

we've made it easier to find the right tool fast...

For easy tool reference, you will find an extensive application based index at the start of each section.

These icons below can be found on the product pages throughout the catalogue, and at a glance the characteristic features of the tool can be identified.

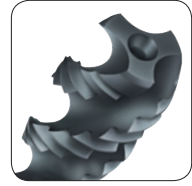
Standard	Sutton Standard	German Standard	International Standard	American Standard	British Standard	Japanese Standard					
Length	Stub	Regular	Long	Extra Long							
Shank	Plain	Form B	Form HB	Form HE	Threaded	Stepped	Reduced	Tanged	Morse Taper	Square Drive	
Colour Band	UNI	VA	H	AI	W	Cu	GG				
Depth	3 x diameter	4 x diameter	5 x diameter	6 x diameter	8 x diameter	10 x diameter	12 x diameter	14 x diameter			
Drill Application	Standard	(DIN 1412)				Carbide					
	Facet	Normal	Form A	Form B	Form C	Special	Normal	IK			
	Radius Lips										
Tap Application	Blind Hole Straight Flute	Through Hole Straight Flute	Through Hole Gun	Blind Hole Spiral Flute	Thread Forming	Countersink Geometry			Crosshole	Single Flute	3 Flutes
	High Speed Cutting	Z-Axis Control	Deep Hole	Single Coolant Groove	Multi Coolant Groove	Internal Coolant			Internal Coolant (Helical)	Internal Coolant (Axial)	Internal Coolant (Radial)
Thread Forms	Metric Coarse	Metric Fine	Unified Coarse	Unified Fine	Unified Series	Unified Extra Fine	(BSPF)	Whitworth Coarse	Whitworth Fine		
	British Association	British Standard Brass	Steel Conduit	(BSPL) Sealing Pipe	(BSPT)	Dryseal Straight	National Pipe Taper	Dryseal Taper			
Endmill Application	Cutting Directions	Slotting	Profiling	Finishing	Universal	Roughing	Geometry	Unequal	Radius	45°	Reduced Neck
	Cutting Edge Forms	HR	HRS	NF	NR	STF	Ti	VA	WR	Micro Geometry	Rake Correction

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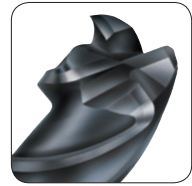
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Countersinks 倒角刀								
C108	35	A1108	○	Countersink, Three Flute, UNI	90°	HSS Co	TiAIN	DIN335
Drills 钻头								
D151	26	A1006	NH	Drill, Stub, CNC	130° Form B	HSS Co	TiAIN	DIN1897
D153	26	A1502	○	Drill, Stub, R40 VA, <i>Black Magic</i>	4 Facet	HSS Co	TiAIN	DIN1897
D155	26	A1502	○	Drill, Stub, R40 UNI	130° 4 Facet Form B	SPM	TiAIN	DIN1897
D163	29	A0418	NH	Drill, Jobber, DHJ	130° Form B	HSS Co	TiAIN	DIN338
D165	29	A0418	WN	Drill, Jobber, DXJ	130° Form A	HSS Co	TiAIN	DIN338
D168	29	A1502	○	Drill, Jobber, R40 UNI	130° 4 Facet Form B	SPM	TiAIN	DIN338
D169	29	A1502	○	Drill, Jobber, R40 VA, <i>Black Magic</i>	4 Facet Form C	HSS Co	TiAIN	DIN338
D170	32	A0504	NH	Drill, Long Series, DHL	130° Form B	HSS Co	BrT	DIN340
D171	32	A0508	NH	Drill, Long Series, DHL	130° Form B	HSS Co	TiAIN	DIN340
D175	35	A1124		Drill, NC Spotting	90°	HSS Co	TiN	DIN1897
D176	35	A1124		Drill, NC Spotting	120°	HSS Co	TiN	DIN1897
D177	26	A1006	WN	Drill, Stub, DXS	130° Form A	HSS Co	TiAIN	DIN1897
D191	33	A0502	NH	Drill, Extra Long, DHXL-1	130° Form B	HSS	Ni + Blu	DIN1869-1
D192	33	A0502	NH	Drill, Extra Long, DHXL-2	130° Form B	HSS	Ni + Blu	DIN1869-2
D193	33	A0502	NH	Drill, Extra Long, DHXL-3	130° Form B	HSS	Ni + Blu	DIN1869-3
D194	34	A0508	NH	Drill, Extra Long, DHXL-1	130° Form B	HSS Co	TiAIN	DIN1869-1
D195	34	A0508	NH	Drill, Extra Long, DHXL-2	130° Form B	HSS Co	TiAIN	DIN1869-2
D196	34	A0508	NH	Drill, Extra Long, DHXL-3	130° Form B	HSS Co	TiAIN	DIN1869-3
D323	18	A0210		Drill, 3xD, Shank Form HA	140° Form C	VHM	AlCrN	DIN6537
D326	21	A0210		Drill, 5xD, Shank Form HA	140° Form C	VHM	AlCrN	DIN6537
D329	18	A0210		Drill, 3xD, Shank Form HA, IK	140° Form C	VHM	AlCrN	DIN6537
D332	21	A0210		Drill, 5xD, Shank Form HA, IK	140° Form C	VHM	AlCrN	DIN6537
D335	24	A0210		Drill, 8xD, Shank Form HA, IK	140° Form C	VHM	AlCrN	DIN6537
D356	18	A0210	○	Drill, 3xD, HA Shank, VA <i>Black Magic</i>	140° 4 Facet Form C	VHM	HELICA	DIN6537
D358	21	A0210	○	Drill, 5xD, HA Shank, VA <i>Black Magic</i>	140° 4 Facet Form C	VHM	HELICA	DIN6537
D364	35	A0210		Drill, NC Spotting	90°	VHM	AlCrN	~DIN1897
D366	35	A0210		Drill, NC Spotting	142°	VHM	AlCrN	~DIN1897
D371	25	A0210		Drill, 12xD, Shank Form HA, IK	135° Form C	VHM	AlCrN Tip	-

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Endmills 铣刀								
E310	41	B0208	○	Slot Drill, Long, 2 Flute, R40, AlCarb	DIN 6535-HA	VHM	BrT	DIN6527L
E400	41	B0210	○	Endmill, Long, 3 Flute, R45/46/44-Al, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	CrN	DIN6527L
E402	41	B0210	○	Endmill, Long Reach, 3 Flute, R45/46/44-Al, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	CrN	-
E404	41	B0210	○	Rougher, Long, 3 Flute, R35/36/36-Al HR, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	CrN	DIN6527L
E408	41	B0210	○	Endmill, Long Reach, Ballnose, 3 Flute, R45/46/44-Al, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	CrN	-
E410	40	B0210	○	Endmill, Long, 3 Flute, R55/54/56-VA, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	DIN6527L
E412	40	B0210	○	Endmill, Long, 4 Flute, R55-VA, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	DIN6527L
E414	40	B0210	○	Endmill, Long Reach, 4 Flute, R55-VA, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	-
E416	40	B0210	○	Rougher, Long, 3 Flute, R35/36/36-Al HR, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	DIN6527L
E418	38	B0210	○	Slot Drill, Long Reach, 2 Flute, R30, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	-
E420	38	B0210	○	Slot Drill, Long Reach, 2 Flute, R30, Corner Rad, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	-
E422	36	B0210	○	Endmill, Short, 3 Flute, R38/37/39, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	DIN6527K
E424	36	B0210	○	Endmill, Long, 3 Flute, R38/37/39, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	DIN6527L
E426	36	B0210	○	Endmill, Long, 4 Flute, R45/44, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	DIN6527L
E428	43	B0210	○	Endmill, Long, 4 Flute, R55-NH, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	DIN6527L
E430	39	B0210	○	Endmill, Long Reach, 4 Flute, R45/44, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	-
E432	43	B0210	○	Endmill, Long, 6-8 Flute, R50/35-NH, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	DIN6527L
E434	43	B0210	○	Endmill, Extra Long, 6-8 Flute, R50/35-NH, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	-
E436	43	B0210	○	Endmill, Long Reach, 6-8 Flute, R50/35-NH, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AlCrN	-
E456	45	B0210		Endmill Chamfer, 4 Flute, 90°	DIN 6535-HA	VHM	TiAIN	-

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E457	45	B0210		Endmill Chamfer, 4 Flute, 60°	DIN 6535-HA	VHM	TiAIN	-
E458	45	B0210		Endmill Chamfer, 4 Flute, Corner Rad	DIN 6535-HA	VHM	TiAIN	-
E459	40	B0210	○	Endmill, Long, 4 Flute, R40/42-VA, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	DIN6527L
E462	37	B0210	○	Endmill, Long, 4 Flute, R40/42-VA Corner Rad, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Helica	DIN6527L
E533	36	B0210	○	Endmill, Short, 4 Flute, R35/38, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AICrN	DIN6527K
E535	36	B0210	○	Endmill, Long, 4 Flute, R35/38, <i>Harmony</i>	DIN 1835-HA	VHM-ULTRA	AICrN	DIN6527L
E543	43	B0210	○	Endmill, Long, 6-8 Flute, R45, VH <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AICrN	DIN6527L
E545	36	B0210	○	Endmill, Long, 4 Flute, R45-STF, <i>Harmony</i>	DIN 1835-HA	VHM-ULTRA	AICrN	DIN6527L
E549	36	B0210	○	Rougher, Long, 3-6 Flute, R45-HRS, <i>Harmony</i>	DIN 1835-HA	VHM-ULTRA	AICrN	DIN6527L
E559	37	B0210	○	Endmill, Long, 4 Flute, R35/38 Corner Rad, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AICrN	DIN6527L
E562	42	B0210	○	Endmill, Long, 4 Flute, R50-NH DUO, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AICrN	DIN6527L
E564	42	B0210	○	Endmill, Long, 4 Flute, R50-NH DUO Corner Rad, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	AICrN	DIN6527L
E566	42	B0210	○	Endmill, Long, 4 Flute, R50-VH DUO, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Aldura	DIN6527L
E568	42	B0210	○	Endmill, Long, 4 Flute, R50-VH DUO Corner Rad, <i>Harmony</i>	DIN 6535-HA	VHM-ULTRA	Aldura	DIN6527L
E603	44	B0210		Slot Drill, Stub, 2 Flute, R30	DIN 6535-HA	VHM	TiAIN	-
E604	44	B0210		Endmill, Regular, 4 Flute, R30	DIN 6535-HA	VHM	TiAIN	-
E605	44	B0210		Slot Drill, Regular, Ballnose, 2 Flute, R30	DIN 6535-HA	VHM	TiAIN	-
E607	44	B0210		Endmill, Regular, Ballnose, 4 Flute, R30	DIN 6535-HA	VHM	TiAIN	-

Catalogue Code 产品目录号	Page No. 页数	Discount Group 折扣组	Sutton Designation Sutton代号	Description 产品名称	Thread 螺纹	Geometry Type 几何结构	Tool Material 刀具材质	Surface Finish 表面处理	Standard 生产标准
Taps 丝锥									
T102	12	D0402		Tap, Gun, N	M	N	HSSE V3	Blu	DIN371
T103	12	D0402		Tap, Gun, N	M	N	HSSE V3	Blu	DIN376
T104	12	D0406		Tap, Gun, N	M	N	HSSE V3	TiN	DIN371
T105	12	D0406		Tap, Gun, N	M	N	HSSE V3	TiN	DIN376
T110	13	D0402	○	Tap, Gun, VA	M	VA	HSSE V3	Blu	DIN371
T111	13	D0402	○	Tap, Gun, VA	M	VA	HSSE V3	Blu	DIN376
T116	13	D0408	○	Tap, Gun, VA PM	M	VA PM	PM-HSSE V3	TiCN	DIN371
T117	13	D0408	○	Tap, Gun, VA PM	M	VA PM	PM-HSSE V3	TiCN	DIN376
T120	13	D0408	○	Tap, Gun, VADH	M	VADH	PM-HSSE V3	TiCN	DIN371
T121	13	D0408	○	Tap, Gun, VADH	M	VADH	PM-HSSE V3	TiCN	DIN376
T122	12	D0402	○	Tap, Gun, W	M	W	HSSE V3	Ni	DIN371
T123	12	D0402	○	Tap, Gun, W	M	W	HSSE V3	Ni	DIN376
T124	13	D0402	○	Tap, Gun, W	M	W	HSSE V3	Blu	DIN371
T125	13	D0402	○	Tap, Gun, W	M	W	HSSE V3	Blu	DIN376
T128	13	D0402	○	Tap, Gun, W-AZ	M	W - AZ	HSSE V3	BrT	DIN371
T129	13	D0402	○	Tap, Gun, W-AZ	M	W - AZ	HSSE V3	BrT	DIN376
T140	13	D0410	NH	Tap, Gun, NH	M	NH	PM-HSSE V3	TiAIN	DIN371
T141	13	D0410	NH	Tap, Gun, NH	M	NH	PM-HSSE V3	TiAIN	DIN376
T144	13	D0402	○	Tap, Gun, H	M	H	PM-HSS Co	Blu	DIN371
T145	13	D0402	○	Tap, Gun, H	M	H	PM-HSS Co	Blu	DIN376
T146	13	D0408	○	Tap, Gun, H	M	H	PM-HSS Co	TiCN	DIN371
T147	13	D0408	○	Tap, Gun, H	M	H	PM-HSS Co	TiCN	DIN376
T156	12	D0402		Tap, Gun, N	MF	N	HSSE V3	Blu	DIN374
T157	12	D0406		Tap, Gun, N	MF	N	HSSE V3	TiN	DIN374
T158	13	D0402	○	Tap, Gun, VA	MF	VA	HSSE V3	Blu	DIN374
T160	13	D0408	○	Tap, Gun, VA PM	MF	VA PM	PM-HSSE V3	TiCN	DIN374
T163	13	D0410	NH	Tap, Gun, NH	MF	NH	PM-HSSE V3	TiAIN	DIN374
T189	10	D0402		Tap, Spiral Flute, R40 N	M	N	HSSE V3	Blu	DIN371
T190	10	D0402		Tap, Spiral Flute, R40 N	M	N	HSSE V3	Blu	DIN376
T197	11	D0402	○	Tap, Spiral Flute, R45 VADH	M	VADH	HSSE V3	Blu	DIN371
T199	11	D0402	○	Tap, Spiral Flute, R45 VADH	M	VADH	HSSE V3	Blu	DIN376
T201	11	D0408	○	Tap, Spiral Flute, R45 VADH	M	VADH	HSSE V3	TiCN	DIN371
T202	11	D0408	○	Tap, Spiral Flute, R45 VADH	M	VADH	HSSE V3	TiCN	DIN376
T205	11	D0408	○	Tap, Spiral Flute, R50 VA PM	M	VA PM	PM-HSSE V3	TiCN	DIN371
T206	11	D0408	○	Tap, Spiral Flute, R50 VA PM	M	VA PM	PM-HSSE V3	TiCN	DIN376

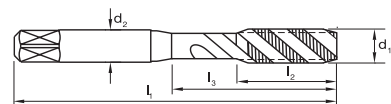
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T209	11	D0402	○	Tap, Spiral Flute, R15 H	M	H	PM-HSS Co	Blu	DIN371
T210	11	D0402	○	Tap, Spiral Flute, R15 H	M	H	PM-HSS Co	Blu	DIN376
T211	11	D0408	○	Tap, Spiral Flute, R15 H	M	H	PM-HSS Co	TiCN	DIN371
T212	11	D0408	○	Tap, Spiral Flute, R15 H	M	H	PM-HSS Co	TiCN	DIN376
T227	11	D0410	NH	Tap, Spiral Flute, R40 NH	M	NH	PM-HSSE V3	TiAlN	DIN371
T228	11	D0410	NH	Tap, Spiral Flute, R40 NH	M	NH	PM-HSSE V3	TiAlN	DIN376
T231	11	D0402	○	Tap, Spiral Flute, R45 Al	M	Al	HSSE V3	Brt	DIN371
T232	11	D0402	○	Tap, Spiral Flute, R45 Al	M	Al	HSSE V3	Brt	DIN376
T235	10	D0402	○	Tap, Spiral Flute, R45 W	M	W	HSSE V3	Ni	DIN371
T236	10	D0402	○	Tap, Spiral Flute, R45 W	M	W	HSSE V3	Ni	DIN376
T239	11	D0404	○	Tap, Spiral Flute, R45 Cu	M	Cu	HSSE V3	CrN	DIN371
T240	11	D0404	○	Tap, Spiral Flute, R45 Cu	M	Cu	HSSE V3	CrN	DIN376
T241	10	D0406	○	Tap, Spiral Flute, R45 W	M	W	HSSE V3	TiN	DIN371
T242	10	D0406	○	Tap, Spiral Flute, R45 W	M	W	HSSE V3	TiN	DIN376
T247	10	D0402		Tap, Spiral Flute, R40 N	MF	N	HSSE V3	Blu	DIN374
T249	11	D0402	○	Tap, Spiral Flute, R45 VADH	MF	VADH	HSSE V3	Blu	DIN374
T251	11	D0408	○	Tap, Spiral Flute, R45 VADH	MF	VADH	HSSE V3	TiCN	DIN374
T252	11	D0408	○	Tap, Spiral Flute, R50 VA PM	MF	VA PM	PM-HSSE V3	TiCN	DIN374
T254	11	D0410	NH	Tap, Spiral Flute, R40 NH	MF	NH	PM-HSSE V3	TiAlN	DIN374
T292	14	D0408	◎	Tap, Straight Flute, GG	M	GG	HSSE V3	TiCN	DIN371
T293	14	D0408	◎	Tap, Straight Flute, GG	M	GG	HSSE V3	TiCN	DIN376
T294	15	D0408	○	Tap, Straight Flute, XH, Form C	M	XH	SPM	TiCN	-
T295	15	D0408	○	Tap, Straight Flute, XH, Form D	M	XH	SPM	TiCN	-
T296	15	D0414	○	Tap, Straight Flute, VH, Form C	M	VH	VHM	TiCN	-
T297	15	D0414	○	Tap, Straight Flute, VH, Form D	M	VH	VHM	TiCN	-
T301	14	D0408	◎	Tap, Straight Flute, GG	MF	GG	HSSE V3	TiCN	DIN374
T325	17	D0410	○	Tap, Forming, with multi coolant groove, UNI	M	UNI	SPM	TiAlN	DIN2174
T326	17	D0410	○	Tap, Forming, with multi coolant groove, UNI	M	UNI	SPM	TiAlN	DIN2174
T327	17	D0410	○	Tap, Forming, with multi coolant groove, UNI, IK	M	UNI - IK	SPM	TiAlN	DIN2174
T328	17	D0410	○	Tap, Forming, with multi coolant groove, UNI, IK	M	UNI - IK	SPM	TiAlN	DIN2174
T335	14	D0408	DC	Tap, Straight Flute, DC	M	DC	PM-HSS Co	TiCN	DIN371
T336	14	D0408	DC	Tap, Straight Flute, DC	M	DC	PM-HSS Co	TiCN	DIN376
T343	15	D0408	○	Tap, Straight Flute, XH, Form C	MF	XH	SPM	TiCN	-
T344	15	D0408	○	Tap, Straight Flute, XH, Form D	MF	XH	SPM	TiCN	-
T345	15	D0414	○	Tap, Straight Flute, VH, Form C	MF	VH	VHM	TiCN	-
T346	15	D0414	○	Tap, Straight Flute, VH, Form D	MF	VH	VHM	TiCN	-
T357	14	D0408	DC	Tap, Straight Flute, DC, IK	M	DC - IK	PM-HSS Co	TiCN	DIN371
T358	14	D0408	DC	Tap, Straight Flute, DC, IK	M	DC - IK	PM-HSS Co	TiCN	DIN376
T365	9	D0412	Synchro	Tap, Spiral Flute, Synchro, L20	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T367	9	D0412	Synchro	Tap, Spiral Flute, Synchro, L20, IK	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T369	9	D0412	Synchro	Tap, Spiral Flute, Synchro, R45 Al	M	~DIN1835-B /HSC	PM-HSSE V3	CrN	-
T371	9	D0412	Synchro	Tap, Spiral Flute, Synchro, R45 Al, IK	M	~DIN1835-B /HSC	PM-HSSE V3	CrN	-
T373	8	D0412	Synchro	Tap, Spiral Flute, Synchro, R50	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T375	8	D0412	Synchro	Tap, Spiral Flute, Synchro, R50, IK	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T377	8	D0412	Synchro	Tap, Gun, Synchro	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T379	8	D0412	Synchro	Tap, Gun, Synchro, IK	M	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T381	9	D0412	Synchro	Tap, Forming, Synchro	M	~DIN1835-B /HSC	PM-HSSE V3	TiN	-
T383	9	D0412	Synchro	Tap, Forming, Synchro, IK	M	~DIN1835-B /HSC	PM-HSSE V3	TiN	-
T499	7	D0602		Tap, Gun, N	M	N	HSSE V3	Brt	JIS
T500	7	D0602		Tap, Gun, N	M	N	HSSE V3	Blu	JIS
T503	6	D0602		Tap, Spiral Flute, R40 N	M	N	HSSE V3	Brt	JIS
T504	6	D0602		Tap, Spiral Flute, R40 N	M	N	HSSE V3	Blu	JIS
T510	16	D0606		Tap, Forming, single coolant groove, P lead	M	N	HSS Co.8	Ni	JIS
T511	16	D0606		Tap, Forming, single coolant groove, B lead	M	N	HSS Co.8	Ni	JIS
T512	16	D0606		Tap, Forming, single coolant groove, P lead	M	N	HSS Co.8	Blu	JIS
T513	16	D0606		Tap, Forming, single coolant groove, B lead	M	N	HSS Co.8	Blu	JIS

Catalogue Code 产品目录号	Page No. 页数	Discount Group 折扣组	Sutton Designation Sutton代号	Description 产品名称	Thread 螺纹	Geometry Type 几何结构	Tool Material 刀具材质	Surface Finish 表面处理	Standard 生产标准
T514	16	D0614		Tap, Forming, single coolant groove, P lead	M	N	HSS Co.8	TiN	JIS
T515	16	D0614		Tap, Forming, single coolant groove, B lead	M	N	HSS Co.8	TiN	JIS
T606	6	D0602		Tap, Spiral Flute, R40 N (Point Removed)	M	N	HSSE V3	BrT	JIS
T607	6	D0602		Tap, Spiral Flute, R40 N (Point Removed)	M	N	HSSE V3	Blu	JIS
T629	16	D0614		Tap, Forming, single coolant groove, P lead	Metric	N	PM-HSSE V3	TiCN	JIS
T630	16	D0614		Tap, Forming, single coolant groove, B lead	Metric	N	PM-HSSE V3	TiCN	JIS
T668	14	D0408	DC	Tap, Straight Flute, DC	MF	DC	PM-HSS Co	TiCN	DIN374
T669	14	D0408	DC	Tap, Straight Flute, DC, IK	MF	DC	PM-HSS Co	TiCN	DIN374
T670	14	D0414	⊙	Tap, Straight Flute, GG	M	GG	VHM	TiCN	DIN371
T671	14	D0414	⊙	Tap, Straight Flute, GG	M	GG	VHM	TiCN	DIN376
T682	17	D0414		Tap, Forming, VH, with multi coolant groove	M	VH	VHM	TiAIN	DIN2174
T683	17	D0414		Tap, Forming, VH, with multi coolant groove	M	VH	VHM	TiAIN	DIN2174
T684	10	D0410	○	Tap, Spiral Flute, R50 <i>Black Magic</i>	M	UNI	PM-HSSE V3	Hardlube	DIN371
T685	10	D0410	○	Tap, Spiral Flute, R50 <i>Black Magic</i>	M	UNI	PM-HSSE V3	Hardlube	DIN376
T686	10	D0410	○	Tap, Spiral Flute, R50 <i>Black Magic</i>	MF	UNI	PM-HSSE V3	Hardlube	DIN374
T687	12	D0410	○	Tap, Gun, <i>Black Magic</i>	M	UNI	PM-HSSE V3	Hardlube	DIN371
T688	12	D0410	○	Tap, Gun, <i>Black Magic</i>	M	UNI	PM-HSSE V3	Hardlube	DIN376
T689	12	D0410	○	Tap, Gun, <i>Black Magic</i>	MF	UNI	PM-HSSE V3	Hardlube	DIN374
T743	14	D0414	⊙	Tap, Straight Flute, GG	MF	GG	VHM	TiCN	DIN374
T747	17	D0414	○	Tap, Forming, VH-IK, with multi coolant groove	M	VH	VHM	TiAIN	DIN2174
T748	17	D0414	○	Tap, Forming, VH-IK, with multi coolant groove	M	VH	VHM	TiAIN	DIN2174
T754	9	D0412	Synchro	Tap, Spiral Flute, Synchro, L20	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T756	9	D0412	Synchro	Tap, Spiral Flute, Synchro, L20, IK	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T758	9	D0412	Synchro	Tap, Spiral Flute, Synchro, R45 Al	MF	~DIN1835-B /HSC	PM-HSSE V3	CrN	-
T760	9	D0412	Synchro	Tap, Spiral Flute, Synchro, R45 Al, IK	MF	~DIN1835-B /HSC	PM-HSSE V3	CrN	-
T762	8	D0412	Synchro	Tap, Spiral Flute, Synchro, R50	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T764	8	D0412	Synchro	Tap, Spiral Flute, Synchro, R50, IK	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T766	8	D0412	Synchro	Tap, Gun, Synchro	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T768	8	D0412	Synchro	Tap, Gun, Synchro, IK	MF	~DIN1835-B /HSC	PM-HSSE V3	TiCN	-
T770	9	D0412	Synchro	Tap, Forming, Synchro	MF	~DIN1835-B /HSC	PM-HSSE V3	TiN	-
T772	9	D0412	Synchro	Tap, Forming, Synchro, IK	MF	~DIN1835-B /HSC	PM-HSSE V3	TiN	-

Taps Metric, Spiral Flute

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁
- 一般用途、适合≤1000N/mm²的材料
- 盲孔用
- 适合机用
- 加工深度 ≤2.5 x d₁



尺寸参考 螺距 精度

Size Ref.	d ₁	Pitch	Limit	Style	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Item # (货号)	Item # (货号)
WITH POINT 尖头												T503	T504
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T503 0100	
0110	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T503 0110	
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T503 0120	
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	T503 0140	
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T503 0160	
1170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T503 0170	
0180	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T503 0180	
0200	M 2	x 0.4	P2	1	40	12	15	3.0	2.5	2	1.60	T503 0200	T504 0200
0220	M 2.2	x 0.45	P2	1	42	13	15	3.0	2.5	2	1.75	T503 0220	T504 0220
0230	M 2.3	x 0.4	P2	1	42	13	15	3.0	2.5	2	1.9	T503 0230	T504 0230
0250	M 2.5	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.05	T503 0250	T504 0250
0260	M 2.6	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.15	T503 0260	T504 0260
0300	M 3	x 0.5	P2	2	46	11	18	4.0	3.2	3	2.5	T503 0300	T504 0300
0350	M 3.5	x 0.6	P1	2	48	13	20	4.0	3.2	3	2.9	T503 0350	T504 0350
0400	M 4	x 0.7	P2	2	52	13	20	5.0	4.0	3	3.3	T503 0400	T504 0400
0500	M 5	x 0.8	P2	2	60	16	25	5.5	4.5	3	4.2	T503 0500	T504 0500
0600	M 6	x 1.0	P2	2	62	19	28	6.0	4.5	3	5.0	T503 0600	T504 0600
WITHOUT POINT 削平头												T606	T607
0200	M 2	x 0.4	P2	4	40	12	16	3.0	2.5	2	1.60	T606 0200	T607 0200
0250	M 2.5	x 0.45	P2	4	44	14	16	3.0	2.5	2	2.05	T606 0250	T607 0250
0300	M 3	x 0.5	P2	5	46	11	18	4.0	3.2	3	2.5	T606 0300	T607 0300
0350	M 3.5	x 0.6	P1	5	48	13	20	4.0	3.2	3	2.9	T606 0350	T607 0350
0400	M 4	x 0.7	P2	5	52	13	20	5.0	4.0	3	3.3	T606 0400	T607 0400
0500	M 5	x 0.8	P2	5	60	16	25	5.5	4.5	3	4.2	T606 0500	T607 0500
0600	M 6	x 1.0	P2	5	62	19	28	6.0	4.5	3	5.0	T606 0600	T607 0600
0700	M 7	x 1.0	P2	3	65	22	-	6.2	5.0	3	6.0	T606 0700	T607 0700
0800	M 8	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T606 0800	T607 0800
1006	MF 10	x 1.25	P2	3	75	24	-	7.0	5.5	3	8.5	T606 1006	T607 1006
1000	M 10	x 1.5	P2	3	75	24	-	7.0	5.5	3	8.8	T606 1000	T607 1000
1200	M 12	x 1.75	P2	3	82	29	-	8.5	6.5	3	10.2	T606 1200	T607 1200



Product Name 产品名称	R40 N	R40 N
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE V3	HSSE V3
Surface Finish 表面处理	Brt 无处理	Blu 氧化处理
Application 色环及应用	N	N
Geometry 几何结构	R40	R40
Lead 切削锥	2.5 x P	2.5 x P

Recommended Tapping Drill

推荐的底孔钻头

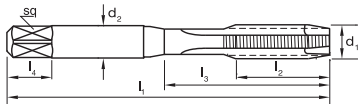
D151 D151



Taps Metric, Gun, (Spiral Point)



