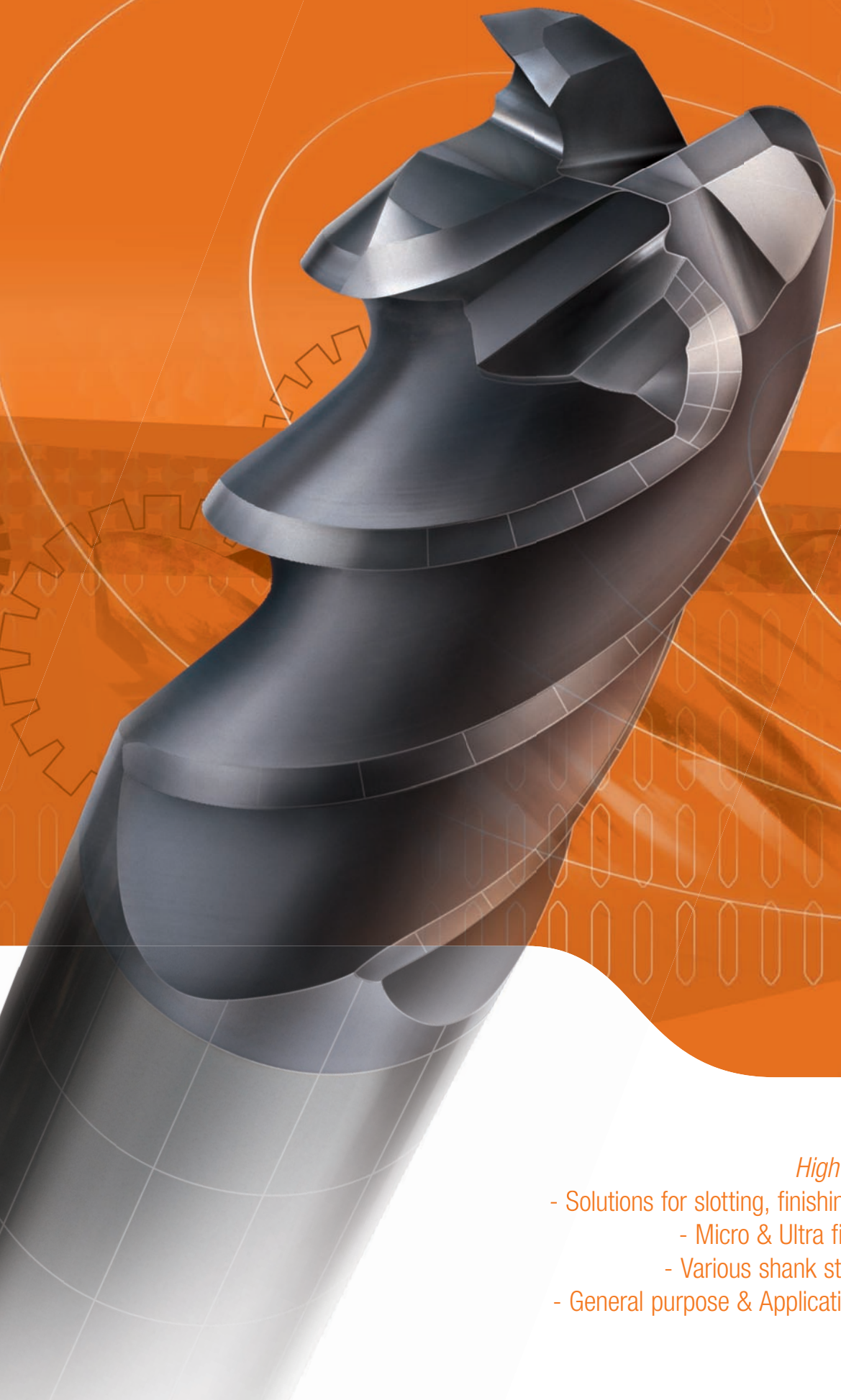
CARBIDE ENDMILLS

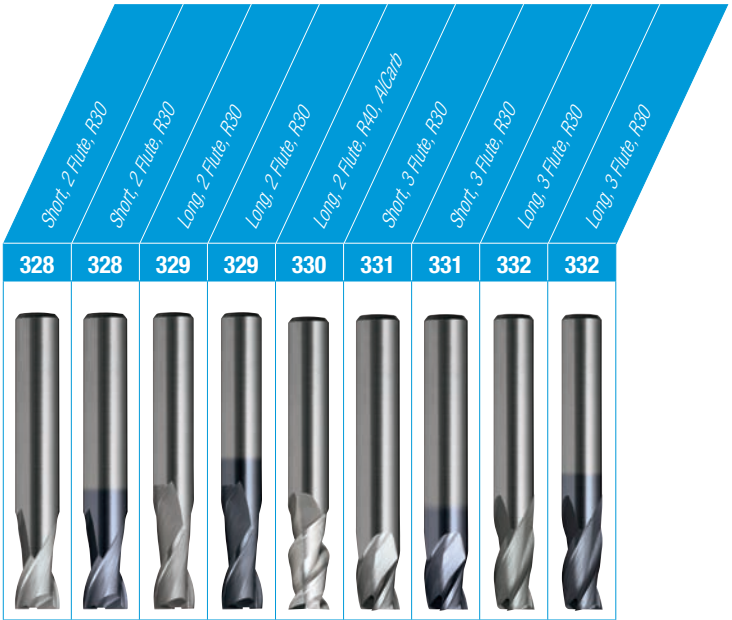


Carbide Endmills

High performance solutions

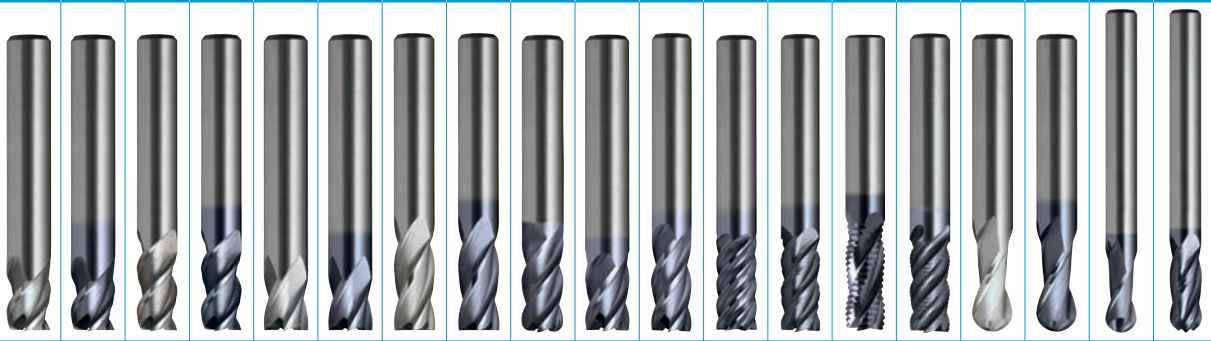
- Solutions for slotting, finishing, roughing & profiling
- Micro & Ultra fine grain type carbides
- Various shank styles to suit your needs
- General purpose & Application specific geometries

Sutton Tools



				Short, 2 Flute, R30	Short, 2 Flute, R30	Long, 2 Flute, R30	Long, 2 Flute, R30	Long, 2 Flute, R40, AlCrO	Short, 3 Flute, R30	Short, 3 Flute, R30	Long, 3 Flute, R30	Long, 3 Flute, R30
			Page	328	328	329	329	330	331	331	332	332
			Catalogue Code	E500	E502	E504	E506	E310	E509	E511	E513	E515
			Material	VHM								
			Surface Finish	*Brt*	*AlCrN*	*Brt*	*AlCrN*	*Brt*	*Brt*	*AlCrN*	*Brt*	*AlCrN*
			Colour Ring & Application	Up to 1600N/mm²				Al	Up to 1600N/mm²			
			Standard	DIN 6527				-	DIN 6527			
			Type of Cut	Slotting					Slotting / Finishing			
Material			**Shank Tolerance**	h6								
1.0 Steels	**HB**	**N/mm²**	**% Elong.**									
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	●	●		●	●	●	●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	●	●		●	●	●	●
1.3 Plain carbon, low allowed	<300	>350 <850	20	●	●	●	●		●	●	●	●
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	○	●	○	●		○	●	○	●
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30	○	●	○	●		○	●	○	●
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12	○	○	○	○		○	○	○	○
1.7 Hardened Steel 45-50 Rc	<550		<12		○		○			○		○
1.8 Hardened Steel 50-62 Rc	<700		<12									
2.0 Stainless Steels												
2.1 Free machining	<250	<850	25	●	●	●	●		●	●	●	●
2.2 Austenitic	<250	<850	20	○	○	○	○		○	○	○	○
2.3 Ferritic + martensitic	<250	<850	20	○	○	○	○		○	○	○	○
3.0 Cast Irons												
