



DRILLS

- Stub Series • Jobber Series
- Long Series • Spotting • Tool Bits



| ISO | VDI | Material Group | Sutton |
|----------|-----|--|--------------|
| P | A | Steel | N |
| M | R | Stainless Steel | VA |
| K | F | Cast Iron | GG |
| N | N | Non-Ferrous Metals, Aluminiums & Coppers | AI W |
| S | S | Titaniums & Super Alloys | TI Ni |
| H | H | Hard Materials (≥ 45 HRC) | H |

Page



^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.

For expert tooling recommendations, go to: www.suttonhps.com

Catalogue Code
Material
Surface Finish
Sutton Designation
Standard
Depth of Cut
Shank Tolerance

| D101 | D102 | D103 | D179 | D109 | D202 | D180 |
|------------|------------|------------|------------------|--------------------|--------------------|------------------|
| HSS | | | HSS Co | | HSSCo | HSS |
| Brt | Blu | TIN | TiAIN Tip | Colour Temp | Colour Temp | TiAIN Tip |
| N | | | | Hard Mat. | N | VA |
| DIN 338 | | | | DIN 338 | DIN 338 | - DIN 338 |
| ≤ 5xØ | | | | ≤ 5xØ | ≤ 5xØ | ≤ 3xØ |
| h9 | | | | - | - | h9 |

| D186 | D126 | D113 |
|------------|-------------|-------------|
| HSS | HSS | HSS |
| Blu | Blu | Blu |
| N | N | N |
| DIN 1897 | ANSI B94-11 | ANSI B94-11 |
| ≤ 3xØ | ≤ 3xØ | 8xØ |
| - | - | h9 |