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Ideally suited for machine applications.
- Depths up to approx. 3 x d₁
- 一般用途、适合≤1000N/mm²的材料
- 通孔用
- 适合机用
- 加工深度 ≤3 x d₁



尺寸参考 螺距 精度

Size Ref.	d ₁	Pitch	Limit	Style	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Item # (货号)	Item # (货号)
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T499 0100	
0110	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T499 0110	
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T499 0120	
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	T499 0140	
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T499 0160	
0170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T499 0170	
0180	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T499 0180	
0200	M 2	x 0.4	P2	1	40	12	-	3.0	2.5	2	1.60	T499 0200	T500 0200
0220	M 2.2	x 0.45	P2	1	42	13	-	3.0	2.5	2	1.75	T499 0220	T500 0220
0230	M 2.3	x 0.4	P2	1	42	13	-	3.0	2.5	2	1.9	T499 0230	T500 0230
0250	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T499 0250	T500 0250
0260	M 2.6	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15	T499 0260	T500 0260
0300	M 3	x 0.5	P2	2	46	11	18	4.0	3.2	3	2.5	T499 0300	T500 0300
0350	M 3.5	x 0.6	P2	2	48	13	20	4.0	3.2	3	2.9	T499 0350	T500 0350
0400	M 4	x 0.7	P2	2	52	13	20	5.0	4.0	3	3.3	T499 0400	T500 0400
0500	M 5	x 0.8	P2	2	60	16	25	5.5	4.5	3	4.2	T499 0500	T500 0500
0600	M 6	x 1.0	P2	2	62	19	28	6.0	4.5	3	5.0	T499 0600	T500 0600
0700	M 7	x 1.0	P2	3	65	22	-	6.2	5.0	3	6.0	T499 0700	T500 0700
0800	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8	T499 0800	T500 0800
1006	MF 10	x 1.25	P3	3	75	24	-	7.0	5.5	3	8.8	T499 1006	T500 1006
1000	M 10	x 1.5	P3	3	75	24	-	7.0	5.5	3	8.5	T499 1000	T500 1000
1200	M 12	x 1.75	P4	3	82	29	-	8.5	6.5	3	10.2	T499 1200	T500 1200
1400	M 14	x 2.0	P4	3	88	30	-	10.5	8.0	3	12.0	T499 1400	T500 1400
1600	M 16	x 2.0	P4	3	95	32	-	12.5	10.0	4	14.0	T499 1600	T500 1600
1800	M 18	x 2.5	P4	3	100	37	-	14.0	11.0	4	15.5	T499 1800	T500 1800
2000	M 20	x 2.5	P4	3	105	37	-	15.0	12.0	4	17.5	T499 2000	T500 2000
2200	M 22	x 2.5	P4	3	115	38	-	17.0	13.0	4	19.5	T499 2200	T500 2200
2400	M 24	x 3.0	P4	3	120	45	-	19.0	15.0	4	21.0	T499 2400	T500 2400



Catalogue Code 目录代码	T499	T500
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE V3	HSSE V3
Surface Finish 表面处理	Brt 无处理	Blu 氧化处理
Application 色环及应用	N	N
Geometry 几何结构		
Lead 切削锥	5 x P	5 x P

Recommended Tapping Drill

推荐的底孔钻头

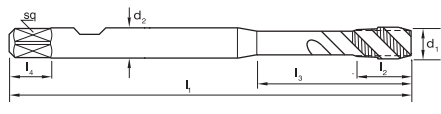
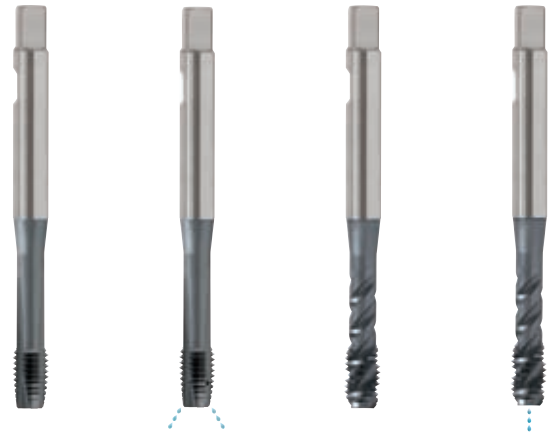
D151 D151



DIN Taps Metric, Synchro Series



- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- With and without internal coolant
- h6 endmill shank
- 适合高速及高精度螺纹加工
- 专供带同步进给的CNC进行刚性攻牙
- 有外冷和内冷油孔
- 高精度h6铣刀柄



Product Name 产品名称
Discount Group 折扣组
Material 材料
Surface Finish 表面处理
Application 色环及应用
Geometry 几何结构
Chamfer 倒角

Synchro	Synchro	Synchro	Synchro
D0412	D0412	D0412	D0412
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
TICN 氮化钛	TICN 氮化钛	TICN 氮化钛	TICN 氮化钛
HSC	HSC	HSC	HSC
Gun	Gun - IK 内冷	R50	R50 IK 内冷
Form B / 4.5 x P	Form B / 4.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
6HX	6HX	6HX	6HX
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T377	T379	T373	T375
T377 0200		T373 0200	
T377 0250		T373 0250	
T377 0300		T373 0300	
T377 0400		T373 0400	
T377 0500	T379 0500	T373 0500	T375 0500
T377 0600	T379 0600	T373 0600	T375 0600
T377 0800	T379 0800	T373 0800	T375 0800
T377 1000	T379 1000	T373 1000	T375 1000
T377 1200	T379 1200	T373 1200	T375 1200
T377 1400	T379 1400	T373 1400	T375 1400
T377 1600	T379 1600	T373 1600	T375 1600
T377 1800	T379 1800	T373 1800	T375 1800
T377 2000	T379 2000	T373 2000	T375 2000
T766	T768	T762	T764
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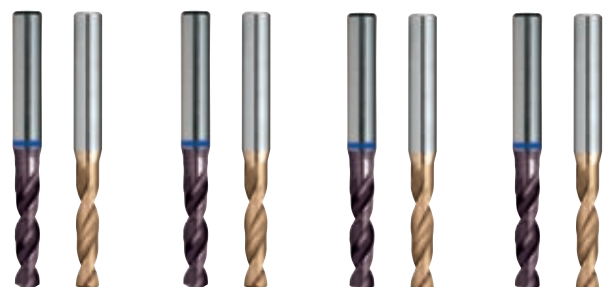
尺寸参考 螺距 Limit & Nut Tolerance 精度及螺母容许公差

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	z	Drill Ø
SUTTON STD SUTTON 标准									
0200	M 2	x 0.4	70	4	13	6.0	4.9	3	1.6
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	3	2.1
0300	M 3	x 0.5	70	5	18	6.0	4.9	3	2.5
0400	M 4	x 0.7	70	7	21	6.0	4.9	3	3.3
0500	M 5	x 0.8	70	8	25	6.0	4.9	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	3	5.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	3	8.5
1200	M 12	x 1.75	110	18	42	12.0	9.0	3	10.3
1400	M 14	x 2	110	20	49	14.0	11.0	3	12.0
1600	M 16	x 2	110	20	55	16.0	12.0	4	14.0
1800	M 18	x 2.5	125	25	-	16.0	12.0	4	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	4	17.5
SUTTON STD - FINE PITCH SUTTON 标准-公制细牙									
0805	MF 8	x 1	90	13	30	8.0	6.2	3	7.8
1005	MF 10	x 1	100	15	39	10.0	8.0	3	9.0
1006	MF 10	x 1.25	100	15	39	10.0	8.0	3	8.8
1205	MF 12	x 1	110	18	42	12.0	9.0	3	11.0
1206	MF 12	x 1.25	110	18	42	12.0	9.0	3	10.8
1207	MF 12	x 1.5	110	18	42	12.0	9.0	3	10.5

Recommended Tapping Drill

推荐的底孔钻头

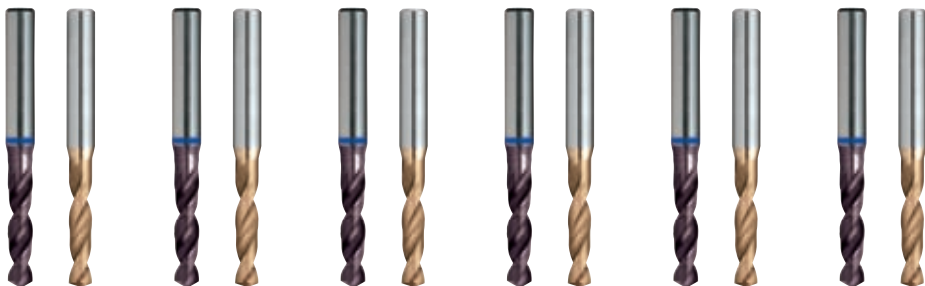
D153 / D356 D153 / D356 D153 / D356 D153 / D356





Synchro	Synchro	Synchro	Synchro	Synchro	Synchro
D0412	D0412	D0412	D0412	D0412	D0412
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
TiCN 氮化钛	TiCN 氮化钛	CrN 氮化铬	CrN 氮化铬	TiN 氮化钛	TiN 氮化钛
HSC	HSC	HSC	HSC	HSC	HSC
L20	L20-IK 内冷	R45 Al	R45 Al - IK 内冷	Forming	Forming - IK 内冷
Form D / 4 x P	Form D / 4 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
6HX	6HX	6HX	6HX	6HX	6HX
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T365	T367	T369	T371	T381	T383
T365 0200		T369 0200		T381 0200	
T365 0250		T369 0250		T381 0250	
T365 0300		T369 0300		T381 0300	
T365 0400		T369 0400		T381 0400	
T365 0500	T367 0500	T369 0500	T371 0500	T381 0500	T383 0500
T365 0600	T367 0600	T369 0600	T371 0600	T381 0600	T383 0600
T365 0800	T367 0800	T369 0800	T371 0800	T381 0800	T383 0800
T365 1000	T367 1000	T369 1000	T371 1000	T381 1000	T383 1000
T365 1200	T367 1200	T369 1200	T371 1200	T381 1200	T383 1200
T365 1400	T367 1400	T369 1400	T371 1400	T381 1400	T383 1400
T365 1600	T367 1600	T369 1600	T371 1600	T381 1600	T383 1600
T365 1800	T367 1800	T369 1800	T371 1800	T381 1800	T383 1800
T365 2000	T367 2000	T369 2000	T371 2000	T381 2000	T383 2000
T754	T756	T758	T760	T770	T772
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•

D153 / D356 D153 / D356 D153 / D356 D153 / D356 D153 / D356 D153 / D356



•Available on request as special manufacture. Subject to lead time. •可定制.

Taps Metric - For Tapping Blind Holes

suttontools

Speed & Feeds - refer page 48

切削速度及进给 - 请参阅第48页



Product Name 产品名称

Discount Group 折扣组

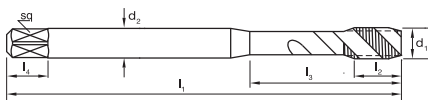
Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Chamfer 倒角



尺寸参考

螺距

Limit & Nut Tolerance 精度及螺母容许公差

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	z	Drill Ø
DIN 371 REINFORCED SHANK									
0300	M 3	x 0.5	56	5	18	3.5	2.7	3	2.5
0400	M 4	x 0.7	63	7	21	4.5	3.4	3	3.3
0500	M 5	x 0.8	70	8	25	6.0	4.9	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	3	5.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	3	8.5
DIN 376 REDUCED SHANK									
0600	M 6	x 1	80	10	-	4.5	3.4	3	5.0
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	3	6.8
1000	M 10	x 1.5	100	15	-	7.0	5.5	3	8.5
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	3	10.2
1400	M 14	x 2	110	20	-	11.0	9.0	3	12.0
1600	M 16	x 2	110	20	-	12.0	9.0	3	14.0
1800	M 18	x 2.5	125	25	-	14.0	11.0	4	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	4	17.5
DIN 374 FINE PITCH - REDUCED SHANK									
0604	MF 6	x 0.75	80	8	-	4.5	3.4	3	5.3
0805	MF 8	x 1	90	8	-	6.0	4.9	3	7.0
1005	MF 10	x 1	90	10	-	7.0	5.5	3	9.0
1006	MF 10	x 1.25	100	13	-	7.0	5.5	3	8.8
1205	MF 12	x 1	100	14	-	9.0	7.0	3	11.0
1206	MF 12	x 1.25	100	14	-	9.0	7.0	3	10.8
1207	MF 12	x 1.5	100	14	-	9.0	7.0	3	10.5
1406	MF 14	x 1.25	100	16	-	11.0	9.0	3	12.8
1407	MF 14	x 1.5	100	16	-	11.0	9.0	3	12.5
1607	MF 16	x 1.5	100	16	-	12.0	9.0	3	16.5

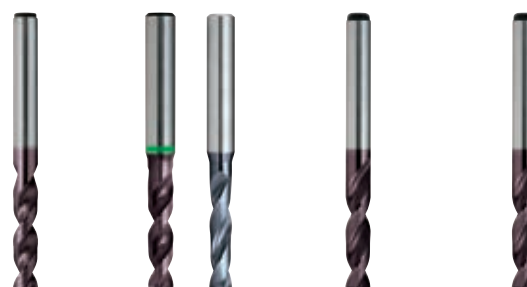
Other Available Thread Forms 可供应右列的其他螺纹

R40 N	Black Magic	R45 W	R45 W
D0402	D0410	D0406	D0402
HSSE V3	PM-HSSE V3	HSSE V3	HSSE V3
Blu 氧化处理	Hardlube HL涂层	TiN 氮化钛	Ni 氮化处理
N	UNI	W	W
R40	R50	R45	R45
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 2 / 6H	6HX	ISO 2 / 6H	ISO 2 / 6H
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T189	T684	T241	T235
T189 0300	T684 0300	T241 0300	T235 0300
T189 0400	T684 0400	T241 0400	T235 0400
T189 0500	T684 0500	T241 0500	T235 0500
T189 0600	T684 0600	T241 0600	T235 0600
T189 0800	T684 0800	T241 0800	T235 0800
T189 1000	T684 1000	T241 1000	T235 1000
T190	T685	T242	T236
T190 0600	•	T242 0600	T236 0600
T190 0800	•	T242 0800	T236 0800
T190 1000	•	T242 1000	T236 1000
T190 1200	T685 1200	T242 1200	T236 1200
T190 1400	T685 1400	T242 1400	T236 1400
T190 1600	T685 1600	T242 1600	T236 1600
T190 1800	T685 1800	T242 1800	T236 1800
T190 2000	T685 2000	T242 2000	T236 2000
T247	T686		
T247 0604	T686 0604		
T247 0805	T686 0805		
T247 1005	T686 1005		
T247 1006	T686 1006		
•	T686 1205		
T247 1206	T686 1206		
T247 1207	T686 1207		
•	T686 1406		
T247 1407	•		
T247 1607	•		
UNC, G(BSPF)	UNC, UNF, G(BSPF)		

Recommended Tapping Drill

推荐的底孔钻头

D151 D155 / D323 D177 D177



• Available on request as special manufacture. Subject to lead time. • 可定制.

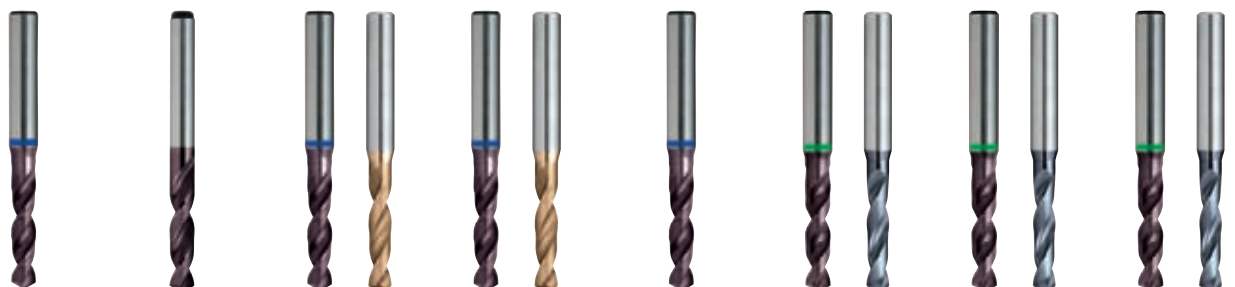
Refer to our complete Industrial Catalogue online for entire range 请参阅我们在线全系列完整产品目录

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R45 AI	R45 Cu	R45 VADH	R45 VADH	R50 VA	R40 NH	R15 H	R15 H
D0402	D0404	D0402	D0408	D0408	D0410	D0402	D0408
HSSE V3	HSSE V3	HSSE V3	HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSS Co	PM-HSS Co
BrT 无处理	CrN 氮化铬	Blu 氧化处理	TiCN 碳氮化钛	TiCN 碳氮化钛	TiAlN 氮化铝钛	Blu 氧化处理	TiCN 碳氮化钛
AI	Cu	VADH	VADH	VA PM	NH	H	H
R45 2 Flute	R45	R45 Back Chamf.	R45° Back Chamf.	R50	R40	R15	R15
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 3 x P	Form C / 3 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H	ISO 2 / 6HX	ISO 2 / 6HX
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T231	T239	T197	T201	T205	T227	T209	T211
T231 0300	T239 0300	T197 0300	T201 0300	T205 0300	T227 0300	T209 0300	T211 0300
T231 0400	T239 0400	T197 0400	T201 0400	T205 0400	T227 0400	T209 0400	T211 0400
T231 0500	T239 0500	T197 0500	T201 0500	T205 0500	T227 0500	T209 0500	T211 0500
T231 0600	T239 0600	T197 0600	T201 0600	T205 0600	T227 0600	T209 0600	T211 0600
T231 0800	T239 0800	T197 0800	T201 0800	T205 0800	T227 0800	T209 0800	T211 0800
T231 1000	T239 1000	T197 1000	T201 1000	T205 1000	T227 1000	T209 1000	T211 1000
T232	T240	T199	T202	T206	T228	T210	T212
•	T240 0600	T199 0600	T202 0600	•	•	•	•
•	•	T199 0800	T202 0800	•	•	•	•
•	•	T199 1000	T202 1000	•	•	•	•
T232 1200	T240 1200	T199 1200	T202 1200	T206 1200	T228 1200	T210 1200	T212 1200
	T240 1400	T199 1400	T202 1400	T206 1400	T228 1400	T210 1400	T212 1400
	T240 1600	T199 1600	T202 1600	T206 1600	T228 1600	T210 1600	T212 1600
	T240 1800	T199 1800	T202 1800	T206 1800	T228 1800	T210 1800	T212 1800
	T240 2000	T199 2000	T202 2000	T206 2000	T228 2000	T210 2000	T212 2000
		T249	T251	T252	T254		
		T249 0604	T251 0604	T252 0604	T254 0604		
		T249 0805	T251 0805	•	T254 0805		
		T249 1005	T251 1005	T252 1005	T254 1005		
		T249 1006	T251 1006	•	T254 1006		
		T249 1205	T251 1205	T252 1205	T254 1205		
		T249 1206	T251 1206	T252 1206	T254 1206		
		•	•	T252 1207	T254 1207		
		•	•	T252 1406	T254 1406		
		T249 1407	T251 1407	T252 1407	T254 1407		
		•	•		T254 1607		
		UNC, UNF, G(BSPF)	UNC, UNF, G(BSPF)	UNC, UNF, G(BSPF)	UNC	UNC	UNC

D153 D177 D153 / D356 D153 / D356 D153 D155 / D323 D155 / D323 D155 / D323



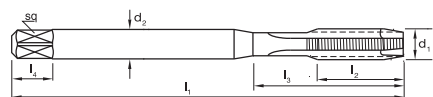
•Available on request as special manufacture. Subject to lead time. •可定制.

Taps Metric - For Tapping Through Holes

suttontools

Speed & Feeds - refer page 49

切削速度及进给、请参阅第49页



尺寸参考

螺距

Limit & Nut Tolerance

精度及螺母容许公差

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	z	Drill Ø
DIN 371 REINFORCED SHANK									
0300	M 3	x 0.5	56	11	18	3.5	2.7	3	2.5
0400	M 4	x 0.7	63	13	21	4.5	3.4	3	3.3
0500	M 5	x 0.8	70	16	25	6.0	4.9	3	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	3	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	3	6.8
1000	M 10	x 1.5	100	24	39	10.0	8.0	3	8.5
DIN 376 REDUCED SHANK									
0600	M 6	x 1	80	19	-	4.5	3.4	3	5.0
0800	M 8	x 1.25	90	22	-	6.0	4.9	3	6.8
1000	M 10	x 1.5	100	24	-	7.0	5.5	3	8.5
1200	M 12	x 1.75	110	28	-	9.0	7.0	3	10.2
1400	M 14	x 2	110	30	-	11.0	9.0	3	12.0
1600	M 16	x 2	110	32	-	12.0	9.0	4	14.0
1800	M 18	x 2.5	125	34	-	14.0	11.0	4	15.5
2000	M 20	x 2.5	140	34	-	16.0	12.0	4	17.5
DIN 374 FINE PITCH - REDUCED SHANK									
0604	MF 6	x 0.75	80	14	-	4.5	3.4	3	5.3
0805	MF 8	x 1	90	22	-	6.0	4.9	3	7.0
1005	MF 10	x 1	90	20	-	7.0	5.5	3	9.0
1006	MF 10	x 1.25	100	24	-	7.0	5.5	3	8.8
1205	MF 12	x 1	100	22	-	9.0	7.0	3	11.0
1206	MF 12	x 1.25	100	22	-	9.0	7.0	3	10.8
1207	MF 12	x 1.5	100	22	-	9.0	7.0	3	10.5
1406	MF 14	x 1.25	100	22	-	11.0	9.0	3	12.8
1407	MF 14	x 1.5	100	22	-	11.0	9.0	3	12.5
1607	MF 16	x 1.5	100	22	-	12.0	9.0	3	14.5

Other Available Thread Forms 可供应右列的其他螺纹

Gun N / 先端 N	Gun N / 先端 N	Black Magic	Gun W / 先端 W
D0402	D0406	D0410	D0402
HSSE V3	HSSE V3	PM-HSSE V3	HSSE V3
Blu 氮化处理	TiN 氮化钛	Hardlube HL涂层	Ni 氮化处理
N	N	UNI	W
Normal	Normal	Special Relief	
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T102	T104	T687	T122
T102 0300	T104 0300	T687 0300	T122 0300
T102 0400	T104 0400	T687 0400	T122 0400
T102 0500	T104 0500	T687 0500	T122 0500
T102 0600	T104 0600	T687 0600	T122 0600
T102 0800	T104 0800	T687 0800	T122 0800
T102 1000	T104 1000	T687 1000	T122 1000
T103	T105	T688	T123
T103 0600	T105 0600		
T103 0800	T105 0800		
T103 1000	T105 1000		
T103 1200	T105 1200	T688 1200	T123 1200
T103 1400	T105 1400	T688 1400	
T103 1600	T105 1600	T688 1600	T123 1600
T103 1800	T105 1800	T688 1800	
T103 2000	T105 2000	T688 2000	T123 2000
T156	T157	T689	
T156 0604	T157 0604	T689 0604	
T156 0805	T157 0805	T689 0805	
T156 1005	T157 1005	T689 1005	
T156 1006	T157 1006	T689 1006	
T156 1205	T157 1205	T689 1205	
T156 1206	T157 1206	T689 1206	
T156 1207	T157 1207	T689 1207	
T156 1406	T157 1406	T689 1406	
T156 1407	T157 1407		
T156 1607	T157 1607		
UNC, G(BSPF)	UNC, UNF, G(BSPF)	UNC, UNF, G(BSPF)	

Recommended Tapping Drill

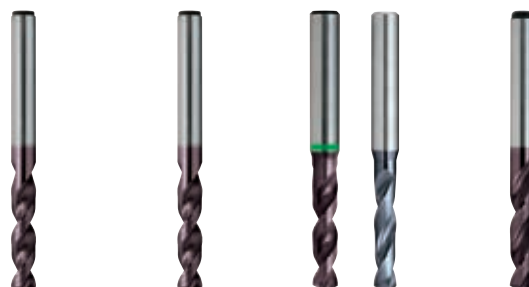
推荐的底孔钻头

D151

D151

D155 / D323

D177





Gun W / 先端 W	Gun W AZ / 先端 W AZ	Gun VA / 先端 VA	Gun VADH / 先端 VADH	Gun VA PM / 先端 VA PM	Gun NH / 先端 NH	Gun H / 先端 H	Gun H / 先端 H
D0402	D0402	D0402	D0408	D0408	D0410	D0402	D0408
HSSE V3	HSSE V3	HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSS Co	PM-HSS Co
Blu 氧化处理	Brt 无处理	Blu 氧化处理	TiCN 碳氮化钛	TiCN 碳氮化钛	TiAlN 氮化铝钛	Blu 氧化处理	TiCN 碳氮化钛
W	Sticky Material	VA	VADH	VA PM	NH	H	H
	Interrupted Threads	Special Relief	Thread Length =10 x P	Special Relief		Low Relief	Low Relief
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX	6HX	ISO 2 / 6H	6HX	6HX
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T124	T128	T110	T120	T116	T140	T144	T146
T124 0300	T128 0300	T110 0300	T120 0300	T116 0300	T140 0300	T144 0300	T146 0300
T124 0400	T128 0400	T110 0400	T120 0400	T116 0400	T140 0400	T144 0400	T146 0400
T124 0500	T128 0500	T110 0500	T120 0500	T116 0500	T140 0500	T144 0500	T146 0500
T124 0600	T128 0600	T110 0600	T120 0600	T116 0600	T140 0600	T144 0600	T146 0600
T124 0800	T128 0800	T110 0800	T120 0800	T116 0800	T140 0800	T144 0800	T146 0800
T124 1000	T128 1000	T110 1000	T120 1000	T116 1000	T140 1000	T144 1000	T146 1000
T125	T129	T111	T121	T117	T141	T145	T147
•	•	T111 0600	•	•	•	•	•
•	•	T111 0800	•	•	•	•	•
•	•	T111 1000	•	•	•	•	•
T125 1200	T129 1200	T111 1200	T121 1200	T117 1200	T141 1200	T145 1200	T147 1200
•	T129 1400	T111 1400	T121 1400	T117 1400	T141 1400	T145 1400	T147 1400
T125 1600	T129 1600	T111 1600	T121 1600	T117 1600	T141 1600	T145 1600	T147 1600
•		T111 1800	T121 1800	T117 1800	T141 1800	T145 1800	T147 1800
T125 2000		T111 2000	T121 2000	T117 2000	T141 2000	T145 2000	T147 2000
		T158		T160	T163		
		T158 0604		T160 0604	T163 0604		
		T158 0805		•	T163 0805		
		T158 1005		T160 1005	T163 1005		
		T158 1006		•	T163 1006		
		T158 1205		T160 1205	T163 1205		
		T158 1206		T160 1206	T163 1206		
		T158 1207		T160 1207	T163 1207		
		T158 1406		T160 1406	T163 1406		
		T158 1407		•	T163 1407		
		•		•	T163 1607		
		UNC, UNF, G(BSPF)		UNC, UNF, G(BSPF)	UNC	UNC	UNC

D177

D177

D153 / D356

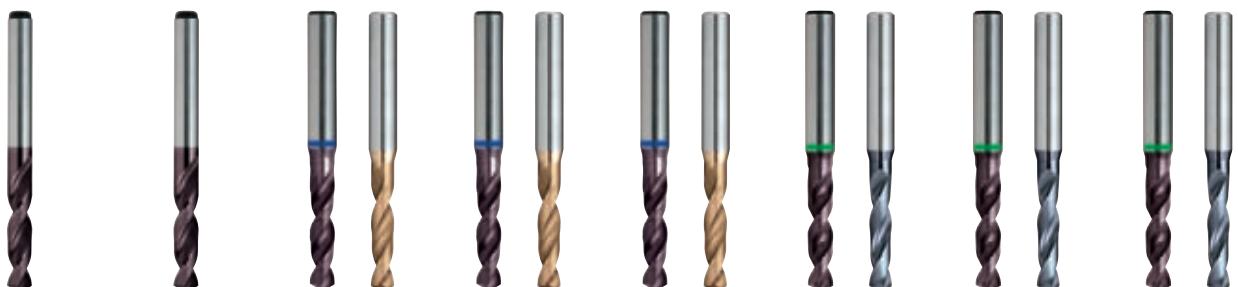
D153 / D356

D153 / D356

D155 / D323

D155 / D323

D155 / D323



•Available on request as special manufacture. Subject to lead time. •可定制。

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Taps Metric, For Tapping Blind/Through Holes

suttontools

- For through & blind holes

T292 - For use in grey cast iron (GG)

T670 - For use in Al >10% Si & cast iron (GGG)

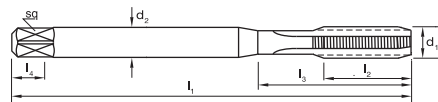
T335/T357 - For production tapping in die cast materials