3.1 Lamellar graphite (Grey soft)	<150	<500	10	●	●	●	●		●	●	●	●
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	○	●	○	●		○	●	○	●
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	●	○	●		○	●	○	●
4.0 Titaniums												
4.1 Pure Titanium	<250	<850	20	○	○	○	○		○	○	○	○
4.2 Titanium alloys	>250	>850	20	○	○	○	○		○	○	○	○
5.0 Nickels												
5.1 Nickel alloys	<250	<850	25	○	○	○	○		○	○	○	○
5.2 Nickel alloys	>250	>850	25	○	○	○	○		○	○	○	○
6.0 Coppers												
6.1 Pure Copper (electrolitic copper)	<120	<400	12	○	○	○	○	●	○	○	○	○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○	○	○	○		○	○	○	○
6.3 Long chip Brass, Bronze	<200	<700	12	○	○	○	○	●	○	○	○	○
7.0 Aluminiums												
7.1 Aluminium unalloyed	<100	<350	15	○	○	○	○	●	○	○	○	○
7.2 Magnesium unalloyed	<150	<350	15	○	○	○	○	●	○	○	○	○
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	○	○	○	○	●	○	○	○	○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○	○	○	○	●	○	○	○	○
7.5 Al Alloyed > 10% Si	-	<400	N	○	○	○	○	●	○	○	○	○
7.6 Magnesium alloys	-	<400	N	○	○	○	○	●	○	○	○	○
8.0 Plastics												
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	○	○	○	○	○	○	○	○	○

● **Optimal** ○ **Effective**

Short, 3 Flute, R45 W	Short, 3 Flute, R45 W	Long, 3 Flute, R45 W	Long, 3 Flute, R45 W	Short, 4 Flute, R30	Short, 4 Flute, R30	Long, 4 Flute, R30	Long, 4 Flute, R30	Long, 4 Flute, R40, Corner Radius	Short, 4 Flute, R35/38, Harmony	Long, 4 Flute, R35/38, Harmony	Long, 6-8 Flute, R45	Long, 4 Flute, R45, STF	Long, 3-4 Flute, R30, NR	Long, 3-6 Flute, R45, HRS	Long, Ballnose, 2 Flute, R30	Long, Ballnose, 2 Flute, R30	Long Reach, Ballnose, 2 Flute, R30	Long Reach, Ballnose, 4 Flute, R30
333	333	334	334	335	335	336	336	337	338	339	340	341	342	343	344	344	345	346
																		