| ISO | VDI ³³²³ | Material | Condition | HB | N/mm ² | | | | | | | |
|------|------------------------------------|--|-------------------------|----------|-------------------|------|---|---|---|---|---|---|
| P | 1 | Steel - Non-alloy, cast & free cutting | - 0.15 %C | A | 125 | 440 | ● | ● | ● | ● | ● | ● |
| | 2 | | - 0.45 %C | A | 190 | 640 | ● | ● | ● | ● | ● | ● |
| | 3 | | | QT | 250 | 840 | ○ | ● | ● | ● | ● | ○ |
| | 4 | | - 0.75 %C | A | 270 | 910 | ○ | ● | ● | ● | ○ | ○ |
| | 5 | | | QT | 300 | 1010 | | ○ | ○ | ○ | ● | |
| | 6 | Steel - Low alloy & cast < 5% of alloying elements | | A | 180 | 610 | ● | ● | ● | ● | ● | ● |
| | 7 | | | QT | 275 | 930 | ○ | ● | ● | ● | ○ | ○ |
| | 8 | | | QT | 300 | 1010 | | ○ | ○ | ○ | ● | |
| | 9 | | | QT | 350 | 1180 | | ○ | ○ | ○ | ○ | |
| | 10 | Steel - High alloy, cast & tool | | A | 200 | 680 | ○ | ● | ● | ● | ○ | |
| | 11 | | | HT | 325 | 1100 | | ○ | ○ | ○ | ○ | |
| 12 | Steel - Corrosion resistant & cast | Ferritic / Martensitic | A | 200 | 680 | | | | | | ○ | |
| 13 | | Martensitic | QT | 240 | 810 | | ○ | ○ | ○ | ○ | ○ | |
| M | 14.1 | Stainless Steel | Austenitic | AH | 180 | 610 | | ○ | ○ | ○ | ○ | ● |
| | 14.2 | | Duplex | | 250 | 840 | | ○ | ○ | ○ | ○ | ● |
| | 14.3 | | Precipitation Hardening | | 250 | 840 | | | | | | ○ |
| K | 15 | Cast Iron - Grey (GG) | Ferritic / Pearlitic | | 180 | 610 | ○ | ○ | ● | ● | ○ | ○ |
| | 16 | | Pearlitic | | 260 | 880 | | ○ | ○ | ○ | ○ | ○ |
| | 17 | Cast Iron - Nodular (GGG) | Ferritic | | 160 | 570 | ○ | ○ | ● | ● | ○ | ○ |
| | 18 | | Pearlitic | | 250 | 840 | | ○ | ○ | ○ | ○ | ○ |
| | 19 | Cast Iron - Malleable | Ferritic | | 130 | 460 | | ○ | ● | ● | ○ | ○ |
| 20 | Pearlitic | | | 230 | 780 | | ○ | ○ | ○ | ○ | ○ | |
| N | 21 | Aluminum & Magnesium - wrought alloy | Non Heat Treatable | | 60 | 210 | ● | ○ | | | ● | ● |
| | 22 | | Heat Treatable | AH | 100 | 360 | ● | ○ | | | ● | ● |
| | 23 | Aluminum & Magnesium - cast alloy ≤12% Si | Non Heat Treatable | | 75 | 270 | ○ | ○ | ○ | ○ | ○ | ● |
| | 24 | | Heat Treatable | AH | 90 | 320 | ○ | | ○ | ○ | ○ | ● |
| | 25 | Al & Mg - cast alloy >12% Si | Non Heat Treatable | | 130 | 460 | ○ | | ○ | ○ | ○ | ○ |
| | 26 | Copper & Cu alloys (Brass/Bronze) | Free cutting, Pb > 1% | | 110 | 390 | ○ | | ○ | ○ | ○ | ○ |
| | 27 | | Brass (CuZn, CuSnZn) | | 90 | 320 | ○ | | ○ | ● | ○ | ○ |
| | 28 | | Bronze (CuSn) | | 100 | 360 | ○ | | ○ | ○ | ○ | ○ |
| | 29 | Non-metallic - Thermosetting & fiber-reinforced plastics | | | | | ○ | ○ | ○ | ○ | ○ | ○ |
| | 30 | Non-metallic - Hard rubber, wood etc. | | | | | | | | | | |
| S | 31 | High temp. alloys | Fe based | A | 200 | 680 | | | | | | |
| | 32 | | | AH | 280 | 950 | | | | | | |
| | 33 | | Ni / Co based | A | 250 | 840 | | | | | | |
| | 34 | | | AH | 350 | 1180 | | | | | | |
| | 35 | | | C | 320 | 1080 | | | | | | |
| | 36 | Titanium & Ti alloys | CP Titanium | | 400 MPa | | | | | | | |
| 37.1 | Alpha alloys | | | 860 MPa | | | | | | | | |
| 37.2 | Alpha / Beta alloys | | A | 960 MPa | | | | | | | | |
| 37.3 | | | AH | 1170 MPa | | | | | | | | |
| 37.4 | Beta alloys | | A | 830 MPa | | | | | | | | |
| 37.5 | | AH | 1400 MPa | | | | | | | | | |
| H | 38.1 | Hardened steel | HT | 45 HRC | | | | | ○ | | | |
| | 38.2 | | HT | 55 HRC | | | | | | | | |
| | 39.1 | | HT | 58 HRC | | | | | | | | |
| | 39.2 | | HT | 62 HRC | | | | | | | | |
| | 40 | Cast Iron | Chilled | C | 400 | 1350 | ○ | ○ | ○ | ○ | ○ | ○ |
| 41 | HT | | 55 HRC | | | | | | | | | |

Condition: A (Annealed), AH (Age Hardened), C (Cast), HT (Hardened & Tempered), QT (Quenched & Tempered)