- 通孔及盲孔用

T292 - 灰铸铁(GG)用

T670 - 球墨铸铁(GGG)及压铸铝 >10% Si用

T335/T357 - 压铸件用



尺寸参考 螺距 Limit & Nut Tolerance 精度及螺母容许公差

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	z	Drill Ø
DIN 371 REINFORCED SHANK									
0300	M 3	x 0.5	56	11	18	3.5	2.7	4	2.5
0400	M 4	x 0.7	63	13	21	4.5	3.4	4	3.3
0500	M 5	x 0.8	70	16	25	6.0	4.9	4	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	4	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	4	6.8
1000	M 10	x 1.5	100	24	39	10.0	8.0	4	8.5
DIN 376 REDUCED SHANK									
0600	M 6	x 1	80	19	-	4.5	3.4	4	5.0
0800	M 8	x 1.25	90	22	-	6.0	4.9	4	6.8
1000	M 10	x 1.5	100	24	-	7.0	5.5	4	8.5
1200	M 12	x 1.75	110	28	-	9.0	7.0	4	10.2
1400	M 14	x 2	110	30	-	11.0	9.0	4	12.0
1600	M 16	x 2	110	32	-	12.0	9.0	4	14.0
2000	M 20	x 2.5	140	34	-	16.0	12.0	4	17.5
DIN 374 FINE PITCH - REDUCED SHANK									
0403	MF 4	x 0.5	63	10	-	2.8	2.1	4	3.5
0503	MF 5	x 0.5	70	12	-	3.5	2.7	4	4.5
0604	MF 6	x 0.75	80	14	-	4.5	3.4	4	5.3
0805	MF 8	x 1	90	22	-	6.0	4.9	4	7.0
1005	MF 10	x 1	90	20	-	7.0	5.5	4	9.0
1006	MF 10	x 1.25	100	24	-	7.0	5.5	4	8.8
1206	MF 12	x 1.25	100	22	-	9.0	7.0	4	10.8
1207	MF 12	x 1.5	100	22	-	9.0	7.0	4	10.5
1406	MF 14	x 1.25	100	22	-	11.0	9.0	4	12.8
1407	MF 14	x 1.5	100	22	-	11.0	9.0	4	12.5
1607	MF 16	x 1.5	100	22	-	12.0	9.0	4	14.5
1807	MF 18	x 1.5	110	25	-	14.0	11.0	4	16.5
2007	MF 20	x 1.5	125	25	-	16.0	12.0	4	18.5

Product Name 产品名称

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Chamfer 倒角

Straight GG	Straight GG	Straight DC	Straight DC
D0408	D0414	D0408	D0408
HSSE V3	VHM 硬质合金	PM-HSS Co	PM-HSS Co
TiCN 氮化钛	TiCN 氮化钛	TiCN 氮化钛	TiCN 氮化钛
GG	GG	Die Cast	Die Cast
Low Relief	Low Relief		IK 内冷
Form C / 2.5 x P	Form C / 2.5 x P	Form E / 1.5 x P	Form E / 1.5 x P
6HX	6H	6HX	6HX
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T292	T670	T335	T357
T292 0300	•		
T292 0400	•		
T292 0500	•		
T292 0600	T670 0600	T335 0600	T357 0600
T292 0800	T670 0800	T335 0800	T357 0800
T292 1000	T670 1000	T335 1000	T357 1000
T293	T671	T336	T358
T293 0600	•		
T293 0800	•		
T293 1000	•		
T293 1200	T671 1200	T336 1200	T358 1200
T293 1400	•	T336 1400	T358 1400
T293 1600	T671 1600	T336 1600	T358 1600
T293 2000	•	T336 2000	T358 2000
T301	T743	T668	T669
T301 0403	•		
T301 0503	•		
T301 0604	•		
T301 0805	•		
T301 1005	•		
T301 1006	•	T668 1006	T669 1006
T301 1206	•		
T301 1207	•	T668 1207	T669 1207
T301 1406	•		
T301 1407	•	T668 1407	T669 1407
T301 1607	•	T668 1607	T669 1607
T301 1807	•		
T301 2007	•		

Recommended Tapping Drill

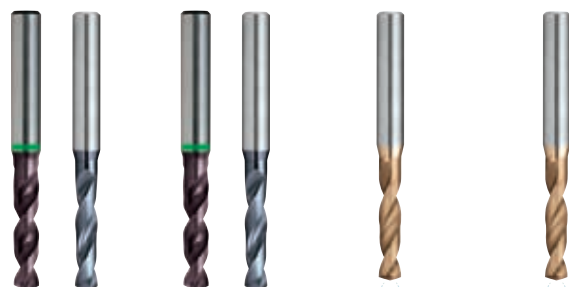
推荐的底孔钻头

D155 / D323

D155 / D323

D356

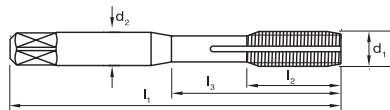
D356



Taps Metric, Forming, Single Coolant Groove

suttontools

- Depths up to approx. 3 x d₁
 - For cold forming of threads in materials with good flow characteristics
 - Ni - For non-ferrous materials
 - Blue - For ferrous materials
 - TiN - For materials up to 1000 N/mm²
 - TiCN - For difficult materials
- 加工深度可达 3 x d₁
 - 用于延展性良好的材料
 - Ni (氮化处理) - 非铁金属用
 - Blu (氧化处理) - 钢用
 - TiN (氮化钛) - 高性能泛用
 - TiCN (碳氮化钛) - 难加工材料用



尺寸参考 螺距 精度

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

色环及应用

Geometry 几何结构

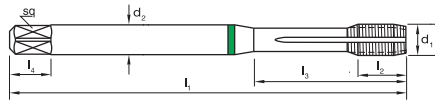
Size Ref.	d ₁	Pitch	Limit Style	l ₁	l ₂	l ₃	d ₂	sq	z	Tap hole min/max	
P LEAD P型-4牙(通孔用)											
0100	M 1	x 0.25	GH4	1	30	7	- 3.0	2.5	4	0.90 - 0.92	
0110	M 1.1	x 0.25	GH4	1	32	8	- 3	3	4	1.00 - 1.02	
0120	M 1.2	x 0.25	GH4	1	32	8	- 3.0	2.5	4	1.10 - 1.12	
0140	M 1.4	x 0.30	GH4	1	34	9	- 3.0	2.5	4	1.27 - 1.29	
0145	M 1.4	x 0.30	GH5	1	34	9	- 3.0	2.5	4	1.28 - 1.31	
0160	M 1.6	x 0.35	GH4	1	36	10	- 3.0	2.5	4	1.44 - 1.47	
0170	M 1.7	x 0.35	GH4	1	36	11	- 3.0	2.5	4	1.54 - 1.57	
0175	M 1.7	x 0.35	GH5	1	36	11	- 3.0	2.5	4	1.55 - 1.58	
0180	M 1.8	x 0.35	GH4	1	36	11	- 3.0	2.5	4	1.64 - 1.67	
0200	M 2	x 0.40	GH4	1	40	12	- 3.0	2.5	4	1.81 - 1.84	
0205	M 2	x 0.40	GH5	1	40	12	- 3.0	2.5	4	1.82 - 1.86	
0220	M 2.2	x 0.45	GH4	1	42	13	- 3.0	2.5	4	1.98 - 2.02	
0230	M 2.3	x 0.40	GH4	1	42	13	- 3.0	2.5	4	2.11 - 2.14	
0250	M 2.5	x 0.45	GH4	1	44	14	- 3.0	2.5	4	2.28 - 2.32	
0255	M 2.5	x 0.45	GH5	1	44	14	- 3.0	2.5	4	2.29 - 2.33	
0260	M 2.6	x 0.45	GH4	1	44	14	- 3.0	2.5	4	2.38 - 2.42	
0300	M 3	x 0.50	GH5	2	46	9	18	4.0	3.2	4	2.76 - 2.80
0306	M 3	x 0.50	GH6	2	46	9	18	4.0	3.2	4	2.78 - 2.82
0307	M 3	x 0.50	GH7	2	46	9	18	4.0	3.2	4	2.79 - 2.83
0350	M 3.5	x 0.60	GH5	2	48	9	18	4.0	3.2	4	3.20 - 3.25
0400	M 4	x 0.70	GH6	2	52	10	20	5.0	4.0	4	3.65 - 3.71
0500	M 5	x 0.80	GH6	2	60	11	22	5.5	4.5	4	4.59 - 4.66
0600	M 6	x 1.00	GH7	2	62	12	24	6.0	4.5	4	5.49 - 5.57
0700	M 7	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49 - 6.57
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34 - 7.44
1000	M 10	x 1.50	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.31
B LEAD B型-2牙(盲孔用)											
0100	M 1	x 0.25	GH4	1	30	7	- 3.0	2.5	4	0.90 - 0.92	
0110	M 1.1	x 0.25	GH4	1	32	8	- 3	3	4	1.00 - 1.02	
0120	M 1.2	x 0.25	GH4	1	32	8	- 3.0	2.5	4	1.10 - 1.12	
0140	M 1.4	x 0.30	GH5	1	34	9	- 3.0	2.5	4	1.27 - 1.29	
0160	M 1.6	x 0.35	GH4	1	36	10	- 3.0	2.5	4	1.44 - 1.47	
0170	M 1.7	x 0.35	GH5	1	36	11	- 3.0	2.5	4	1.54 - 1.57	
0180	M 1.8	x 0.35	GH4	1	36	11	- 3.0	2.5	4	1.64 - 1.67	
0200	M 2	x 0.40	GH4	1	40	12	- 3.0	2.5	4	1.81 - 1.84	
0220	M 2.2	x 0.45	GH4	1	42	13	- 3.0	2.5	4	1.98 - 2.02	
0230	M 2.3	x 0.40	GH4	1	42	13	- 3.0	2.5	4	2.11 - 2.14	
0250	M 2.5	x 0.45	GH4	1	44	14	- 3.0	2.5	4	2.28 - 2.32	
0260	M 2.6	x 0.45	GH4	1	44	14	- 3.0	2.5	4	2.38 - 2.42	
0300	M 3	x 0.50	GH5	2	46	9	19	4.0	3.2	4	2.76 - 2.80
0350	M 3.5	x 0.60	GH5	2	48	9	23	4.0	3.2	4	3.20 - 3.25
0400	M 4	x 0.70	GH6	2	52	10	21	5.0	4.0	4	3.65 - 3.71
0500	M 5	x 0.80	GH6	2	60	11	24	5.5	4.5	4	4.59 - 4.66
0600	M 6	x 1.00	GH7	2	62	12	31	6.0	4.5	4	5.49 - 5.57
0700	M 7	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49 - 6.57
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34 - 7.44
1000	M 10	x 1.50	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.31

D0606	D0606	D0614	D0614
HSS Co.8	HSS Co.8	HSS Co.8	PM-HSSE V3
Ni 氮化处理	Blu 氧化处理	TiN 氮化钛	TiCN 碳氮化钛
General Production	General Production	Medium Production	High Production
一般产量	一般产量	中/高产量	高产量
1 Coolant Groove M3+	1 Coolant Groove M3+	1 Coolant Groove M3+	1 Coolant Groove M3+
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
T510	T512	T514	T629
T510 0100	T512 0100	T514 0100	T629 0100
T510 0110	T512 0110	T514 0110	
T510 0120	T512 0120	T514 0120	T629 0120
T510 0140	T512 0140	T514 0140	T629 0140
		T514 0145	
T510 0160	T512 0160	T514 0160	T629 0160
T510 0170	T512 0170	T514 0170	T629 0170
		T514 0175	
T510 0180	T512 0180	T514 0180	T629 0180
T510 0200	T512 0200	T514 0200	T629 0200
		T514 0205	
T510 0220	T512 0220	T514 0220	T629 0220
T510 0230	T512 0230	T514 0230	T629 0230
T510 0250	T512 0250	T514 0250	T629 0250
T510 0255	T512 0255	T514 0255	
T510 0260	T512 0260	T514 0260	T629 0260
T510 0300	T512 0300	T514 0300	T629 0300
T510 0306	T512 0306	T514 0306	
		T514 0307	
T510 0350	T512 0350	T514 0350	T629 0350
T510 0400	T512 0400	T514 0400	T629 0400
T510 0500	T512 0500	T514 0500	T629 0500
T510 0600	T512 0600	T514 0600	T629 0600
T510 0700	T512 0700	T514 0700	
T510 0800	T512 0800	T514 0800	T629 0800
T510 1000	T512 1000	T514 1000	T629 1000
T511	T513	T515	T630
T511 0100	T513 0100	T515 0100	T630 0100
T511 0110	T513 0110	T515 0110	
T511 0120	T513 0120	T515 0120	T630 0120
T511 0140	T513 0140	T515 0140	T630 0140
T511 0160	T513 0160	T515 0160	T630 0160
T511 0170	T513 0170	T515 0170	T630 0170
T511 0180	T513 0180	T515 0180	T630 0180
T511 0200	T513 0200	T515 0200	T630 0200
T511 0220	T513 0220	T515 0220	T630 0220
T511 0230	T513 0230	T515 0230	T630 0230
T511 0250	T513 0250	T515 0250	T630 0250
T511 0260	T513 0260	T515 0260	T630 0260
T511 0300	T513 0300	T515 0300	T630 0300
T511 0350	T513 0350	T515 0350	T630 0350
T511 0400	T513 0400	T515 0400	T630 0400
T511 0500	T513 0500	T515 0500	T630 0500
T511 0600	T513 0600	T515 0600	T630 0600
T511 0700	T513 0700	T515 0700	
T511 0800	T513 0800	T515 0800	T630 0800
T511 1000	T513 1000	T515 1000	T630 1000

Taps - Thread Forming

suttontools

- SPM for superior performance
- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d₁
- 高钴粉末钢及硬质合金可大大提升效能
- 适用于延展率>10%的材料
- 通孔及盲孔合用
- 加工深度可达 3x d₁



尺寸参考 螺距 Limit & Nut Tolerance 精度及螺母容许公差

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Product Name	Material	Surface Finish	Application	Geometry	Chamfer
DIN 2174 REINFORCED SHANK										RLC	RLC	RLC	RLC		
										D0410	D0410	D0414	D0414		
										SPM 高钴粉末钢	SPM 高钴粉末钢	VHM 硬质合金	VHM 硬质合金		
										TiAIN 氮化铝钛	TiAIN 氮化铝钛	TiAIN 氮化铝钛	TiAIN 氮化铝钛		
										UNI	UNI	N	N		
										Multi Coolant Groove	IK 内冷	Multi Coolant Groove	Multi Coolant Groove IK 内冷		
										Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P		
										6HX	6HX	6HX	6HX		
										Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)		
										T325	T327	T682	T747		
0200	M 2	x 0.4	45	6	-	2.8	2.1	1.8		T325 0200					
0220	M 2.2	x 0.45	45	7	-	2.8	2.1	2.0		•					
0230	M 2.3	x 0.4	45	7	-	2.8	2.1	2.1		•					
0250	M 2.5	x 0.45	50	8	-	2.8	2.1	2.3		T325 0250					
0260	M 2.6	x 0.45	50	8	-	2.8	2.1	2.4		•					
0300	M 3	x 0.5	56	9	18	3.5	2.7	2.8		T325 0300		•			
0350	M 3.5	x 0.6	56	11	20	4.0	3.0	3.2		•					
0400	M 4	x 0.7	63	12	21	4.5	3.4	3.7		T325 0400		•			
0500	M 5	x 0.8	70	13	25	6.0	4.9	4.6		T325 0500	T327 0500	•			
0600	M 6	x 1	80	15	30	6.0	4.9	5.5		T325 0600	T327 0600	•			•
0700	M 7	x 1	80	15	30	7.0	5.5	6.5		•	•				
0800	M 8	x 1.25	90	18	35	8.0	6.2	7.4		T325 0800	T327 0800	•			•
1000	M 10	x 1.5	100	20	39	10.0	8.0	9.3		T325 1000	T327 1000	•			•
DIN 2174 REDUCED SHANK										T326	T328	T683	T748		
1200	M 12	x 1.75	110	23	-	9.0	7.0	11.2		T326 1200	T328 1200	•			•
1400	M 14	x 2	110	25	-	11.0	9.0	13.1		T326 1400	•	•			•
1600	M 16	x 2	110	25	-	12.0	9.0	15.1		T326 1600	•	•			•
1800	M 18	x 2.5	125	30	-	14.0	11.0	16.9		•	•				
2000	M 20	x 2.5	140	30	-	16.0	12.0	18.9		•	•				



Recommended Tapping Drill

推荐的底孔钻头



•Available on request as special manufacture. Subject to lead time. •可定制.

Drills Carbide 3 x D

suttontools

D323/D329

- Suitable for materials up to 1400N/mm²
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life

D356

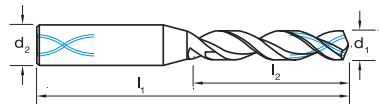
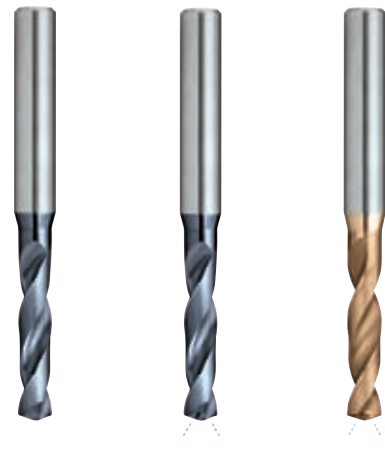
- Excellent solution for stainless steels & difficult super alloy type materials
- Optimised geometry ensures no work hardening and high productivity
- HELICA for outstanding oxidation resistance and hot hardness

D323/D329

- 钢件用、可达1400N/mm²
- 微型几何设计及表面微处理、具有最佳切屑控制效果
- 采用氮化铝铬涂层、最大程度延长刀具的使用寿命

D356

- 针对不锈钢及耐热合金等难削材
- 优化的几何设计、确保无加工硬化及最高生产率
- 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)
0300	3.0	62	20	6
0310	3.1	62	20	6
0318	3.18 1/8	62	20	6
0320	3.2	62	20	6
0330	3.3	62	20	6
0340	3.4	62	20	6
0350	3.5	62	20	6
0357	3.57 9/64	62	20	6
0360	3.6	62	20	6
0370	3.7	62	20	6
0380	3.8	66	24	6
0390	3.9	66	24	6
0397	3.97 5/32	66	24	6
0400	4.0	66	24	6
0410	4.1	66	24	6
0420	4.2	66	24	6
0430	4.3	66	24	6
0437	4.37 11/64	66	24	6
0440	4.4	66	24	6
0450	4.5	66	24	6
0460	4.6	66	24	6
0470	4.7	66	24	6
0476	4.76 3/16	66	24	6
0480	4.8	66	28	6
0490	4.9	66	28	6
0500	5.0	66	28	6
0510	5.1	66	28	6
0516	5.16 13/64	66	28	6
0520	5.2	66	28	6
0530	5.3	66	28	6
0540	5.4	66	28	6
0550	5.5	66	28	6
0556	5.56 7/32	66	28	6
0560	5.6	66	28	6
0570	5.7	66	28	6
0580	5.8	66	28	6
0590	5.9	66	28	6
0595	5.95 15/64	66	28	6
0600	6.0	66	28	6
0610	6.1	79	34	8
0620	6.2	79	34	8
0630	6.3	79	34	8
0635	6.35 1/4	79	34	8
0640	6.4	79	34	8
0650	6.5	79	34	8
0660	6.6	79	34	8
0670	6.7	79	34	8
0676	6.76 17/64	79	34	8
0680	6.8	79	34	8
0690	6.9	79	34	8

Catalogue Code 目录代码

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Point Type 钻尖类别

Shank Form (DIN 6535) 柄径型

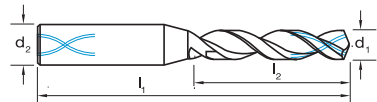
D323	D329	D356
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
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D323 0310	D329 0310	D356 0310
D323 0318	D329 0318	D356 0318
D323 0320	D329 0320	D356 0320
D323 0330	D329 0330	D356 0330
D323 0340	D329 0340	D356 0340
D323 0350	D329 0350	D356 0350
D323 0357	D329 0357	D356 0357
D323 0360	D329 0360	D356 0360
D323 0370	D329 0370	D356 0370
D323 0380	D329 0380	D356 0380
D323 0390	D329 0390	D356 0390
D323 0397	D329 0397	D356 0397
D323 0400	D329 0400	D356 0400
D323 0410	D329 0410	D356 0410
D323 0420	D329 0420	D356 0420
D323 0430	D329 0430	D356 0430
D323 0437	D329 0437	D356 0437
D323 0440	D329 0440	D356 0440
D323 0450	D329 0450	D356 0450
D323 0460	D329 0460	D356 0460
D323 0470	D329 0470	D356 0470
D323 0476	D329 0476	D356 0476
D323 0480	D329 0480	D356 0480
D323 0490	D329 0490	D356 0490
D323 0500	D329 0500	D356 0500
D323 0510	D329 0510	D356 0510
D323 0516	D329 0516	D356 0516
D323 0520	D329 0520	D356 0520
D323 0530	D329 0530	D356 0530
D323 0540	D329 0540	D356 0540
D323 0550	D329 0550	D356 0550
D323 0556	D329 0556	D356 0556
D323 0560	D329 0560	D356 0560
D323 0570	D329 0570	D356 0570
D323 0580	D329 0580	D356 0580
D323 0590	D329 0590	D356 0590
D323 0595	D329 0595	D356 0595
D323 0600	D329 0600	D356 0600
D323 0610	D329 0610	D356 0610
D323 0620	D329 0620	D356 0620
D323 0630	D329 0630	D356 0630
D323 0635	D329 0635	D356 0635
D323 0640	D329 0640	D356 0640
D323 0650	D329 0650	D356 0650
D323 0660	D329 0660	D356 0660
D323 0670	D329 0670	D356 0670
D323 0676	D329 0676	D356 0676
D323 0680	D329 0680	D356 0680
D323 0690	D329 0690	D356 0690

Drills Carbide 3 x D



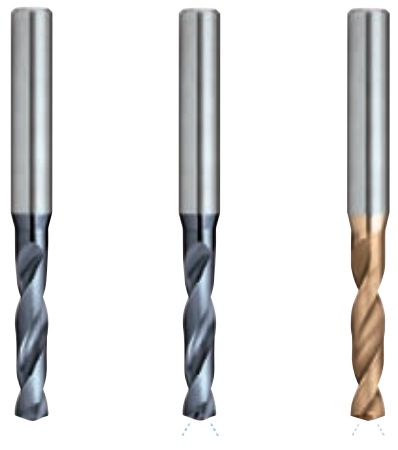
- D323/D329
- Suitable for materials up to 1400N/mm²
 - Micro geometry & surface conditioning for optimal chip control
 - AlCrN for maximum tool life
- D356
- Excellent solution for stainless steels & difficult super alloy type materials
 - Optimised geometry ensures no work hardening and high productivity
 - HELICA for outstanding oxidation resistance and hot hardness

- D323/D329
- 钢件用、可达1400N/mm²
 - 微型几何设计及表面处理、具有最佳切屑控制效果
 - 采用氮化铝铬涂层、最大程度延长刀具的使用寿命
- D356
- 针对不锈钢及耐热合金等难削材
 - 优化的几何设计、确保无加工硬化及最高生产率
 - 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)
0700	7.0	79	34	8
0710	7.1	79	41	8
0714	7.14 9/32	79	41	8
0720	7.2	79	41	8
0730	7.3	79	41	8
0740	7.4	79	41	8
0750	7.5	79	41	8
0754	7.54 19/64	79	41	8
0760	7.6	79	41	8
0770	7.7	79	41	8
0780	7.8	79	41	8
0790	7.9	79	41	8
0794	7.94 5/16	79	41	8
0800	8.0	79	41	8
0810	8.1	89	47	10
0820	8.2	89	47	10
0830	8.3	89	47	10
0833	8.33 21/64	89	47	10
0840	8.4	89	47	10
0850	8.5	89	47	10
0860	8.6	89	47	10
0870	8.7	89	47	10
0873	8.73 11/32	89	47	10
0880	8.8	89	47	10
0890	8.9	89	47	10
0900	9.0	89	47	10
0910	9.1	89	47	10
0913	9.13 23/64	89	47	10
0920	9.2	89	47	10
0930	9.3	89	47	10
0940	9.4	89	47	10
0950	9.5	89	47	10
0953	9.53 3/8	89	47	10
0960	9.6	89	47	10
0970	9.7	89	47	10
0980	9.8	89	47	10
0990	9.9	89	47	10
0992	9.92 25/64	89	47	10
1000	10.0	89	47	10
1010	10.1	102	55	12
1020	10.2	102	55	12
1030	10.3	102	55	12
1032	10.32 13/32	102	55	12
1040	10.4	102	55	12
1050	10.5	102	55	12
1060	10.6	102	55	12
1070	10.7	102	55	12
1072	10.72 27/64	102	55	12
1080	10.8	102	55	12
1090	10.9	102	55	12



Catalogue Code 目录代码
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Geometry 几何结构
 Point Type 钻尖类别
 Shank Form (DIN 6535) 柄径型

D323	D329	D356
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
D323 0700	D329 0700	D356 0700
D323 0710	D329 0710	D356 0710
D323 0714	D329 0714	D356 0714
D323 0720	D329 0720	D356 0720
D323 0730	D329 0730	D356 0730
D323 0740	D329 0740	D356 0740
D323 0750	D329 0750	D356 0750
D323 0754	D329 0754	D356 0754
D323 0760	D329 0760	D356 0760
D323 0770	D329 0770	D356 0770
D323 0780	D329 0780	D356 0780
D323 0790	D329 0790	D356 0790
D323 0794	D329 0794	D356 0794
D323 0800	D329 0800	D356 0800
D323 0810	D329 0810	D356 0810
D323 0820	D329 0820	D356 0820
D323 0830	D329 0830	D356 0830
D323 0833	D329 0833	D356 0833
D323 0840	D329 0840	D356 0840
D323 0850	D329 0850	D356 0850
D323 0860	D329 0860	D356 0860
D323 0870	D329 0870	D356 0870
D323 0873	D329 0873	D356 0873
D323 0880	D329 0880	D356 0880
D323 0890	D329 0890	D356 0890
D323 0900	D329 0900	D356 0900
D323 0910	D329 0910	D356 0910
D323 0913	D329 0913	D356 0913
D323 0920	D329 0920	D356 0920
D323 0930	D329 0930	D356 0930
D323 0940	D329 0940	D356 0940
D323 0950	D329 0950	D356 0950
D323 0953	D329 0953	D356 0953
D323 0960	D329 0960	D356 0960
D323 0970	D329 0970	D356 0970
D323 0980	D329 0980	D356 0980
D323 0990	D329 0990	D356 0990
D323 0992	D329 0992	D356 0992
D323 1000	D329 1000	D356 1000
D323 1010	D329 1010	D356 1010
D323 1020	D329 1020	D356 1020
D323 1030	D329 1030	D356 1030
D323 1032	D329 1032	D356 1032
D323 1040	D329 1040	D356 1040
D323 1050	D329 1050	D356 1050
D323 1060	D329 1060	D356 1060
D323 1070	D329 1070	D356 1070
		D356 1072
D323 1080	D329 1080	D356 1080
D323 1090	D329 1090	D356 1090

* HB & HE Shank styles available * HB 和 HE 柄径样式可供选购

Drills Carbide 3 x D



D323/D329

- Suitable for materials up to 1400N/mm²
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life

D356

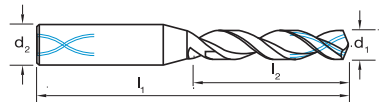
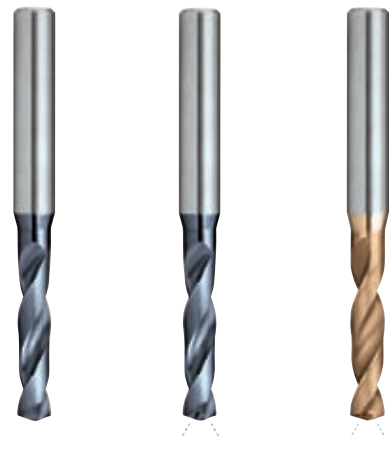
- Excellent solution for stainless steels & difficult super alloy type materials
- Optimised geometry ensures no work hardening and high productivity
- HELICA for outstanding oxidation resistance and hot hardness

D323/D329

- 钢件用、可达1400N/mm²
- 微型几何设计及表面微处理、具有最佳切屑控制效果
- 采用氮化铝铬涂层、最大程度延长刀具的使用寿命

D356

- 针对不锈钢及耐热合金等难削材
- 优化的几何设计、确保无加工硬化及最高生产率
- 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)
1100	11.0	102	55	12
1110	11.1	102	55	12
1111	11.11 7/16	102	55	12
1120	11.2	102	55	12
1130	11.3	102	55	12
1140	11.4	102	55	12
1150	11.5	102	55	12
1151	11.51 29/64	102	55	12
1160	11.6	102	55	12
1170	11.7	102	55	12
1180	11.8	102	55	12
1190	11.9	102	55	12
1191	11.91 15/32	102	55	12
1200	12.0	102	55	12
1231	12.30 31/64	107	60	14
1250	12.5	107	60	14
1269	12.69 1/2	107	60	14
1280	12.8	107	60	14
1300	13.0	107	60	14
1310	13.10 33/64	107	60	14
1349	13.49 17/32	107	60	14
1350	13.5	107	60	14
1380	13.8	107	60	14
1389	13.89 35/64	107	60	14
1400	14.0	107	60	14
1429	14.29 9/16	115	65	16
1450	14.5	115	65	16
1468	14.68 37/64	115	65	16
1480	14.8	115	65	16
1500	15.0	115	65	16
1508	15.08 19/32	115	65	16
1548	15.48 39/64	115	65	16
1550	15.5	115	65	16
1580	15.8	115	65	16
1588	15.88 5/8	115	65	16
1600	16.0	115	65	16
1650	16.5	123	73	18
1667	16.67 21/32	123	73	18
1680	16.8	123	73	18
1700	17.0	123	73	18
1746	17.46 11/16	123	73	18
1750	17.5	123	73	18
1780	17.8	123	73	18
1800	18.0	123	73	18
1826	18.26 23/32	131	79	20
1850	18.5	131	79	20
1900	19.0	131	79	20
1905	19.05 3/4	131	79	20
1950	19.5	131	79	20
2000	20.0	131	79	20

Catalogue Code 目录代码
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Geometry 几何结构
 Point Type 钻尖类别
 Shank Form (DIN 6535) 柄径型

D323	D329	D356
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
D323 1100	D329 1100	D356 1100
D323 1110	D329 1110	D356 1110
D323 1111	D329 1111	D356 1111
D323 1120	D329 1120	D356 1120
D323 1130	D329 1130	D356 1130
D323 1140	D329 1140	D356 1140
D323 1150	D329 1150	D356 1150
		D356 1151
D323 1160	D329 1160	D356 1160
D323 1170	D329 1170	D356 1170
D323 1180	D329 1180	D356 1180
D323 1190	D329 1190	D356 1190
D323 1191	D329 1191	D356 1191
D323 1200	D329 1200	D356 1200
		D356 1231
D323 1250	D329 1250	D356 1250
D323 1269	D329 1269	D356 1269
D323 1280	D329 1280	D356 1280
D323 1300	D329 1300	D356 1300
		D356 1310
D323 1349	D329 1349	D356 1349
D323 1350	D329 1350	D356 1350
D323 1380		
		D356 1389
D323 1400	D329 1400	D356 1400
D323 1429	D329 1429	D356 1429
D323 1450	D329 1450	D356 1450
		D356 1468
D323 1480		
D323 1500	D329 1500	D356 1500
		D356 1508
		D356 1548
D323 1550	D329 1550	D356 1550
D323 1580		
D323 1588	D329 1588	D356 1588
D323 1600	D329 1600	D356 1600
D323 1650	D329 1650	D356 1650
		D356 1667
D323 1680		
D323 1700	D329 1700	D356 1700
D323 1746	D329 1746	D356 1746
D323 1750	D329 1750	D356 1750
D323 1780		
D323 1800	D329 1800	D356 1800
		D356 1826
D323 1850	D329 1850	D356 1850
D323 1900	D329 1900	D356 1900
D323 1905	D329 1905	D356 1905
D323 1950	D329 1950	D356 1950
D323 2000	D329 2000	D356 2000

*Available on request as special manufacture. Subject to lead time. *可定制.