E517	E519	E521	E523	E525	E527	E529	E531	E348	E533	E535	E543	E545	E547	E549	E551	E553	E555	E557
VHM									VHM-ULTRA				VHM	VHM-ULTRA			VHM-ULTRA	
Brt	AlCrN	Brt	AlCrN	Brt	AlCrN	Brt	AlCrN								Brt	AlCrN		
W				Up to 1600N/mm²				Up to 1300N/mm²	UNI		H	UNI	Up to 1600N/mm²	UNI	Up to 1600N/mm²		Up to 1300N/mm²	
DIN 6527												DIN 6527					-	-
Slotting / Finishing				Finishing								Semi Finishing	Roughing		Profiling			
h6																		
●	●	●	●	●	●	●	●	○	●	●		●	●	○	●	●	●	●
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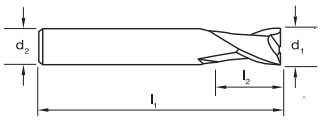
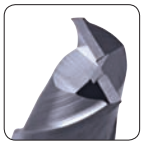
Endmills Carbide, Short, 2 Flute, R30

Sutton Tools

- For precision milling of slots & cavities
- Suitable for materials up to 1600 N/mm²
- AlCrN longer tool life



DIN 6527K

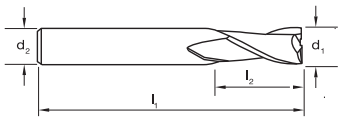


Catalogue Code					E500	E501	E502	E503
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
2.0	50	3	6	2	E500 0200	E501 0200	E502 0200	E503 0200
3.0	50	4	6	2	E500 0300	E501 0300	E502 0300	E503 0300
4.0	54	5	6	2	E500 0400	E501 0400	E502 0400	E503 0400
5.0	54	6	6	2	E500 0500	E501 0500	E502 0500	E503 0500
6.0	54	7	6	2	E500 0600	E501 0600	E502 0600	E503 0600
8.0	58	9	8	2	E500 0800	E501 0800	E502 0800	E503 0800
10.0	66	11	10	2	E500 1000	E501 1000	E502 1000	E503 1000
12.0	72	12	12	2	E500 1200	E501 1200	E502 1200	E503 1200
16.0	82	16	16	2	E500 1600	E501 1600	E502 1600	E503 1600
20.0	92	20	20	2	E500 2000	E501 2000	E502 2000	E503 2000

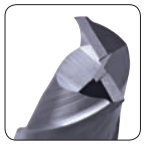
Endmills Carbide, Long, 2 Flute, R30

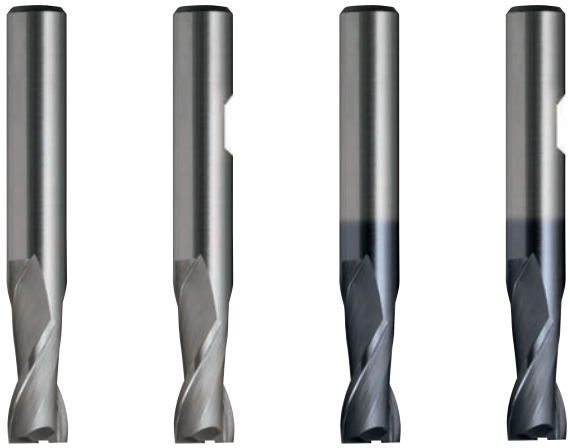
Sutton Tools

- For precision milling of slots & cavities
- Suitable for materials up to 1600 N/mm²
- AlCrN longer tool life



DIN 6527L



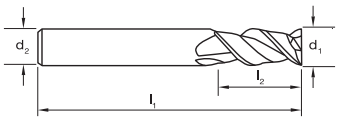


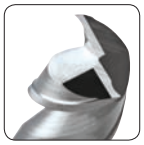
Catalogue Code					E504	E505	E506	E507
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
2.0	57	6	6	2	E504 0200	E505 0200	E506 0200	E507 0200
3.0	57	7	6	2	E504 0300	E505 0300	E506 0300	E507 0300
4.0	57	8	6	2	E504 0400	E505 0400	E506 0400	E507 0400
5.0	57	10	6	2	E504 0500	E505 0500	E506 0500	E507 0500
6.0	57	10	6	2	E504 0600	E505 0600	E506 0600	E507 0600
7.0	63	13	8	2	E504 0700	E505 0700	E506 0700	E507 0700
8.0	63	16	8	2	E504 0800	E505 0800	E506 0800	E507 0800
9.0	72	16	10	2	E504 0900	E505 0900	E506 0900	E507 0900
10.0	72	19	10	2	E504 1000	E505 1000	E506 1000	E507 1000
12.0	83	22	12	2	E504 1200	E505 1200	E506 1200	E507 1200
14.0	83	22	14	2	E504 1400	E505 1400	E506 1400	E507 1400
16.0	92	26	16	2	E504 1600	E505 1600	E506 1600	E507 1600
18.0	92	26	18	2	E504 1800	E505 1800	E506 1800	E507 1800
20.0	104	32	20	2	E504 2000	E505 2000	E506 2000	E507 2000

Endmills Carbide, Long, 2 Flute, R40, *AlCarb*

Sutton Tools

- For precision milling of slots & cavities
- Optimized geometry for aluminums & non-ferrous materials
- High speed & high feed rates can be achieved
- Highly efficient chip disposal





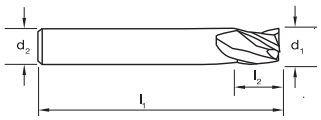
Catalogue Code	**E310**
Discount Group	B0208
Material	**VHM**
Surface Finish	***Brt***
Colour Ring & Application	**Al**
Geometry	R40º
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

d_1	l_1	l_2	d_2	z	Item #
3.0	60	10	6	2	E310 0300
4.0	60	14	6	2	E310 0400
5.0	60	15	6	2	E310 0500
6.0	60	20	6	2	E310 0600
8.0	64	20	8	2	E310 0800
10.0	70	22	10	2	E310 1000
12.0	75	25	12	2	E310 1200
16.0	90	32	16	2	E310 1600
20.0	100	38	20	2	E310 2000

