

## Drill *Reduced Shank*

### Large scale drilling

Designed to increase the drilling capacity of drill chucks and for slow speed (350rpm or less), large scale boring.

- 6" (152mm) overall length with a 3-3/8" (86mm) flute length
- Size range: 13.5 to 30mm, 33/64 to 1-1/4"

#### 118° Standard Point

Common point for general purpose applications

#### Precision Ground Flute

Bright cutting edge with blue flute making it a better choice when drilling ferrous materials

#### Reduced Shank

12.5mm (Metric)  
1/2" (Imperial)

## Drill *Morse Taper Shank*

### For machine drilling

Sutton Tools recognise the demand in the market for higher quality large diameter drills. We have purpose built CNC flute grinding machines that are capable of grinding the flutes from a solid round High-Speed-Steel blank up to 50mm in diameter, providing higher quality and larger product offering.

- Fully ground from solid flute profile up to 50mm
- Blue finish general purpose for materials up to 900N/mm<sup>2</sup>
- Also available in TiAlN coated, Cobalt HSS, and long series
- Size range: 1/8–3" (3.18–76.20mm)

#### 118° Standard Point

Common point for general purpose applications

#### Fully Ground Finish

Higher precision cuts from fully ground finish cutting edges and flutes

#### Morse Taper Shank

Fits in morse taper sleeve in machine drilling applications

## Performance Summary

		Viper Bit	Cobalt Drill	Long Series Drill	Panel & Rivet Drill	Reduced Shank Drill	Morse Taper Shank Drill
Metal	Low Carbon Steel	5	4	5	5	5	5
	High Carbon Steel	4	5	4	4	4	4
	Stainless steel	3	5	3	3	3	3
	Non ferrous metal	4	5	3	4	3	3
	Aluminium	5	3	4	5	4	4
Timber	Softwood	4	3	3	4	3	3
	Hardwood	4	3	3	4	3	3
	Plywood	4	3	3	4	3	3
	Wood & nails	4	3	3	4	3	3
	Chipboard	4	3	3	4	3	3
Misc.	Glass	X	X	X	X	X	X
	Plastics	3	4	X	3	X	X
	Plasterboard	2	3	X	2	X	X
	Cement Sheet	X	2	X	X	X	X

#### PERFORMANCE INDICATOR

1		Adequate to perform task
2		Suitable to perform task
3		More suitable to perform task
4		Most suitable to perform task
5		Best solution to perform task
X		Not recommended

# METAL

## Drill Range

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world class cutting tools

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## Drill Viper

Drills bits with bite



Sutton Tools presents a breakthrough in twist drill technology - the revolutionary Viper Bit. The Viper Bit has been developed specifically for the semi-industrial trades person and the home handy person.

The Viper Bit point design is 118° Split Point is self-centring. It minimises wandering when starting and requires less power when drilling. A reduced shank on larger sizes suits 3/8" and 10mm power drill chucks.

Size range: 1-13mm, 1/16-1/2"

## Drill Heavy Duty Cobalt

Superior drilling performance

Precision ground from solid cobalt alloyed high speed steel for superior drilling performance. The higher cobalt alters the material characteristics by increasing the hardness and high resistance to abrasion. This type of drill is suited to drilling materials that have high hardness and tensile strength such as cast iron, bronze, weld seams, hardened steel & stainless steel.

- Industrial quality for drilling hardened steel

Size range: 1-13mm, 1/16-1/2"

## Drill Long Series

For long reach

Offers longer flute & overall length than standard drill bits. Ideal for long reach applications.

The blue finish is a ferric oxide surface coating which resists chip build up on the cutting edge, reducing frictional drag, and therefore reducing heat generated. It greatly increases drilling life and ability, especially in ferrous materials such as steel, stainless steels, high tensile steel, alloy and tool steel.

Size range: 2-13mm, 1/16-1/2"

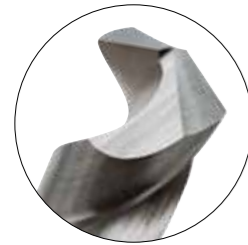
## Drill Panel & Rivet

For sheet metal

Developed to drill holes for rivets in flat and curved panels and used in sheet metal fabrication. The shallow point is especially designed to engage with minimal wandering in thin sheet metals. Note: Drill holes must be larger than rivet size to allow expansion and reduce metal fatigue.

