



## D102-Sets -Jobber Drill Sets - Blue Bullet -Sutton Tools -Blue Bullet

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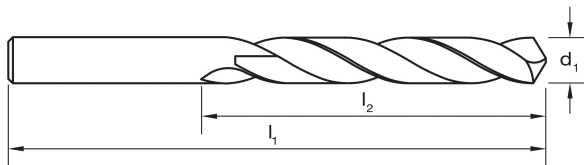
Sutton Tools Blue Bullet jobber drills are a general purpose drill bit designed for machine and hand held drilling ferrous metals. The blue finish reduces chip build up on the cutting edge and is a better choice when drilling ferrous materials.

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### Features:

- 118° web thinned point reduces the amount of thrust required
- Precision engineered parallel shank for accurate hole size
- Made from M2 High Speed Steel (HSS) offering the best combination of strength, heat & wear resistance
- Blue surface finish for ferrous applications. The steam oxide finish prevents chip build-up on the cutting edges and reduces cutting friction, especially in low carbon steels

Range:



| Item #    | Description | Pieces | Range  | Case      |
|-----------|-------------|--------|--|-----------|
| D102S8    | S8          | 29     | Suits S7 Stand: 1/16 – 1/2 x 1/64 rises  | Quad Pack |
| D102SM8   | SM8         | 29     | Suits SM7 Stand: 1.0 – 3.0mm x 0.25, 3.5 – 13.0mm x 0.5                          | Quad Pack |
| D102SM30  | SM30        | 50     | 1.0 – 5.9mm x 0.1mm rises  | Metal     |
| D102SM41  | SM41        | 41     | 6.0 – 10.0mm x 0.1 rises   | Metal     |
| D102S2    | S2          | 21     | 1/16 – 3/8 x 1/64 rises  | ABS       |
| D102S3    | S3          | 29     | 1/16 – 1/2 x 1/64 rises  | ABS       |
| D102SM1   | SM1         | 13     | 1.5 – 6.5mm x 0.5mm rises + 3.2, 4.8mm   | Plastic   |
| D102SM2   | SM2         | 19     | 1.0 – 10.0mm x 0.5mm rises   | ABS       |
| D102SM3   | SM3         | 25     | 1.0 – 13.0mm x 0.5mm rises   | ABS       |
| D102SM101 | SM101       | 101    | 1.0 – 10.0mm x 0.5 (Plus Bonus 25g Venom Cutting Paste)                          | Plastic   |
| D102SM99  | SM99        | 100    | 1.0 – 10.0mm x 0.1 (Plus 10.5, 10.9, 11.0, 11.5, 11.9, 12.0, 12.5, 12.9, 13.0mm) | Plastic   |

### Applications:

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

#### KEY

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

### Applications:

| ISO | VDI  | Description         | Condition           | Hardness | Strength | Optimal |
|-----|------|---------------------|---------------------|----------|----------|---------|
| H   | 39.1 | Hardened steel      | Hardened & Tempered | 58HRC    |          |         |
| H   | 39.2 | Hardened steel      | Hardened & Tempered | 62HRC    |          |         |
| H   | 40   | Cast Iron - Chilled | Cast                | 400MPa   | 1350MPa  | o       |
| H   | 41   | Cast Iron           | Hardened & Tempered | 55HRC    |          |         |

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### Trade/DIY Applications:

| Wood                  |   | Metal           |   | Specialty                           |   | Masonry                 |  |
|-----------------------|---|-----------------|---|-------------------------------------|---|-------------------------|--|
| Soft Wood             | o | Steel           | • | PVC Plastic                         | o | Masonry                 |  |
| Hard Wood             | o | Hard Steel      |   | Acrylic                             |   | Plasterboard            |  |
| Wood & Nails          | o | Stainless Steel |   | mineral rock wool foams (EPS, PUR), |   | Compressed Fibre Cement |  |
| Chipboard             | o | Aluminium       | o | Polystyrene                         |   | Cement Sheet            |  |
| Plywood               | o | Copper / Brass  | o | Leather                             |   | Ceramic Tile            |  |
| MDF                   | o | Cast Iron       | o | Rubber                              |   | Hebel                   |  |
| Green Wood            |   | Sheet Metal     | o | Fibreglass                          |   | Brick                   |  |
| Sandwich Construction | o | Precious Metals |   | Carbon Fibre                        |   | Concrete                |  |
| Pallet                | o | Metal Pipe      | o | Glass                               |   | Reinforced Concrete     |  |
| Window Frame          | o |                 |   | Laminate                            |   | Stone                   |  |
|                       |   |                 |   |                                     |   | Granite                 |  |
|                       |   |                 |   |                                     |   | Marble                  |  |

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