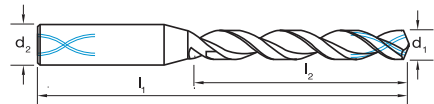
* HB & HE Shank styles available * HB 和 HE 柄径样式可供选购

Drills Carbide 5 x D



- D326/D332
- Suitable for materials up to 1400N/mm²
 - Micro geometry & surface conditioning for optimal chip control
 - AlCrN for maximum tool life
- D358
- Excellent solution for stainless steels & difficult super alloy type materials
 - Optimised geometry ensures no work hardening and high productivity
 - HELICA for outstanding oxidation resistance and hot hardness

- D326/D332
- 钢件用、可达1400N/mm²
 - 微型几何设计及表面微处理、具有最佳切屑控制效果
 - 采用氮化铝铬涂层、最大程度延长刀具的使用寿命
- D358
- 针对不锈钢及耐热合金等难削材
 - 优化的几何设计、确保无加工硬化及最高生产率
 - 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)
0300	3.0	66	28	6
0310	3.1	66	28	6
0318	3.18 1/8	66	28	6
0320	3.2	66	28	6
0330	3.3	66	28	6
0340	3.4	66	28	6
0350	3.5	66	28	6
0357	3.57 9/64	66	28	6
0360	3.6	66	28	6
0370	3.7	66	28	6
0380	3.8	74	36	6
0390	3.9	74	36	6
0397	3.97 5/32	74	36	6
0400	4.0	74	36	6
0410	4.1	74	36	6
0420	4.2	74	36	6
0430	4.3	74	36	6
0437	4.37 11/64	74	36	6
0440	4.4	74	36	6
0450	4.5	74	36	6
0460	4.6	74	36	6
0470	4.7	74	36	6
0476	4.76 3/16	74	36	6
0480	4.8	82	44	6
0490	4.9	82	44	6
0500	5.0	82	44	6
0510	5.1	82	44	6
0516	5.16 13/64	82	44	6
0520	5.2	82	44	6
0530	5.3	82	44	6
0540	5.4	82	44	6
0550	5.5	82	44	6
0556	5.56 7/32	82	44	6
0560	5.6	82	44	6
0570	5.7	82	44	6
0580	5.8	82	44	6
0590	5.9	82	44	6
0595	5.95 15/64	82	44	6
0600	6.0	82	44	6
0610	6.1	91	53	8
0620	6.2	91	53	8
0630	6.3	91	53	8
0635	6.35 1/4	91	53	8
0640	6.4	91	53	8
0650	6.5	91	53	8
0660	6.6	91	53	8
0670	6.7	91	53	8
0676	6.76 17/64	91	53	8
0680	6.8	91	53	8
0690	6.9	91	53	8

- Catalogue Code 目录代码
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Geometry 几何结构
 Point Type 钻尖类别
 Shank Form (DIN 6535) 柄径型

D326	D332	D358
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
D326 0300	D332 0300	D358 0300
D326 0310	D332 0310	D358 0310
D326 0318	D332 0318	D358 0318
D326 0320	D332 0320	D358 0320
D326 0330	D332 0330	D358 0330
D326 0340	D332 0340	D358 0340
D326 0350	D332 0350	D358 0350
D326 0357	D332 0357	D358 0357
D326 0360	D332 0360	D358 0360
D326 0370	D332 0370	D358 0370
D326 0380	D332 0380	D358 0380
D326 0390	D332 0390	D358 0390
D326 0397	D332 0397	D358 0397
D326 0400	D332 0400	D358 0400
D326 0410	D332 0410	D358 0410
D326 0420	D332 0420	D358 0420
D326 0430	D332 0430	D358 0430
D326 0437	D332 0437	D358 0437
D326 0440	D332 0440	D358 0440
D326 0450	D332 0450	D358 0450
D326 0460	D332 0460	D358 0460
D326 0470	D332 0470	D358 0470
D326 0476	D332 0476	D358 0476
D326 0480	D332 0480	D358 0480
D326 0490	D332 0490	D358 0490
D326 0500	D332 0500	D358 0500
D326 0510	D332 0510	D358 0510
D326 0516	D332 0516	D358 0516
D326 0520	D332 0520	D358 0520
D326 0530	D332 0530	D358 0530
D326 0540	D332 0540	D358 0540
D326 0550	D332 0550	D358 0550
D326 0556	D332 0556	D358 0556
D326 0560	D332 0560	D358 0560
D326 0570	D332 0570	D358 0570
D326 0580	D332 0580	D358 0580
D326 0590	D332 0590	D358 0590
D326 0595	D332 0595	D358 0595
D326 0600	D332 0600	D358 0600
D326 0610	D332 0610	D358 0610
D326 0620	D332 0620	D358 0620
D326 0630	D332 0630	D358 0630
D326 0635	D332 0635	D358 0635
D326 0640	D332 0640	D358 0640
D326 0650	D332 0650	D358 0650
D326 0660	D332 0660	D358 0660
D326 0670	D332 0670	D358 0670
D326 0676	D332 0676	D358 0676
D326 0680	D332 0680	D358 0680
D326 0690	D332 0690	D358 0690

* HB & HE Shank styles available

* HB 和 HE 柄径样式可供选购

Drills Carbide 5 x D



D326/D332

- Suitable for materials up to 1400N/mm²
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life

D358

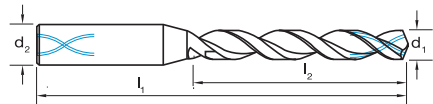
- Excellent solution for stainless steels & difficult super alloy type materials
- Optimised geometry ensures no work hardening and high productivity
- HELICA for outstanding oxidation resistance and hot hardness

D326/D332

- 钢件用、可达1400N/mm²
- 微型几何设计及表面微处理、具有最佳切屑控制效果
- 采用氮化铝铬涂层、最大程度延长刀具的使用寿命

D358

- 针对不锈钢及耐热合金等难削材
- 优化的几何设计、确保无加工硬化及最高生产率
- 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)	
0700	7.0	91	53	8	
0710	7.1	91	53	8	
0714	7.14	9/32	91	53	8
0720	7.2	91	53	8	
0730	7.3	91	53	8	
0740	7.4	91	53	8	
0750	7.5	91	53	8	
0754	7.54	19/64	91	53	8
0760	7.6	91	53	8	
0770	7.7	91	53	8	
0780	7.8	91	53	8	
0790	7.9	91	53	8	
0794	7.94	5/16	91	53	8
0800	8.0	91	53	8	
0810	8.1	103	61	10	
0820	8.2	103	61	10	
0830	8.3	103	61	10	
0833	8.33	21/64	103	61	10
0840	8.4	103	61	10	
0850	8.5	103	61	10	
0860	8.6	103	61	10	
0870	8.7	103	61	10	
0873	8.73	11/32	103	61	10
0880	8.8	103	61	10	
0890	8.9	103	61	10	
0900	9.0	103	61	10	
0910	9.1	103	61	10	
0913	9.13	23/64	103	61	10
0920	9.2	103	61	10	
0930	9.3	103	61	10	
0940	9.4	103	61	10	
0950	9.5	103	61	10	
0953	9.53	3/8	103	61	10
0960	9.6	103	61	10	
0970	9.7	103	61	10	
0980	9.8	103	61	10	
0990	9.9	103	61	10	
0992	9.92	25/64	103	61	10
1000	10.0	103	61	10	
1010	10.1	118	71	12	
1020	10.2	118	71	12	
1030	10.3	118	71	12	
1032	10.32	13/32	118	71	12
1040	10.4	118	71	12	
1050	10.5	118	71	12	
1060	10.6	118	71	12	
1070	10.7	118	71	12	
1072	10.72	27/64	118	71	12
1080	10.8	118	71	12	
1090	10.9	118	71	12	

Catalogue Code 目录代码

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Point Type 钻尖类别

Shank Form (DIN 6535) 柄径型

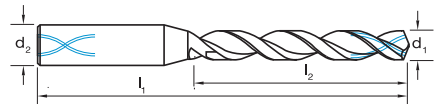
D326	D332	D358
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
D326 0700	D332 0700	D358 0700
D326 0710	D332 0710	D358 0710
D326 0714	D332 0714	D358 0714
D326 0720	D332 0720	D358 0720
D326 0730	D332 0730	D358 0730
D326 0740	D332 0740	D358 0740
D326 0750	D332 0750	D358 0750
D326 0754	D332 0754	D358 0754
D326 0760	D332 0760	D358 0760
D326 0770	D332 0770	D358 0770
D326 0780	D332 0780	D358 0780
D326 0790	D332 0790	D358 0790
D326 0794	D332 0794	D358 0794
D326 0800	D332 0800	D358 0800
D326 0810	D332 0810	D358 0810
D326 0820	D332 0820	D358 0820
D326 0830	D332 0830	D358 0830
D326 0833	D332 0833	D358 0833
D326 0840	D332 0840	D358 0840
D326 0850	D332 0850	D358 0850
D326 0860	D332 0860	D358 0860
D326 0870	D332 0870	D358 0870
D326 0873	D332 0873	D358 0873
D326 0880	D332 0880	D358 0880
D326 0890	D332 0890	D358 0890
D326 0900	D332 0900	D358 0900
D326 0910	D332 0910	D358 0910
D326 0913	D332 0913	D358 0913
D326 0920	D332 0920	D358 0920
D326 0930	D332 0930	D358 0930
D326 0940	D332 0940	D358 0940
D326 0950	D332 0950	D358 0950
D326 0953	D332 0953	D358 0953
D326 0960	D332 0960	D358 0960
D326 0970	D332 0970	D358 0970
D326 0980	D332 0980	D358 0980
D326 0990	D332 0990	D358 0990
D326 0992	D332 0992	D358 0992
D326 1000	D332 1000	D358 1000
D326 1010	D332 1010	D358 1010
D326 1020	D332 1020	D358 1020
D326 1030	D332 1030	D358 1030
D326 1032	D332 1032	D358 1032
D326 1040	D332 1040	D358 1040
D326 1050	D332 1050	D358 1050
D326 1060	D332 1060	D358 1060
D326 1070	D332 1070	D358 1070
		D358 1072
D326 1080	D332 1080	D358 1080
D326 1090	D332 1090	D358 1090

Drills Carbide 5 x D



- D326/D332
- Suitable for materials up to 1400N/mm²
 - Micro geometry & surface conditioning for optimal chip control
 - AlCrN for maximum tool life
- D358
- Excellent solution for stainless steels & difficult super alloy type materials
 - Optimised geometry ensures no work hardening and high productivity
 - HELICA for outstanding oxidation resistance and hot hardness

- D326/D332
- 钢件用、可达1400N/mm²
 - 微型几何设计及表面微处理、具有最佳切屑控制效果
 - 采用氮化铝铬涂层、最大程度延长刀具的使用寿命
- D358
- 针对不锈钢及耐热合金等难削材
 - 优化的几何设计、确保无加工硬化及最高生产率
 - 专用HELICA涂层、超卓的耐高温氧化及红硬性



尺寸参考

Size Ref.	d ₁ (m7)	l ₁	l ₂	d ₂ (h6)
1100	11.0	118	71	12
1110	11.1	118	71	12
1111	11.11 7/16	118	71	12
1120	11.2	118	71	12
1130	11.3	118	71	12
1140	11.4	118	71	12
1150	11.5	118	71	12
1151	11.51 29/64	118	71	12
1160	11.6	118	71	12
1170	11.7	118	71	12
1180	11.8	118	71	12
1190	11.9	118	71	12
1191	11.91 15/32	118	71	12
1200	12.0	118	71	12
1231	12.31 31/64	124	77	14
1250	12.5	124	77	14
1269	12.69 1/2	124	77	14
1280	12.8	124	77	14
1300	13.0	124	77	14
1310	13.10 33/64	124	77	14
1349	13.49 17/32	124	77	14
1350	13.5	124	77	14
1380	13.8	124	77	14
1389	13.89 35/64	124	77	14
1400	14.0	124	77	14
1429	14.29 9/16	133	83	16
1450	14.5	133	83	16
1468	14.68 37/64	133	83	16
1480	14.8	133	83	16
1500	15.0	133	83	16
1508	15.08 19/32	133	83	16
1548	15.48 39/64	133	83	16
1550	15.5	133	83	16
1580	15.8	133	83	16
1588	15.88 5/8	133	83	16
1600	16.0	133	83	16
1650	16.5	143	93	18
1667	16.67 21/32	143	93	18
1680	16.8	143	93	18
1700	17.0	143	93	18
1746	17.46 11/16	143	93	18
1750	17.5	143	93	18
1780	17.8	143	93	18
1800	18.0	143	93	18
1826	18.26 23/32	153	101	20
1850	18.5	153	101	20
1900	19.0	153	101	20
1905	19.05 3/4	153	101	20
1950	19.5	153	101	20
1980	19.8	153	101	20
2000	20.0	153	101	20

- Catalogue Code 目录代码
Discount Group 折扣组
Material 材料
Surface Finish 表面处理
Application 色环及应用
Geometry 几何结构
Point Type 钻尖类别
Shank Form (DIN 6535) 柄径型

D326	D332	D358
A0210	A0210	A0210
VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
AlCrN 氮化铝铬	AlCrN 氮化铝铬	HELICA
N	N	VA
R30	R30 - IK 内冷	R30 - IK 内冷
140° Form C	140° Form C	140° 4 Facet Form C
HA	HA	HA
Item # (货号)	Item # (货号)	Item # (货号)
D326 1100	D332 1100	D358 1100
D326 1110	D332 1110	D358 1110
D326 1111	D332 1111	D358 1111
D326 1120	D332 1120	D358 1120
D326 1130	D332 1130	D358 1130
D326 1140	D332 1140	D358 1140
D326 1150	D332 1150	D358 1150
		D358 1151
D326 1160	D332 1160	D358 1160
D326 1170	D332 1170	D358 1170
D326 1180	D332 1180	D358 1180
D326 1190	D332 1190	D358 1190
D326 1191	D332 1191	D358 1191
D326 1200	D332 1200	D358 1200
		D358 1231
D326 1250	D332 1250	D358 1250
D326 1269	D332 1269	D358 1269
D326 1280	D332 1280	D358 1280
D326 1300	D332 1300	D358 1300
		D358 1310
D326 1349	D332 1349	D358 1349
D326 1350	D332 1350	D358 1350
D326 1380	•	
		D358 1389
D326 1400	D332 1400	D358 1400
D326 1429	D332 1429	D358 1429
D326 1450	D332 1450	D358 1450
		D358 1468
D326 1480	•	
D326 1500	D332 1500	D358 1500
		D358 1508
		D358 1548
D326 1550	D332 1550	D358 1550
D326 1580	•	
D326 1588	D332 1588	D358 1588
D326 1600	D332 1600	D358 1600
D326 1650	D332 1650	D358 1650
		D358 1667
D326 1680	•	
D326 1700	D332 1700	D358 1700
D326 1746	D332 1746	D358 1746
D326 1750	D332 1750	D358 1750
D326 1780	•	
D326 1800	D332 1800	D358 1800
		D358 1826
D326 1850	D332 1850	D358 1850
D326 1900	D332 1900	D358 1900
D326 1905	D332 1905	D358 1905
D326 1950	D332 1950	D358 1950
	•	
D326 2000	D332 2000	D358 2000

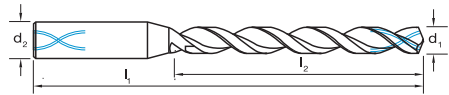
*Available on request as special manufacture. Subject to lead time. *可定制.

* HB & HE Shank styles available * HB 和 HE 柄径样式可供选购

Drills Carbide 8 x D

suttontools

- Suitable for materials up to 1400N/mm² - 钢件用、可达1400N/mm²
- Strong core with internal coolant supply - 高刚性芯径及内冷油孔设计
- Micro geometry & surface conditioning for optimal chip control - 微型几何设计及表面微处理、具有最佳切屑控制效果
- AlCrN for maximum tool life - 采用氮化铝铬涂层、最大程度延长刀具的使用寿命



尺寸参考

Size Ref.	d ₁	l ₁	l ₂	d ₂	Item # (货号)	
0500	5.0	95	57	6	D335 0500	
0510	5.1	95	57	6	D335 0510	
0516	5.16	13/64	95	57	6	D335 0516
0520	5.2	95	57	6	D335 0520	
0530	5.3	95	57	6	D335 0530	
0540	5.4	95	57	6	D335 0540	
0550	5.5	95	57	6	D335 0550	
0556	5.56	7/32	95	57	6	D335 0556
0560	5.6	95	57	6	D335 0560	
0570	5.7	95	57	6	D335 0570	
0580	5.8	95	57	6	D335 0580	
0590	5.9	95	57	6	D335 0590	
0595	5.95	15/64	95	57	6	D335 0595
0600	6.0	95	57	6	D335 0600	
0610	6.1	114	76	8	D335 0610	
0620	6.2	114	76	8	D335 0620	
0630	6.3	114	76	8	D335 0630	
0635	6.35	1/4	114	76	8	D335 0635
0640	6.4	114	76	8	D335 0640	
0650	6.5	114	76	8	D335 0650	
0660	6.6	114	76	8	D335 0660	
0670	6.7	114	76	8	D335 0670	
0676	6.76	17/64	114	76	8	D335 0676
0680	6.8	114	76	8	D335 0680	
0690	6.9	114	76	8	D335 0690	
0700	7.0	114	76	8	D335 0700	
0710	7.1	114	76	8	D335 0710	
0714	7.14	9/32	114	76	8	D335 0714
0720	7.2	114	76	8	D335 0720	
0730	7.3	114	76	8	D335 0730	
0740	7.4	114	76	8	D335 0740	
0750	7.5	114	76	8	D335 0750	
0754	7.54	19/64	114	76	8	D335 0754
0760	7.6	114	76	8	D335 0760	
0770	7.7	114	76	8	D335 0770	
0780	7.8	114	76	8	D335 0780	
0790	7.9	114	76	8	D335 0790	
0794	7.94	5/16	114	76	8	D335 0794
0800	8.0	114	76	8	D335 0800	
0810	8.1	142	95	10	D335 0810	
0820	8.2	142	95	10	D335 0820	
0830	8.3	142	95	10	D335 0830	
0833	8.33	21/64	142	95	10	D335 0833
0840	8.4	142	95	10	D335 0840	



Catalogue Code 目录代码
Discount Group 折扣组
Material 材料
Surface Finish 表面处理
Application 色环及应用
Geometry 几何结构
Point Type 钻尖类别
Shank Form 柄径型

D335
A0210
VHM 硬质合金
AlCrN 氮化铝铬
Up to 1400N/mm ²
R30 - IK 内冷
140° Form C
HA (h6)

尺寸参考

Size Ref.	d ₁	l ₁	l ₂	d ₂	Item # (货号)	
0850	8.5	142	95	10	D335 0850	
0860	8.6	142	95	10	D335 0860	
0870	8.7	142	95	10	D335 0870	
0873	8.73	11/32	142	95	10	D335 0873
0880	8.8	142	95	10	D335 0880	
0890	8.9	142	95	10	D335 0890	
0900	9.0	142	95	10	D335 0900	
0910	9.1	142	95	10	D335 0910	
0913	9.13	23/64	142	95	10	D335 0913
0920	9.2	142	95	10	D335 0920	
0930	9.3	142	95	10	D335 0930	
0940	9.4	142	95	10	D335 0940	
0950	9.5	142	95	10	D335 0950	
0953	9.53	3/8	142	95	10	D335 0953
0960	9.6	142	95	10	D335 0960	
0970	9.7	142	95	10	D335 0970	
0980	9.8	142	95	10	D335 0980	
0990	9.9	142	95	10	D335 0990	
0992	9.92	25/64	142	95	10	D335 0992
1000	10.0	142	95	10	D335 1000	
1010	10.1	162	114	12	D335 1010	
1020	10.2	162	114	12	D335 1020	
1030	10.3	162	114	12	D335 1030	
1032	10.32	13/32	162	114	12	D335 1032
1040	10.4	162	114	12	D335 1040	
1050	10.5	162	114	12	D335 1050	
1060	10.6	162	114	12	D335 1060	
1070	10.7	162	114	12	D335 1070	
1080	10.8	162	114	12	D335 1080	
1090	10.9	162	114	12	D335 1090	
1100	11.0	162	114	12	D335 1100	
1110	11.1	162	114	12	D335 1110	
1111	11.11	7/16	162	114	12	D335 1111
1120	11.2	162	114	12	D335 1120	
1130	11.3	162	114	12	D335 1130	
1140	11.4	162	114	12	D335 1140	
1150	11.5	162	114	12	D335 1150	
1160	11.6	162	114	12	D335 1160	
1170	11.7	162	114	12	D335 1170	
1180	11.8	162	114	12	D335 1180	
1190	11.9	162	114	12	D335 1190	
1191	11.91	15/32	162	114	12	D335 1191
1200	12.0	162	114	12	D335 1200	

Drills Carbide 12 x D

suttontools

- Suitable for materials up to 1200N/mm² - 钢件用、可达1200N/mm²
- Strong core with internal coolant supply - 高刚性芯径及内冷油孔设计
- Micro geometry & surface conditioning for optimal chip control - 微型几何设计及表面微处理、具有最佳切屑控制效果
- AlCrN for maximum tool life - 采用氮化铝涂层、最大程度延长刀具的使用寿命



尺寸参考

Size Ref.	d ₁ (h7)	l ₁	l ₂	d ₂ (h6)	Item # (货号)	
0300	3.0	90	50	6	D371 0300	
0310	3.1	90	50	6	D371 0310	
0318	3.18	1/8	90	50	6	D371 0318
0320	3.2	90	50	6	D371 0320	
0330	3.3	90	50	6	D371 0330	
0340	3.4	90	50	6	D371 0340	
0350	3.5	90	50	6	D371 0350	
0357	3.57	9/64	90	50	6	D371 0357
0360	3.6	90	50	6	D371 0360	
0370	3.7	90	50	6	D371 0370	
0380	3.8	102	64	6	D371 0380	
0390	3.9	102	64	6	D371 0390	
0397	3.97	5/32	102	64	6	D371 0397
0400	4.0	102	64	6	D371 0400	
0410	4.1	102	64	6	D371 0410	
0420	4.2	102	64	6	D371 0420	
0430	4.3	102	64	6	D371 0430	
0437	4.37	9/64	102	64	6	D371 0437
0440	4.4	102	64	6	D371 0440	
0450	4.5	102	64	6	D371 0450	
0460	4.6	102	64	6	D371 0460	
0470	4.7	102	64	6	D371 0470	
0476	4.76	3/16	102	64	6	D371 0476
0480	4.8	116	78	6	D371 0480	
0490	4.9	116	78	6	D371 0490	
0500	5.0	116	78	6	D371 0500	
0510	5.1	116	78	6	D371 0510	
0516	5.16	13/64	116	78	6	D371 0516
0520	5.2	116	78	6	D371 0520	
0530	5.3	116	78	6	D371 0530	
0540	5.4	116	78	6	D371 0540	
0550	5.5	116	78	6	D371 0550	
0556	5.56	7/32	116	78	6	D371 0556
0560	5.6	116	78	6	D371 0560	
0570	5.7	116	78	6	D371 0570	
0580	5.8	116	78	6	D371 0580	
0590	5.9	116	78	6	D371 0590	
0595	5.95	15/64	116	78	6	D371 0595
0600	6.0	116	78	6	D371 0600	
0610	6.1	146	108	8	D371 0610	
0620	6.2	146	108	8	D371 0620	
0630	6.3	146	108	8	D371 0630	
0635	6.35	1/4	146	108	8	D371 0635
0640	6.4	146	108	8	D371 0640	
0650	6.5	146	108	8	D371 0650	
0660	6.6	146	108	8	D371 0660	
0670	6.7	146	108	8	D371 0670	
0676	6.76	17/64	146	108	8	D371 0676
0680	6.8	146	108	8	D371 0680	
0690	6.9	146	108	8	D371 0690	
0700	7.0	146	108	8	D371 0700	
0710	7.1	146	108	8	D371 0710	
0714	7.14	9/32	146	108	8	D371 0714
0720	7.2	146	108	8	D371 0720	
0730	7.3	146	108	8	D371 0730	
0740	7.4	146	108	8	D371 0740	

尺寸参考

Size Ref.	d ₁ (h7)	l ₁	l ₂	d ₂ (h6)	Item # (货号)	
0750	7.5	146	108	8	D371 0750	
0754	7.54	19/64	146	108	8	D371 0754
0760	7.6	146	108	8	D371 0760	
0770	7.7	146	108	8	D371 0770	
0780	7.8	146	108	8	D371 0780	
0790	7.9	146	108	8	D371 0790	
0794	7.94	5/16	146	108	8	D371 0794
0800	8.0	146	108	8	D371 0800	
0810	8.1	162	120	10	D371 0810	
0820	8.2	162	120	10	D371 0820	
0830	8.3	162	120	10	D371 0830	
0833	8.33	21/64	162	120	10	D371 0833
0840	8.4	162	120	10	D371 0840	
0850	8.5	162	120	10	D371 0850	
0860	8.6	162	120	10	D371 0860	
0870	8.7	162	120	10	D371 0870	
0873	8.73	11/32	162	120	10	D371 0873
0880	8.8	162	120	10	D371 0880	
0890	8.9	162	120	10	D371 0890	
0900	9.0	162	120	10	D371 0900	
0910	9.1	162	120	10	D371 0910	
0913	9.13	23/64	162	120	10	D371 0913
0920	9.2	162	120	10	D371 0920	
0930	9.3	162	120	10	D371 0930	
0940	9.4	162	120	10	D371 0940	
0950	9.5	162	120	10	D371 0950	
0952	9.52	3/8	162	120	10	D371 0952
0960	9.6	162	120	10	D371 0960	
0970	9.7	162	120	10	D371 0970	
0980	9.8	162	120	10	D371 0980	
0990	9.9	162	120	10	D371 0990	
0992	9.92	25/64	162	120	10	D371 0992
1000	10.0	162	120	10	D371 1000	
1010	10.1	204	156	12	D371 1010	
1020	10.2	204	156	12	D371 1020	
1030	10.3	204	156	12	D371 1030	
1032	10.32	13/32	204	156	12	D371 1032
1040	10.4	204	156	12	D371 1040	
1050	10.5	204	156	12	D371 1050	
1060	10.6	204	156	12	D371 1060	
1070	10.7	204	156	12	D371 1070	
1080	10.8	204	156	12	D371 1080	
1090	10.9	204	156	12	D371 1090	
1100	11.0	204	156	12	D371 1100	
1110	11.1	204	156	12	D371 1110	
1111	11.11	7/16	204	156	12	D371 1111
1120	11.2	204	156	12	D371 1120	
1130	11.3	204	156	12	D371 1130	
1140	11.4	204	156	12	D371 1140	
1150	11.5	204	156	12	D371 1150	
1160	11.6	204	156	12	D371 1160	
1170	11.7	204	156	12	D371 1170	
1180	11.8	204	156	12	D371 1180	
1190	11.9	204	156	12	D371 1190	
1191	11.91	15/32	204	156	12	D371 1191
1200	12.0	204	156	12	D371 1200	