- Available in shortie (single sided) and tupoint (double ended)
- Also available in TiN coated & cobalt HSS

Size range: 1/8", #30, #20, #11



**118° Split Point**  
Self-centring  
minimises wandering  
when starting



**Made from HSS**  
Stronger and out performs  
a conventional drill bit

**Reduced Shank**  
Drill sizes above 10mm & 3/8"  
feature reduced shanks to suit  
drill chucks



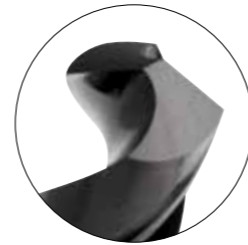
**135° Split Point**  
Enables accurate  
positioning and less  
drilling pressure



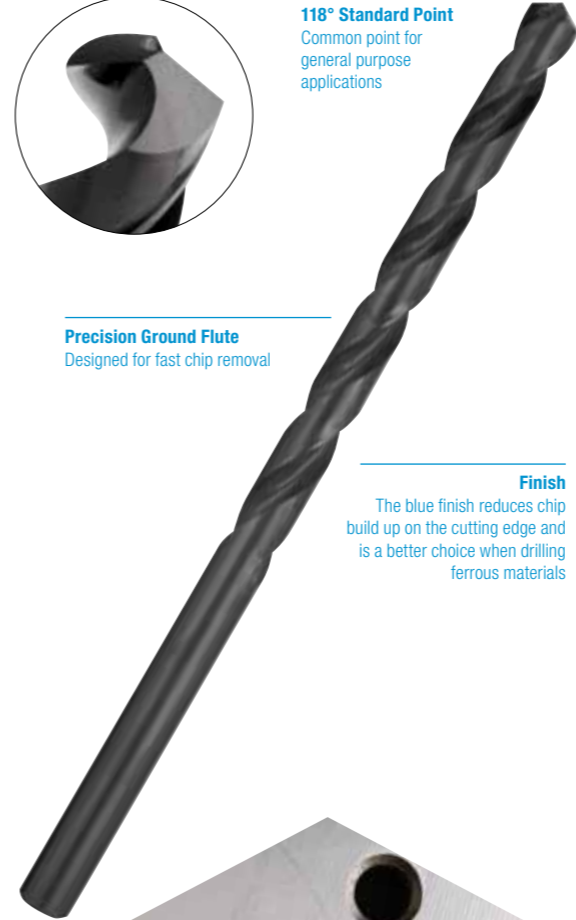
**Surface Finish**  
Colour tempered finish  
enables identification  
of cobalt drills

**Thick Core**  
for increased rigidity in  
hardened steels

**Cobalt Alloyed**  
The 5% cobalt formula  
improves abrasive & heat  
resistance, for increased  
strength at higher drilling  
temperatures

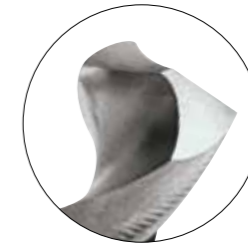


**118° Standard Point**  
Common point for  
general purpose  
applications

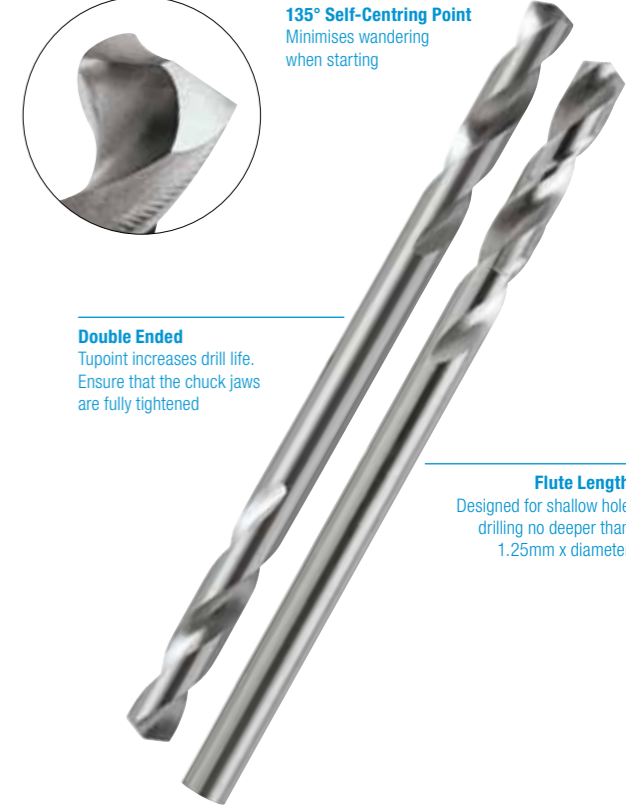


**Precision Ground Flute**  
Designed for fast chip removal

**Finish**  
The blue finish reduces chip  
build up on the cutting edge and  
is a better choice when drilling  
ferrous materials



**135° Self-Centring Point**  
Minimises wandering  
when starting



**Double Ended**  
Tupoint increases drill life.  
Ensure that the chuck jaws  
are fully tightened

**Flute Length**  
Designed for shallow hole  
drilling no deeper than  
1.25mm x diameter