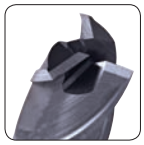
Endmills Carbide, Short, 3 Flute, R30

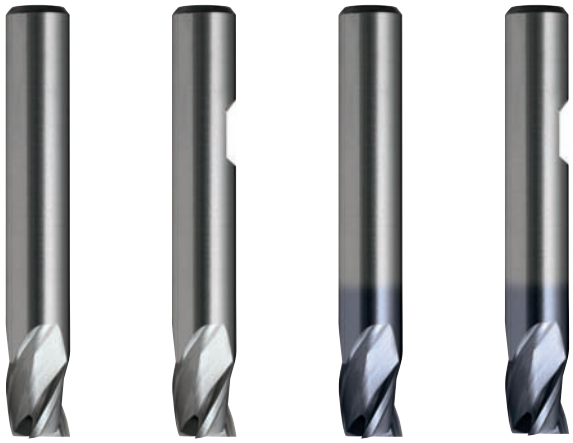
Sutton Tools

- Universal use for slotting and finishing with the one tool
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



DIN 6527K



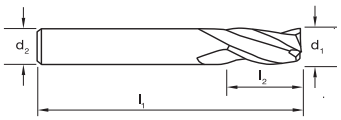


Catalogue Code					E509	E510	E511	E512
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	50	4	6	3	E509 0300	E510 0300	E511 0300	E512 0300
4.0	54	5	6	3	E509 0400	E510 0400	E511 0400	E512 0400
5.0	54	6	6	3	E509 0500	E510 0500	E511 0500	E512 0500
6.0	54	7	6	3	E509 0600	E510 0600	E511 0600	E512 0600
8.0	58	9	8	3	E509 0800	E510 0800	E511 0800	E512 0800
10.0	66	11	10	3	E509 1000	E510 1000	E511 1000	E512 1000
12.0	73	12	12	3	E509 1200	E510 1200	E511 1200	E512 1200
16.0	82	16	16	3	E509 1600	E510 1600	E511 1600	E512 1600
20.0	92	20	20	3	E509 2000	E510 2000	E511 2000	E512 2000

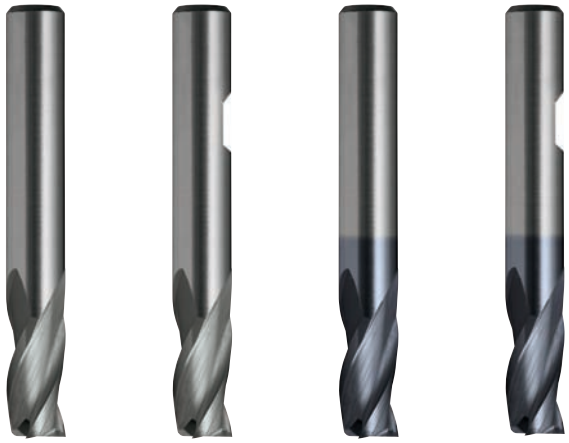
Endmills Carbide, Long, 3 Flute, R30

Sutton Tools

- Universal use for slotting and finishing with the one tool
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



DIN 6527L

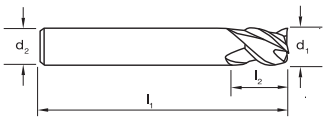


Catalogue Code					E513	E514	E515	E516
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	57	7	6	3	E513 0300	E514 0300	E515 0300	E516 0300
4.0	57	8	6	3	E513 0400	E514 0400	E515 0400	E516 0400
5.0	57	10	6	3	E513 0500	E514 0500	E515 0500	E516 0500
6.0	57	10	6	3	E513 0600	E514 0600	E515 0600	E516 0600
7.0	63	13	8	3	E513 0700	E514 0700	E515 0700	E516 0700
8.0	63	16	8	3	E513 0800	E514 0800	E515 0800	E516 0800
9.0	72	16	10	3	E513 0900	E514 0900	E515 0900	E516 0900
10.0	72	19	10	3	E513 1000	E514 1000	E515 1000	E516 1000
12.0	83	22	12	3	E513 1200	E514 1200	E515 1200	E516 1200
14.0	83	22	14	3	E513 1400	E514 1400	E515 1400	E516 1400
16.0	92	26	16	3	E513 1600	E514 1600	E515 1600	E516 1600
18.0	92	26	18	3	E513 1800	E514 1800	E515 1800	E516 1800
20.0	104	32	20	3	E513 2000	E514 2000	E515 2000	E516 2000

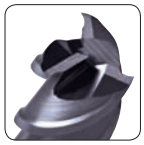
Endmills Carbide, Short, 3 Flute, R45 W

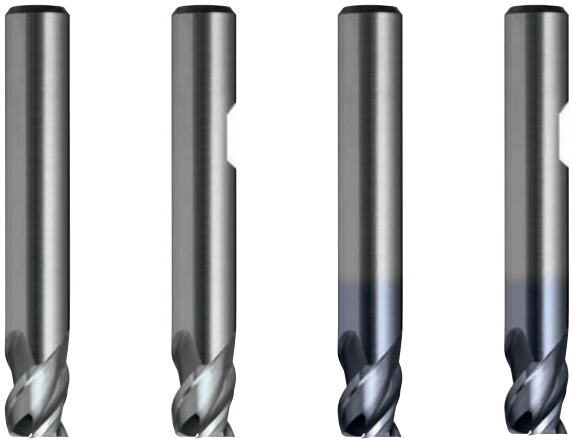
Sutton Tools

- Universal use for slotting & finishing applications, with one tool
- Optimized geometry for soft materials
- Brt for non ferrous materials
- AlCrN for longer tool life