Catalogue Code 目录代码

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Point Type 钻尖类别

Shank Form 柄径型

D371

A0210

VHM 硬质合金

AlCrN Tip 前端涂层

Up to 1200N/mm²

R30 - IK 内冷

135° Form C

HA

* HB & HE Shank styles available

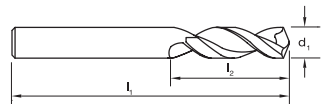
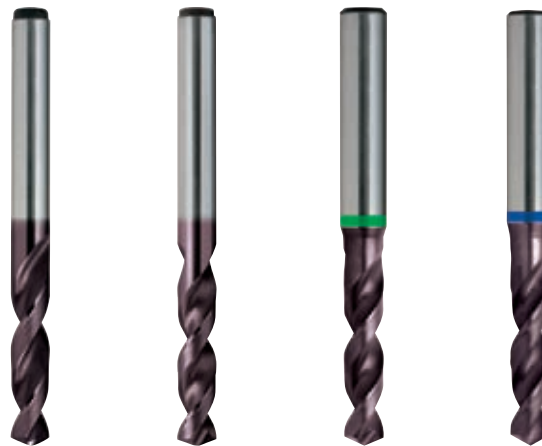
* HB 和 HE 柄径样式可供选购

Drills Stub 3 x D

suttontools

D177 - For soft materials up to 850N/mm²
 D151 - For materials up to 1200N/mm²
 D155 - Production drilling in materials up to 1500N/mm²
 D153 - For austenitic stainless steels and most long chipping materials

D177 - 软材用、≤850N/mm²
 D151 - 中硬材用、≤1200N/mm²
 D155 - 量产作业用、≤1500N/mm²
 D153 - 不锈钢及长屑材料用



尺寸参考

Size Ref.	d ₁	l ₁	l ₂	d ₂	
0100	1.0	26	6	3	
0110	1.1	28	7	3	
0120	1.2	30	8	3	
0130	1.3	30	8	3	
0140	1.4	32	9	3	
0150	1.5	32	9	3	
0160	1.6	34	10	3	
0170	1.7	34	10	3	
0180	1.8	36	11	3	
0190	1.9	36	11	3	
0200	2.0	38	12	3	
0210	2.1	40	13	3	
0220	2.2	40	13	3	
0230	2.3	40	13	3	
0240	2.4	43	14	3	
0250	2.5	43	14	3	
0260	2.6	43	14	3	
0270	2.7	46	16	3	
0280	2.8	46	16	3	
0290	2.9	46	16	3	
0300	3.0	46	16	3	
0310	3.1	49	18	4	
0318	3.18	1/8	49	18	4
0320	3.2	49	18	4	
0330	3.3	49	18	4	
0340	3.4	52	20	4	
0350	3.5	52	20	4	
0357	3.57	9/64	52	20	4
0360	3.6	52	20	4	
0370	3.7	52	20	4	
0380	3.8	55	22	4	
0390	3.9	55	22	4	
0397	3.97	5/32	55	22	4
0400	4.0	55	22	4	
0410	4.1	55	22	6	
0420	4.2	55	22	6	
0430	4.3	58	24	6	
0437	4.37	11/64	58	24	6
0440	4.4	58	24	6	
0450	4.5	58	24	6	
0460	4.6	58	24	6	
0470	4.7	58	24	6	
0476	4.76	3/16	62	26	6
0480	4.8	62	26	6	
0490	4.9	62	26	6	
0500	5.0	62	26	6	
0510	5.1	62	26	6	
0516	5.16	13/64	62	26	6
0520	5.2	62	26	6	
0530	5.3	62	26	6	
0540	5.4	66	28	6	
0550	5.5	66	28	6	
0556	5.56	7/32	66	28	6
0560	5.6	66	28	6	

Catalogue Code 目录代码

Product Name 产品名称

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Point Type 钻尖类别

Shank Tolerance 柄径容许公差

D177	D151	D155	D153
DXS	CNC	UNI	Black Magic
A1006	A1006	A1502	A1502
HSS Co 含钴高速钢	HSS Co 含钴高速钢	SPM 高钴粉末钢	HSS Co 含钴高速钢
TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛
R35 WN	R40 NH	R40 UNI	R40 VA
130° Form A	130° Form B	130° 4 Facet Form B	4 Facet
h9	h9	h7	h7
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
D177 0100	D151 0100	D155 0100	D153 0100
D177 0110	D151 0110	D155 0110	D153 0110
D177 0120	D151 0120	D155 0120	D153 0120
D177 0130	D151 0130	D155 0130	D153 0130
D177 0140	D151 0140	D155 0140	D153 0140
D177 0150	D151 0150	D155 0150	D153 0150
D177 0160	D151 0160	D155 0160	D153 0160
D177 0170	D151 0170	D155 0170	D153 0170
D177 0180	D151 0180	D155 0180	D153 0180
D177 0190	D151 0190	D155 0190	D153 0190
D177 0200	D151 0200	D155 0200	D153 0200
D177 0210	D151 0210	D155 0210	D153 0210
D177 0220	D151 0220	D155 0220	D153 0220
D177 0230	D151 0230	D155 0230	D153 0230
D177 0240	D151 0240	D155 0240	D153 0240
D177 0250	D151 0250	D155 0250	D153 0250
D177 0260	D151 0260	D155 0260	D153 0260
D177 0270	D151 0270	D155 0270	D153 0270
D177 0280	D151 0280	D155 0280	D153 0280
D177 0290	D151 0290	D155 0290	D153 0290
D177 0300	D151 0300	D155 0300	D153 0300
D177 0310	D151 0310	D155 0310	D153 0310
D177 0318	D151 0318		D153 0318
D177 0320	D151 0320	D155 0320	D153 0320
D177 0330	D151 0330	D155 0330	D153 0330
D177 0340	D151 0340	D155 0340	D153 0340
D177 0350	D151 0350	D155 0350	D153 0350
D177 0357	D151 0357		D153 0357
D177 0360	D151 0360	D155 0360	D153 0360
D177 0370	D151 0370	D155 0370	D153 0370
D177 0380	D151 0380	D155 0380	D153 0380
D177 0390	D151 0390	D155 0390	D153 0390
D177 0397	D151 0397		D153 0397
D177 0400	D151 0400	D155 0400	D153 0400
D177 0410	D151 0410	D155 0410	D153 0410
D177 0420	D151 0420	D155 0420	D153 0420
D177 0430	D151 0430	D155 0430	D153 0430
D177 0437	D151 0437		D153 0437
D177 0440	D151 0440	D155 0440	D153 0440
D177 0450	D151 0450	D155 0450	D153 0450
D177 0460	D151 0460	D155 0460	D153 0460
D177 0470	D151 0470	D155 0470	D153 0470
D177 0476	D151 0476		D153 0476
D177 0480	D151 0480	D155 0480	D153 0480
D177 0490	D151 0490	D155 0490	D153 0490
D177 0500	D151 0500	D155 0500	D153 0500
D177 0510	D151 0510	D155 0510	D153 0510
D177 0516	D151 0516		D153 0516
D177 0520	D151 0520	D155 0520	D153 0520
D177 0530	D151 0530	D155 0530	D153 0530
D177 0540	D151 0540	D155 0540	D153 0540
D177 0550	D151 0550	D155 0550	D153 0550
D177 0556	D151 0556		D153 0556
D177 0560	D151 0560	D155 0560	D153 0560

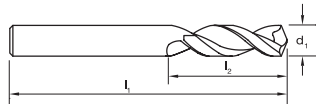
d₂ ref - D155 & D153 d₂ 钻头柄尺寸 - D155及D153

Drills Stub 3 x D

suttontools

D177 - For soft materials up to 850N/mm²
 D151 - For materials up to 1200N/mm²
 D155 - Production drilling in materials up to 1500N/mm²
 D153 - For austenitic stainless steels and most long chipping materials

D177 - 软材用、≤850N/mm²
 D151 - 中硬材用、≤1200N/mm²
 D155 - 量产作业用、≤1500N/mm²
 D153 - 不锈钢及长屑材料用



尺寸参考

Size Ref.	d ₁	l ₁	l ₂	d ₂	
0570	5.7	66	28	6	
0580	5.8	66	28	6	
0590	5.9	66	28	6	
0595	5.95	15/64	66	28	6
0600	6.0	66	28	6	
0610	6.1	70	31	8	
0620	6.2	70	31	8	
0630	6.3	70	31	8	
0635	6.35	1/4	70	31	8
0640	6.4	70	31	8	
0650	6.5	70	31	8	
0660	6.6	70	31	8	
0670	6.7	70	31	8	
0676	6.76	17/64	74	34	8
0680	6.8	74	34	8	
0690	6.9	74	34	8	
0700	7.0	74	34	8	
0710	7.1	74	34	8	
0714	7.14	9/32	74	34	8
0720	7.2	74	34	8	
0730	7.3	74	34	8	
0740	7.4	74	34	8	
0750	7.5	74	34	8	
0754	7.54	19/64	79	37	8
0760	7.6	79	37	8	
0770	7.7	79	37	8	
0780	7.8	79	37	8	
0790	7.9	79	37	8	
0794	7.94	5/16	79	37	8
0800	8.0	79	37	8	
0810	8.1	79	37	10	
0820	8.2	79	37	10	
0830	8.3	79	37	10	
0833	8.33	21/64	79	37	10
0840	8.4	79	37	10	
0850	8.5	79	37	10	
0860	8.6	84	40	10	
0870	8.7	84	40	10	
0873	8.73	11/32	84	40	10
0880	8.8	84	40	10	
0890	8.9	84	40	10	
0900	9.0	84	40	10	
0910	9.1	84	40	10	
0913	9.13	23/64	84	40	10
0920	9.2	84	40	10	
0930	9.3	84	40	10	
0940	9.4	84	40	10	
0950	9.5	84	40	10	
0953	9.53	3/8	89	43	10
0960	9.6	89	43	10	
0970	9.7	89	43	10	
0980	9.8	89	43	10	
0990	9.9	89	43	10	
0992	9.92	25/64	89	43	10

Shank Tolerance 柄径容许公差



Catalogue Code 目录代码
 Product Name 产品名称
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Point Type 钻尖类别

D177	D151	D155	D153
DXS	CNC	UNI	Black Magic
A1006	A1006	A1502	A1502
HSS Co 含钴高速钢	HSS Co 含钴高速钢	SPM 高钴粉末钢	HSS Co 含钴高速钢
TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛
R35 WN	R40 NH	R40 UNI	R40 VA
130° Form A	130° Form B	130° 4 Facet Form B	4 Facet
h9	h9	h7	h7
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
D177 0570	D151 0570	D155 0570	D153 0570
D177 0580	D151 0580	D155 0580	D153 0580
D177 0590	D151 0590	D155 0590	D153 0590
D177 0595	D151 0595		D153 0595
D177 0600	D151 0600	D155 0600	D153 0600
D177 0610	D151 0610	•	D153 0610
D177 0620	D151 0620	D155 0620	D153 0620
D177 0630	D151 0630	D155 0630	D153 0630
D177 0635	D151 0635		D153 0635
D177 0640	D151 0640	D155 0640	D153 0640
D177 0650	D151 0650	D155 0650	D153 0650
D177 0660	D151 0660	D155 0660	D153 0660
D177 0670	D151 0670	D155 0670	D153 0670
D177 0676	D151 0676		D153 0676
D177 0680	D151 0680	D155 0680	D153 0680
D177 0690	D151 0690	D155 0690	D153 0690
D177 0700	D151 0700	D155 0700	D153 0700
D177 0710	D151 0710	D155 0710	D153 0710
D177 0714	D151 0714		D153 0714
D177 0720	D151 0720	D155 0720	D153 0720
D177 0730	D151 0730	D155 0730	D153 0730
D177 0740	D151 0740	D155 0740	D153 0740
D177 0750	D151 0750	D155 0750	D153 0750
D177 0754	D151 0754		D153 0754
D177 0760	D151 0760	D155 0760	D153 0760
D177 0770	D151 0770	D155 0770	D153 0770
D177 0780	D151 0780	D155 0780	D153 0780
D177 0790	D151 0790	D155 0790	D153 0790
D177 0794	D151 0794		D153 0794
D177 0800	D151 0800	D155 0800	D153 0800
D177 0810	D151 0810	D155 0810	D153 0810
D177 0820	D151 0820	D155 0820	D153 0820
D177 0830	D151 0830	D155 0830	D153 0830
D177 0840	D151 0840	D155 0840	D153 0840
D177 0850	D151 0850	D155 0850	D153 0850
D177 0860	D151 0860	D155 0860	D153 0860
D177 0870	D151 0870	D155 0870	D153 0870
D177 0873	D151 0873		D153 0873
D177 0880	D151 0880	D155 0880	D153 0880
D177 0890	D151 0890	D155 0890	D153 0890
D177 0900	D151 0900	D155 0900	D153 0900
D177 0910	D151 0910	D155 0910	D153 0910
D177 0913	D151 0913		D153 0913
D177 0920	D151 0920	D155 0920	D153 0920
D177 0930	D151 0930	D155 0930	D153 0930
D177 0940	D151 0940	D155 0940	D153 0940
D177 0950	D151 0950	D155 0950	D153 0950
D177 0953	D151 0953		D153 0953
D177 0960	D151 0960	D155 0960	D153 0960
D177 0970	D151 0970	D155 0970	D153 0970
D177 0980	D151 0980	D155 0980	D153 0980
D177 0990	D151 0990	D155 0990	D153 0990
D177 0992	D151 0992		D153 0992

• Available on request as special manufacture. Subject to lead time. •可定制。

d₂ ref - D155 & D153 d₂铣刀柄尺寸 - D155及D153

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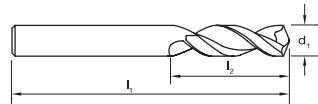
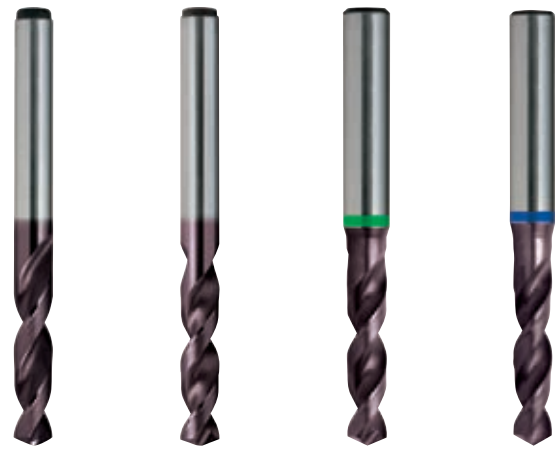
请参阅我们在线全系列完整产品目录 Refer to our complete Industrial Catalogue online for entire range

Drills Stub 3 x D

suttontools

D177 - For soft materials up to 850N/mm²
 D151 - For materials up to 1200N/mm²
 D155 - Production drilling in materials up to 1500N/mm²
 D153 - For austenitic stainless steels and most long chipping materials

D177 - 软材用、≤850N/mm²
 D151 - 中硬材用、≤1200N/mm²
 D155 - 量产作业用、≤1500N/mm²
 D153 - 不锈钢及长屑材料用



尺寸参考

Catalogue Code 目录代码
 Product Name 产品名称
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Point Type 钻尖类别
 Shank Tolerance 柄径容许公差

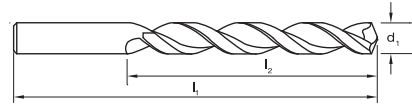
Size Ref.	d ₁	l ₁	l ₂	d ₂	D177	D151	D155	D153
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1010	10.1	89	43	10	A1006	A1006	A1502	A1502
1020	10.2	89	43	10	HSS Co 含钴高速钢	HSS Co 含钴高速钢	SPM 高钴粉末钢	HSS Co 含钴高速钢
1030	10.3	89	43	10	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛
1032	10.32	13/32	89	43	R35 WN	R40 NH	R40 UNI	R40 VA
1040	10.4	89	43	10	130° Form A	130° Form B	130° 4 Facet Form B	4 Facet
1050	10.5	89	43	10	h9	h9	h7	h7
1060	10.6	89	43	12	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
1070	10.7	95	47	12	D177 1000	D151 1000	D155 1000	D153 1000
1072	10.72	27/64	95	47	D177 1010	D151 1010	D155 1010	D153 1010
1080	10.8	95	47	12	D177 1020	D151 1020	D155 1020	D153 1020
1090	10.9	95	47	12	D177 1032	D151 1032	D155 1030	D153 1030
1100	11.0	95	47	12	D177 1032	D151 1032	D155 1030	D153 1032
1110	11.1	95	47	12	D177 1050	D151 1050	D155 1050	D153 1050
1111	11.11	7/16	95	47	D177 1050	D151 1050	D155 1050	D153 1050
1120	11.2	95	47	12	D177 1072	D151 1072	D155 1072	D153 1072
1130	11.3	95	47	12	D177 1080	D151 1080	D155 1080	D153 1080
1140	11.4	95	47	12	D177 1090	D151 1090	D155 1090	D153 1090
1150	11.5	95	47	12	D177 1100	D151 1100	D155 1100	D153 1100
1151	11.51	29/64	95	47	D177 1100	D151 1100	D155 1100	D153 1100
1160	11.6	95	47	12	D177 1110	D151 1110	D155 1110	D153 1110
1170	11.7	95	47	12	D177 1111	D151 1111	D155 1110	D153 1110
1180	11.8	95	47	12	D177 1120	D151 1120	D155 1120	D153 1120
1190	11.9	102	51	12	D177 1120	D151 1120	D155 1120	D153 1120
1191	11.91	15/32	102	51	D177 1130	D151 1130	D155 1130	D153 1130
1200	12.0	102	51	12	D177 1140	D151 1140	D155 1140	D153 1140
1210	12.1	102	51	12	D177 1150	D151 1150	D155 1150	D153 1150
1220	12.2	102	51	12	D177 1151	D151 1151	D155 1150	D153 1150
1230	12.3	102	51	12	D177 1160	D151 1160	D155 1160	D153 1160
1231	12.31	31/64	102	51	D177 1170	D151 1170	D155 1170	D153 1170
1240	12.4	102	51	12	D177 1180	D151 1180	D155 1170	D153 1170
1250	12.5	102	51	12	D177 1180	D151 1180	D155 1180	D153 1180
1260	12.6	102	51	12	D177 1190	D151 1190	D155 1190	D153 1190
1269	12.69	1/2	102	51	D177 1191	D151 1191	D155 1190	D153 1190
1270	12.7	102	51	12	D177 1200	D151 1200	D155 1200	D153 1200
1280	12.8	102	51	12	D177 1210	D151 1210	D155 1210	D153 1210
1290	12.9	102	51	12	D177 1220	D151 1220	D155 1220	D153 1220
1300	13.0	102	51	12	D177 1230	D151 1230	D155 1230	D153 1230
1350	13.5	107	54	16	D177 1231	D151 1231	D155 1230	D153 1230
1400	14.0	107	54	16	D177 1240	D151 1240	D155 1240	D153 1240
1450	14.5	111	56	16	D177 1250	D151 1250	D155 1250	D153 1250
1500	15.0	111	56	16	D177 1269	D151 1269	D155 1260	D153 1260
1550	15.5	115	58	16	D177 1270	D151 1270	D155 1270	D153 1270
1600	16.0	115	58	16	D177 1280	D151 1280	D155 1280	D153 1280
1650	16.5	119	60	20	D177 1290	D151 1290	D155 1290	D153 1290
1700	17.0	119	60	20	D177 1300	D151 1300	D155 1300	D153 1300
1750	17.5	123	62	20	D177 1350	D151 1350	D155 1350	D153 1350
1800	18.0	123	62	20	D177 1400	D151 1400	D155 1400	D153 1400
1850	18.5	127	64	20	D177 1450	D151 1450	D155 1450	D153 1450
1900	19.0	127	64	20	D177 1500	D151 1500	D155 1500	D153 1500
1950	19.5	131	66	20	D177 1550	D151 1550	D155 1550	D153 1550
2000	20.0	131	66	20	D177 1600	D151 1600	D155 1600	D153 1600
					D177 1650	D151 1650	D155 1650	D153 1650
					D177 1700	D151 1700	D155 1700	D153 1700
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					D177 1850	D151 1850	D155 1850	D153 1850
					D177 1900	D151 1900	D155 1900	D153 1900
					D177 1950	D151 1950	D155 1950	D153 1950
					D177 2000	D151 2000	D155 2000	D153 2000

d₂ ref - D155 & D153 d₂ 钻头柄尺寸 - D155及D153

Drills Jobber 5 x D



- D165 - For soft materials up to 850N/mm² D165 - 软材用、≤850N/mm²
- D163 - For materials up to 1200N/mm² D163 - 中硬材用、≤1200N/mm²
- D168 - Production drilling in materials up to 1500N/mm² D168 - 量产作业加用、≤1500N/mm²
- D169 - For austenitic stainless steels and most long chipping materials D169 - 氏体不锈钢及长屑材料用



尺寸参考

- Catalogue Code 目录代码
- Product Name 产品名称
- Discount Group 折扣组
- Material 材料
- Surface Finish 表面处理
- Application 色环及应用
- Point Type 钻尖类别
- Shank Tolerance 柄径容许公差



Size Ref.	d ₁	l ₁	l ₂	d ₂	D165 DXJ A0418 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R35 WN 130° Form A h9	D163 DHJ A0418 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R40 NH 130° Form B h9	D168 UNI A1502 SPM 高钴粉末钢 TiAlN 氮化铝钛 R40 UNI 130° 4 Facet Form B h7	D169 Black Magic A1502 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R40 VA 4 Facet Form C h7	
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)					
0100	1.0	34	13	3					
0110	1.1	36	15	3		D163 0100	D168 0100		
0120	1.2	38	17	3		D163 0110	D168 0110		
0130	1.3	38	17	3		D163 0120	D168 0120		
0140	1.4	40	19	3		D163 0130	D168 0130		
0150	1.5	40	19	3		D163 0140	D168 0140		
0159	1.59	1/16	43	21	3	D163 0150	D168 0150		
0160	1.6	43	21	3					
0170	1.7	43	21	3		D163 0160	D168 0160		
0180	1.8	46	23	3		D163 0170	D168 0170		
0190	1.9	46	23	3		D163 0180	D168 0180		
0198	1.98	5/64	49	24	3	D163 0190	D168 0190		
0200	2.0	49	24	3					
0210	2.1	49	24	3		D163 0200	D168 0200	D169 0200	
0220	2.2	53	28	3		D163 0210	D168 0210	D169 0210	
0230	2.3	53	28	3		D163 0220	D168 0220	D169 0220	
0238	2.38	3/32	57	31	3	D163 0230	D168 0230	D169 0230	
0240	2.4	57	31	3					
0250	2.5	57	31	3		D163 0240	D168 0240	D169 0240	
0260	2.6	57	31	3		D163 0250	D168 0250	D169 0250	
0270	2.7	61	34	3		D163 0260	D168 0260	D169 0260	
0278	2.78	7/64	61	34	3	D163 0270	D168 0270	D169 0270	
0280	2.8	61	34	3					
0290	2.9	61	34	3		D163 0280	D168 0280	D169 0280	
0300	3.0	61	33	3		D163 0290	D168 0290	D169 0290	
0310	3.1	65	36	4	D165 0300	D163 0300	D168 0300	D169 0300	
0318	3.18	1/8	65	36	4	D165 0310	D163 0310	D168 0310	D169 0310
0320	3.2	65	36	4	D165 0318	D163 0318		D169 0318	
0330	3.3	65	36	4	D165 0320	D163 0320	D168 0320	D169 0320	
0340	3.4	70	39	4	D165 0330	D163 0330	D168 0330	D169 0330	
0350	3.5	70	39	4	D165 0340	D163 0340	D168 0340	D169 0340	
0357	3.57	9/64	70	39	4	D165 0350	D163 0350	D168 0350	D169 0350
0360	3.6	70	39	4	D165 0357	D163 0357		D169 0357	
0370	3.7	70	39	4	D165 0360	D163 0360	D168 0360	D169 0360	
0380	3.8	75	43	4	D165 0370	D163 0370	D168 0370	D169 0370	
0390	3.9	75	43	4	D165 0380	D163 0380	D168 0380	D169 0380	
0397	3.97	5/32	75	43	4	D165 0390	D163 0390	D168 0390	D169 0390
0400	4.0	75	43	4	D165 0397	D163 0397		D169 0397	
0410	4.1	75	43	6	D165 0400	D163 0400	D168 0400	D169 0400	
0420	4.2	75	43	6	D165 0410	D163 0410	D168 0410	D169 0410	
0430	4.3	80	47	6	D165 0420	D163 0420	D168 0420	D169 0420	
0437	4.37	11/64	80	47	6	D165 0430	D163 0430	D168 0430	D169 0430
0440	4.4	80	47	6	D165 0437	D163 0437		D169 0437	
0450	4.5	80	47	6	D165 0440	D163 0440	D168 0440	D169 0440	
0460	4.6	80	47	6	D165 0450	D163 0450	D168 0450	D169 0450	
0470	4.7	80	47	6	D165 0460	D163 0460	D168 0460	D169 0460	
0476	4.76	3/16	80	47	6	D165 0470	D163 0470	D168 0470	D169 0470
0480	4.8	86	52	6	D165 0476	D163 0476		D169 0476	
0490	4.9	86	52	6	D165 0480	D163 0480	D168 0480	D169 0480	
0500	5.0	86	52	6	D165 0490	D163 0490	D168 0490	D169 0490	
0510	5.1	86	52	6	D165 0500	D163 0500	D168 0500	D169 0500	
0516	5.16	13/64	86	52	6	D165 0510	D163 0510	D168 0510	D169 0510
0520	5.2	86	52	6	D165 0516	D163 0516		D169 0516	
0530	5.3	86	52	6	D165 0520	D163 0520	D168 0520	D169 0520	
0540	5.4	93	57	6	D165 0530	D163 0530	D168 0530	D169 0530	
0550	5.5	93	57	6	D165 0540	D163 0540	D168 0540	D169 0540	
					D165 0550	D163 0550	D168 0550	D169 0550	

* Available on request as special manufacture. Subject to lead time. *可定制。

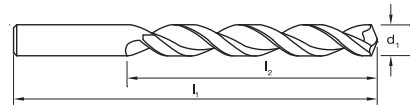
d₂ ref - D168 & D169 d₂钻头柄尺寸 - D168及D169

Drills Jobber 5 x D

suttontools

D165 - For soft materials up to 850N/mm²
 D163 - For materials up to 1200N/mm²
 D168 - Production drilling in materials up to 1500N/mm²
 D169 - For austenitic stainless steels and most long chipping materials

D165 - 软材用、≤850N/mm²
 D163 - 中硬材用、≤1200N/mm²
 D168 - 量产作业加用、≤1500N/mm²
 D169 - 氏体不锈钢及长屑材料用



尺寸参考

Shank Tolerance 柄径容许公差

Size Ref.	d ₁	l ₁	l ₂	d ₂	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
0556	5.56	7/32	93	57	6	D165 0556	D163 0556	D169 0556
0560	5.6		93	57	6	D165 0560	D163 0560	D169 0560
0570	5.7		93	57	6	D165 0570	D163 0570	D169 0570
0580	5.8		93	57	6	D165 0580	D163 0580	D169 0580
0590	5.9		93	57	6	D165 0590	D163 0590	D169 0590
0595	5.95	15/64	93	57	6	D165 0595	D163 0595	D169 0595
0600	6.0		93	57	6	D165 0600	D163 0600	D169 0600
0610	6.1		101	63	8	D165 0610	D163 0610	D169 0610
0620	6.2		101	63	8	D165 0620	D163 0620	D169 0620
0630	6.3		101	63	8	D165 0630	D163 0630	D169 0630
0635	6.35	1/4	101	63	8	D165 0635	D163 0635	D169 0635
0640	6.4		101	63	8	D165 0640	D163 0640	D169 0640
0650	6.5		101	63	8	D165 0650	D163 0650	D169 0650
0660	6.6		101	63	8	D165 0660	D163 0660	D169 0660
0670	6.7		101	63	8	D165 0670	D163 0670	D169 0670
0676	6.75	17/64	109	69	8	D165 0676	D163 0676	D169 0676
0680	6.8		109	69	8	D165 0680	D163 0680	D169 0680
0690	6.9		109	69	8	D165 0690	D163 0690	D169 0690
0700	7.0		109	69	8	D165 0700	D163 0700	D169 0700
0710	7.1		109	69	8	D165 0710	D163 0710	D169 0710
0714	7.14	9/32	109	69	8	D165 0714	D163 0714	D169 0714
0720	7.2		109	69	8	D165 0720	D163 0720	D169 0720
0730	7.3		109	69	8	D165 0730	D163 0730	D169 0730
0740	7.4		109	69	8	D165 0740	D163 0740	D169 0740
0750	7.5		109	69	8	D165 0750	D163 0750	D169 0750
0754	7.54	19/64	117	75	8	D165 0754	D163 0754	D169 0754
0760	7.6		117	75	8	D165 0760	D163 0760	D169 0760
0770	7.7		117	75	8	D165 0770	D163 0770	D169 0770
0780	7.8		117	75	8	D165 0780	D163 0780	D169 0780
0790	7.9		117	75	8	D165 0790	D163 0790	D169 0790
0794	7.94	5/16	117	75	8	D165 0794	D163 0794	D169 0794
0800	8.0		117	75	8	D165 0800	D163 0800	D169 0800
0810	8.1		117	75	10	D165 0810	D163 0810	D169 0810
0820	8.2		117	75	10	D165 0820	D163 0820	D169 0820
0830	8.3		117	75	10	D165 0830	D163 0830	D169 0830
0833	8.33	21/64	117	75	10	D165 0833	D163 0833	D169 0833
0840	8.4		117	75	10	D165 0840	D163 0840	D169 0840
0850	8.5		117	75	10	D165 0850	D163 0850	D169 0850
0860	8.6		125	81	10	D165 0860	D163 0860	D169 0860
0870	8.7		125	81	10	D165 0870	D163 0870	D169 0870
0873	8.73	11/32	125	81	10	D165 0873	D163 0873	D169 0873
0880	8.8		125	81	10	D165 0880	D163 0880	D169 0880
0890	8.9		125	81	10	D165 0890	D163 0890	D169 0890
0900	9.0		125	81	10	D165 0900	D163 0900	D169 0900
0910	9.1		125	81	10	D165 0910	D163 0910	D169 0910
0913	9.13	23/64	125	81	10	D165 0913	D163 0913	D169 0913
0920	9.2		125	81	10	D165 0920	D163 0920	D169 0920
0930	9.3		125	81	10	D165 0930	D163 0930	D169 0930
0940	9.4		125	81	10	D165 0940	D163 0940	D169 0940
0950	9.5		125	81	10	D165 0950	D163 0950	D169 0950
0953	9.52	3/8	133	87	10	D165 0953	D163 0953	D169 0953
0960	9.6		133	87	10	D165 0960	D163 0960	D169 0960
0970	9.7		133	87	10	D165 0970	D163 0970	D169 0970
0980	9.8		133	87	10	D165 0980	D163 0980	D169 0980
0990	9.9		133	87	10	D165 0990	D163 0990	D169 0990
0992	9.92	25/64	133	87	10	D165 0992	D163 0992	D169 0992