Drills Sets - Metric

sutton



D101 SM1



D101 SM2



D101 SM3



D101 MTL SM2



D101 MTL SM3



D105 VRKM2



D105 VRKM3



D101 SM7



D102 SM1



D102 SM2



D102 SM3



D102 SM8



D102 SM30



D102 SM41



D102 SM99



D102 SM101



D103 SM3



D105 SLV7M



D105 SLV10M



D105 SLV13M



D105 V2M



D105 V3M



D109 SM2



D109 SM3



D179 SM2



D179 SM3



D180 SM2



D180 SM3

Drills Sets - Imperial

sutton



D101 S2



D101 S3



D101 MTL S2*



D101 MTL S3*



D101 S30



D101 S31



D105 VRK1



D105 VRK2



D105 VRK3



D101 S7



D102 S2



D102 S3



D102 S8



D103 S3



D105 SLV7



D105 SLV13



D105 V2



D105 V3



D109 S2



D109 S3



D179 S2



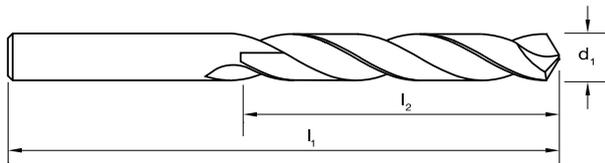
D179 S3

Drills Jobber, Heavy Duty

sutton



- Heavy duty design
- Cobalt content ensures high abrasion resistance
- Suitable for hard materials up to 850N/mm²
- Self centring 135° split point



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Point Type
Order Quantity

| |
|----------------------------------|
| D109 |
| A0404 |
| HSS Co |
| Colour Temp |
| Hard Materials |
| R25 |
| 135° Form C > 3/32" ≥ 3.0 ≥ 1/8" |
| Bulk (10) |

| Size Ref. | d ₁ (h8) mm inch | L ₁ | L ₂ | Item # |
|-----------|--------------------------------|----------------|----------------|-----------|
| 0100 | 1.00* | 34 | 12 | D109 0100 |
| 0110 | 1.10* | 36 | 14 | D109 0110 |
| 0120 | 1.20* | 38 | 16 | D109 0120 |
| 0130 | 1.30* | 38 | 16 | D109 0130 |
| 0140 | 1.40* | 40 | 18 | D109 0140 |
| 0150 | 1.50* | 40 | 18 | D109 0150 |
| 0159 | 1.59* 1/16 | 43 | 20 | D109 0159 |
| 0160 | 1.60* | 43 | 20 | D109 0160 |
| 0170 | 1.70* | 43 | 20 | D109 0170 |
| 0180 | 1.80* | 46 | 22 | D109 0180 |
| 0190 | 1.90* | 46 | 22 | D109 0190 |
| 0198 | 1.98* 5/64 | 49 | 24 | D109 0198 |
| 0200 | 2.00* | 49 | 24 | D109 0200 |
| 0205 | 2.05* | 49 | 24 | D109 0205 |
| 0210 | 2.10* | 49 | 24 | D109 0210 |
| 0220 | 2.20* | 53 | 27 | D109 0220 |
| 0230 | 2.30* | 53 | 27 | D109 0230 |
| 0238 | 2.38* 3/32 | 57 | 30 | D109 0238 |
| 0240 | 2.40* | 57 | 30 | D109 0240 |
| 0250 | 2.50 | 57 | 30 | D109 0250 |
| 0260 | 2.60 | 57 | 30 | D109 0260 |
| 0270 | 2.70 | 61 | 33 | D109 0270 |
| 0278 | 2.78 7/64 | 61 | 33 | D109 0278 |
| 0280 | 2.80 | 61 | 33 | D109 0280 |
| 0290 | 2.90 | 61 | 33 | D109 0290 |
| 0300 | 3.00 | 61 | 33 | D109 0300 |
| 0310 | 3.10 | 65 | 36 | D109 0310 |
| 0318 | 3.18 1/8 | 65 | 36 | D109 0318 |
| 0320 | 3.20 | 65 | 36 | D109 0320 |
| 0330 | 3.30 | 65 | 36 | D109 0330 |
| 0340 | 3.40 | 70 | 39 | D109 0340 |
| 0350 | 3.50 | 70 | 39 | D109 0350 |
| 0357 | 3.57 9/64 | 70 | 39 | D109 0357 |
| 0360 | 3.60 | 70 | 39 | D109 0360 |
| 0370 | 3.70 | 70 | 39 | D109 0370 |
| 0380 | 3.80 | 75 | 43 | D109 0380 |
| 0390 | 3.90 | 75 | 43 | D109 0390 |
| 0397 | 3.97 5/32 | 75 | 43 | D109 0397 |
| 0400 | 4.00 | 75 | 43 | D109 0400 |
| 0410 | 4.10 | 75 | 43 | D109 0410 |