DIN 6527K



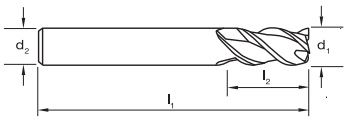


Catalogue Code					E517	E518	E519	E520
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					W	W	W	W
Geometry					R45º	R45º	R45º	R45º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	50	4	6	3	E517 0300	E518 0300	E519 0300	E520 0300
4.0	54	5	6	3	E517 0400	E518 0400	E519 0400	E520 0400
5.0	54	6	6	3	E517 0500	E518 0500	E519 0500	E520 0500
6.0	54	7	6	3	E517 0600	E518 0600	E519 0600	E520 0600
8.0	58	9	8	3	E517 0800	E518 0800	E519 0800	E520 0800
10.0	66	11	10	3	E517 1000	E518 1000	E519 1000	E520 1000
12.0	73	12	12	3	E517 1200	E518 1200	E519 1200	E520 1200
16.0	82	16	16	3	E517 1600	E518 1600	E519 1600	E520 1600
20.0	92	20	20	3	E517 2000	E518 2000	E519 2000	E520 2000

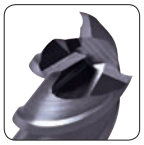
Endmills Carbide, Long, 3 Flute, R45 W

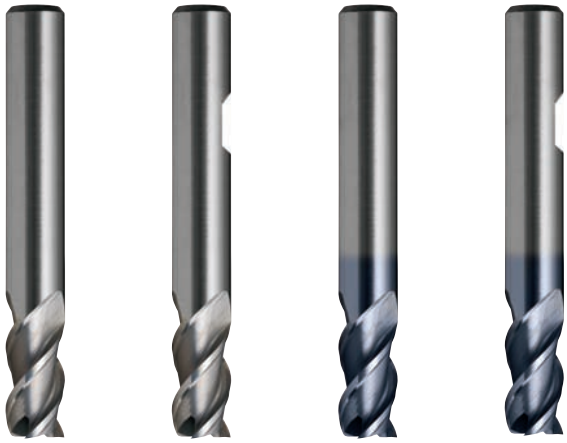
Sutton Tools

- Universal use for slotting & finishing applications, with one tool
- Optimized geometry for soft materials
- Brt for non ferrous materials
- AlCrN for longer tool life



DIN 6527L



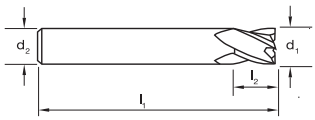


Catalogue Code					E521	E522	E523	E524
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					W	W	W	W
Geometry					R45º	R45º	R45º	R45º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	57	7	6	3	E521 0300	E522 0300	E523 0300	E524 0300
4.0	57	8	6	3	E521 0400	E522 0400	E523 0400	E524 0400
5.0	57	10	6	3	E521 0500	E522 0500	E523 0500	E524 0500
6.0	57	10	6	3	E521 0600	E522 0600	E523 0600	E524 0600
8.0	63	16	8	3	E521 0800	E522 0800	E523 0800	E524 0800
10.0	72	19	10	3	E521 1000	E522 1000	E523 1000	E524 1000
12.0	83	22	12	3	E521 1200	E522 1200	E523 1200	E524 1200
16.0	92	26	16	3	E521 1600	E522 1600	E523 1600	E524 1600
20.0	104	32	20	3	E521 2000	E522 2000	E523 2000	E524 2000

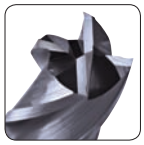
Endmills Carbide, Short, 4 Flute, R30

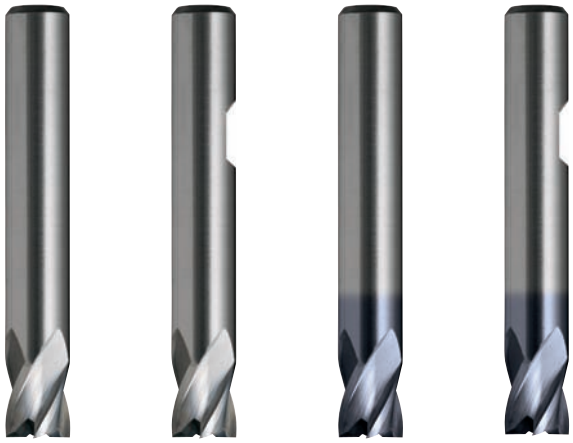
Sutton Tools

- For precision finish milling applications
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



DIN 6527K



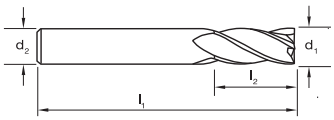


Catalogue Code					E525	E526	E527	E528
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30°	R30°	R30°	R30°
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	50	5	6	4	E525 0300	E526 0300	E527 0300	E528 0300
4.0	54	8	6	4	E525 0400	E526 0400	E527 0400	E528 0400
5.0	54	9	6	4	E525 0500	E526 0500	E527 0500	E528 0500
6.0	54	10	6	4	E525 0600	E526 0600	E527 0600	E528 0600
8.0	58	12	8	4	E525 0800	E526 0800	E527 0800	E528 0800
10.0	66	14	10	4	E525 1000	E526 1000	E527 1000	E528 1000
12.0	73	16	12	4	E525 1200	E526 1200	E527 1200	E528 1200
16.0	82	22	16	4	E525 1600	E526 1600	E527 1600	E528 1600
20.0	92	26	20	4	E525 2000	E526 2000	E527 2000	E528 2000

