

17570

Countersink milling cutter for backward operation 180°



**ATORN®**

**Type**

- Delivery **without** indexable inserts

**Use**

For rearward countersinking of bores.

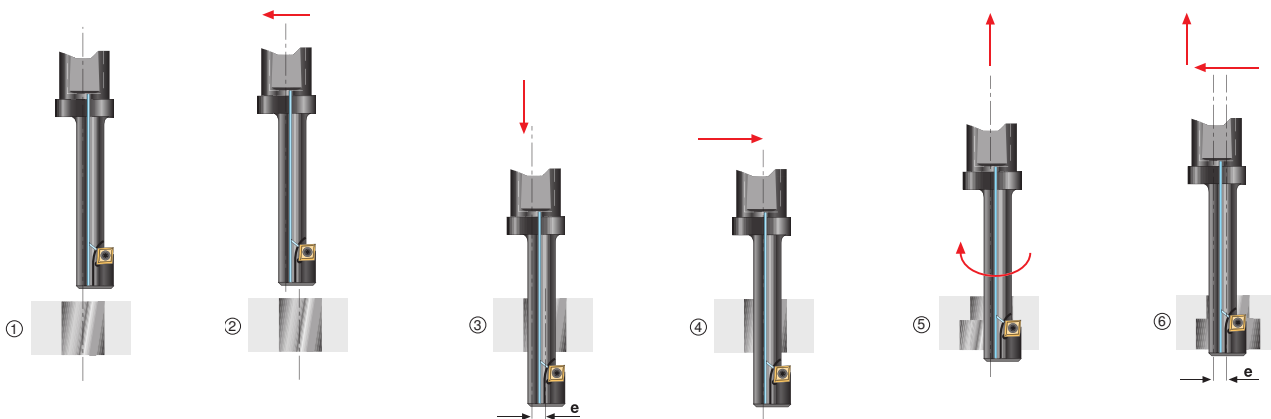
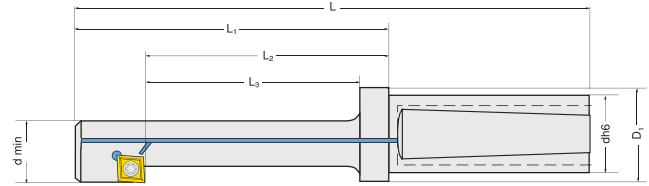
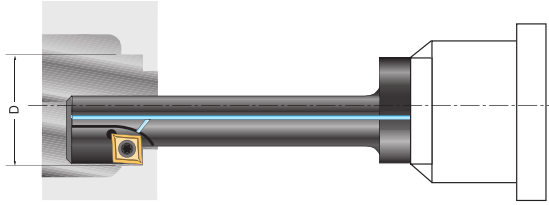
17570 101

Without internal coolant feed.

**Note:**

Indexable inserts  
see cat. no. 18550 ff.

17570



- 1) Position the tool on the centre of the bore. Orientation of spindle: 0°.
- 2) Offset of the tool by the programming dimension (e).
- 3) Plunging to the position below the lower edge of the workpiece with safety distance.
- 4) Move back to the centre of the bore by the dimension (e), then start spindle.
- 5) Countersink to the desired depth.
- 6) Position at safety distance below the lower edge of the workpiece Orientation of spindle: 0°. Subsequent offset of the tool by the programming dimension (e) and extension of the milling cutter.

Ø D mm	d min mm	L mm	L1 mm	L2 mm	L3 mm	dh6 mm	D1 mm	e mm	Indexable inserts	17570	...
18	10,5	112	62	47	40	20	25	4,0	CC.. 0602..		101
20	13,0	117	67	52	45	20	25	3,75	CC.. 0602..		102
24	15,0	122	72	57	50	20	25	4,75	CC.. 0602..		103
26	17,0	132	82	67	60	20	25	5,0	CC.. 0602..		104
30	19,0	142	92	77	65	20	25	6,0	CC.. 0602..		105
33	21,0	152	102	82	75	20	25	6,5	CC.. 09T3..		106
36	23,0	173	113	93	85	32	40	7,0	CC.. 09T3..		107 <b>NEW</b>
40	25,0	183	123	103	95	32	40	8,0	CC.. 09T3..		108 <b>NEW</b>
43	30,0	183	123	103	95	32	40	7,0	CC.. 09T3..		109 <b>NEW</b>
48	33,0	223	163	143	135	32	40	8,0	CC.. 09T3..		110 <b>NEW</b>
53	36,0	210	140	40	110	40	-	9,0	CC.. 1204..		111 <b>NEW</b>
57	39,0	220	150	40	120	40	-	9,5	CC.. 1204..		112 <b>NEW</b>
66	45,0	245	165	50	135	50	-	11,0	CC.. 1204..		113 <b>NEW</b>
76	52,0	265	185	50	155	50	-	12,5	CC.. 1204..		114 <b>NEW</b>