| Size Ref. | d ₁ (h8) mm inch | L ₁ | L ₂ | Item # |
|-----------|--------------------------------|----------------|----------------|-----------|
| 0420 | 4.20 | 75 | 43 | D109 0420 |
| 0430 | 4.30 | 80 | 47 | D109 0430 |
| 0437 | 4.37 11/64 | 80 | 47 | D109 0437 |
| 0440 | 4.40 | 80 | 47 | D109 0440 |
| 0450 | 4.50 | 80 | 47 | D109 0450 |
| 0460 | 4.60 | 80 | 47 | D109 0460 |
| 0470 | 4.70 | 80 | 47 | D109 0470 |
| 0476 | 4.76 3/16 | 86 | 52 | D109 0476 |
| 0480 | 4.80 | 86 | 52 | D109 0480 |
| 0490 | 4.90 | 86 | 52 | D109 0490 |
| 0500 | 5.00 | 86 | 52 | D109 0500 |
| 0510 | 5.10 | 86 | 52 | D109 0510 |
| 0516 | 5.16 13/64 | 86 | 52 | D109 0516 |
| 0520 | 5.20 | 86 | 52 | D109 0520 |
| 0530 | 5.30 | 86 | 52 | D109 0530 |
| 0540 | 5.40 | 93 | 57 | D109 0540 |
| 0550 | 5.50 | 93 | 57 | D109 0550 |
| 0556 | 5.56 7/32 | 93 | 57 | D109 0556 |
| 0560 | 5.60 | 93 | 57 | D109 0560 |
| 0570 | 5.70 | 93 | 57 | D109 0570 |
| 0580 | 5.80 | 93 | 57 | D109 0580 |
| 0590 | 5.90 | 93 | 57 | D109 0590 |
| 0595 | 5.95 15/64 | 93 | 57 | D109 0595 |
| 0600 | 6.00 | 93 | 57 | D109 0600 |
| 0610 | 6.10 | 101 | 63 | D109 0610 |
| 0620 | 6.20 | 101 | 63 | D109 0620 |
| 0630 | 6.30 | 101 | 63 | D109 0630 |
| 0635 | 6.35 1/4 | 101 | 63 | D109 0635 |
| 0640 | 6.40 | 101 | 63 | D109 0640 |
| 0650 | 6.50 | 101 | 63 | D109 0650 |
| 0660 | 6.60 | 101 | 63 | D109 0660 |
| 0670 | 6.70 | 101 | 63 | D109 0670 |
| 0676 | 6.75 17/64 | 109 | 69 | D109 0676 |
| 0680 | 6.80 | 109 | 69 | D109 0680 |
| 0690 | 6.90 | 109 | 69 | D109 0690 |
| 0700 | 7.00 | 109 | 69 | D109 0700 |
| 0710 | 7.10 | 109 | 69 | D109 0710 |
| 0714 | 7.14 9/32 | 109 | 69 | D109 0714 |
| 0720 | 7.20 | 109 | 69 | D109 0720 |
| 0730 | 7.30 | 109 | 69 | D109 0730 |

| ISO | P | | | | | | | | | | | | | M | | | | | K | | | | | N | | | | | | | | | | S | | | | | | | | | | H | | | | | | | | | | | |
|----------|---|---|---|---|---|---|---|---|---|----|----|----|----|------|------|------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|------|------|------|------|------|------|------|------|------|----|----|--|--|--|--|--|--|
| VDI 3323 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14.1 | 14.2 | 14.3 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37.1 | 37.2 | 37.3 | 37.4 | 37.5 | 38.1 | 38.2 | 39.1 | 39.2 | 40 | 41 | | | | | | |
| D109 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials

