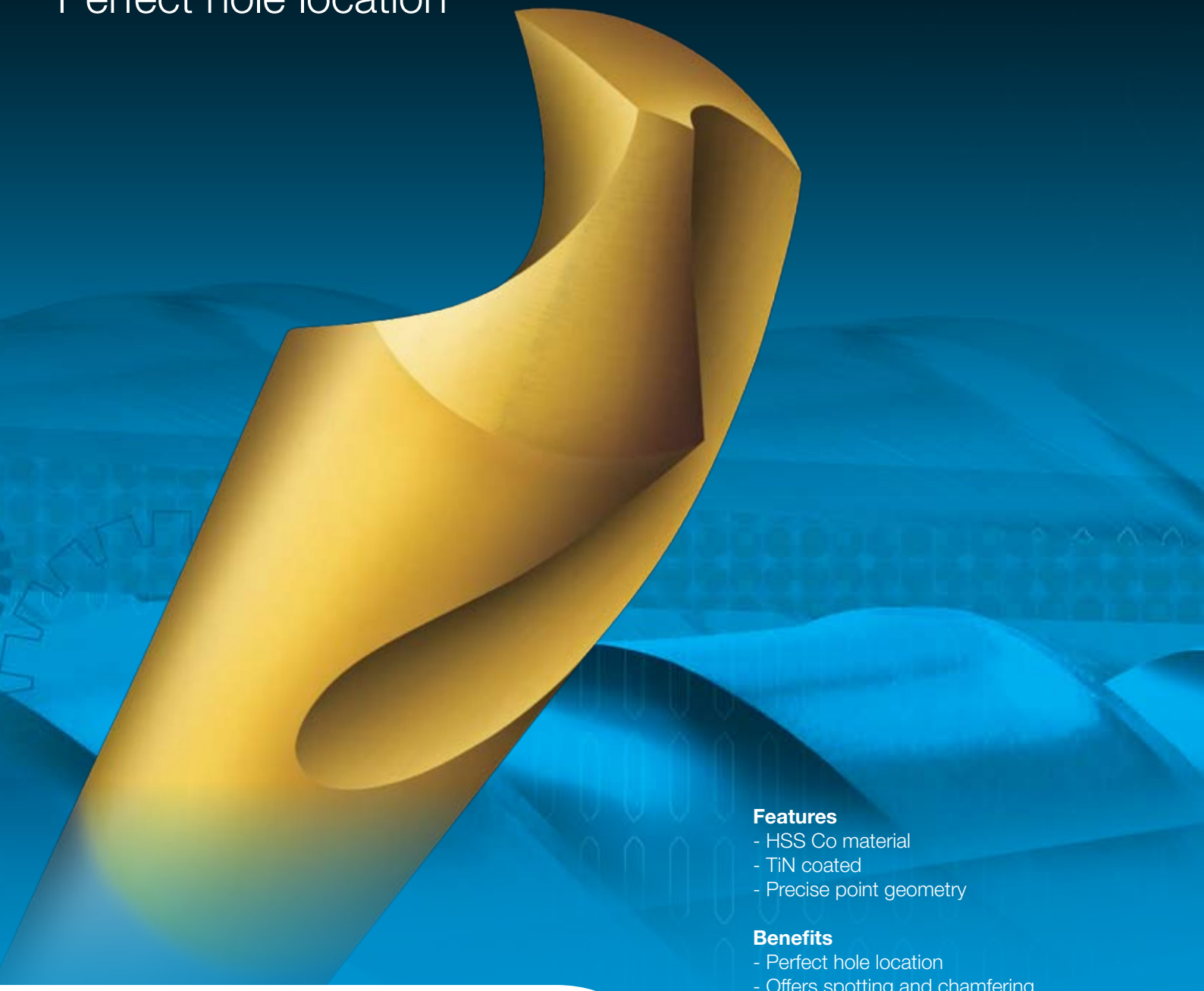
Accurate Positioning...