**Spare parts**

For indexable inserts size	TORX® size	Clamping screw	Screwdriver
CC.. 0602..	8	17528	52529
CC.. 09T3..	15	101	403
CC.. 1204..	20	102	406
		103	407

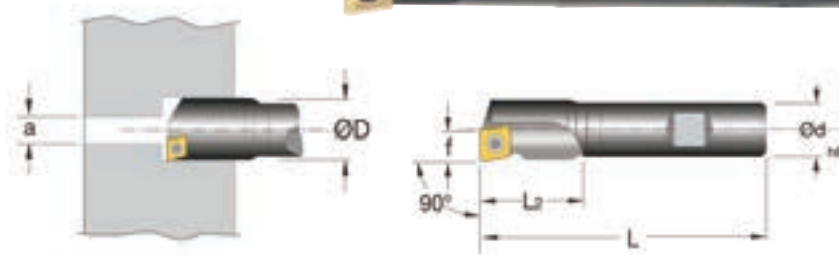


17576 - 17577 Core Drills and Countersinking Cutters

17576 **ATORN®**

**Type**  
 - Single-flute boring bar with internal cooling  
 - Without indexable inserts  
**Hole tolerances:**  
 Indexable insert radius 0,2 mm = +0,05 / -0,10 mm  
 Indexable insert radius 0,4 mm = +0,03 / -0,18 mm  
**Use**  
 For counterboring and core-drilling.

**Note:**  
 Indexable inserts, see cat. no. 18550 ff.



17576

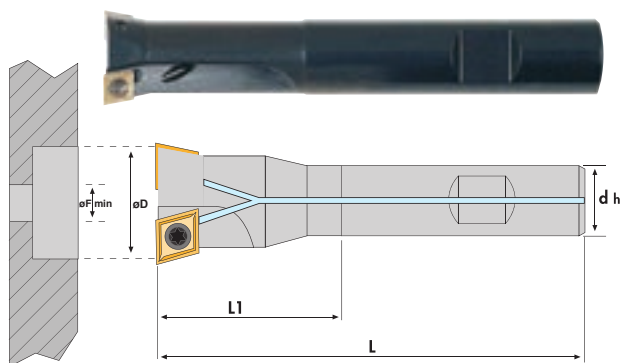
Single cutting									
Ø D	Ø d	a	f	L	L <sub>2</sub>	Indexable inserts	17576	...	
mm	mm	mm	mm	mm	mm				
10	12	4	6,0	85	15	CC.. 0602..			101
11	12	4	6,0	85	16	CC.. 0602..			102
12	10	4	6,0	85	20	CC.. 0602..			103
13	12	5	6,5	85	21	CC.. 0602..			104
14	12	5	7,0	85	21	CC.. 0602..			105
15	12	5	7,5	85	24	CC.. 0602..			106
16	12	5	8,0	85	28	CC.. 0602..			107
17	16	5	8,5	95	40	CC.. 09T3..			108
18	16	5	9,0	95	40	CC.. 09T3..			109
19	16	5	9,5	95	40	CC.. 09T3..			110
20	16	5	10,0	95	40	CC.. 09T3..			111
21	16	5	10,5	95	33	CC.. 09T3..			112

Single cutting									
Ø D	Ø d	a	f	L	L <sub>2</sub>	Indexable inserts	17576	...	
mm	mm	mm	mm	mm	mm				
22	16	6	11,0	95	37	CC.. 09T3..			113
23	16	6	11,5	95	40	CC.. 09T3..			114
24	16	6	12,0	95	34	CC.. 09T3..			115
25	16	8	12,5	95	33	CC.. 09T3..			116
26	20	8	13,0	120	53	CC.. 09T3..			117
27	20	9	13,5	120	56	CC.. 09T3..			118
28	20	10	14,0	120	53	CC.. 09T3..			119
29	20	11	14,5	120	55	CC.. 09T3..			120
30	20	12	15,0	121	57	CC.. 09T3..			121
31	20	14	15,5	120	55	CC.. 09T3..			122
32	20	15	16,0	120	54	CC.. 09T3..			123
33	20	16	16,5	120	55	CC.. 09T3..			124

17577 **ATORN®**

**Type**  
 - Double-edged boring bar with internal cooling  
 - Without indexable inserts  
**Hole tolerances:**  
 Indexable insert radius 0,2 mm = +0,05 / -0,10 mm  
 Indexable insert radius 0,4 mm = +0,03 / -0,18 mm  
**Use**  
 For counterboring and core-drilling.