● Optimal
 ○ Effective

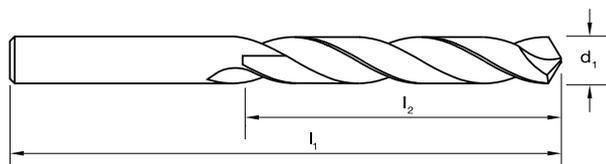
* Standard 135° point below 3/00"

Drills Jobber, Heavy Duty

sutton



- Heavy duty design
- Cobalt content ensures high abrasion resistance
- Suitable for hard materials up to 850N/mm²
- Self centring 135° split point



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Point Type
Order Quantity

| |
|-----------------------|
| D109 |
| A0404 |
| HSS Co |
| Colour Temp |
| Hard Materials |
| R25 |
| 135° Form C > 3/32* |
| Bulk 10 (5 > 7.5mm) |

| Size Ref. | d ₁ (h8) | l ₁ | l ₂ | Item # |
|-----------|---------------------|----------------|----------------|-----------|
| | mm inch | | | |
| 0740 | 7.40 | 109 | 69 | D109 0740 |
| 0750 | 7.50 | 109 | 69 | D109 0750 |
| 0754 | 7.54 19/64 | 117 | 75 | D109 0754 |
| 0760 | 7.60 | 117 | 75 | D109 0760 |
| 0770 | 7.70 | 117 | 75 | D109 0770 |
| 0780 | 7.80 | 117 | 75 | D109 0780 |
| 0790 | 7.90 | 117 | 75 | D109 0790 |
| 0794 | 7.94 5/16 | 117 | 75 | D109 0794 |
| 0800 | 8.00 | 117 | 75 | D109 0800 |
| 0810 | 8.10 | 117 | 75 | D109 0810 |
| 0820 | 8.20 | 117 | 75 | D109 0820 |
| 0830 | 8.30 | 117 | 75 | D109 0830 |
| 0833 | 8.33 21/64 | 117 | 75 | D109 0833 |
| 0840 | 8.40 | 117 | 75 | D109 0840 |
| 0850 | 8.50 | 117 | 75 | D109 0850 |
| 0860 | 8.60 | 125 | 81 | D109 0860 |
| 0870 | 8.70 | 125 | 81 | D109 0870 |
| 0873 | 8.73 11/32 | 125 | 81 | D109 0873 |
| 0880 | 8.80 | 125 | 81 | D109 0880 |
| 0890 | 8.90 | 125 | 81 | D109 0890 |
| 0900 | 9.00 | 125 | 81 | D109 0900 |
| 0910 | 9.10 | 125 | 81 | D109 0910 |
| 0913 | 9.13 23/64 | 125 | 81 | D109 0913 |
| 0920 | 9.20 | 125 | 81 | D109 0920 |
| 0930 | 9.30 | 125 | 81 | D109 0930 |
| 0940 | 9.40 | 125 | 81 | D109 0940 |
| 0950 | 9.50 | 125 | 81 | D109 0950 |
| 0953 | 9.52 3/8 | 133 | 87 | D109 0953 |
| 0960 | 9.60 | 133 | 87 | D109 0960 |
| 0970 | 9.70 | 133 | 87 | D109 0970 |
| 0980 | 9.80 | 133 | 87 | D109 0980 |
| 0990 | 9.90 | 133 | 87 | D109 0990 |
| 0992 | 9.92 25/64 | 133 | 87 | D109 0992 |
| 1000 | 10.00 | 133 | 87 | D109 1000 |
| 1010 | 10.10 | 133 | 87 | D109 1010 |
| 1020 | 10.20 | 133 | 87 | D109 1020 |
| 1030 | 10.30 | 133 | 87 | D109 1030 |
| 1032 | 10.32 13/32 | 133 | 87 | D109 1032 |
| 1040 | 10.40 | 133 | 87 | D109 1040 |
| 1050 | 10.50 | 133 | 87 | D109 1050 |