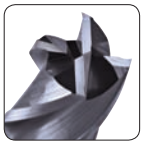
Endmills Carbide, Long, 4 Flute, R30

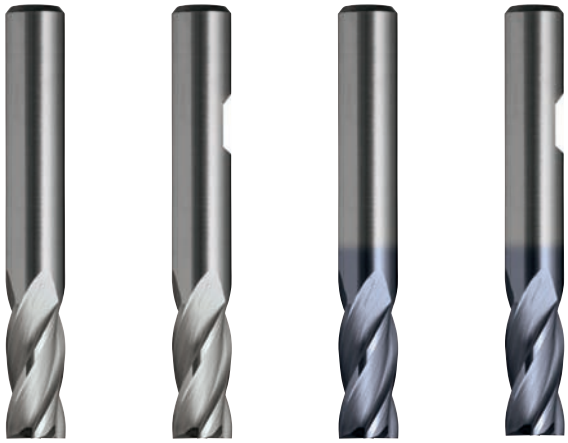
Sutton Tools

- For precision finish milling applications
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



DIN 6527L



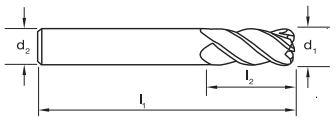


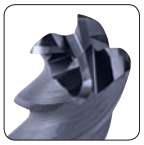
Catalogue Code					E529	E530	E531	E532
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
3.0	57	8	6	4	E529 0300	E530 0300	E531 0300	E532 0300
4.0	57	11	6	4	E529 0400	E530 0400	E531 0400	E532 0400
5.0	57	13	6	4	E529 0500	E530 0500	E531 0500	E532 0500
6.0	57	13	6	4	E529 0600	E530 0600	E531 0600	E532 0600
7.0	63	16	8	4	E529 0700	E530 0700	E531 0700	E532 0700
8.0	63	19	8	4	E529 0800	E530 0800	E531 0800	E532 0800
9.0	72	19	10	4	E529 0900	E530 0900	E531 0900	E532 0900
10.0	72	22	10	4	E529 1000	E530 1000	E531 1000	E532 1000
12.0	83	26	12	4	E529 1200	E530 1200	E531 1200	E532 1200
14.0	83	26	14	4	E529 1400	E530 1400	E531 1400	E532 1400
16.0	92	32	16	4	E529 1600	E530 1600	E531 1600	E532 1600
18.0	92	32	18	4	E529 1800	E530 1800	E531 1800	E532 1800
20.0	104	38	20	4	E529 2000	E530 2000	E531 2000	E532 2000

Endmills Carbide, Long, 4 Flute, R40, Corner Radius

Sutton Tools

- For precision finishing applications
- Ideally suited to materials up to 1300 N/mm²
- AlCrN for longer tool life





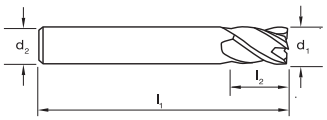
Catalogue Code	**E348**
Discount Group	B0210
Material	**VHM**
Surface Finish	***AlCrN***
Colour Ring & Application	**Up to 1300N/mm²**
Geometry	R40º
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

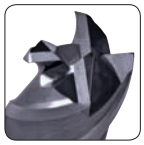
d_1	l_1	l_2	d_2	z	rad	Item #
3	40	9	3	4	0.3	E348 0303
	40	9	3	4	0.5	E348 0305
4	50	12	4	4	0.3	E348 0403
	50	12	4	4	0.5	E348 0405
	50	12	4	4	1.0	E348 0410
5	50	15	5	4	0.3	E348 0503
	50	15	5	4	0.5	E348 0505
	50	15	5	4	1.0	E348 0510
6	60	20	6	4	0.3	E348 0603
	60	20	6	4	0.5	E348 0605
	60	20	6	4	1.0	E348 0610
8	64	20	8	4	0.3	E348 0803
	64	20	8	4	0.5	E348 0805
	64	20	8	4	1.0	E348 0810
	64	20	8	4	1.5	E348 0815
	64	20	8	4	2.0	E348 0820
10	70	22	10	4	0.3	E348 1003
	70	22	10	4	0.5	E348 1005
	70	22	10	4	1.0	E348 1010
	70	22	10	4	1.5	E348 1015
	70	22	10	4	2.0	E348 1020
12	75	25	12	4	0.3	E348 1203
	75	25	12	4	0.5	E348 1205
	75	25	12	4	1.0	E348 1210
	75	25	12	4	1.5	E348 1215
	75	25	12	4	2.0	E348 1220
	75	25	12	4	3.0	E348 1230
16	90	32	16	4	0.5	E348 1605
	90	32	16	4	1.0	E348 1610
	90	32	16	4	1.5	E348 1615
	90	32	16	4	2.0	E348 1620
	90	32	16	4	3.0	E348 1630
20	100	38	20	4	0.5	E348 2005
	100	38	20	4	1.0	E348 2010
	100	38	20	4	1.5	E348 2015
	100	38	20	4	2.0	E348 2020
	100	38	20	4	3.0	E348 2030

Endmills Carbide, Short, 4 Flute, R35/38, *Harmony*

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- 35/38º variable flute helix for chatter free milling
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