**Note:**  
 Indexable inserts, see cat. no. 18550 ff.



17577

Double edged						
Ø D	Ø d	Ø F min	L	L <sub>1</sub>	Indexable inserts	17577
mm	mm	mm	mm	mm		
16	12	5	92	30	CC.. 0602..	101 NEW
17	16	6	94	32	CC.. 0602..	102 NEW
18	16	7	97	41	CC.. 0602..	103 NEW
19	16	8	100	41	CC.. 0602..	104 NEW
20	16	9	102	41	CC.. 0602..	105 NEW
21	16	10	105	41	CC.. 0602..	106 NEW
22	16	11	110	41	CC.. 0602..	107 NEW
23	16	12	112	41	CC.. 0602..	108 NEW
24	16	13	115	41	CC.. 0602..	109 NEW
25	16	8	120	40	CC.. 09T3..	110 NEW
26	20	9	125	55	CC.. 09T3..	111 NEW
27	20	10	128	55	CC.. 09T3..	112 NEW
28	20	11	130	55	CC.. 09T3..	113 NEW
29	20	12	132	55	CC.. 09T3..	114 NEW

Double edged						
Ø D	Ø d	Ø F min	L	L <sub>1</sub>	Indexable inserts	17577
mm	mm	mm	mm	mm		
30	20	13	134	55	CC.. 09T3..	115 NEW
31	20	14	136	55	CC.. 09T3..	116 NEW
32	20	15	138	55	CC.. 09T3..	117 NEW
33	20	16	140	55	CC.. 09T3..	118 NEW
34	25	16	140	60	CC.. 09T3..	119 NEW
35	25	17	140	60	CC.. 09T3..	120 NEW
36	25	18	140	60	CC.. 09T3..	121 NEW
37	25	19	140	60	CC.. 09T3..	122 NEW
38	25	20	140	60	CC.. 09T3..	123 NEW
39	25	21	140	60	CC.. 09T3..	124 NEW
40	25	22	140	60	CC.. 09T3..	125 NEW
41	25	23	140	60	CC.. 09T3..	126 NEW
42	25	24	140	60	CC.. 09T3..	127 NEW

Spare parts		Clamping screw	Screwdriver
For indexable inserts size	TORX® size T	17528	52529
CC.. 0602..	8	101	403
CC.. 09T3..	15	102	406



# ATORN®

### Type

- Special steel, nickel-plated
- Adjustment range 2 - 5 mm
- **Without** indexable inserts

### Advantage:

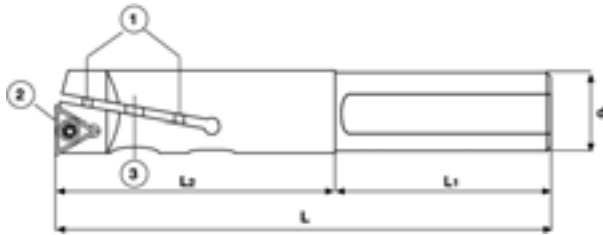
- Cost-effective alternative to spindle tools

### Use

For ISO indexable inserts CCMT and CCGT.

### Note:

Indexable inserts, see cat. no. 18550 ff.



- 1 = Draw bolt,  
2 = Clamping screw,  
3 = Lock screw



D min mm	D max mm	d mm	L mm	L2 mm	L1 mm	Indexable inserts	Holder		Tension screw		Lock screw	
							17578	...	17578	...	17578	...
10	12	10	100	30	70	CC.. 0602..		101		201		301
12	15	12	105	30	70	CC.. 0602..		102		201		302
15	20	16	110	50	60	CC.. 0602..		103		202		303
20	25	20	120	60	60	CC.. 0602..		104		203		304
25	30	25	140	70	70	CC.. 09T3..		105		204		305
30	35	25	160	90	70	CC.. 09T3..		106		205		306
35	40	32	170	100	70	CC.. 09T3..		107		206		307
40	45	32	190	120	70	CC.. 09T3..		108		207		308
45	50	32	220	160	70	CC.. 09T3..		109		208		309

### Spare parts

For indexable inserts size	TORX® size	Clamping screw	Screwdriver
CC.. 0602..	8	17528	52529
CC.. 09T3..	15	101 102	403 406

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