| Size Ref. | d ₁ (h8) | l ₁ | l ₂ | Item # |
|-----------|---------------------|----------------|----------------|-----------|
| | mm inch | | | |
| 1060 | 10.60 | 133 | 87 | D109 1060 |
| 1070 | 10.70 | 142 | 94 | D109 1070 |
| 1072 | 10.72 27/64 | 142 | 94 | D109 1072 |
| 1080 | 10.80 | 142 | 94 | D109 1080 |
| 1090 | 10.90 | 142 | 94 | D109 1090 |
| 1100 | 11.00 | 142 | 94 | D109 1100 |
| 1111 | 11.11 7/16 | 142 | 94 | D109 1111 |
| 1110 | 11.10 | 142 | 94 | D109 1110 |
| 1120 | 11.20 | 142 | 94 | D109 1120 |
| 1130 | 11.30 | 142 | 94 | D109 1130 |
| 1140 | 11.40 | 142 | 94 | D109 1140 |
| 1150 | 11.50 | 142 | 94 | D109 1150 |
| 1151 | 11.51 29/64 | 142 | 94 | D109 1151 |
| 1160 | 11.60 | 142 | 94 | D109 1160 |
| 1170 | 11.70 | 142 | 94 | D109 1170 |
| 1180 | 11.80 | 142 | 94 | D109 1180 |
| 1190 | 11.90 | 142 | 94 | D109 1190 |
| 1191 | 11.91 15/32 | 151 | 101 | D109 1191 |
| 1200 | 12.00 | 151 | 101 | D109 1200 |
| 1210 | 12.10 | 151 | 101 | D109 1210 |
| 1220 | 12.20 | 151 | 101 | D109 1220 |
| 1230 | 12.30 | 151 | 101 | D109 1230 |
| 1231 | 12.30 31/64 | 149 | 111 | D109 1231 |
| 1240 | 12.40 | 151 | 101 | D109 1240 |
| 1250 | 12.50 | 151 | 101 | D109 1250 |
| 1260 | 12.60 | 151 | 101 | D109 1260 |
| 1270 | 12.70 1/2 | 151 | 101 | D109 1270 |
| 1280 | 12.80 | 151 | 101 | D109 1280 |
| 1290 | 12.90 | 151 | 101 | D109 1290 |
| 1300 | 13.00 | 151 | 101 | D109 1300 |

| ISO | P | | | | | | | | | | | | | M | | | K | | | | | | | N | | | | | | | S | | | | | | | H | | | | | | | | | | | | | | | | |
|----------|---|---|---|---|---|---|---|---|---|----|----|----|----|------|------|------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|------|------|------|------|------|------|------|------|------|----|----|--|--|--|--|--|
| VDI 3323 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14.1 | 14.2 | 14.3 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37.1 | 37.2 | 37.3 | 37.4 | 37.5 | 38.1 | 38.2 | 39.1 | 39.2 | 40 | 41 | | | | | |
| D109 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials

● Optimal
 ○ Effective

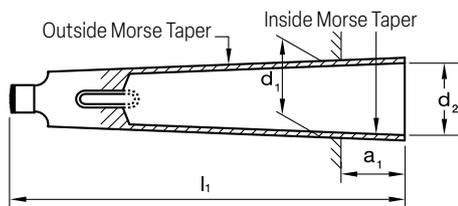
Drills Morse Taper Accessories



Morse Taper Sleeve

- Hardened alloy steel
- Precision ground internally and externally

Drill Drift key - to eject Morse Taper drills from sleeves, sockets and machine spindles



| | | |
|--------------------|--------------|----------------------|
| Catalogue Code | D142 | D118 |
| Discount Group | A0702 | A0702 |
| Material | - | Alloyed Steel |
| Surface Finish | Br | Br |
| Sutton Designation | Drift | Sleeve |
| Geometry | - | - |
| Point Type | - | - |
| Shank Tolerance | - | - |