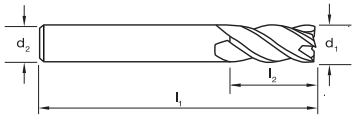


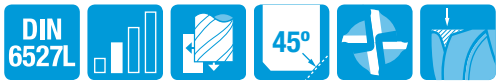
Catalogue Code					E533	E534
Discount Group					B0210	B0210
Material					VHM-ULTRA	VHM-ULTRA
Surface Finish					*AlCrN*	*AlCrN*
Colour Ring & Application					UNI	UNI
Geometry					R35º / 38º	R35º / 38º
Shank Form (DIN 6535)					HA	HB
Shank Tolerance					h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #
6.0	54	10	6	4	E533 0600	E534 0600
8.0	58	12	8	4	E533 0800	E534 0800
10.0	66	14	10	4	E533 1000	E534 1000
12.0	73	16	12	4	E533 1200	E534 1200
16.0	82	22	16	4	E533 1600	E534 1600
20.0	92	26	20	4	E533 2000	E534 2000

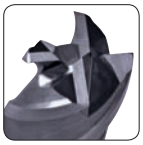
Endmills Carbide, Long, 4 Flute, R35/38, *Harmony*

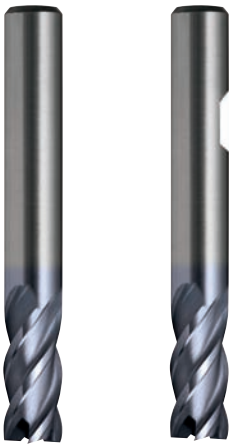
Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- 35/38º variable flute helix for chatter free milling
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life







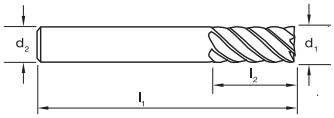


Catalogue Code					E535	E536
Discount Group					B0210	B0210
Material					VHM-ULTRA	VHM-ULTRA
Surface Finish					*AlCrN*	*AlCrN*
Colour Ring & Application					UNI	UNI
Geometry					R35º / 38º	R35º / 38º
Shank Form (DIN 6535)					HA	HB
Shank Tolerance					h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #
6.0	57	13	6	4	E535 0600	E536 0600
8.0	63	19	8	4	E535 0800	E536 0800
10.0	72	22	10	4	E535 1000	E536 1000
12.0	83	26	12	4	E535 1200	E536 1200
16.0	92	32	16	4	E535 1600	E536 1600
20.0	104	38	20	4	E535 2000	E536 2000

Endmills Carbide, Long, 6-8 Flute, R45

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- For super fine finishing applications
- Suitable for hard, short chipping materials up to 65 HR_c
- Multi-flute & heavy core design enable high feed rates
- AlCrN for longer tool life



DIN 6527L

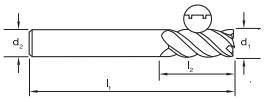
Catalogue Code						E543	E544
Discount Group						B0210	B0210
Material						VHM-ULTRA	VHM-ULTRA
Surface Finish						*AlCrN*	*AlCrN*
Colour Ring & Application						H	H
Geometry						R45º	R45º
Shank Form (DIN 6535)						HA	HB
Shank Tolerance						h6	h6
d_1	l_1	l_2	d_2	z		Item #	Item #
6.0	57	13	6	6		E543 0600	E544 0600
8.0	63	19	8	6		E543 0800	E544 0800
10.0	72	22	10	6		E543 1000	E544 1000
12.0	83	26	12	6		E543 1200	E544 1200
16.0	92	32	16	8		E543 1600	E544 1600
20.0	104	38	20	8		E543 2000	E544 2000

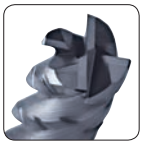
Endmills Carbide, Long, 4 Flute, R45, STF

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- For finishing & semi-roughing applications
- Suitable for materials up to 1400 N/mm²
- Unequal flute design with Special Tooth Form (STF), produces excellent surface finish
- Eliminates the use of finishing endmills in many cases
- AlCrN for longer tool life

STF



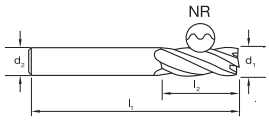


Catalogue Code					E545	E546
Discount Group					B0210	B0210
Material					VHM-ULTRA	VHM-ULTRA
Surface Finish					*AlCrN*	*AlCrN*
Colour Ring & Application					UNI	UNI
Geometry					R45º (Uneq. Flute)	R45º (Uneq. Flute)
Shank Form (DIN 6535)					HA	HB
Shank Tolerance					h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #
4.0	57	11	6	4	E545 0400	E546 0400
5.0	57	13	6	4	E545 0500	E546 0500
6.0	57	13	6	4	E545 0600	E546 0600
8.0	63	19	8	4	E545 0800	E546 0800
10.0	72	22	10	4	E545 1000	E546 1000
12.0	83	26	12	4	E545 1200	E546 1200
16.0	92	32	16	4	E545 1600	E546 1600
20.0	104	38	20	4	E545 2000	E546 2000

Endmills Carbide, Long, 3-4 Flute, R30, NR

Sutton Tools

- For roughing applications
- NR geometry allows for heavy cuts
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life

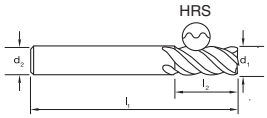


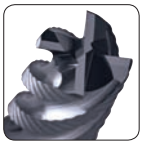
Catalogue Code						E547	E548
Discount Group						B0210	B0210
Material						VHM	VHM
Surface Finish						*AlCrN*	*AlCrN*
Colour Ring & Application						Up to 1600N/mm²	Up to 1600N/mm²
Geometry						R30º NR	R30º NR
Shank Form (DIN 6535)						HA	HB
Shank Tolerance						h6	h6
d_1	l_1	l_2	d_2	z		Item #	Item #
4.0	57	11	6	3		E547 0400	E548 0400
5.0	57	13	6	3		E547 0500	E548 0500
6.0	57	13	6	3		E547 0600	E548 0600
8.0	63	19	8	3		E547 0800	E548 0800
10.0	72	22	10	4		E547 1000	E548 1000
12.0	83	26	12	4		E547 1200	E548 1200
16.0	92	32	16	4		E547 1600	E548 1600
20.0	104	38	20	4		E547 2000	E548 2000

