



suttontools

E125 -4 Flute Endmills - R30 N - Regular -Sutton Tools

For precision finish milling applications

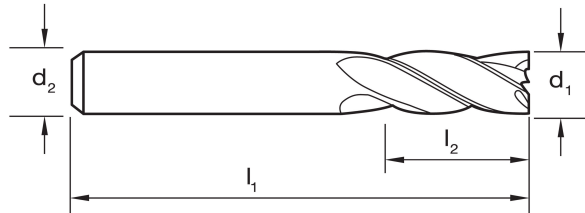
Features:

- 4 Flute Endmill R30 N
- Suitable for materials up to 1000 N/mm²
- TiCN for longer tool life

Specifications:

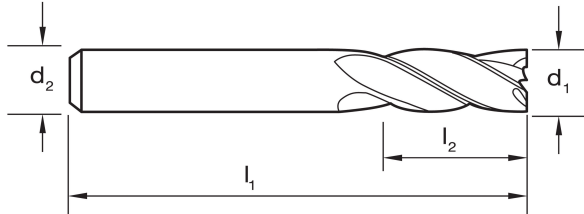
Designation:	N
Material:	HSS Co.8
Finish:	Brt
Shank Form:	A
Helix Angle:	R30
Point Tolerance:	k9
Shank Tolerance:	h6
Point Form:	Square End
Standard:	JIS

Range:



Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	Diameter d2 (inch)	z
E1250159	1.59	1/16	50	6.4	-	1/4	4
E1250238	2.38	3/32	50	7	-	1/4	4
E1250318	3.18	1/8	50	8.5	-	1/4	4
E1250476	4.76	3/16	60	15	-	1/4	4
E1250635	6.35	1/4	60	15	-	1/4	4
E1250794	7.94	5/16	65	20	-	3/8	4
E1250953	9.53	3/8	75	24.5	-	3/8	4
E1251270	12.70	1/2	82	35	-	1/2	4
E1251588	15.88	5/8	95	39.5	-	5/8	4
E1251905	19.05	3/4	110	44.5	-	3/4	4
E1252223	22.23	7/8	110	44.5	-	3/4	4
E1252540	25.40	1	120	50	-	3/4	4
E1252541	25.40	1	120	50	-	1	4
E1250150	1.50	-	50	3	6	-	4
E1250200	2.00	-	50	6	6	-	4
E1250250	2.50	-	50	7	6	-	4
E1250300	3.00	-	50	9	6	-	4
E1250650	6.50	-	65	20	10	-	4
E1250700	7.00	-	65	20	10	-	4
E1250750	7.50	-	65	20	10	-	4
E1250800	8.00	-	65	20	10	-	4
E1250850	8.50	-	75	25	10	-	4
E1250900	9.00	-	75	25	10	-	4
E1250950	9.50	-	75	25	10	-	4
E1251000	10.00	-	75	25	10	-	4
E1251050	10.50	-	80	30	12	-	4
E1251100	11.00	-	80	30	12	-	4
E1251150	11.50	-	80	30	12	-	4
E1251200	12.00	-	80	30	12	-	4
E1251300	13.00	-	90	35	16	-	4
E1251400	14.00	-	90	35	16	-	4
E1251500	15.00	-	95	40	16	-	4
E1251600	16.00	-	95	40	16	-	4
E1251700	17.00	-	105	40	20	-	4
E1251800	18.00	-	105	40	20	-	4

Range:



Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	Diameter d2 (inch)	z
E1251900	19.00	-	110	45	20	-	4
E1252000	20.00	-	110	45	20	-	4
E1252200	22.00	-	110	45	20	-	4
E1252400	24.00	-	120	50	25	-	4
E1252500	25.00	-	120	50	25	-	4
E1252800	28.00	-	125	55	25	-	6
E1253000	30.00	-	125	55	25	-	6
E1253200	32.00	-	145	60	32	-	6
E1250350	3.50	-	60	12	8	-	4
E1250400	4.00	-	60	12	8	-	4
E1250450	4.50	-	60	15	8	-	4
E1250500	5.00	-	60	15	8	-	4
E1250550	5.50	-	60	15	8	-	4
E1250600	6.00	-	60	15	8	-	4

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	270HB	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	275HB	930MPa	
P	8	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	300HB	1010MPa	
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200HB	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	240HB	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 Treatabl		130HB	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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