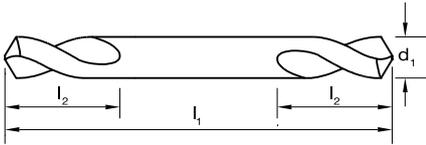
| Size Ref. | MT # (internal) | MT # (external) | d ₁ | l ₁ | a ₁ | d ₂ | Item # | Item # |
|-----------|--------------------|--------------------|----------------|----------------|----------------|----------------|--------|-----------|
| 0012 | 1 | 2 | 17.780 | 92 | 17 | 12.065 | | D118 0012 |
| 0013 | 1 | 3 | 23.825 | 99 | 5 | 12.065 | | D118 0013 |
| 0023 | 2 | 3 | 23.825 | 112 | 18 | 17.78 | | D118 0023 |
| 0014 | (1)* | 4 | 31.267 | 124 | 6.5 | 12.065 | | D118 0014 |
| 0024 | 2 | 4 | 31.267 | 124 | 6.5 | 17.78 | | D118 0024 |
| 0034 | 3 | 4 | 31.267 | 140 | 22.5 | 23.825 | | D118 0034 |
| 0015 | (1)* | 5 | 44.399 | 156 | 6.5 | 12.065 | | D118 0015 |
| 0025 | (2)* | 5 | 44.399 | 156 | 6.5 | 17.78 | | D118 0025 |
| 0035 | 3 | 5 | 44.399 | 156 | 6.5 | 23.825 | | D118 0035 |
| 0045 | 4 | 5 | 44.399 | 171 | 21.5 | 31.267 | | D118 0045 |
| 0036 | 3 | 6 | 63.348 | 218 | 8 | 23.825 | | D118 0036 |
| 0046 | 4 | 6 | 63.348 | 218 | 8 | 31.267 | | D118 0046 |
| 0056 | 5 | 6 | 63.348 | 218 | 8 | 44.399 | | D118 0056 |

| | | |
|-----|------------|----------|
| MT1 | MT #1 & #2 | D142 MT1 |
| MT3 | MT #3 | D142 MT3 |
| MT4 | MT #4 | D142 MT4 |

Drills Panel, Double Ended



- Double ended rigid design for through hole drilling
- Ideal for rivet holes in sheet metal fabrication
- Recommended for shallow holes no deeper than 1-1/4 x d₁
- Tpoint drills require fully tightened chuck jaws



| | |
|----------------------------|---------------------|
| Catalogue Code | D130 |
| Discount Group | A0802 |
| Material | HSS Co |
| Surface Finish | Colour Temp |
| Sutton Designation | Tough Steels |
| Geometry | - |
| Point Type | 135° Standard |
| Packaging & Order Quantity | Bulk (10) |

| Size Ref. | d ₁ (h8) | | l ₁ | l ₂ | d ₂ | Rivet Size | Item # |
|-------------|---------------------|------------|----------------|----------------|----------------|--------------|-----------|
| 0318 | 3.18 | 1/8 | 54 | 19 | 3.18 | 3.00 | D130 0318 |
| 0326 | 3.26 | #30 | 54 | 19 | 3.26 | 3.18 (1/8") | D130 0326 |
| 0409 | 4.09 | #20 | 54 | 22 | 4.09 | 3.97 (5/32") | D130 0409 |
| 0485 | 4.85 | #11 | 54 | 22 | 4.85 | 4.76 (3/16") | D130 0485 |

| ISO | P | | | | | | | | | | | | | M | | | K | | | N | | | | | | S | | | | | | H | | | | | | | | | | | | | | | | | |
|-------------|---|---|---|---|---|---|---|---|---|----|----|----|----|------|------|------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|------|------|------|------|------|------|------|------|------|----|----|
| VDI 3323 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14.1 | 14.2 | 14.3 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37.1 | 37.2 | 37.3 | 37.4 | 37.5 | 38.1 | 38.2 | 39.1 | 39.2 | 40 | 41 |
| D130 | ● | ● | ● | ● | ● | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ |

