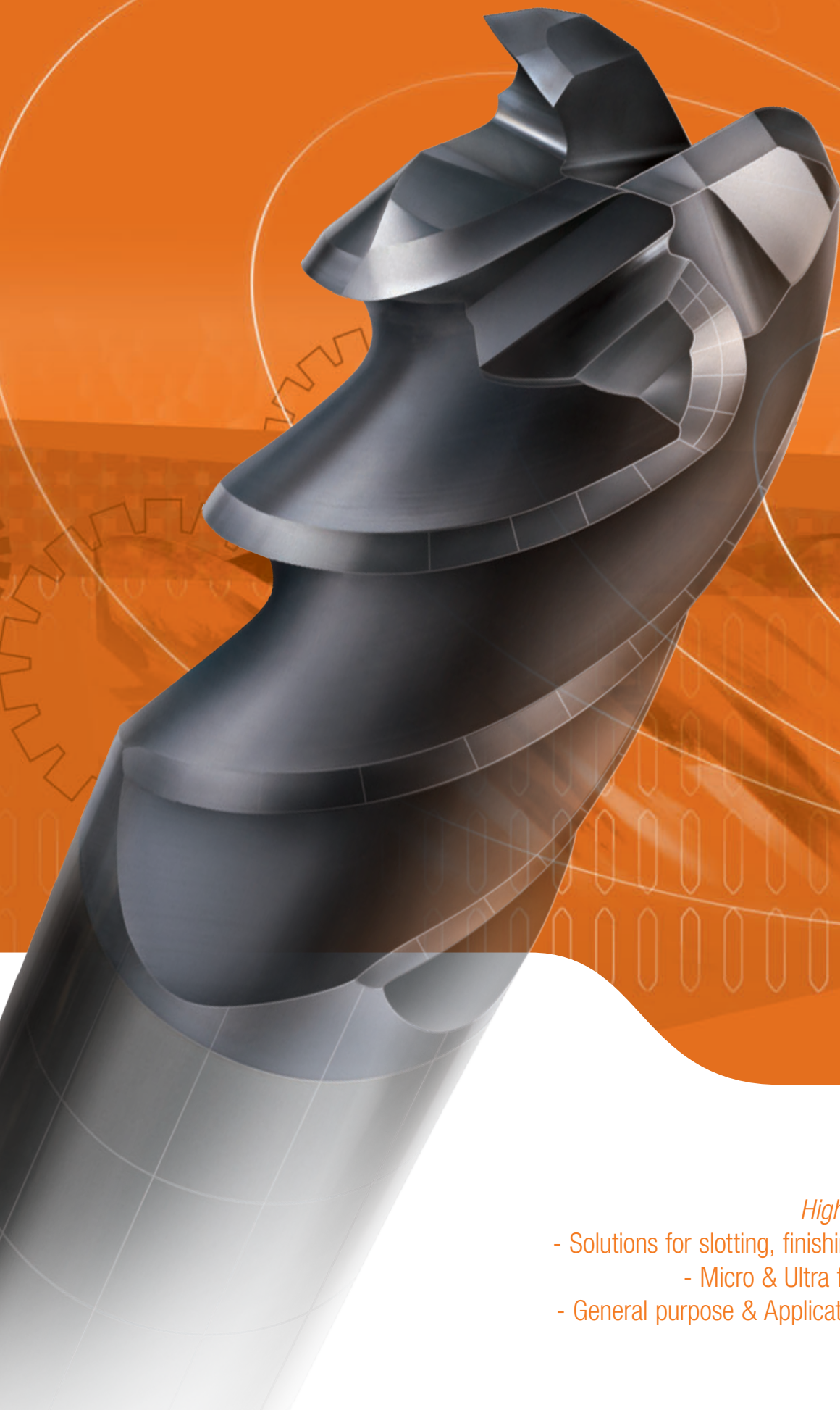


CARBIDE ENDMILLS



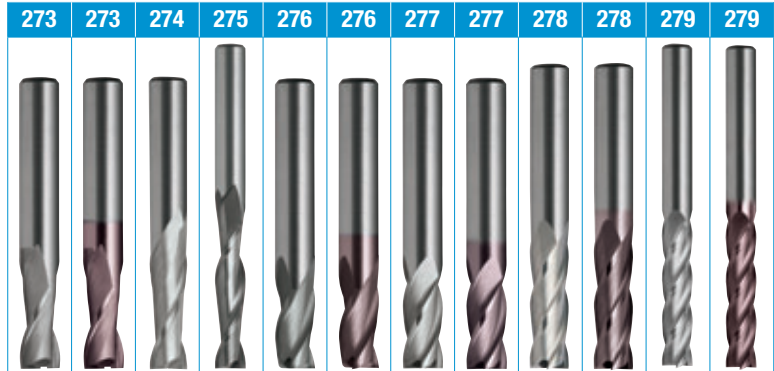
Carbide Endmills

High performance solutions

- Solutions for slotting, finishing, roughing & profiling
 - Micro & Ultra fine grain type carbides
- General purpose & Application specific geometries



Page



ISO	VDI	Material Group	Sutton
P	A	Steel	N
M	R	Stainless Steel	VA
K	F	Cast Iron	GG
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W
S	S	Titaniums & Super Alloys	Ti Ni
H	H	Hard Materials (≥ 45 HRC)	H

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.

