		
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50				
10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M						
10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00						
15.5	0.610	10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-15.50M			
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50				
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M				
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00				

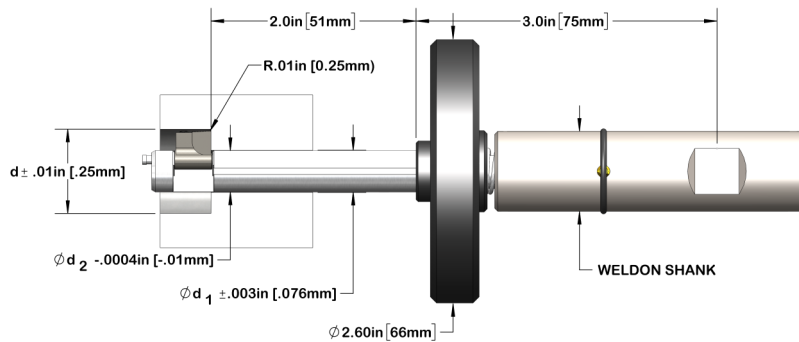
Counterbore Ø | 16mm (0.630in) - 19mm (0.748in)



Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
16.0	0.630	8.0	0.315	7.9	0.310	Ø20mm	AF31-8.00M	CB31-16.00M
		8.0	0.315	7.9	0.310	Ø0.75in	AF31-8.00	
		8.5	0.335	8.4	0.330	Ø20mm	AF31-8.50M	
		8.5	0.335	8.4	0.330	Ø0.75in	AF31-8.50	
		9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-16.00M
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00	
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-16.00M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-16.00M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-16.00M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-16.00M		
11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00			
16.5	0.650	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-16.50M
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00	
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-16.50M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-16.50M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-16.50M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-16.50M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-16.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
17.0	0.669	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-17.00M
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00	
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-17.00M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-17.00M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-17.00M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-17.00M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-17.00M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
17.5	0.689	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-17.50M
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00	
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-17.50M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-17.50M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-17.50M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-17.50M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-17.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	

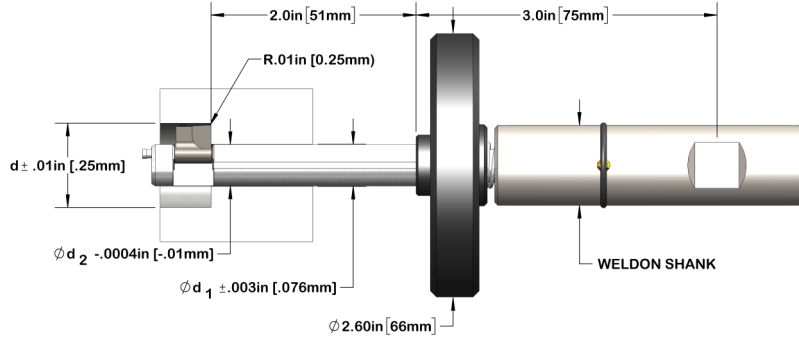
Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
18.0	0.709	9.0	0.354	8.9	0.349	Ø20mm	AF34-9.00M	CB34-18.00M
		9.0	0.354	8.9	0.349	Ø0.75in	AF34-9.00	
		9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-18.00M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-18.00M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-18.00M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-18.00M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-18.00M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-18.00M		
12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00			
18.5	0.728	9.5	0.374	9.4	0.369	Ø20mm	AF38-9.50M	CB38-18.50M
		9.5	0.374	9.4	0.369	Ø0.75in	AF38-9.50	
		10.0	0.394	9.9	0.389	Ø20mm	AF38-10.00M	CB38-18.50M
		10.0	0.394	9.9	0.389	Ø0.75in	AF38-10.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-18.50M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-18.50M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-18.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-18.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
19.0	0.748	12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-18.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-18.50M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-19.00M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	CB40-19.00M
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-19.00M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-19.00M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-19.00M		
12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50			
13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-19.00M		
13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00			

Counterbore Ø | 19.5mm (0.768in) - 22mm (0.866in)



Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
19.5	0.768	10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-19.50M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-19.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-19.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-19.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-19.50M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M			
14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			
20.0	0.787	10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-20.00M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-20.00M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-20.00M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-20.00M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-20.00M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M			
14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			
20.5	0.807	10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-20.50M
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50	
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M	
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00	
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-20.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-20.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-20.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-20.50M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M			
14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			

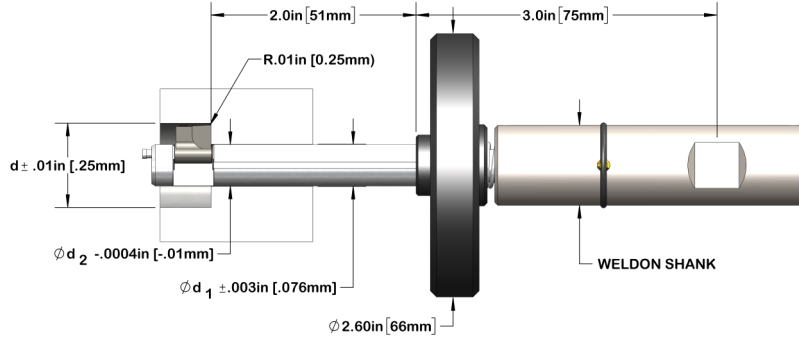
Counterbore		Pilot Hole		Autofacer		Order Number				
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N		
21.0	0.827	10.5	0.413	10.4	0.408	Ø20mm	AF40-10.50M	CB40-21.00M		
		10.5	0.413	10.4	0.408	Ø0.75in	AF40-10.50			
		11.0	0.433	10.9	0.428	Ø20mm	AF40-11.00M			
		11.0	0.433	10.9	0.428	Ø0.75in	AF40-11.00			
		11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-21.00M		
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50			
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-21.00M		
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00			
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-21.00M		
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50			
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M			
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00			
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-21.00M		
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50			
14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M					
14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00					
21.5	0.846	11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-21.50M		
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50			
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-21.50M		
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00			
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-21.50M		
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50			
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M			
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00			
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-21.50M		
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50			
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M			
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			
		22.0	0.866	14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-21.50M
				14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
11.5	0.453			11.4	0.448	Ø20mm	AF44-11.50M	CB44-22.00M		
11.5	0.453			11.4	0.448	Ø0.75in	AF44-11.50			
12.0	0.472			11.9	0.467	Ø20mm	AF47-12.00M	CB47-22.00M		
12.0	0.472			11.9	0.467	Ø0.75in	AF47-12.00			
12.5	0.492			12.4	0.487	Ø20mm	AF50-12.50M	CB50-22.00M		
12.5	0.492			12.4	0.487	Ø0.75in	AF50-12.50			
13.0	0.512			12.9	0.507	Ø20mm	AF50-13.00M			
13.0	0.512			12.9	0.507	Ø0.75in	AF50-13.00			
13.5	0.531			13.4	0.526	Ø20mm	AF53-13.50M	CB53-22.00M		
13.5	0.531			13.4	0.526	Ø0.75in	AF53-13.50			
14.0	0.551			13.9	0.546	Ø20mm	AF53-14.00M			
14.0	0.551			13.9	0.546	Ø0.75in	AF53-14.00			
22.0	0.866	14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-22.00M		
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50			
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-22.00M		
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00			
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M			
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			



Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d₁ (mm)	d₁ (in)	d₂ (mm)	d₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
22.5	0.886	11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-22.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-22.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-22.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-22.50M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB56-22.50M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB59-22.50M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-22.50M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M			
15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			
23.0	0.906	11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-23.00M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-23.00M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-23.00M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-23.00M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB56-23.00M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB59-23.00M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-23.00M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M			
15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			

Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d₁ (mm)	d₁ (in)	d₂ (mm)	d₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
23.5	0.925	11.5	0.453	11.4	0.448	Ø20mm	AF44-11.50M	CB44-23.50M
		11.5	0.453	11.4	0.448	Ø0.75in	AF44-11.50	
		12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-23.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-23.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-23.50M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB56-23.50M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB59-23.50M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-23.50M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M			
15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			
24.0	0.945	12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-24.00M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-24.00M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB53-24.00M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB56-24.00M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB59-24.00M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-24.00M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50	
24.5	0.965	12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-24.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-24.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB53-24.50M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB56-24.50M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB59-24.50M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-24.50M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50	

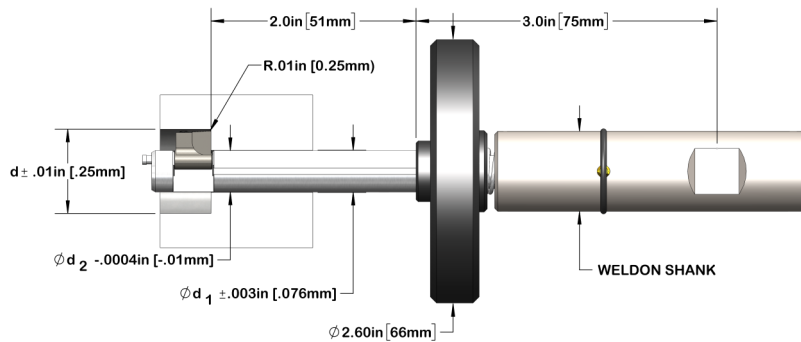
Counterbore Ø | 25mm (0.984in) - 27.5mm (1.083in)



Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
25.0	0.984	12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-25.00M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-25.00M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-25.00M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-25.00M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB53-25.00M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-25.00M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-25.00M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	CB59-25.00M
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50	
25.5	1.004	12.0	0.472	11.9	0.467	Ø20mm	AF47-12.00M	CB47-25.50M
		12.0	0.472	11.9	0.467	Ø0.75in	AF47-12.00	
		12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-25.50M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-25.50M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-25.50M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB53-25.50M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-25.50M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-25.50M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	CB59-25.50M
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50	
26.0	1.024	12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-26.00M
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-26.00M
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00	
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-26.00M
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50	
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB53-26.00M
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00	
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-26.00M
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-26.00M
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	CB59-26.00M
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50	

Counterbore		Pilot Hole		Autofacer		Order Number				
d (mm)	d (in)	d ₁ (mm)	d ₁ (in)	d ₂ (mm)	d ₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N		
26.5	1.043	12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-26.50M		
		12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50			
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-26.50M		
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00			
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-26.50M		
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50			
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB53-26.50M		
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-26.50M		
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50			
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-26.50M		
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00			
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	CB59-26.50M		
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			
		27.0	1.063	12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-27.00M
				12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
13.0	0.512			12.9	0.507	Ø20mm	AF50-13.00M	CB50-27.00M		
13.0	0.512			12.9	0.507	Ø0.75in	AF50-13.00			
13.5	0.531			13.4	0.526	Ø20mm	AF53-13.50M	CB53-27.00M		
13.5	0.531			13.4	0.526	Ø0.75in	AF53-13.50			
14.0	0.551			13.9	0.546	Ø20mm	AF53-14.00M	CB53-27.00M		
14.0	0.551			13.9	0.546	Ø0.75in	AF53-14.00			
14.5	0.571			14.4	0.566	Ø20mm	AF56-14.50M	CB56-27.00M		
14.5	0.571			14.4	0.566	Ø0.75in	AF56-14.50			
15.0	0.591			14.9	0.585	Ø20mm	AF59-15.00M	CB59-27.00M		
15.0	0.591			14.9	0.585	Ø0.75in	AF59-15.00			
15.5	0.610			15.4	0.605	Ø20mm	AF59-15.50M	CB59-27.00M		
15.5	0.610			15.4	0.605	Ø0.75in	AF59-15.50			
27.5	1.083			12.5	0.492	12.4	0.487	Ø20mm	AF50-12.50M	CB50-27.50M
				12.5	0.492	12.4	0.487	Ø0.75in	AF50-12.50	
		13.0	0.512	12.9	0.507	Ø20mm	AF50-13.00M	CB50-27.50M		
		13.0	0.512	12.9	0.507	Ø0.75in	AF50-13.00			
		13.5	0.531	13.4	0.526	Ø20mm	AF53-13.50M	CB53-27.50M		
		13.5	0.531	13.4	0.526	Ø0.75in	AF53-13.50			
		14.0	0.551	13.9	0.546	Ø20mm	AF53-14.00M	CB53-27.50M		
		14.0	0.551	13.9	0.546	Ø0.75in	AF53-14.00			
		14.5	0.571	14.4	0.566	Ø20mm	AF56-14.50M	CB56-27.50M		
		14.5	0.571	14.4	0.566	Ø0.75in	AF56-14.50			
		15.0	0.591	14.9	0.585	Ø20mm	AF59-15.00M	CB59-27.50M		
		15.0	0.591	14.9	0.585	Ø0.75in	AF59-15.00			
		15.5	0.610	15.4	0.605	Ø20mm	AF59-15.50M	CB59-27.50M		
		15.5	0.610	15.4	0.605	Ø0.75in	AF59-15.50			