Catalogue Code 目录代码

Product Name 产品名称

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Point Type 钻尖类别

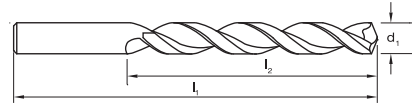
D165	D163	D168	D169
DXJ	DHJ	UNI	Black Magic
A0418	A0418	A1502	A1502
HSS Co 含钴高速钢	HSS Co 含钴高速钢	SPM 高钴粉末钢	HSS Co 含钴高速钢
TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛
R35 W → N	R40 N → H	R40 UNI	R40 VA
130° Form A	130° Form B	130° 4 Facet Form B	4 Facet Form C
h9	h9	h7	h7

d₂ ref - D168 & D169 d₂ 铣刀柄尺寸 - D168及D169

Drills Jobber 5 x D



- D165 - For soft materials up to 850N/mm² D165 - 软材用、≤850N/mm²
- D163 - For materials up to 1200N/mm² D163 - 中硬材用、≤1200N/mm²
- D168 - Production drilling in materials up to 1500N/mm² D168 - 量产作业加用、≤1500N/mm²
- D169 - For austenitic stainless steels and most long chipping materials D169 - 氏体不锈钢及长屑材料用



尺寸参考

- Catalogue Code 目录代码
- Product Name 产品名称
- Discount Group 折扣组
- Material 材料
- Surface Finish 表面处理
- Application 色环及应用
- Point Type 钻尖类别
- Shank Tolerance 柄径容许公差



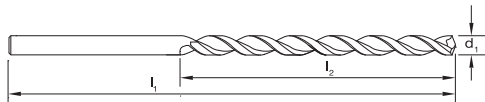
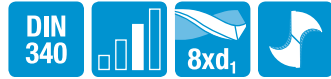
Size Ref.	d ₁	l ₁	l ₂	d ₂	D165 DXJ A0418 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R35 W → N 130° Form A h9	D163 DHJ A0418 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R40 N → H 130° Form B h9	D168 UNI A1502 SPM 高钴粉末钢 TiAlN 氮化铝钛 R40 UNI 130° 4 Facet Form B h7	D169 Black Magic A1502 HSS Co 含钴高速钢 TiAlN 氮化铝钛 R40 VA 4 Facet Form C h7
Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)				
1000	10.0	133	87	10	D165 1000	D163 1000	D168 1000	D169 1000
1010	10.1	133	87	10	D165 1010	•	D168 1010	D169 1010
1020	10.2	133	87	10	D165 1020	D163 1020	D168 1020	D169 1020
1030	10.3	133	87	10	•	•	D168 1030	D169 1030
1032	10.32	13/32	133	87	D165 1032	D163 1032	•	D169 1032
1040	10.4	133	87	10	•	•	D168 1040	D169 1040
1050	10.5	133	87	10	D165 1050	D163 1050	D168 1050	D169 1050
1060	10.6	133	87	12	•	•	D168 1060	D169 1060
1070	10.7	142	94	12	•	•	D168 1070	D169 1070
1072	10.72	27/64	142	94	D165 1072	D163 1072	•	D169 1072
1080	10.8	142	94	12	D165 1080	D163 1080	D168 1080	D169 1080
1090	10.9	142	94	12	•	•	D168 1090	D169 1090
1100	11.0	142	94	12	D165 1100	D163 1100	D168 1100	D169 1100
1110	11.1	142	94	12	D165 1110	D163 1110	D168 1110	D169 1110
1111	11.11	7/16	142	94	D165 1111	D163 1111	•	D169 1111
1120	11.2	142	94	12	D165 1120	•	D168 1120	D169 1120
1130	11.3	142	94	12	•	•	D168 1130	D169 1130
1140	11.4	142	94	12	•	•	D168 1140	D169 1140
1150	11.5	142	94	12	D165 1150	D163 1150	D168 1150	D169 1150
1151	11.51	29/64	142	94	D165 1151	D163 1151	•	D169 1151
1160	11.6	142	94	12	•	•	D168 1160	D169 1160
1170	11.7	142	94	12	•	•	D168 1170	D169 1170
1180	11.8	142	94	12	D165 1180	D163 1180	D168 1180	D169 1180
1190	11.9	151	94	12	•	•	D168 1190	D169 1190
1191	11.91	15/32	151	101	D165 1191	D163 1191	•	D169 1191
1200	12.0	151	101	12	D165 1200	D163 1200	D168 1200	D169 1200
1210	12.1	151	101	12	•	•	D168 1210	D169 1210
1220	12.2	151	101	12	D165 1220	D163 1220	D168 1220	D169 1220
1230	12.3	151	101	12	•	•	D168 1230	D169 1230
1231	12.3	31/64	151	101	D165 1231	D163 1231	•	D169 1231
1240	12.4	151	101	12	•	•	D168 1240	D169 1240
1250	12.5	151	101	12	D165 1250	D163 1250	D168 1250	D169 1250
1260	12.6	151	101	12	•	•	D168 1260	D169 1260
1269	12.7	1/2	151	101	D165 1269	D163 1269	•	D169 1269
1270	12.7	151	101	12	•	D163 1270	D168 1270	D169 1270
1280	12.8	151	101	12	D165 1280	•	D168 1280	D169 1280
1290	12.9	151	101	12	•	•	D168 1290	D169 1290
1300	13.0	151	101	12	D165 1300	D163 1300	D168 1300	D169 1300
1350	13.5	160	108	16	•	D163 1350	D168 1350	D169 1350
1400	14.0	160	108	16	•	D163 1400	D168 1400	D169 1400
1450	14.5	169	114	16	•	D163 1450	D168 1450	D169 1450
1500	15.0	169	114	16	•	D163 1500	D168 1500	D169 1500
1550	15.5	178	120	16	•	D163 1550	D168 1550	D169 1550
1600	16.0	178	120	16	•	D163 1600	D168 1600	D169 1600
1650	16.5	184	125	20	•	•	D168 1650	D169 1650
1700	17.0	184	125	20	•	•	D168 1700	D169 1700
1750	17.5	191	130	20	•	•	D168 1750	D169 1750
1800	18.0	191	130	20	•	•	D168 1800	D169 1800
1850	18.5	198	135	20	•	•	D168 1850	D169 1850
1900	19.0	198	135	20	•	•	D168 1900	D169 1900
1950	19.5	205	140	20	•	•	D168 1950	D169 1950
2000	20.0	205	140	20	•	•	D168 2000	D169 2000

• Available on request as special manufacture. Subject to lead time. •可定制。
d₂ ref - D168 & D169 d₂ 钻头柄尺寸 - D168及D169

Drills Long 8 x D

suttontools

- High performance drill
- Suitable for materials up to 1200N/mm²
- Point geometry ensures high strength
- Parabolic flute design for optimal chip transportation
- Less pecking required over standard drills
- TiAlN for longer tool life
- 高效能钻头
- 加工硬度可达1200N/mm²
- 高强度钻尖
- 高效排屑的抛物线槽形设计
- 大幅降低啄钻或退刀次数
- TiAlN涂层延长刀具寿命



尺寸参考

Size Ref.	d ₁	l ₁	l ₂	Item # (货号)	Item # (货号)
0100	1.0	56	33	D170 0100	D171 0100
0110	1.1	60	37	D170 0110	D171 0110
0120	1.2	65	41	D170 0120	D171 0120
0130	1.3	65	41	D170 0130	D171 0130
0140	1.4	70	45	D170 0140	D171 0140
0150	1.5	70	45	D170 0150	D171 0150
0160	1.6	76	50	D170 0160	D171 0160
0170	1.7	76	50	D170 0170	D171 0170
0180	1.8	80	53	D170 0180	D171 0180
0190	1.9	80	53	D170 0190	D171 0190
0200	2.0	85	56	D170 0200	D171 0200
0210	2.1	85	56	D170 0210	D171 0210
0220	2.2	90	59	D170 0220	D171 0220
0230	2.3	90	59	D170 0230	D171 0230
0240	2.4	95	62	D170 0240	D171 0240
0250	2.5	95	62	D170 0250	D171 0250
0260	2.6	95	62	D170 0260	D171 0260
0270	2.7	100	66	D170 0270	D171 0270
0280	2.8	100	66	D170 0280	D171 0280
0290	2.9	100	66	D170 0290	D171 0290
0300	3.0	100	66	D170 0300	D171 0300
0310	3.1	106	69	D170 0310	D171 0310
0320	3.2	106	69	D170 0320	D171 0320
0330	3.3	106	69	D170 0330	D171 0330
0340	3.4	112	73	D170 0340	D171 0340
0350	3.5	112	73	D170 0350	D171 0350
0360	3.6	112	73	D170 0360	D171 0360
0370	3.7	112	73	D170 0370	D171 0370
0380	3.8	119	78	D170 0380	D171 0380
0390	3.9	119	78	D170 0390	D171 0390
0400	4.0	119	78	D170 0400	D171 0400
0410	4.1	119	78	D170 0410	D171 0410
0420	4.2	119	78	D170 0420	D171 0420
0430	4.3	126	82	D170 0430	D171 0430
0440	4.4	126	82	D170 0440	D171 0440
0450	4.5	126	82	D170 0450	D171 0450
0460	4.6	126	82	D170 0460	D171 0460
0470	4.7	126	82	D170 0470	D171 0470
0480	4.8	132	87	D170 0480	D171 0480
0490	4.9	132	87	D170 0490	D171 0490
0500	5.0	132	87	D170 0500	D171 0500
0510	5.1	132	87	D170 0510	D171 0510
0520	5.2	132	87	D170 0520	D171 0520
0530	5.3	132	87	D170 0530	D171 0530
0540	5.4	139	91	D170 0540	D171 0540
0550	5.5	139	91	D170 0550	D171 0550
0560	5.6	139	91	D170 0560	D171 0560
0570	5.7	139	91	D170 0570	D171 0570

Catalogue Code 目录代码

Product Name 产品名称

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Point Type 钻尖类别

Shank Tolerance 柄径容许公差

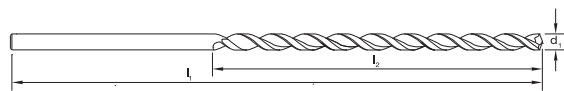
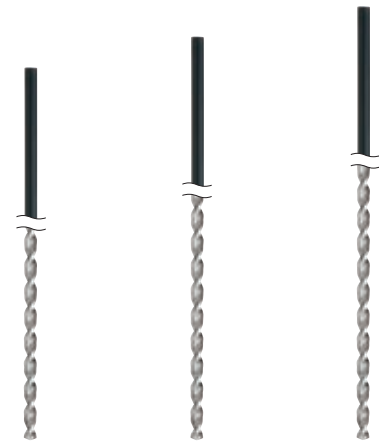
	D170	D171
DHL	DHL	DHL
A0504	A0504	A0508
HSS Co 含钴高速钢	HSS Co 含钴高速钢	HSS Co 含钴高速钢
BrT 无处理	BrT 无处理	TiAlN 氮化铝钛
R40 NH	R40 NH	R40 NH
130° Form B	130° Form B	130° Form B
h9	h9	h9

Size Ref.	d ₁	l ₁	l ₂	Item # (货号)	Item # (货号)
0580	5.8	139	91	D170 0580	D171 0580
0590	5.9	139	91	D170 0590	D171 0590
0600	6.0	139	91	D170 0600	D171 0600
0610	6.1	148	97	D170 0610	D171 0610
0620	6.2	148	97	D170 0620	D171 0620
0630	6.3	148	97	D170 0630	D171 0630
0640	6.4	148	97	D170 0640	D171 0640
0650	6.5	148	97	D170 0650	D171 0650
0660	6.6	148	97	D170 0660	D171 0660
0670	6.7	148	97	D170 0670	D171 0670
0680	6.8	156	102	D170 0680	D171 0680
0690	6.9	156	102	D170 0690	D171 0690
0700	7.0	156	102	D170 0700	D171 0700
0710	7.1	156	102	D170 0710	D171 0710
0720	7.2	156	102	D170 0720	D171 0720
0730	7.3	156	102	D170 0730	D171 0730
0740	7.4	156	102	D170 0740	D171 0740
0750	7.5	156	102	D170 0750	D171 0750
0760	7.6	165	109	D170 0760	D171 0760
0770	7.7	165	109	D170 0770	D171 0770
0780	7.8	165	109	D170 0780	D171 0780
0790	7.9	165	109	D170 0790	D171 0790
0800	8.0	165	109	D170 0800	D171 0800
0810	8.1	165	109	D170 0810	D171 0810
0820	8.2	165	109	D170 0820	D171 0820
0830	8.3	165	109	D170 0830	D171 0830
0840	8.4	165	109	D170 0840	D171 0840
0850	8.5	165	109	D170 0850	D171 0850
0860	8.6	175	115	D170 0860	D171 0860
0870	8.7	175	115	D170 0870	D171 0870
0880	8.8	175	115	D170 0880	D171 0880
0890	8.9	175	115	D170 0890	D171 0890
0900	9.0	175	115	D170 0900	D171 0900
0910	9.1	175	115	D170 0910	D171 0910
0920	9.2	175	115	D170 0920	D171 0920
0930	9.3	175	115	D170 0930	D171 0930
0940	9.4	175	115	D170 0940	D171 0940
0950	9.5	175	115	D170 0950	D171 0950
0980	9.8	184	121	D170 0980	D171 0980
1000	10.0	184	121	D170 1000	D171 1000
1020	10.2	184	121	D170 1020	D171 1020
1050	10.5	184	121	D170 1050	D171 1050
1100	11.0	195	128	D170 1100	D171 1100
1150	11.5	195	128	D170 1150	D171 1150
1200	12.0	205	134	D170 1200	D171 1200
1250	12.5	205	134	D170 1250	D171 1250
1300	13.0	205	134	D170 1300	D171 1300

Drills Extra Long 10-14 x D



- High performance drill
 - Suitable for materials up to 1200N/mm²
 - Point geometry ensures high strength
 - Parabolic flute design for optimal chip transportation
 - Less pecking required over standard drills
- 高效能钻头
 - 加工硬度可达1200N/mm²
 - 高强度钻头
 - 高效排屑的抛物线槽形设计
 - 大幅降低啄钻或退刀次数



Catalogue Code 目录代码
 Product Name 产品名称
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 色环及应用
 Point Type 钻尖类别

D191	D192	D193
DHXL-1	DHXL-2	DHXL-3
A0502	A0502	A0502
HSS	HSS	HSS
Ni + Blu 氮氧化	Ni + Blu 氮氧化	Ni + Blu 氮氧化
R40 NH	R40 NH	R40 NH
130° Form B	130° Form B	130° Form B
h9	h9	h9
Item # (货号)	Item # (货号)	Item # (货号)

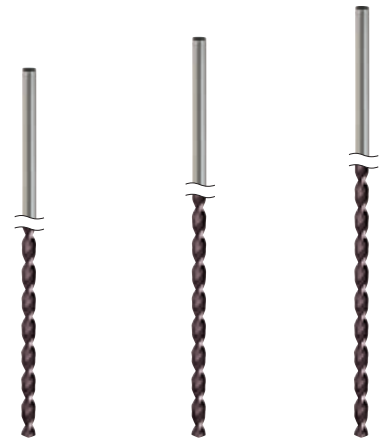
Shank Tolerance 柄径容许公差	DIN1869-1 (D191)		DIN1869-2 (D192)		DIN1869-3 (D193)		Item # (货号)	Item # (货号)	Item # (货号)
	Size Ref.	d ₁	l ₁	l ₂	l ₁	l ₂			
0200	2.0		125	85			D191 0200		
0250	2.5		135	90			D191 0250		
0300	3.0		155	105	200	135	D191 0300	D192 0300	
0350	3.5		165	115	210	145	D191 0350	D192 0350	D193 0350
0400	4.0		175	120	220	150	D191 0400	D192 0400	D193 0400
0450	4.5		185	125	235	160	D191 0450	D192 0450	D193 0450
0500	5.0		195	135	245	170	D191 0500	D192 0500	D193 0500
0550	5.5		205	140	260	180	D191 0550	D192 0550	D193 0550
0600	6.0		205	140	260	180	D191 0600	D192 0600	D193 0600
0650	6.5		215	150	275	190	D191 0650	D192 0650	D193 0650
0700	7.0		225	155	290	200	D191 0700	D192 0700	D193 0700
0750	7.5		225	155	290	200	D191 0750	D192 0750	D193 0750
0800	8.0		240	165	305	210	D191 0800	D192 0800	D193 0800
0850	8.5		240	165	305	210	D191 0850	D192 0850	D193 0850
0900	9.0		250	175	320	220	D191 0900	D192 0900	D193 0900
0950	9.5		250	175	320	220	D191 0950	D192 0950	D193 0950
1000	10.0		265	185	340	235	D191 1000	D192 1000	D193 1000
1050	10.5		265	185	340	235	D191 1050	D192 1050	D193 1050
1100	11.0*		280	195	365	250	D191 1100	D192 1100	D193 1100
1150	11.5*		280	195	365	250	D191 1150	D192 1150	D193 1150
1200	12.0*		295	205	375	260	D191 1200	D192 1200	D193 1200
1250	12.5*		295	205	375	260	D191 1250	D192 1250	D193 1250
1300	13.0*		295	205	375	260	D191 1300	D192 1300	D193 1300

*Sutton Tools Standard *Sutton Tools 标准

Drills Extra Long 10-14 x D



- High performance drill
 - Suitable for materials up to 1200N/mm²
 - Point geometry ensures high strength
 - Parabolic flute design for optimal chip transportation
 - Less pecking required over standard drills
 - TiAIN for longer tool life
- 高效能钻头
 - 加工硬度可达1200N/mm²
 - 高强度钻尖
 - 高效排屑的抛物线槽形设计
 - 大幅降低啄钻或退刀次数
 - TiAIN涂层延长刀具寿命



Catalogue Code 目录代码
Product Name 产品名称
Discount Group 折扣组
Material 材料
Surface Finish 表面处理
Application 色环及应用
Point Type 钻尖类别

D194	D195	D196
DHXL-1	DHXL-2	DHXL-3
A0508	A0508	A0508
HSS Co 含钴高速钢	HSS Co 含钴高速钢	HSS Co 含钴高速钢
TiAIN 氮化铝钛	TiAIN 氮化铝钛	TiAIN 氮化铝钛
R40 NH	R40 NH	R40 NH
130° Form B	130° Form B	130° Form B
h9	h9	h9

Shank Tolerance

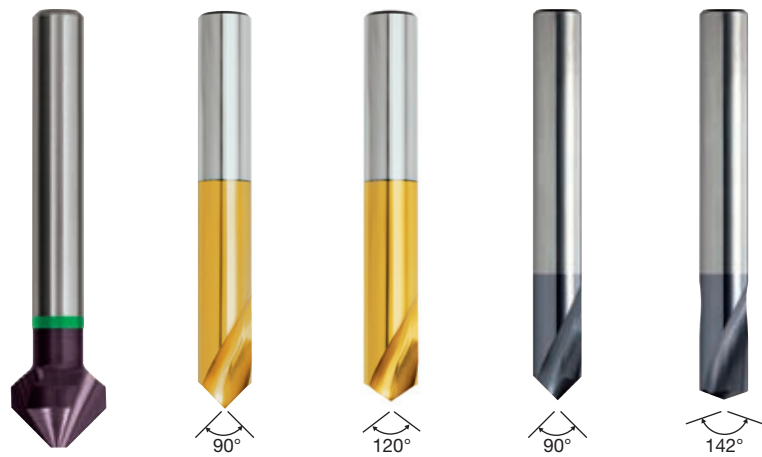
	DIN1869-1 (D194)	DIN1869-2 (D195)	DIN1869-3 (D196)
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Size Ref.	d ₁	l ₁	l ₂	l ₁	l ₂	l ₁	l ₂	Item # (货号)	Item # (货号)	Item # (货号)
0200	2.0	125	85					D194 0200		
0250	2.5	135	90					D194 0250		
0300	3.0	155	105	200	135	240	160	D194 0300	D195 0300	
0350	3.5	165	115	210	145	265	180	D194 0350	D195 0350	D196 0350
0400	4.0	175	120	220	150	280	190	D194 0400	D195 0400	D196 0400
0450	4.5	185	125	235	160	295	200	D194 0450	D195 0450	D196 0450
0500	5.0	195	135	245	170	315	210	D194 0500	D195 0500	D196 0500
0550	5.5	205	140	260	180	330	225	D194 0550	D195 0550	D196 0550
0600	6.0	205	140	260	180	330	225	D194 0600	D195 0600	D196 0600
0650	6.5	215	150	275	190	350	235	D194 0650	D195 0650	D196 0650
0700	7.0	225	155	290	200	370	250	D194 0700	D195 0700	D196 0700
0750	7.5	225	155	290	200	370	250	D194 0750	D195 0750	D196 0750
0800	8.0	240	165	305	210	390	265	D194 0800	D195 0800	D196 0800
0850	8.5	240	165	305	210	390	265	D194 0850	D195 0850	D196 0850
0900	9.0	250	175	320	220	410	280	D194 0900	D195 0900	D196 0900
0950	9.5	250	175	320	220	410	280	D194 0950	D195 0950	D196 0950
1000	10.0	265	185	340	235	430	295	D194 1000	D195 1000	D196 1000

Drills Spotting & Countersinks

suttontools

- Precision drill for machine use
- Rigid design for "seat" position accuracy
- 90° offers hole chamfering and spotting with the one tool
- 120°/142° designed to match drill point
- 机用精密钻削
- 高刚性设计、倒角位更精确
- 90° 型号适合同时倒角及定位
- 120° 及142° 用于针对相应的钻尖角度



Catalogue Code 目录代码

Discount Group 折扣组

Material 材料

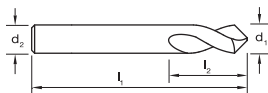
Surface Finish 表面处理

Application 色环及应用

Geometry 几何结构

Point Type 钻尖类别

Shank Tolerance 柄径容许公差



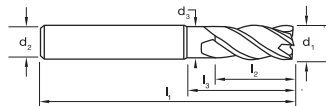
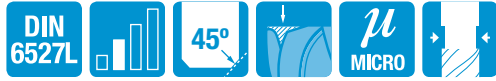
尺寸参考

	C108				D175		D176		D364		D366	
	A1108				A1124		A1124		A0210		A0210	
	HSS Co 含钴高速钢				HSS Co 含钴高速钢		HSS Co 含钴高速钢		VHM 硬质合金		VHM 硬质合金	
	TiAlN 氮化铝钛				TiN 氮化钛		TiN 氮化钛		AlCrN 氮化铝铬		AlCrN 氮化铝铬	
	UNI				NC		NC		NC		NC	
	-				-		-		-		-	
	90°				90°		120°		90° Form A		142° Form A	
	-				h9		h9		h9		h9	
Size Ref.	d ₁	l ₁	l ₂	d ₂	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	
DIN 335												
0430	4.3	40		4	C108 0430							
0530	5.3	40		4	C108 0530							
0630	6.3	45		5	C108 0630							
0730	7.3	50		6	C108 0730							
0800	8.0	50		6	C108 0800							
0840	8.4	50		6	C108 0840							
0940	9.4	50		6	C108 0940							
1000	10.0	50		6	C108 1000							
1040	10.4	50		6	C108 1040							
1150	11.5	56		8	C108 1150							
1240	12.4	56		8	C108 1240							
1340	13.4	56		8	C108 1340							
1500	15.0	60		10	C108 1500							
1650	16.5	60		10	C108 1650							
1900	19.0	63		10	C108 1900							
2050	20.5	63		10	C108 2050							
2300	23.0	67		10	C108 2300							
2500	25.0	67		10	C108 2500							
3000	30.0	71		12	C108 3000							
3100	31.0	71		12	C108 3100							
DIN 1897												
0300	3.0	49	16	3.0		D175 0300	D176 0300					
0400	4.0	55	22	4.0		D175 0400	D176 0400					
0500	5.0	62	25	5.0		D175 0500	D176 0500					
0600	6.0	66	25	6.0		D175 0600	D176 0600					
0800	8.0	79	29	8.0		D175 0800	D176 0800					
1000	10.0	89	32	10.0		D175 1000	D176 1000					
1200	12.0	102	32	12.0		D175 1200	D176 1200					
1600	16.0	115	35	16.0		D175 1600	D176 1600					
2000	20.0	131	37	20.0		D175 2000	D176 2000					
2500	25.0	151	37	25.0		D175 2500	D176 2500					
SUTTON STD												
0300	3.0	46	9	3.0				D364 0300	D366 0300			
0400	4.0	55	12	4.0				D364 0400	D366 0400			
0500	5.0	62	15	5.0				D364 0500	D366 0500			
0600	6.0	66	18	6.0				D364 0600	D366 0600			
0800	8.0	79	23	8.0				D364 0800	D366 0800			
1000	10.0	89	24	10.0				D364 1000	D366 1000			
1200	12.0	102	24	12.0				D364 1200	D366 1200			
1600	16.0	115	26	16.0				D364 1600	D366 1600			
2000	20.0	131	35	20.0				D364 2000	D366 2000			

Endmills Harmony UNI Series

suttontools

- VHM-ULTRA grade of carbide for high performance
- For universal application in materials up to 1600N/mm²
- AlCrN for longer tool life
- 采用高效能用的VHM-Ultra超微粒硬质合金
- 高泛用性、加工硬度达1600N/mm²
- 氮化铝铬涂层延长刀具寿命



尺寸参考

Type 型	3 Flute / 3 刃	4 Flute / 4 刃	4 Flute / 4 刃	Universal / 半精粗	Roughing / 粗铣
Discount Group 折扣组	B0210	B0210	B0210	B0210	B0210
Material 材料	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA
Surface Finish 表面处理	AlCrN 氮化铝铬	AlCrN 氮化铝铬	AlCrN 氮化铝铬	AlCrN 氮化铝铬	AlCrN 氮化铝铬
Application 色环及应用	UNI	UNI	UNI	UNI	UNI
Geometry 螺旋角别	R38/37/39	R35 / 38	R45/44	R45 STF	R45 HRS
Shank Form (DIN 6535) 柄径形 (DIN 6535)	HA	HA	HA	HA	HA
Shank Tolerance 柄径容许公差	h5	h6	h5	h6	h6

Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
DIN 6527K								E422	E533			
0300	3.0	50	5	*	6	*	3	E422 0300				
0350	3.5	50	6	*	6	*	3	E422 0350				
0400	4.0	54	8	*	6	*	3	E422 0400				
0450	4.5	54	8	*	6	*	3	E422 0450				
0500	5.0	54	9	*	6	*	3	E422 0500				
0550	5.5	54	9	*	6	*	3	E422 0550				
0600	6.0	54	10	*	6	*	3	E422 0600	E533 0600			
0800	8.0	58	12	*	8	*	3	E422 0800	E533 0800			
1000	10.0	66	14	*	10	*	3	E422 1000	E533 1000			
1200	12.0	73	16	*	12	*	3	E422 1200	E533 1200			
1400	14.0	73	16	*	14	*	3	E422 1400				
1600	16.0	82	22	*	16	*	3	E422 1600	E533 1600			
1800	18.0	82	22	*	18	*	3	E422 1800				
2000	20.0	92	26	*	20	*	3	E422 2000	E533 2000			
DIN 6527L								E424	E535	E426	E545	E549
0300	3.0	57	8	*	6	*	4	E424 0300	E535 0300	E426 0300		
0350	3.5	57	11	*	6	*	4	E424 0350		E426 0350		
0400	4.0	57	11	*	6	*	4	E424 0400	E535 0400	E426 0400	E545 0400	
0450	4.5	57	13	*	6	*	4	E424 0450		E426 0450		
0500	5.0	57	13	*	6	*	4	E424 0500	E535 0500	E426 0500	E545 0500	
0550	5.5	57	13	*	6	*	4	E424 0550		E426 0550		
0600	6.0	57	13	*	6	*	4	E424 0600	E535 0600	E426 0600	E545 0600	
0800	8.0	63	19	*	8	*	4	E424 0800	E535 0800	E426 0800	E545 0800	
1000	10.0	72	22	*	10	*	4	E424 1000	E535 1000	E426 1000	E545 1000	
1200	12.0	83	26	*	12	*	4	E424 1200	E535 1200	E426 1200	E545 1200	
1400	14.0	83	26	*	14	*	4	E424 1400	E535 1400	E426 1400		
1600	16.0	92	32	*	16	*	4	E424 1600	E535 1600	E426 1600	E545 1600	
1800	18.0	92	32	*	18	*	4	E424 1800	E535 1800	E426 1800		
2000	20.0	104	38	*	20	*	4	E424 2000	E535 2000	E426 2000	E545 2000	
2500	25.0	120	45	*	25	*	4		E535 2500	E426 2500		
DIN 6527L												
0400	4.0	57	11	19	6	3.7	3					E549 0400
0500	5.0	57	13	20	6	4.6	4					E549 0500
0600	6.0	57	16	21	6	5.5	4					E549 0600
0800	8.0	63	19	27	8	7.5	4					E549 0800
1000	10.0	72	22	32	10	9.5	4					E549 1000
1200	12.0	83	26	38	12	11.2	4					E549 1200
1600	16.0	92	32	44	16	15.0	5					E549 1600
2000	20.0	104	38	54	20	19.0	6					E549 2000

*Refer to full catalogue for l₃ and d₃ dimensions *l₃及d₃尺寸请参阅厚本目

Endmills Harmony, Corner Radius

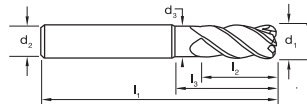


E559 - For precision finishing applications
 - Ideally suited to materials up to 1300 N/mm²
 - AlCrN for longer tool life

E462 - Optimised geometry for soft stainless steels
 - Helica for superior wear resistance in stainless steel

E559 - 高精度精铣用
 - 加工硬度可达1300N/mm²
 - 氮化铝铬涂层延长刀具寿命

E462 - 特殊几何设计、针对软质不锈钢类
 - 不锈钢专用Helica涂层可延长刀具寿命



尺寸参考

Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad
0303	3.0	57	8	19	6	3.7	4	0.3
0305		57	8	19	6	3.7	4	0.5
0403	4.0	57	11	19	6	3.7	4	0.3
0405		57	11	19	6	3.7	4	0.5
0410		57	11	19	6	3.7	4	1.0
0503	5.0	57	13	20	6	4.6	4	0.3
0505		57	13	20	6	4.6	4	0.5
0510		57	13	20	6	4.6	4	1.0
0603	6.0	57	13	21	6	5.5	4	0.3
0605		57	13	21	6	5.5	4	0.5
0610		57	13	21	6	5.5	4	1.0
0803	8.0	63	19	27	8	7.5	4	0.3
0805		63	19	27	8	7.5	4	0.5
0810		63	19	27	8	7.5	4	1.0
0815		63	19	27	8	7.5	4	1.5
0820		63	19	27	8	7.5	4	2.0
1003	10.0	72	22	32	10	9.5	4	0.3
1005		72	22	32	10	9.5	4	0.5
1010		72	22	32	10	9.5	4	1.0
1015		72	22	32	10	9.5	4	1.5
1020		72	22	32	10	9.5	4	2.0
1203	12.0	83	26	38	12	11.2	4	0.3
1205		83	26	38	12	11.2	4	0.5
1210		83	26	38	12	11.2	4	1.0
1215		83	26	38	12	11.2	4	1.5
1220		83	26	38	12	11.2	4	2.0
1230		83	26	38	12	11.2	4	3.0
1605	16.0	92	32	44	16	15.0	4	0.5
1610		92	32	44	16	15.0	4	1.0
1615		92	32	44	16	15.0	4	1.5
1620		92	32	44	16	15.0	4	2.0
1630		92	32	44	16	15.0	4	3.0
2005	20.0	104	38	54	20	19.0	4	0.5
2010		104	38	54	20	19.0	4	1.0
2015		104	38	54	20	19.0	4	1.5
2020		104	38	54	20	19.0	4	2.0
2030		104	38	54	20	19.0	4	3.0

Type 型	4 Flute - Rad / 4 刃圆角	4 Flute - Rad / 4 刃圆角
Discount Group 折扣组	B0210	B0210
Material 材料	VHM-ULTRA	VHM-ULTRA
Surface Finish 表面处理	AlCrN 氮化铝铬	HELICA
Application 色环及应用	UNI	VA
Geometry 螺旋角别	R35 / 38	R40/42
Shank Form (DIN 6535) 柄径形 (DIN 6535)	HA	HA
Shank Tolerance 柄径容许公差	h6	h5

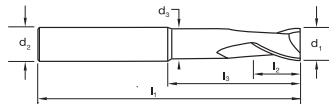
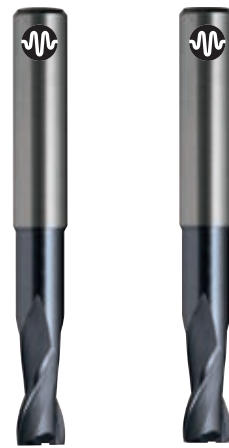
Item # (货号)	Item # (货号)
E559	E462
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E559 0405	
E559 0410	
E559 0503	
E559 0505	
E559 0510	
E559 0603	E462 0603
E559 0605	E462 0605
E559 0610	E462 0610
E559 0803	E462 0803
E559 0805	E462 0805
E559 0810	E462 0810
E559 0815	E462 0815
E559 0820	E462 0820
E559 1003	E462 1003
E559 1005	E462 1005
E559 1010	E462 1010
E559 1015	E462 1015
E559 1020	E462 1020
E559 1203	E462 1203
E559 1205	E462 1205
E559 1210	E462 1210
E559 1215	E462 1215
E559 1220	E462 1220
E559 1230	E462 1230
E559 1605	E462 1605
E559 1610	E462 1610
E559 1615	E462 1615
E559 1620	E462 1620
E559 1630	E462 1630
E559 2005	E462 2005
E559 2010	E462 2010
E559 2015	E462 2015
E559 2020	E462 2020
E559 2030	E462 2030

Endmills Harmony UNI Series

suttontools

- VHM-ULTRA grade of carbide for high performance
- For precision milling of slots & cavities
- AlCrN for longer tool life
- E418 - Suitable for materials up to 1600 N/mm²
- E420 - Suitable for materials up to 1300 N/mm²

- 采用高效能用的VHM-Ultra超微晶粒硬质合金
- 适合高精度槽铣及型腔铣削
- 氮化铝铬涂层延长刀具寿命
- E418 - 加工硬度可达1600N/mm²
- E420 - 加工硬度可达1300N/mm²



尺寸参考

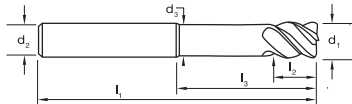
Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad*	Type 型	Discount Group 折扣组	Material 材料	Surface Finish 表面处理	Application 色环及应用	Geometry 螺旋角别	Shank Form (DIN 6535) 柄径形 (DIN 6535)	Shank Tolerance 柄径容许公差	Item # (货号)	Item # (货号)
									2 Flute / 2 刃	B0210	VHM-ULTRA	AlCrN 氮化铝铬	UNI	R30	HA	h5	E418	E420
0200	2.0	54	3	9	6	1.8	2										E418 0200	
0250	2.5	54	3.5	9	6	2.2	2										E418 0250	
0300	3.0	54	4	11	6	2.7	2										E418 0300	
0350	3.5	57	4.5	11	6	3.1	2										E418 0350	
0400	4.0	57	5	15	6	3.6	2	0.3									E418 0400	E420 0403
0405		57	5	15	6	3.6	2	0.5										E420 0405
0450	4.5	57	5.5	15	6	4.1	2										E418 0450	
0500	5.0	62	6	23	6	4.5	2										E418 0500	
0550	5.5	62	6.5	23	6	5.0	2										E418 0550	
0600	6.0	62	7	24	6	5.4	2	0.3									E418 0600	E420 0603
0605		62	7	24	6	5.4	2	0.5										E420 0605
0610		62	7	24	6	5.4	2	1.0										E420 0610
0615		62	7	24	6	5.4	2	1.5										E420 0615
0700	7.0	68	8	28	8	6.3	2										E418 0700	
0800	8.0	68	9	30	8	7.2	2	0.3									E418 0800	E420 0803
0805		68	9	30	8	7.2	2	0.5										E420 0805
0810		68	9	30	8	7.2	2	1.0										E420 0810
0815		68	9	30	8	7.2	2	1.5										E420 0815
0900	9.0	80	10	36	10	8.2	2										E418 0900	
1000	10.0	80	11	38	10	9.0	2	0.5									E418 1000	E420 1005
1010		80	11	38	10	9.0	2	1.0										E420 1010
1015		80	11	38	10	9.0	2	1.5										E420 1015
1020		80	11	38	10	9.0	2	2.0										E420 1020
1100	11.0	93	12	44	12	10.0	2										E418 1100	
1200	12.0	93	13	46	12	11.0	2	0.5									E418 1200	E420 1205
1210		93	13	46	12	11.0	2	1.0										E420 1210
1215		93	13	46	12	11.0	2	1.5										E420 1215
1220		93	13	46	12	11.0	2	2.0										E420 1220
1300	13.0	93	14	44	14	12.0	2										E418 1300	
1400	14.0	93	15	46	14	13.0	2										E418 1400	
1500	15.0	108	16	56	16	14.0	2										E418 1500	
1600	16.0	108	17	58	16	15.0	2	1.0									E418 1600	E420 1610
1620		108	17	58	16	15.0	2	2.0										E420 1620
1630		108	17	58	16	15.0	2	3.0										E420 1630
1640		108	17	58	16	15.0	2	4.0										E420 1640
1800	18.0	108	19	58	18	17.0	2										E418 1800	
2000	20.0	126	21	74	20	19.0	2										E418 2000	

*Rad applies to E420 *E420带圆角

Endmills Harmony UNI Series, Corner Radius



- VHM-ULTRA grade of carbide for high performance
- 45/44° variable flute helix for chatter free milling
- Suitable for materials up to 1300 N/mm²
- AlCrN for longer tool life
- 采用高效能用的VHM-Ultra超微粒粒硬质合金
- 45/44° 不等螺旋角有效抑制共振
- 加工硬度可达1300N/mm²
- 氮化铝铬涂层延长刀具寿命



尺寸参考

Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad	Item # (货号)
0403	4.0	57	5	16	6	3.6	4	0.3	E430 E430 0403
0405		57	5	16	6	3.6	4	0.5	E430 0405
0603	6.0	62	7	24	6	5.4	4	0.3	E430 0603
0605		62	7	24	6	5.4	4	0.5	E430 0605
0610		62	7	24	6	5.4	4	1.0	E430 0610
0615		62	7	24	6	5.4	4	1.5	E430 0615
0803	8.0	68	9	30	8	7.2	4	0.3	E430 0803
0805		68	9	30	8	7.2	4	0.5	E430 0805
0810		68	9	30	8	7.2	4	1.0	E430 0810
0815		68	9	30	8	7.2	4	1.5	E430 0815
1005	10.0	80	11	38	10	9.0	4	0.5	E430 1005
1010		80	11	38	10	9.0	4	1.0	E430 1010
1015		80	11	38	10	9.0	4	1.5	E430 1015
1020		80	11	38	10	9.0	4	2.0	E430 1020
1205	12.0	93	13	46	12	11.0	4	0.5	E430 1205
1210		93	13	46	12	11.0	4	1.0	E430 1210
1215		93	13	46	12	11.0	4	1.5	E430 1215
1220		93	13	46	12	11.0	4	2.0	E430 1220
1610	16.0	108	17	58	16	15.0	4	1.0	E430 1610
1620		108	17	58	16	15.0	4	2.0	E430 1620
1630		108	17	58	16	15.0	4	3.0	E430 1630
1640		108	17	58	16	15.0	4	4.0	E430 1640



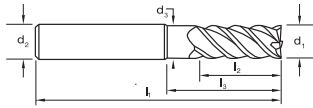
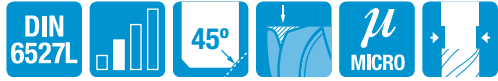
Type 型	4 Flute - Rad / 4 刃圆角
Discount Group 折扣组	B0210
Material 材料	VHM-ULTRA
Surface Finish 表面处理	AlCrN 氮化铝铬
Application 色环及应用	UNI
Geometry 螺旋角别	R45 / 44
Shank Form (DIN 6535) 柄径形 (DIN 6535)	HA
Shank Tolerance 柄径容许公差	h5

Endmills Harmony VA Series

suttontools

- VHM-ULTRA grade of carbide for high performance
- Optimised geometry for soft stainless steels
- Helica for superior wear resistance in stainless steel

- 采用高效能用的VHM-Ultra超微晶粒硬质合金
- 特殊几何设计、针对软质不锈钢类
- 不锈钢专用Helica涂层可延长刀具寿命



Shank Form (DIN 6535) 柄径形 (DIN 6535)

Shank Tolerance 柄径容许公差

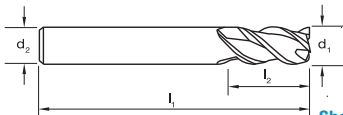
尺寸参考

Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Type 型	Discount Group 折扣组	Material 材料	Surface Finish 表面处理	Application 应用代号	Geometry 螺旋角别	3 Flute / 3 刃	4 Flute / 4 刃	4 Flute / 4 刃	4 Flute / 4 刃	Roughing / 粗铣
DIN6527L																		
0300	3.0	57	8	14	6	2.8	3	VA	B0210	VHM-ULTRA	HELICA	VA	R55/54/56	E410	E459	E412	E414	E416
0400	4.0	57	11	16	6	3.8	3	VA	B0210	VHM-ULTRA	HELICA	VA	R40/42	E410 0300	E459 0300			
0500	5.0	57	13	18	6	4.8	3	VA	B0210	VHM-ULTRA	HELICA	VA	R55	E410 0400	E459 0400			
0600	6.0	57	13	19	6	5.7	3	VA	B0210	VHM-ULTRA	HELICA	VA	R55	E410 0500	E459 0500			
0800	8.0	63	19	25	8	7.6	3	VA	B0210	VHM-ULTRA	HELICA	VA	R35/36/36 HR	E410 0600	E459 0600	E412 0600	E414 0600	E416 0600
1000	10.0	72	22	30	10	9.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	HA	E410 0800	E459 0800	E412 0800		E416 0800
1200	12.0	83	26	36	12	11.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	h5	E410 1000	E459 1000	E412 1000		E416 1000
1400	14.0	83	26	36	14	13.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	HA	E410 1200	E459 1200	E412 1200		E416 1200
1600	16.0	92	32	42	16	15.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	h5	E410 1400	E459 1400	E412 1400		E416 1400
1800	18.0	92	32	42	18	17.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	HA	E410 1600	E459 1600	E412 1600		E416 1600
2000	20.0	104	38	52	20	19.5	3	VA	B0210	VHM-ULTRA	HELICA	VA	h5	E410 1800	E459 1800	E412 1800		E416 1800
														E410 2000	E459 2000	E412 2000		E416 2000
DIN6527L																		
0300	3.0	57	8	18	6	2.8	4	VA										
0400	4.0	57	11	19	6	3.8	4	VA										
0500	5.0	57	13	20	6	4.8	4	VA										
0600	6.0	57	13	21	6	5.7	4	VA										
0800	8.0	63	19	27	8	7.6	4	VA										
1000	10.0	72	22	32	10	9.5	4	VA										
1200	12.0	83	26	38	12	11.5	4	VA										
1400	14.0	83	26	38	14	13.5	4	VA										
1600	16.0	92	32	44	16	15.5	4	VA										
1800	18.0	92	32	44	18	17.5	4	VA										
2000	20.0	104	38	54	20	19.5	4	VA										
SUTTON STD																		
0600	6.0	62	7	24	6	5.0	4	VA										E414 0600
0800	8.0	68	9	30	8	7.0	4	VA										E414 0800
1000	10.0	80	24	38	10	9.0	4	VA										E414 1000
1200	12.0	93	13	46	12	11.0	4	VA										E414 1200
1400	14.0	93	13	46	14	13.0	4	VA										E414 1400
1600	16.0	108	17	58	16	15.0	4	VA										E414 1600

Endmills Harmony Al Series

suttontools

- VHM-ULTRA grade of carbide for high performance
- Optimised geometry for soft materials
- CrN for copper and non-ferrous materials
- 采用高效能用的VHM-Ultra超微晶粒硬质合金
- 特殊几何设计、针对软质材料
- 氮化铬涂层针对铜材及非铁金属



Shank Form (DIN 6535) 柄径形 (DIN 6535)
Shank Tolerance 柄径容许公差

尺寸参考

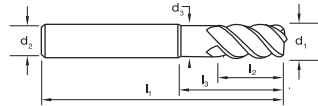
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DIN 6527L												
0200	2.0	57	7	10	6		2		E310	E400	E404	E408
0300	3.0	57	8	10	6		2		E310 0200			
0400	4.0	57	11	10	6		2		E310 0300			
0500	5.0	57	13	8	6		2		E310 0400			
0600	6.0	57	13		6		2		E310 0500			
0800	8.0	63	19		8		2		E310 0600			
1000	10.0	72	22		10		2		E310 0800			
1200	12.0	83	26		12		2		E310 1000			
1600	16.0	92	32		16		2		E310 1200			
2000	20.0	104	38		20		2		E310 1600			
									E310 2000			
DIN 6527L												
0600	6.0	57	13		6		3	0.2		E400 0600		
0800	8.0	63	19		8		3	0.2		E400 0800		
1000	10.0	72	24		10		3	0.3		E400 1000		
1200	12.0	83	28		12		3	0.4		E400 1200		
1400	14.0	83	30		14		3	0.4		E400 1400		
1600	16.0	92	35		16		3	0.5		E400 1600		
1800	18.0	92	38		18		3	0.5		E400 1800		
2000	20.0	104	42		20		3	0.6		E400 2000		
2500	25.0	120	50		25		3	0.6		E400 2500		
SUTTON STD												
0600	6.0	62	7	24	6	5.0	3	0.2		E402		
0800	8.0	68	9	30	8	7.0	3	0.2		E402 0600		
1000	10.0	80	12	38	10	9.0	3	0.3		E402 0800		
1200	12.0	93	14	46	12	11.0	3	0.4		E402 1000		
1400	14.0	93	16	46	14	13.0	3	0.4		E402 1200		
1600	16.0	108	18	58	16	15.0	3	0.5		E402 1400		
1800	18.0	108	20	58	18	17.0	3	0.5		E402 1600		
2000	20.0	126	22	74	20	19.0	3	0.6		E402 1800		
2500	25.0	150	27	92	25	24.0	3	0.6		E402 2000		
										E402 2500		
DIN 6527L												
1000	10.0	72	23		10		3				E404 1000	
1200	12.0	83	28		12		3				E404 1200	
1400	14.0	83	28		14		3				E404 1400	
1600	16.0	92	34		16		3				E404 1600	
1800	18.0	92	34		18		3				E404 1800	
2000	20.0	104	42		20		3				E404 2000	
2500	25.0	120	52		25		3				E404 2500	
SUTTON STD												
0600	6.0	62	9	24	6		3					E408 0600
0800	8.0	68	12	30	8		3					E408 0800
1000	10.0	80	15	38	10		3					E408 1000
1200	12.0	93	18	46	12		3					E408 1200
1400	14.0	93	21	46	14		3					E408 1400
1600	16.0	108	24	58	16		3					E408 1600
1800	18.0	108	27	58	18		3					E408 1800
2000	20.0	126	30	74	20		3					E408 2000
2500	25.0	150	38	92	25		3					E408 2500

Endmills Harmony DUO

suttontools

- VHM-ULTRA grade of carbide for high performance
 - Dual stepped core for optimal strength
 E562-E564 - Ideal design for pocket milling in materials up to 48HRC
 E566-E568 - For hard machining in materials up to 63HRC

- 采用高效能用的VHM-Ultra超微晶粒硬质合金
 - 双芯径设计、刚性特高
 E562/E564 - 特别适合48HRC的型腔铣削
 E566/E568 - 适合高硬铣削、硬度可达63HRC



尺寸参考

Type 型
 Discount Group 折扣组
 Material 材料
 Surface Finish 表面处理
 Application 应用代号
 Geometry 螺旋角别
 Shank Form (DIN 6535) 柄径形 (DIN 6535)
 Shank Tolerance 柄径容许公差

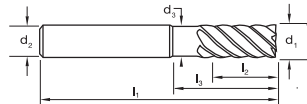
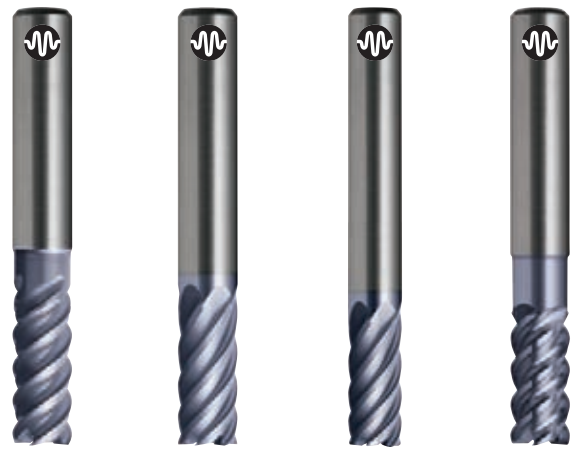
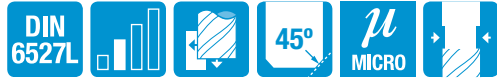
										DUO	DUO	DUO	DUO	
										B0210	B0210	B0210	B0210	
										VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	
										AlCrN 氮化铝钴	AlCrN 氮化铝钴	Aldura	Aldura	
										NH	NH	VH	VH	
										R50	R50	R50	R50	
										HA	HA	HA	HA	
										h6	h6	h6	h6	
Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad		Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)	
										DIN 6527L	E562	E564	E566	E568
0600	6.0	57	13	21	6	5.5	4			E562 0600		E566 0600		
0800	8.0	63	19	27	8	7.5	4			E562 0800		E566 0800		
1000	10.0	72	22	32	10	9.5	4			E562 1000		E566 1000		
1200	12.0	83	26	38	12	11.2	4			E562 1200		E566 1200		
1400	14.0	83	26	38	14	13.0	4			E562 1400		E566 1400		
1600	16.0	92	32	44	16	15.0	4			E562 1600		E566 1600		
2000	20.0	104	38	54	20	19.0	4			E562 2000		E566 2000		
										DIN 6527L				
0603	6.0	57	13	21	6	5.5	4	0.3			E564 0603			
0605		57	13	21	6	5.5	4	0.5			E564 0605			
0610		57	13	21	6	5.5	4	1.0			E564 0610		E568 0610	
0803	8.0	63	19	27	8	7.5	4	0.3			E564 0803			
0805		63	19	27	8	7.5	4	0.5			E564 0805			
0810		63	19	27	8	7.5	4	1.0			E564 0810			
0815		63	19	27	8	7.5	4	1.5			E564 0815			
0820		63	19	27	8	7.5	4	2.0			E564 0820		E568 0820	
1003	10.0	72	22	32	10	9.5	4	0.3			E564 1003			
1005		72	22	32	10	9.5	4	0.5			E564 1005			
1010		72	22	32	10	9.5	4	1.0			E564 1010			
1015		72	22	32	10	9.5	4	1.5			E564 1015			
1020		72	22	32	10	9.5	4	2.0			E564 1020		E568 1020	
1203	12.0	83	26	38	12	11.2	4	0.3			E564 1203			
1205		83	26	38	12	11.2	4	0.5			E564 1205			
1210		83	26	38	12	11.2	4	1.0			E564 1210			
1215		83	26	38	12	11.2	4	1.5			E564 1215			
1220		83	26	38	12	11.2	4	2.0			E564 1220			
1230		83	26	38	12	11.2	4	3.0			E564 1230		E568 1230	
1430	14.0	83	26	38	14	13.0	4	0.3			E564 1403			
1405		83	26	38	14	13.0	4	0.5			E564 1405			
1410		83	26	38	14	13.0	4	1.0			E564 1410			
1415		83	26	38	14	13.0	4	1.5			E564 1415			
1420		83	26	38	14	13.0	4	2.0			E564 1420			
1430		83	26	38	14	13.0	4	3.0			E564 1430		E568 1430	
1605	16.0	92	32	44	16	15.0	4	0.5			E564 1605			
1610		92	32	44	16	15.0	4	1.0			E564 1610			
1615		92	32	44	16	15.0	4	1.5			E564 1615			
1620		92	32	44	16	15.0	4	2.0			E564 1620			
1630		92	32	44	16	15.0	4	3.0			E564 1630			
1630		92	32	44	16	15.0	4	4.0			E564 1640		E568 1640	
2005	20.0	104	38	54	20	19.0	4	0.5			E564 2005			
2010		104	38	54	20	19.0	4	1.0			E564 2010			
2015		104	38	54	20	19.0	4	1.5			E564 2015			
2020		104	38	54	20	19.0	4	2.0			E564 2020			
2030		104	38	54	20	19.0	4	3.0			E564 2030			
2040		104	38	54	20	19.0	4	4.0			E564 2040		E568 2040	

Endmills Harmony H Series

suttontools

- For super fine finishing applications
- Suitable for hard, short chipping materials
- NH - For materials up to 48HRc
- VH - For materials up to 63HRc

- 高精铣用
- 适合高硬度、短屑材料
- NH - 加工硬度可达48HRc
- VH - 加工硬度可达63HRc



Shank Form (DIN 6535) 柄径形 (DIN 6535)
Shank Tolerance 柄径容许公差

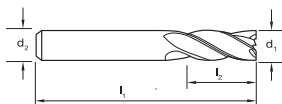
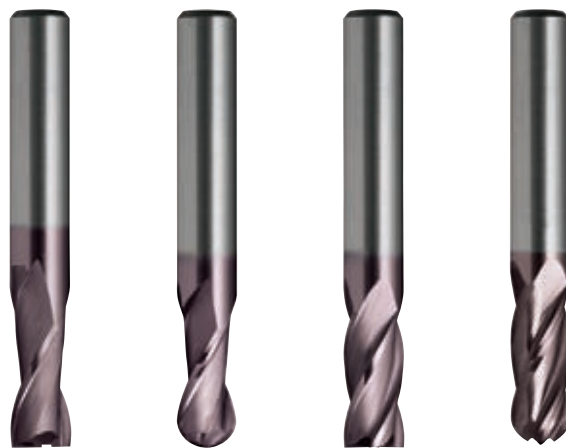
尺寸参考

Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
DIN 6527L												
0400	4.0	57	11	19	6	3.7	4		E428 E428 0400	E432	E436	E543
0500	5.0	57	13	20	6	4.7	4		E428 0500			
0600	6.0	57	13	21	6	5.7	6		E428 0600			E543 0600
0800	8.0	63	19	27	8	7.6	6		E428 0800			E543 0800
1000	10.0	72	22	32	10	9.5	6		E428 1000			E543 1000
1200	12.0	83	26	38	12	11.5	6		E428 1200			E543 1200
1600	16.0	92	32	44	16	15.5	8		E428 1600			E543 1600
2000	20.0	104	38	54	20	19.0	8					E543 2000
DIN 6527L												
0600	6.0	57	13		6		6			E432 0600		
0800	8.0	63	19		8		6			E432 0800		
1000	10.0	72	22		10		6			E432 1000		
1200	12.0	83	26		12		6			E432 1200		
1400	14.0	83	26		14		6			E432 1400		
1600	16.0	92	32		16		6			E432 1600		
1800	18.0	92	32		18		8			E432 1800		
2000	20.0	104	38		20		8			E432 2000		
2500	25.0	120	45		25		8			E432 2500		
SUTTON STD												
0600	6.0	62	18		6		6			E434 E434 0600		
0800	8.0	68	24		8		6			E434 0800		
1000	10.0	80	30		10		6			E434 1000		
1200	12.0	93	36		12		6			E434 1200		
1600	16.0	108	48		16		6			E434 1600		
2000	20.0	126	60		20		8			E434 2000		
2500	25.0	150	85		25		8			E434 2500		
0605	6.0	62	13		6		6	0.5			E436 0605	
0610	6.0	62	13		6		6	1.0			E436 0610	
0805	8.0	68	19		8		6	0.5			E436 0805	
0810	8.0	68	19		8		6	1.0			E436 0810	
1005	10.0	80	22		10		6	0.5			E436 1005	
1010	10.0	80	22		10		6	1.0			E436 1010	
1015	10.0	80	22		10		6	1.5			E436 1015	
1020	10.0	80	22		10		6	2.0			E436 1020	
1205	12.0	93	26		12		6	0.5			E436 1205	
1210	12.0	93	26		12		6	1.0			E436 1210	
1215	12.0	93	26		12		6	1.5			E436 1215	
1220	12.0	93	26		12		6	2.0			E436 1220	
1605	16.0	108	32		16		6	0.5			E436 1605	
1610	16.0	108	32		16		6	1.0			E436 1610	
1615	16.0	108	32		16		6	1.5			E436 1615	
1620	16.0	108	32		16		6	2.0			E436 1620	
2005	20.0	126	38		20		8	0.5			E436 2005	
2010	20.0	126	38		20		8	1.0			E436 2010	
2015	20.0	126	38		20		8	1.5			E436 2015	
2020	20.0	126	38		20		8	2.0			E436 2020	

