



*suttontools*

## E100 -2 Flute Slot Drills - R30 N - Regular -Sutton Tools

For precision milling of slots & cavities

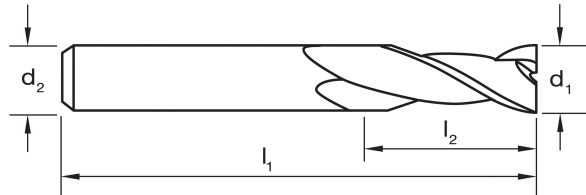
### Features:

- 2 Flute Slot Drill R30 N
- Suitable for materials up to 1000 N/mm<sup>2</sup>
- For soft steels & non-ferrous material
- TiCN for longer tool life

### Specifications:

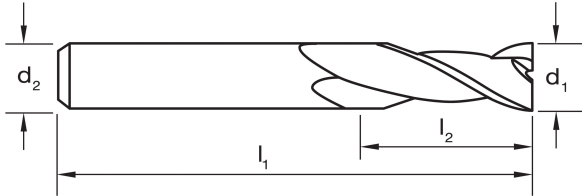
<b>Designation:</b>	N
<b>Material:</b>	HSS Co.8
<b>Finish:</b>	Brt
<b>Shank Form:</b>	A
<b>Helix Angle:</b>	R30
<b>Point Tolerance:</b>	e8
<b>Shank Tolerance:</b>	h6
<b>Point Form:</b>	Square End
<b>Standard:</b>	JIS

Range:



Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	Diameter d2 (inch)	z
E1000159	1.59	1/16	50	3.2	-	1/4	2
E1000238	2.38	3/32	50	4.75	-	1/4	2
E1000318	3.18	1/8	50	5.5	-	1/4	2
E1000476	4.76	3/16	60	9.5	-	1/4	2
E1000635	6.35	1/4	65	14	-	1/4	2
E1000794	7.94	5/16	65	14	-	3/8	2
E1000953	9.53	3/8	70	18	-	3/8	2
E1001270	12.70	1/2	90	25.5	-	1/2	2
E1001588	15.88	5/8	95	30	-	5/8	2
E1001905	19.05	3/4	110	39.5	-	3/4	2
E1002540	25.40	1	120	51	-	3/4	2
E1000100	1.00	-	50	3	6	-	2
E1000150	1.50	-	50	4.5	6	-	2
E1000200	2.00	-	50	7	6	-	2
E1000250	2.50	-	50	7	6	-	2
E1000300	3.00	-	50	9	6	-	2
E1000350	3.50	-	60	12	8	-	2
E1000400	4.00	-	60	12	8	-	2
E1000450	4.50	-	60	15	8	-	2
E1000500	5.00	-	60	15	8	-	2
E1000550	5.50	-	60	15	8	-	2
E1000600	6.00	-	60	15	8	-	2
E1000650	6.50	-	65	20	10	-	2
E1000700	7.00	-	65	20	10	-	2
E1000750	7.50	-	65	20	10	-	2
E1000800	8.00	-	65	20	10	-	2
E1000850	8.50	-	75	25	10	-	2
E1000900	9.00	-	75	25	10	-	2
E1000950	9.50	-	75	25	10	-	2
E1001000	10.00	-	75	25	10	-	2
E1001100	11.00	-	80	30	12	-	2
E1001200	12.00	-	80	30	12	-	2
E1001300	13.00	-	90	35	16	-	2
E1001400	14.00	-	90	35	16	-	2
E1001500	15.00	-	95	40	16	-	2

Range:



Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	Diameter d2 (inch)	z
E1001600	16.00	-	95	40	16	-	2
E1001700	17.00	-	105	40	20	-	2
E1001800	18.00	-	105	40	20	-	2
E1001900	19.00	-	110	45	20	-	2
E1002000	20.00	-	110	45	20	-	2
E1002100	21.00	-	110	45	20	-	2
E1002200	22.00	-	110	45	20	-	2
E1002400	24.00	-	120	50	25	-	2
E1002500	25.00	-	120	50	25	-	2
E1002800	28.00	-	125	55	25	-	2
E1003000	30.00	-	125	55	25	-	2
E1003200	32.00	-	145	60	32	-	2

### 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	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200MPa	680MPa	○
P	11	Steel - High alloy, cast & tool	Hardened & Tempered	325HB	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	180HB	610MPa	
M	14.2	Stainless Steel - Duplex		250HB	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		75MPa	270MPa	○
N	24	Aluminum & Magnesium, cast alloy ?12% Si - Heat Treatable	Age Hardened	90MPa	320MPa	○
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatable		130MPa	460MPa	○
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1%		110MPa	390MPa	○
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100MPa	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	400HB	1350MPa	
H	41	Cast Iron	Hardened & Tempered	55HRC		

### KEY

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  Effective
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  M Stainless
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  H Hard Materials