Endmills Carbide, Long, 3-6 Flute, R45, HRS

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- For roughing applications
- HRS geometry allows for heavy cuts in short & long chipping materials
- Suitable for materials up to 1600 N/mm^2
- AlCrN for longer tool life



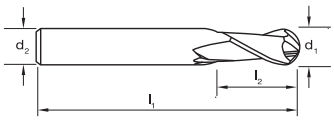


Catalogue Code					E549	E550
Discount Group					B0210	B0210
Material					VHM-ULTRA	VHM-ULTRA
Surface Finish					*AlCrN*	*AlCrN*
Colour Ring & Application					UNI	UNI
Geometry					R45º HRS	R45º HRS
Shank Form (DIN 6535)					HA	HB
Shank Tolerance					h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #
4.0	57	11	6	3	E549 0400	E550 0400
5.0	57	13	6	4	E549 0500	E550 0500
6.0	57	16	6	4	E549 0600	E550 0600
8.0	63	19	8	4	E549 0800	E550 0800
10.0	72	22	10	4	E549 1000	E550 1000
12.0	83	26	12	4	E549 1200	E550 1200
16.0	92	32	16	5	E549 1600	E550 1600
20.0	104	38	20	6	E549 2000	E550 2000

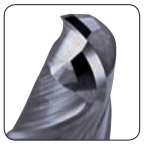
Endmills Carbide, Long, Ballnose, 2 Flute, R30

Sutton Tools

- For profile & contour milling applications
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



DIN 6527L

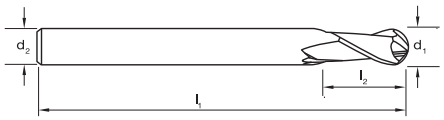


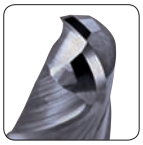
Catalogue Code					E551	E552	E553	E554
Discount Group					B0208	B0208	B0210	B0210
Material					VHM	VHM	VHM	VHM
Surface Finish					*Brt*	*Brt*	*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²	Up to 1600N/mm²
Geometry					R30º	R30º	R30º	R30º
Shank Form (DIN 6535)					HA	HB	HA	HB
Shank Tolerance					h6	h6	h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #	Item #	Item #
2.0	57	6	6	2	E551 0200	E552 0200	E553 0200	E554 0200
3.0	57	7	6	2	E551 0300	E552 0300	E553 0300	E554 0300
4.0	57	8	6	2	E551 0400	E552 0400	E553 0400	E554 0400
5.0	57	10	6	2	E551 0500	E552 0500	E553 0500	E554 0500
6.0	57	10	6	2	E551 0600	E552 0600	E553 0600	E554 0600
8.0	63	16	8	2	E551 0800	E552 0800	E553 0800	E554 0800
10.0	72	19	10	2	E551 1000	E552 1000	E553 1000	E554 1000
12.0	83	22	12	2	E551 1200	E552 1200	E553 1200	E554 1200

Endmills Carbide, Long Reach, Ballnose, 2 Flute, R30

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- For profile & contour milling applications
- Suitable for materials up to 1600 N/mm²
- AlCrN for longer tool life



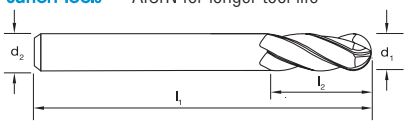


Catalogue Code					E555	E556
Discount Group					B0210	B0210
Material					VHM-ULTRA	VHM-ULTRA
Surface Finish					*AlCrN*	*AlCrN*
Colour Ring & Application					Up to 1300N/mm²	Up to 1300N/mm²
Geometry					R30º	R30º
Shank Form (DIN 6535)					HA	HB
Shank Tolerance					h6	h6
d_1	l_1	l_2	d_2	z	Item #	Item #
2.0	50	5	6	2	E555 0200	E556 0200
3.0	60	8	6	2	E555 0300	E556 0300
4.0	70	8	6	2	E555 0400	E556 0400
5.0	80	10	6	2	E555 0500	E556 0500
6.0	90	12	6	2	E555 0600	E556 0600
8.0	100	14	8	2	E555 0800	E556 0800
10.0	100	18	10	2	E555 1000	E556 1000
12.0	110	22	12	2	E555 1200	E556 1200

Endmills Carbide, Long Reach, Ballnose, 4 Flute, R30

Sutton Tools

- VHM-ULTRA grade of carbide for high performance
- For profile & contour milling applications
- Suitable for materials up to 1600 N/mm²
- Increased feed rates than 2 flute variety
- Minimal deflection due to strong/larger core
- AlCrN for longer tool life



Catalogue Code						E557	E558
Discount Group						B0210	B0210
Material						VHM-ULTRA	VHM-ULTRA
Surface Finish						*AlCrN*	*AlCrN*
Colour Ring & Application						Up to 1300N/mm²	Up to 1300N/mm²
Geometry						R30º	R30º
Shank Form (DIN 6535)						HA	HB
Shank Tolerance						h6	h6
d_1	l_1	l_2	d_2	z		Item #	Item #
2.0	50	5	6	4		E557 0200	E558 0200
3.0	60	8	6	4		E557 0300	E558 0300
4.0	70	8	6	4		E557 0400	E558 0400
5.0	80	10	6	4		E557 0500	E558 0500
6.0	90	12	6	4		E557 0600	E558 0600
8.0	100	14	8	4		E557 0800	E558 0800
10.0	100	18	10	4		E557 1000	E558 1000
12.0	110	22	12	4		E557 1200	E558 1200