Counterbore Ø | 28mm (1.102in) - 33mm (1.299in)



Counterbore		Pilot Hole		Autofacer		Order Number			
d (mm)	d (in)	d₁ (mm)	d₁ (in)	d₂ (mm)	d₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N	
28.0	1.102	12.5	0.492	12.37	0.487	Ø20mm	AF50-12.50M	CB50-28.00M	
		12.5	0.492	12.37	0.487	Ø0.75in	AF50-12.50		
		13.0	0.512	12.87	0.507	Ø20mm	AF50-13.00M		
		13.0	0.512	12.87	0.507	Ø0.75in	AF50-13.00		
		13.5	0.531	13.37	0.526	Ø20mm	AF53-13.50M	CB53-28.00M	
		13.5	0.531	13.37	0.526	Ø0.75in	AF53-13.50		
		14.0	0.551	13.87	0.546	Ø20mm	AF53-14.00M		
		14.0	0.551	13.87	0.546	Ø0.75in	AF53-14.00		
		14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-28.00M	
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M		
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00		
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-28.00M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50		
13.5	0.531	13.37	0.526	Ø20mm	AF53-13.50M	CB53-28.50M			
13.5	0.531	13.37	0.526	Ø0.75in	AF53-13.50				
14.0	0.551	13.87	0.546	Ø20mm	AF53-14.00M				
14.0	0.551	13.87	0.546	Ø0.75in	AF53-14.00				
28.5	1.122	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-28.50M	
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M		
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00		
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-28.50M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50		
		13.5	0.531	13.37	0.526	Ø20mm	AF53-13.50M		CB53-29.00M
		13.5	0.531	13.37	0.526	Ø0.75in	AF53-13.50		
14.0	0.551	13.87	0.546	Ø20mm	AF53-14.00M				
14.0	0.551	13.87	0.546	Ø0.75in	AF53-14.00				
29.0	1.142	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-29.00M	
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M		
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00		
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-29.00M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50		
		14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M		CB56-29.50M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M				
15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00				
29.5	1.161	15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-29.50M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50		
		14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M		CB56-30.00M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M		
15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00				
30.0	1.181	15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-30.00M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50		
		14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M		CB56-30.50M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50		
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M		
15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00				

Counterbore		Pilot Hole		Autofacer		Order Number		
d (mm)	d (in)	d₁ (mm)	d₁ (in)	d₂ (mm)	d₂ (in)	Weldon Shank	Autofacer P/N	Cutter Blade P/N
30.5	1.201	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-30.50M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-30.50M
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	
31.0	1.220	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-31.00M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-31.00M
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	
31.5	1.240	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-31.50M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-31.50M
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	
32.0	1.260	14.5	0.571	14.37	0.566	Ø20mm	AF56-14.50M	CB56-32.00M
		14.5	0.571	14.37	0.566	Ø0.75in	AF56-14.50	
		15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	CB59-32.00M
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	
32.5	1.280	15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	CB59-32.50M
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	
33.0	1.299	15.0	0.591	14.87	0.585	Ø20mm	AF59-15.00M	CB59-33.00M
		15.0	0.591	14.87	0.585	Ø0.75in	AF59-15.00	
		15.5	0.610	15.37	0.605	Ø20mm	AF59-15.50M	
		15.5	0.610	15.37	0.605	Ø0.75in	AF59-15.50	