Perfect hole location



Features
- HSS Co material
- TiN coated
- Precise point geometry

Benefits
- Perfect hole location
- Offers spotting and chamfering with one tool

SPOTTING DRILL

for an on-site demonstration contact Sutton Tools on 1800 335 350

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Sutton Tools

Drills Spotting

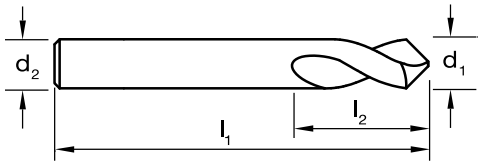
Sutton Tools

- Rigid twist drill
- For use to the depth of the point only
- Provides an accurate location "seat" for position accuracy

90º Point angle - offers hole chamfering & spotting with the one tool

120º Point angle - specifically for spotting, closely matches a typical drill point

- cutting edges of the following drill engage easily, for perfect hole location



DIN 1897

Catalogue Code	D175	D176
Discount Group	A1124	A1124
Material	HSS Co	HSS Co
Surface Finish	TiN	TiN
Colour Ring & Application	N	N
Geometry	-	-
Point Type	90º	120º
Shank Tolerance	h9	h9

d_1	l_1	l_2	Price	Item #	Price	Item #
DIN 1897						
3.0	46	16		378794		423616
4.0	55	22		378800		423623
5.0	62	26		378817		423630
6.0	63	25		081748		423647
8.0	80	29		081755		423654
10.0	90	32		081762		423661
12.0	100	32		081779		423678
16.0	114	35		081786		423685
20.0	130	37		081793		423692
25.0	130	37		095066		423708

Materials	Material examples	Vc (m/min)	feed no.	Vc (m/min)	feed no.
Free-cutting steel		35	4	35	4
Structural steels		25	4	25	4
Carbon steels	1020, 1024, 1045, 1060	20	4	20	4
Alloy steels < 850-1200 N/mm²	4140, O1, A2, D3, M42, P20	15	3	15	3
Alloy steels hard./temp. > 1200-1400 N/mm²	EN26, O1, L6, M42, D3, 4140	10	3	10	3
Free machining stainless steel	416, 430F	10	3	10	3
Austenitic stainless steels	303, 304, 316, 317, 321	15	2	15	2
Ferritic + martensitic < 1000 N/mm²	409, 430, 436, Duplex Alloys	10	2	10	2
Cast iron ≤ 240 HB	GG10, GG20	30	5	30	5
Cast iron < 240 HB	GG25, GG40	20	4	20	4
Spheroidal graphite + Malleable cast iron	GGG50, GGG70	20	4	20	4
Copper unalloyed		50	4	50	4
Short chip brass + phosphor bronze + gun metal		30	4	30	4
Long chip brass		40	4	40	4
Al / Mg unalloyed		50	5	50	5
Al alloyed Si < 5%		50	4	50	4
Al alloyed Si > 1.5% < 10%		35	4	35	4

Feed No.	Feed Table (f) (mm/rev) Ø								
	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
1	0.030	0.040	0.045	0.050	0.060	0.080	0.080	0.100	0.150
2	0.040	0.050	0.055	0.060	0.080	0.100	0.100	0.120	0.200
3	0.050	0.060	0.065	0.080	0.100	0.120	0.120	0.150	0.250
4	0.060	0.080	0.085	0.100	0.120	0.150	0.150	0.200	0.300
5	0.080	0.100	0.110	0.120	0.150	0.200	0.200	0.250	0.400

Notes: For calculating revolutions per minute, apply hole diameter
For calculating feed, apply large end diameter

LEGEND

n = rev. per minute
v_c = cutting speed (m/min)
f = feed (mm/rev)
v_f = feed rate (mm/min)
z = no. cutting edges

FORMULAS

$n = (v_c \times 1000) / (Ø \times \pi)$
$v_c = (Ø \times \pi \times n) / 1000$
$v_f = f \times n$