Endmills Carbide

suttontools

- Economy range endmills - 经济型通用铣刀
- Standard grade carbide - 标准级别硬质合金材质
- For conventional milling applications - 适合常规铣削加工



尺寸参考

Catalogue Code 目录代码

Discount Group 折扣组

Material 材料

Surface Finish 表面处理

Application 色环及应用

Geometry 螺旋角别

Shank Form (DIN 6535) 柄径形 (DIN 6535)

Shank Tolerance 柄径容许公差

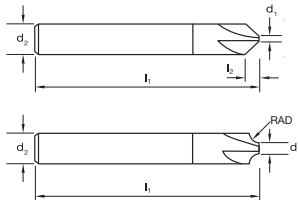
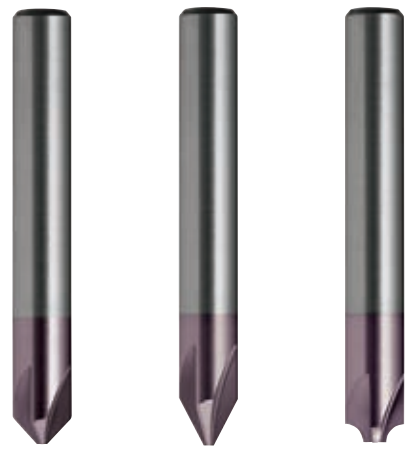
	E603	E605	E604*	E607*					
Catalogue Code	B0212	B0212	B0212	B0212					
Discount Group									
Material	VHM 硬质合金	VHM 硬质合金	VHM 硬质合金	VHM 硬质合金					
Surface Finish	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛	TiAlN 氮化铝钛					
Application	Up to 1600N/mm ²	Up to 1600N/mm ²	Up to 1600N/mm ²	Up to 1600N/mm ²					
Geometry	R30	R30	R30	R30					
Shank Form	HA	HA	HA	HA					
Shank Tolerance	h6	h6	h6	h6					
Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item # (货号)	Item # (货号)	Item # (货号)	Item # (货号)
0100	1.0	38	4	3	2	E603 0100	E605 0100	E604 0100	E607 0100
0150	1.5	38	4.5	3	2	E603 0150	E605 0150	E604 0150	E607 0150
0200	2.0	38	6	3	2	E603 0200	E605 0200	E604 0200	E607 0200
0250	2.5	38	9.5	3	2	E603 0250	E605 0250	E604 0250	E607 0250
0300	3.0	38	12	3	2	E603 0300	E605 0300	E604 0300	E607 0300
0350	3.5	50	12	4	2	E603 0350		E604 0350	E607 0350
0400	4.0	50	14	4	2	E603 0400	E605 0400	E604 0400	E607 0400
0450	4.5	50	16	6	2	E603 0450		E604 0450	E607 0450
0500	5.0	50	16	6	2	E603 0500	E605 0500	E604 0500	E607 0500
0600	6.0	50	19	6	2	E603 0600	E605 0600	E604 0600	E607 0600
0700	7.0	63	19	8	2	E603 0700		E604 0700	E607 0700
0800	8.0	63	20	8	2	E603 0800	E605 0800	E604 0800	E607 0800
0900	9.0	75	22	10	2	E603 0900		E604 0900	E607 0900
1000	10.0	75	22	10	2	E603 1000		E604 1000	E607 1000
1100	11.0	75	25	12	2	E603 1100		E604 1100	E607 1100
1200	12.0	75	25	12	2	E603 1200		E604 1200	E607 1200
1400	14.0	89	32	14	2	E603 1400		E604 1400	E607 1400
1600	16.0	89	32	16	2	E603 1600		E604 1600	E607 1600
1800	18.0	100	38	18	2	E603 1800		E604 1800	E607 1800
2000	20.0	100	38	20	2	E603 2000		E604 2000	E607 2000
2500	25.0	100	38	25	2	E603 2500		E604 2500	E607 2500

Endmills Carbide, Chamfer

suttontools

- For chamfering & deburring component edges
- Straight flute for smooth cutting
- TiAIN for longer tool life
- E456 - 90° form
- E457 - 60° form
- E458 - Radius for corner rounding

- 适合倒角及去毛边
- 更顺畅的直刃设计
- 氮化钛涂层大幅度层延长刀具寿命
- E456 - 90° 倒角
- E457 - 60° 倒角
- E458 - 内圆弧倒角



尺寸参考

Size Ref.	d ₁	l ₁	d ₂	z	l ₂	rad	Item # (货号)	Item # (货号)	Item # (货号)
SUTTON STD							E456	E457	E458
0600	1.2	57	6	4	2.4		E456 0600		
0800	1.6	63	8	4	3.2		E456 0800		
1000	2.0	72	10	4	4.0		E456 1000		
1200	2.4	83	12	4	4.8		E456 1200		
0600	1.2	57	6	4	3.8			E457 0600	
0800	1.6	63	8	4	5.5			E457 0800	
1000	2.0	72	10	4	6.9			E457 1000	
1200	2.4	83	12	4	8.3			E457 1200	
0605	5.0	57	6	4	0.5				E458 0605
0610	4.0	57	6	4	1				E458 0610
0815	5.0	63	8	4	1.5				E458 0815
0820	4.0	63	8	4	2				E458 0820
1025	5.0	72	10	4	2.5				E458 1025
1030	4.0	72	10	4	3				E458 1030
1235	5.0	83	12	4	3.5				E458 1235
1240	4.0	83	12	4	4				E458 1240

Type 型	90°	60°	Corner Radius / 内圆弧倒角
Discount Group 折扣组	B0210	B0210	B0210
Material 材料	VHM 硬质合金	VHM 硬质合金	VHM 硬质合金
Surface Finish 表面处理	TIAIN 氮化铝钛	TIAIN 氮化铝钛	TIAIN 氮化铝钛
Application 应用代号	N	N	N
Geometry 倒角别	90°	60°	Rad
Shank Form (DIN 6535) 柄径形 (DIN 6535)	HA	HA	HA
Shank Tolerance 柄径容许公差	h6	h6	h6

Application Guide Colour Band Selection



Sutton Tools have made the tool selection for cutting different materials easy by applying colour coded bands to the shanks of the tools which relates to the material it is best suited to.

Sutton Tools — 神盾工具通过在刀具柄径上标识的色环来显示其最适宜切割的材料。由此可轻松选择用于切削不同材料的刀具。

Why Colour Band? 为何要使用色环?

- Each colour gives clear assignment of materials, different choice of tools and applications
每种色彩清楚地表明刀具的材料、刀具及其应用的不同选择。
- Internationally recognised
国际公认
- All suitable standard tools are identified at a glance
可一目了然地识别所有合适的标准刀具
- A simplified tool selection lends itself to rationalisation
轻松地选择刀具有利于其合理使用
- Rejects are reduced due to correct tool choice.
选择正确的刀具可减少不良品。

Selection Made Easy! 选择使一切变得轻松!

ISO	VDI	Material Group 工件材料类别	Sutton 应用材料代号
P	A	Steel 钢件	N
M	R	Stainless Steel 不锈钢	VA
K	F	Cast Iron 铸铁	GG
N	N	Non-Ferrous Metals, Aluminiums & Coppers 有色金属	AI W
S	S	Titaniums & Super Alloys 钛合金及超级合金	Ti Ni
H	H	Hard Materials (> 45 HRC) 淬火钢 (> 45 HRC)	H

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide of our main catalogue.
^ VDI 3323 工件材料类别明细可查阅产品目录技术篇的工件材料分类表。

ISO及VDI应用材料代号

for general purpose 般用	for universal materials 高效通用	for aluminiums 铝用	for soft materials 软质材料用	for copper materials 红铜用	for tough materials 不锈钢用	for cast iron materials 铸铁用	for hard materials 硬质材料用	for extra hard materials 高硬材料用	for very hard materials 较高硬材料用	for titaniums 钛合金用	for nickels 镍合金用
N	UNI	AI	W	Cu	VA	GG	H	XH	VH	Ti	Ni

ISO	VDI 3323	Material 工件材料	Condition 材料状态	HB 硬度	N/mm ²	N	UNI	AI	W	Cu	VA	GG	H	XH	VH	Ti	Ni		
P	1	Steel - Non-alloy, cast & free cutting 钢件-非合金及易切削	~ 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 钢件-低合金钢	A	180	610	●	●	●	●	●	●	●	●	●	●	●	●	●	
	7		QT	275	930	○	●	○	○	○	○	○	○	○	○	○	○	○	
	8		QT	300	1010		●							●	○				
	9		QT	350	1180		○							●	●	○			
	10	Steel - High alloy, cast & tool 高合金钢及工具钢	A	200	680	○	●					○		○					
	11		HT	325	1100		○							●	●	○			
12	Steel - Corrosion resistant & cast 钢件-耐酸钢	Ferritic / Martensitic	A	200	680		●				●		○						
13		Martensitic	QT	240	810		○				●		○	●	○				
M	14.1	Stainless Steel 不锈钢	Austenitic	A	180	610		○			●								
	14.2		Duplex		250	840		○			●					○			
	14.3		Precipitation Hardening	PH	250	840		●			●			○			○		
K	15	Cast Iron - Grey (GG) 灰铸铁	Ferritic / Pearlitic		180	610	○	●				●	○						
	16		Pearlitic		260	880		●				●	●	●					
	17	Cast Iron - Nodular (GGG) 球墨铸铁	Ferritic		160	570	○	●				●	○						
	18		Pearlitic		250	840		●				●	●	●					
	19	Cast Iron - Malleable 可锻铸铁	Ferritic		130	460	○	●				○	○						
20	Pearlitic			230	780	○	●				○	●							
N	21	Aluminum & Magnesium - wrought alloy 锻造铝合金	Non Heat Treatable		60	210	●	○	●	●	●	○							
	22		Heat Treatable	AH	100	360	●	○	●	●	●	○							
	23	Aluminum & Magnesium - cast alloy ≤12% Si 压铸铝 ≤12% Si	Non Heat Treatable		75	270	○	○	●	○	○	○							
	24		Heat Treatable	AH	90	320	○	○	●	○	○	○							
	25	Al & Mg-cast alloy 压铸铝 >12% Si	Non Heat Treatable		130	460		○	○	○	○	○	●	○					
	26	Copper & Cu alloys (Brass/Bronze) 铜及铜合金	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 耐热合金	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 钛合金	CP Titanium		400 MPa												●		
	37.1				860 MPa												●		
37.2	Alpha / Beta alloys		A	960 MPa			○									●			
37.3			AH	1170 MPa												●			
37.4			A	830 MPa												●			
37.5	AH	1400 MPa													●				
H	38.1	Hardened steel 淬火钢	HT	45 HRC			○						○	●	●				
	38.2			55 HRC											●	●			
	39.1			58 HRC												●	●		
	39.2			62 HRC												●	●		
	40	Cast Iron 硬铸铁	Chilled	C	400	1350		●				●	●	●	○				
41	HT			55 HRC											●				

Condition: A (Annealed) (正火), AH (Age Hardened) (时效硬化), C (Cast) (铸件), HT (Hardened & Tempered) (淬火及回火), QT (Quenched & Tempered) (调质及回火)

● Optimal 非常适合 | ○ Effective 适合



VHM-ULTRA				VHM-ULTRA																						
CrN				HELICA																						
Al				VA																						
1.0	1.5	1.5	0.1	0.1	0.25	2.3	2.3	1.0	1.0	1.0	1.0	1.0	1.75	1.75	0.5	0.5	0.5	1.0	1.75	1.75						
1.0	0.25	0.5	0.1	0.05	1.0	0.2	0.4	1.0	0.3	1.0	0.3	1.0	0.2	0.4	1.0	0.2	0.4	1.0	0.4	0.6						

Vc	Feed #			Vc	Feed #			Vc	Feed #			Vc	Feed #			Vc	Feed #			Vc	Feed #			VDI* 3323	ISO	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1	P	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	3		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	4		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	5		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	6		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	7		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	8		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	9		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	10		
-	-	-	-	-	120	11	16	18	120	9	12	120	9	12	120	7	6	11	120	7	6	11	120	8		5
-	-	-	-	-	100	11	16	18	100	9	12	100	9	12	100	7	6	11	100	7	6	11	100	8	5	12
-	-	-	-	-	120	11	16	18	120	9	12	120	9	12	120	7	6	11	120	7	6	11	120	8	5	12
-	-	-	-	-	100	11	16	18	100	9	12	100	9	12	100	7	6	11	100	7	6	11	100	8	5	12
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	15	
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-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	19	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	20	
200	9	11	18	200	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	21	
200	9	11	18	200	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	22	
200	9	11	18	200	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	23	
200	9	11	18	200	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	24	
200	9	11	18	200	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	25	
500	9	11	18	500	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	26	
500	9	11	18	500	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	27	
500	9	11	18	500	18	15	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	28	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	29	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	30	
-	-	-	-	-	70	10	14	18	70	8	11	70	8	11	70	7	6	11	70	7	6	11	70	8	5	12
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-	-	-	-	-	90	10	14	18	90	8	11	90	8	11	90	7	6	11	90	7	6	11	90	8	5	12
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-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	38.1	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	38.2	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	39.1	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	39.2	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	40	
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	41	

IMPERIAL ENDMILLS (inch size)

Ø = nominal tool diameter (inch)
n = Spindel speed (RPM) $n = \frac{v_c \times 12}{\phi \times \pi} \approx \frac{v_c}{\phi} \times 3.82$
v_c = Cutting speed (SFM)
f_z = Feed rate per tooth (inch/tooth) $v_c = \frac{n \times \phi \times \pi}{12} \approx \frac{n \times \phi}{3.82}$
v_f = Feed rate (inch/min)
z = No. cutting edges $f_z = \frac{v_f}{z \times n}$ $v_f = f_z \times z \times n$
Q = Metal removal rate (in³/min)
a_p = Cutting depth (inch)
a_e = Cutting width (inch)
 $Q = \frac{a_p \times a_e \times v_f}{1000}$

METRIC ENDMILLS (mm size)

Ø = nominal tool diameter (mm)
n = Spindel speed (RPM) $n = \frac{v_c \times 1000}{\phi \times \pi} \approx \frac{v_c}{\phi} \times 318$
v_c = Cutting speed (m/min)
f_z = Feed rate per tooth (mm/tooth) $v_c = \frac{n \times \phi \times \pi}{1000} \approx \frac{n \times \phi}{318}$
v_f = Feed rate (mm/min)
z = No. cutting edges $f_z = \frac{v_f}{z \times n}$ $v_f = f_z \times z \times n$
Q = Metal removal rate (cm³/min)
a_p = Cutting depth (mm)
a_e = Cutting width (mm)
 $Q = \frac{a_p \times a_e \times v_f}{1000}$

Application Guide Speeds & Feeds - Taps



ISO VDI Material Group 工件材料类别 Sutton 应用材料代号

P	A	Steel 钢件	N	UNI
M	R	Stainless Steel 不锈钢	VA	
K	F	Cast Iron 铸铁	GG	
N	N	Non-Ferrous Metals, Aluminiums & Coppers 有色金属	Al W	
S	S	Titaniums & Super Alloys 钛合金及超级合金	Ti Ni	
H	H	Hard Materials (> 45 HRC) 淬火钢(> 45 HRC)	H	

ISO及VDI应用材料代号

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

^ VDI 3323 工件材料类别明细可查阅产品目录技术篇的工件材料分类表。

Catalogue Code / 目录代码 M

MF

UNC

UNF

G (BSPF)

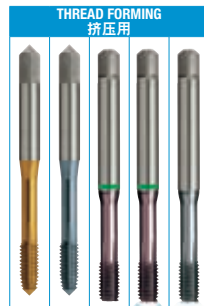
Material / 材料

Surface Finish / 表面处理

Sutton Designation / 应用材料代号

Geometry / 螺旋角别

Thread Depth / 有效攻牙深度



THREAD FORMING 挤压用

T514	T629	T325	T327	T682
T526				
T538				

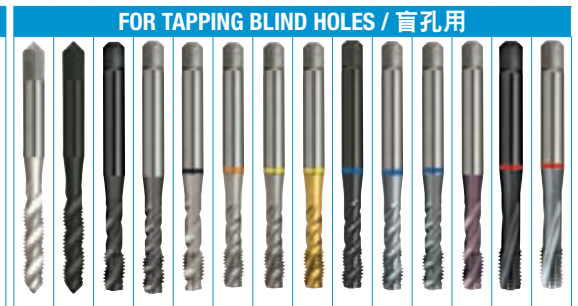
HSS Co.8 PMSSE V3 SPM VHM

TIN TICN TIAN

N NH UNI N

Single-Coolant Groove Multi-Coolant Groove IK Multi-Coolant Groove

≤3x0



FOR TAPPING BLIND HOLES / 盲孔用

T503	T504	T189	T684	T231	T239	T235	T241	T197	T201	T205	T227	T209	T211
		T247	T686					T249	T251	T252	T254		T707
T618	T619	T260	T691					T261	T262	T695	T267	T265	T667
T625	T626	T701	T692					T276	T277	T696			
		T282	T699					T284	T285	T352			

HSSE V3 PMSSE V3 Hand-Tube HSSE V3 PM-HSSE V3 PM-HSS Co

BrT Blu CrN Ni TIN Blu TICN TIAN Blu TICN

N UNI A Cu W VADH VA PM NH H

R40 R50 R40 R50 R45 2F R45 R50 R40 R15

≤2.5x0 ≤3x0 ≤2.5x0 ≤1.5x0

ISO	VDI 3323	Material 工件材料	Condition 材料状态	HB 硬度	N/mm²	Vc (m/min)											
P	1	Steel - Non-alloy, cast & free cutting 钢件-非合金及易切削	A	125	440	18	18	23	28	36							
	2			190	640	18	18	23	28	36							
	3			250	840	15	15	20	23	30							
	4	~ 0.75 %C	A	270	910	17	17	21	26	33							
			QT	300	1010	-	-	-	-	27							
	5	Steel - Low alloy & cast < 5% of alloying elements 钢件-低合金钢	A	180	610	18	18	23	28	36							
	6		QT	275	930	-	-	16	19	24							
	7		QT	300	1010	-	-	-	-	18							
	8		QT	350	1180	-	-	-	-	-							
	9		A	200	680	-	-	16	19	24							
10	Steel - High alloy, cast & tool 高合金钢及工具钢	HT	325	1100	-	-	-	-	-								
11		HT	325	1100	-	-	-	-	-								
12		HT	325	1100	-	-	-	-	-								
M	14.1	Stainless Steel 不锈钢	A	180	610	9	9	12	14	18							
	14.2			250	840	6	6	8	9	12							
	14.3			250	840	-	-	-	-	-							
K	15	Cast Iron - Grey (GG) 灰铸铁	A	180	610	-	-	-	-	-	10	11	11	17	-	-	-
	16			260	880	-	-	-	-	-	-	-	-	-	14	11	14
	17	Cast Iron - Nodular (GGG) 球墨铸铁	A	160	570	-	-	-	-	-	10	11	11	17	-	-	-
	18			250	840	-	-	-	-	-	-	-	-	-	14	11	14
	19	Cast Iron - Malleable 可锻铸铁	A	130	460	-	-	-	-	-	12	13	13	22	-	-	-
	20			230	780	-	-	-	-	-	-	10	11	11	17	-	-
N	21	Aluminum & Magnesium - wrought alloy 锻造铝合金	AH	60	210	18	18	23	28	36	10	-	-	17	10	14	14
	22			100	360	23	23	29	35	45	12	-	-	22	12	18	18
	23	Aluminum & Magnesium - cast alloy ≤12% Si 压铸铝 ≤12% Si	AH	75	270	23	23	29	35	45	12	-	-	22	12	-	-
	24			90	320	23	23	29	35	45	12	-	-	22	12	-	-
	25	Al & Mg-cast alloy 压铸铝 >12% Si	A	130	460	-	-	-	-	-	-	-	-	14	-	-	-
	26			110	390	12	12	16	19	-	6	-	-	12	6	10	10
	27	Copper & Cu alloys (Brass/Bronze) 铜及铜合金	A	90	320	-	-	-	-	-	14	-	-	26	-	-	-
	28			100	360	21	21	27	33	42	-	-	-	11	17	17	17
	29	Non-metallic - Thermosetting & fiber-reinforced plastics															
	30	Non-metallic - Hard rubber, wood etc.															
S	31	High temp. alloys 耐热合金	A	200	680	-	-	-	-	-	-	-	-	-	-	4	4
	32			280	950	-	-	-	-	-	-	-	-	-	-	-	-
	33			250	840	-	-	-	-	-	-	-	-	-	-	3	4
	34			350	1180	-	-	-	-	-	-	-	-	-	-	-	-
	35			320	1080	-	-	-	-	-	-	-	-	-	-	-	-
	36	Titanium & Ti alloys 钛合金	A	400 MPa		-	-	-	-	-	-	-	-	-	-	-	8
37.1	860 MPa				-	-	-	-	-	-	-	-	-	-	-	5	7
37.2	960 MPa				-	-	-	-	-	-	-	-	-	-	-	5	7
37.3	1170 MPa				-	-	-	-	-	-	-	-	-	-	-	5	7
37.4	830 MPa				-	-	-	-	-	-	-	-	-	-	-	3	4
37.5	1400 MPa		-	-	-	-	-	-	-	-	-	-	-	2	3		
H	38.1	Hardened steel 淬火钢	HT	45 HRC		-	-	-	-	-	-	-	-	-	-	-	-
	38.2			55 HRC		-	-	-	-	-	-	-	-	-	-	-	-
	39.1			58 HRC		-	-	-	-	-	-	-	-	-	-	-	-
	39.2			62 HRC		-	-	-	-	-	-	-	-	-	-	-	-
	40	Cast Iron 硬铸铁	C	400	1350	-	-	-	-	-	-	-	-	-	-	12	8
41	55 HRC				-	-	-	-	-	-	-	-	-	-	-	12	

Condition: A (Annealed) (正火), AH (Age Hardened) (时效硬化), C (Cast) (铸件), HT (Hardened & Tempered) (淬火及回火), QT (Quenched & Tempered) (调质及回火)

Bold = Optimal | Regular = Effective 粗体 = 非常适合 | 细体 = 适合

Notes on Tapping

- The speeds listed above are a recommendation only, and are based on depth of thread listed, speeds can be adjusted on application. As a general rule;
 - If hole depth required is less than above mentioned = increase speed
 - If hole depth required is more than above mentioned = reduce speed
- Taps must be driven by the square to eliminate slippage, eg, ER-GB collets (square drive).
- When using spiral flute taps with length compensation tapping attachment, it is recommended to short pitch the feed 95%, to eliminate tap cutting oversize, eg. M6x1 @ 1000RPM, Feedrate= 950mm/min.
- Forming taps are suitable for materials with >10% elongation



Trade Name	Coating	Coating Structure	Micro-hardness	Coeff. of Friction vs Steel	Thermal Stability	Colour	Application & Benefits
Br 光亮,无表面处理	-	-	-	0.8 - 1.0	-	-	<ul style="list-style-type: none"> For general purpose applications
Blu 表面氧化处理(黑色)	Steam Oxide	-	-	0.8 - 1.0	-	Blue - Black 蓝黑	<ul style="list-style-type: none"> For ferrous metals Prevents chip build-up on the cutting edges, especially in low carbon steels Oxide layer protects surface Good carrier of lubricants
Ni 表面氮化处理	Plasma Nitride	-	-	0.8 - 1.0	-	-	<ul style="list-style-type: none"> Increases surface hardness Better lubricant carrying properties Abrasive materials - cast iron and Aluminium alloys
Futura Nano (TiAlN) 高铝钛涂层	Titanium Aluminium Nitride	Nano Layer	3300 HV	0.3 - 0.35	up to 900°C	Violet - Grey 灰紫	<ul style="list-style-type: none"> Abrasive materials - cast iron and heat treated steel Difficult to machine materials, such as stainless steel Higher speeds and feeds Reduces or eliminates use of coolants
Hardlube HL 涂层	TiAlN + WC/C	Nano Layer	3000 HV	0.15 - 0.20	up to 800°C	Dark Grey 灰黑	<ul style="list-style-type: none"> Excellent friction and lubricating properties of the coating provide optimal chip flow Tapping and drilling of hard to machine materials Suitable for minimum quantity lubrication (MQL) and dry machining
Alcrona 氮化铝铬涂层	Aluminium Chromium Nitride	Mono Layer	3200 HV	0.35	up to 1100°C	Blue - Grey 灰蓝	<ul style="list-style-type: none"> Low alloy steels and high tensile steels Hardened steels up to 54 HRC Ideal for carbide tools
Helica Helica涂层	Alcrona based	Multi Layer	3000 HV	0.25	up to 1100°C	Copper 紫铜	<ul style="list-style-type: none"> Longer tool life Higher cutting speeds and feeds Superb chip evacuation Greater number of regrinds Improved drill hole quality Excellent performance in abrasive material
TiCN 碳氮化钛涂层	Titanium Carbonitride	Gradient Coating	3000 HV	0.4	up to 400°C	Blue - Grey 灰蓝	<ul style="list-style-type: none"> High performance applications Difficult to machine materials Abrasive materials - cast iron and Aluminium alloys Adhesive materials - copper and copper based alloys
TiN 氮化钛涂层	Titanium Nitride	Mono Layer	2300 HV	0.4	up to 600°C	Gold - Yellow 金黄	<ul style="list-style-type: none"> General purpose use Wide range of materials 3 to 8 times longer tool life than uncoated tools Higher tool speeds and feeds than uncoated tools
CrN 氮化铬涂层	Chromium Nitride	Gradient Coating	1750 HV	0.5	up to 700°C	Silver - Grey 银灰	<ul style="list-style-type: none"> Cutting and forming of copper, nickel, & monel metal Enhanced thermal stability and oxidation resistance Excellent corrosion resistance Low internal stress of coating results in excellent adhesion under high loads

Abbreviations	Type	Application	Description
HSS 高速钢	Conventional high speed steel	Standard tool material for most common applications	Used for the manufacturing of cutting tools such as twist drills, end mills and taps.
HSS Co 含钴高速钢	5% cobalt grade of high speed steel	High-heat resistance, especially suited for roughing or when coolant insufficient	Cobalt alloyed, tungsten-molybdenum high speed steel possessing high hardness, excellent cutting properties, high-red hardness and good toughness.
HSSE Co8% 含8%钴高速钢	8% cobalt grade of high speed steel	Increased heat resistance & hardness, suitable for difficult-to-machine materials	Available for applications that require a strong resistance to softening at elevated cutting temperatures. The ability of the steel to maintain its "red-hot hardness" is provided by the addition of cobalt. The high hot hardness is required for machining difficult materials such as nickel-base, titanium and highly alloyed steel.
HSSE V3 钒钨高速钢	Premium grade of high speed steel	Wide range of machine taps.	Vanadium grade gives high wear resistance and toughness for most tapping applications.
PM-HSSE V3 粉末冶金高速钢	Powdered metallurgy - vanadium grade of high speed steel	Materials with hardness up to 40HRC Difficult to machine materials eg. stainless steels.	PM-HSS V3 for higher performance tools, incorporates very fine and uniform grain structure allowing a high hardness to be achieved, whilst maintaining good toughness.
PM-HSS Co 粉末冶金含钴高速钢	Powdered metallurgy - 8% Cobalt grade of high speed steel	Materials with hardness up to 45HRC	The addition of cobalt provides this material with the ability to maintain its strength and hardness level when exposed to extremely high cutting temperatures. This makes PM-HSS Co suitable for heavy duty tapping, in materials such as high alloyed steels to non-ferrous metals like Ni-base alloys & Ti-alloys.
SPM 粉末冶金含11%钴高速钢	Powdered metallurgy - 11% Cobalt grade of high speed steel	Special applications, requiring very high edge hardness. Cutting tools with the appropriate geometry can be applied to workpiece materials with hardness up to 55HRC	An excellent bridge material between high speed steel and carbide. SPM offers very high red hardness, wear resistance and the highest compressive strength of any high speed steel.
VHM 硬质合金 (0.8 μm)	Sub-micron grade of solid Carbide (ISO K15-K30)	Tapping hardened steel	Ultra fine grain type (0.8μm) with maximum toughness & high hardness, therefore especially recommended for rotating tools to machine hardened parts.
VHM 硬质合金 (0.6 μm)	Sub-micron grade of solid Carbide (ISO K40)	Sutton standard grade for endmills & drills	Ultra fine grain type (0.6μm) offers the ideal combination of hardness & toughness for high performance drilling & general milling applications
VHM-ULTRA 硬质合金 (0.5 μm)	Sub-micron grade of solid Carbide (ISO K40-K50)	High performance grade for endmills	Ultra fine grain type (0.5μm) offers the best wear resistance for high performance milling applications.