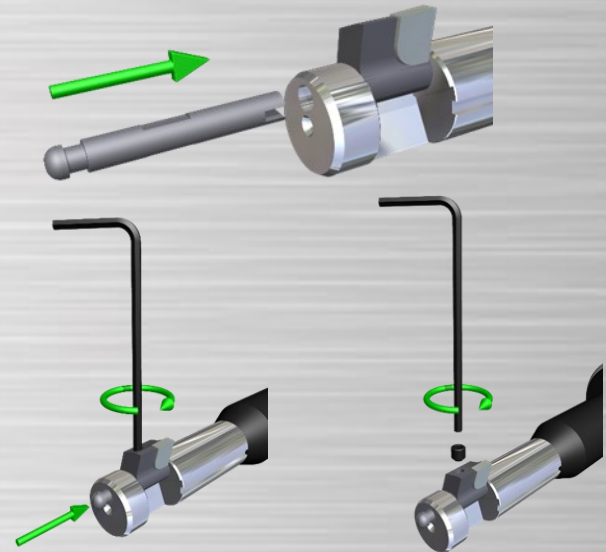
Cutting Data Recommendations: (Max RPM 1500)

	Mild Steel	Prehardened Steel	Stainless Steel	Cast Iron	Aluminum
Speed (SFM)	300	220	150	350	600
Speed (SMPM)	91	67	46	107	183
Feed Rate (IPR)	.001-.002	.001-.002	.001-.002	.0015-.0025	.002-.003
Feed Rate (MMPR)	.028-.038	.028-.038	.025-.038	.038-.050	.050-.063

Cutter Blade Installation:

1. Insert the pivot pin into the cutter body and thru the blade. Rotate the pivot pin until it engages the tang of the activating rod.
2. With the blade in the open position, rotate the clutch of the tool until the alignment mark on the pivot pin is parallel to the hex wrench and set screw in the cutter blade. This will ensure the set screw is aligned with the flat on the pivot pin.
3. Apply a small amount of serviceable Loctite (provided) to threads of screw. Tighten set screw to 6-10 in/lbs., being careful not to overtighten and ensuring set screw is on flat of pivot pin. If second follow up screw is provided, install and tighten to 6 in/lbs.

TIP: To verify the set screw is located on the flat of the pivot pin, loosen set screw slightly and attempt to pull pivot pin out of tool. The pin should only be able to slide until the set screw stops on the end of the pivot pin flat.



Operating Sequence:

1. With through coolant **OFF** and flood coolant **ON** enter work hole in **clockwise** rotation at **500-800 rpm**.
2. Feed to open area so blade can be opened completely before cutting.
3. Reverse spindle rotation to **counterclockwise** at **500-800 rpm**. Do not stop spindle between changing rotation. Blade will open. After a 1-3 revolution dwell, increase rpm to proper cutting speed. Turn through coolant **ON**.
4. Back feed to counterbore depth. Dwell for 1-3 revolutions to clean up cut.
5. Feed back to open area to clear part. Turn **OFF** through coolant. Leave flood coolant **ON**.
6. Set spindle to **500-800 rpm** and reverse to **clockwise**. Do not stop spindle between changing rotation. Blade will close. Fast feed out to complete

Spare Parts Kits

(Includes: Activator Pin, Activating Rod, Retaining Ring, 3pcs Shear Pins, O-Ring, Pivot Pin)

Part Number	Tool Sizes	Shear Pin
SPK-AF25	25	203020-02
SPK-AF28	28	203020-02
SPK-AF31-34	31, 34	203020-02
SPK-AF38-40	38, 40	204020-02
SPK-AF44-47	44, 47	204020-02
SPK-AF50-53	50, 53	205020-02
SPK-AF56-59	56, 59	205620-02

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