P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials
 ● Optimal ○ Effective

Tool Bits Turning & Machining



M2 HSS

- Recommended for turning or machining of low-alloy and free-machining steels and most non-ferrous materials.

M42 CoHSS

- Can withstand high cutting speeds
- Especially suited to production turning of high alloy steels and other materials



| | | |
|----------------|---------------|------------------|
| Catalogue Code | M301 | M302 |
| Discount Group | Z0802 | Z0802 |
| Material | M2 HSS | M42 CoHSS |
| Surface Finish | Brt | Brt |
| Geometry | Square | Square |
| Order Quantity | 1 | 1 |

| Size Ref. | Size | Length | Item # | Item # |
|-----------|------|--------|-----------|-----------|
| 0472 | 3/16 | 2-1/2 | M301 0472 | |
| 0473 | 3/16 | 3 | | M302 0473 |
| 0632 | 1/4 | 2-1/2 | M301 0632 | M302 0632 |
| 0633 | 1/4 | 3 | | M302 0633 |
| 0634 | 1/4 | 4 | | M302 0634 |
| 0792 | 5/16 | 2-1/2 | M301 0792 | M302 0792 |
| 0793 | 5/16 | 3 | | M302 0793 |
| 0794 | 5/16 | 4 | | M302 0794 |
| 0953 | 3/8 | 3 | M301 0953 | M302 0953 |
| 0954 | 3/8 | 4 | | M302 0954 |
| 0956 | 3/8 | 6 | | M302 0956 |
| 1274 | 1/2 | 4 | M301 1274 | M302 1274 |
| 1276 | 1/2 | 6 | | M302 1276 |
| 1584 | 5/8 | 4-1/2 | M301 1584 | M302 1584 |
| 1905 | 3/4 | 5 | | M302 1905 |
| 2547 | 1 | 7 | | M302 2547 |

Tool Bits Turning & Machining



M2 HSS

- Recommended for turning or machining of low-alloy and free-machining steels and most non-ferrous materials.

M42 CoHSS

- Can withstand high cutting speeds
- Especially suited to production turning of high alloy steels and other materials



| | | |
|----------------|---------------|------------------|
| Catalogue Code | M300 | M304* |
| Discount Group | Z0802 | Z0802 |
| Material | M2 HSS | M35 CoHSS |
| Surface Finish | Brt | Brt |
| Geometry | Round | Bevel |
| Order Quantity | 5 | 1 |

| Size Ref. | Size | Length | Width | Item # | Item # |
|-----------|------|--------|-------|------------|-----------|
| 0233 | 3/32 | 3 | | M300 0233* | |
| 0313 | 1/8 | 3 | | M300 0313* | |
| 0474 | 3/16 | 4 | | M300 0474 | |
| 0634 | 1/4 | 4 | | M300 0634 | |
| 0794 | 5/16 | 4 | | M300 0794 | |
| 0954 | 3/8 | 4 | | M300 0954 | |
| 1114 | 7/16 | 4 | | M300 1114* | |
| 1274 | 1/2 | 4 | | M300 1274 | |
| 1274 | 1/2 | 4-1/2 | 3/32 | | M304 1274 |
| 1584 | 5/8 | 5 | 3/32 | | M304 1584 |
| 1906 | 3/4 | 6 | 1/8 | | M304 1906 |
| 2227 | 7/8 | 7 | 1/8 | | M304 2227 |
| 2548 | 1 | 8 | 3/16 | | M304 2548 |

* Not available once current stock is depleted