Catalogue Code
Type of Cut: *Slotting*
Finishing
Universal
Roughing
Profiling
Material
Surface Finish
Sutton Designation
Standard
Shank Tolerance

E600	E603	E308	E309	E513	E515	E601	E604	E337	E340	E341	E344	
●	●	●	●	●	●	●	●	●	●	●	●	
				●	●	●	●	●	●	●	●	
				●	●	●	●	●	●	●	●	
VHM												
Brt	TiAIN	Brt	Brt	TiAIN	Brt	TiAIN	Brt	TiAIN	Brt	TiAIN	Brt	TiAIN
N												
DIN 6527L												
h6												

ISO	VDI ³³²³	Material	Condition	HB	N/mm ²	E600	E603	E308	E309	E513	E515	E601	E604	E337	E340	E341	E344			
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●	●	●	●	●	●	●		
	2		~ 0.45 %C	A	190	640	●	●	●	●	●	●	●	●	●	●	●	●	●	
	3		~ 0.75 %C	QT	250	840	●	●	●	○	●	●	●	●	●	●	●	○	●	
	4			A	270	910	●	●	●	○	●	●	●	●	●	●	○	●	●	
	5			QT	300	1010		○	○		○	●		○	○	●	○	○	●	●
	6	Steel - Low alloy & cast < 5% of alloying elements	A	180	610	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
	7		QT	275	930	○	●	●	○	●	●	○	●	●	●	●	○	○	●	
	8		QT	300	1010		○	○		○	●		○	○	○	○	○	○	○	
	9		QT	350	1180		○	○			○		○	○	○	○	○	○	○	
	10	Steel - High alloy, cast & tool	A	200	680	○	●	●	○	○	●	○	●	●	●	●	○	○	●	
	11		HT	325	1100		○	○			○		○	○	○	○	○	○	○	
12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680			○	○	○	●			○	●	○	○	●		
13		Martensitic	QT	240	810			○	○	○	●			○	○	○	○	○		
M	14.1	Stainless Steel	Austenitic	AH	180	610	○	○	●	○	○	○	○	○	●	●	●	●		
	14.2		Duplex		250	840	○	○	○	○	○	○	○	○		○	○	○		
	14.3		Precipitation Hardening		250	840				○	○							○		
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610	○	○	●	○	●	●	○	○	●	●	○	●		
	16		Pearlitic		260	880	○	○	○	○	○	○	○	○	○	○	○	○		
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570	○	○	●	○	●	○	○	○	●	●	○	●		
	18		Pearlitic		250	840	○	○	○	○	○	○	○	○	○	○	○	○		
	19		Ferritic		130	460	○	○	○	○	○	○	○	○	○	○	○	○		
20	Cast Iron - Malleable	Pearlitic		230	780	○	○	○	○	○	○	○	○	○	○	○	○			
N	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210			●	○					●	●	○	●		
	22		Heat Treatable	AH	100	360			●	○					●	●	○	●		
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270			○	○					○	○	○	○		
	24		Heat Treatable	AH	90	320			○	○					○	○	○	○		
	25	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460			○	○					○	○	○	○		
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390			○	○					○	○	○	○		
	27		Brass (CuZn, CuSnZn)		90	320			○	○					○	○	○	○		
	28		Bronze (CuSn)		100	360			○	○					○	○	○	○		
	29	Non-metallic - Thermosetting & fiber-reinforced plastics																		
30	Non-metallic - Hard rubber, wood etc.																			
S	31	High temp. alloys	Fe based	A	200	680			○	○	○			○	○		○			
	32			AH	280	950			○	○	○			○	○		○			
	33		Ni / Co based	A	250	840			○	○	○				○	○		○		
	34			AH	350	1180			○	○	○				○	○		○		
	35			C	320	1080			○	○	○				○	○		○		
	36	Titanium & Ti alloys	CP Titanium		400 MPa				○	○	○				○	○		○		
	37.1		Alpha alloys		860 MPa				○	○	○				○	○		○		
37.2	Alpha / Beta alloys		A	960 MPa					○	○	○				○	○		○		
37.3			AH	1170 MPa					○	○	○				○	○		○		
37.4	Beta alloys		A	830 MPa					○	○	○				○	○		○		
37.5	AH	1400 MPa						○	○	○				○	○		○			
H	38.1	Hardened steel		HT	45 HRC													○		
	38.2			HT	55 HRC															
	39.1			HT	58 HRC															
	39.2			HT	62 HRC															
	40	Cast Iron	Chilled	C	400	1350									○	●	○	●		
41	HT			55 HRC																

Condition: A (Annealed), AH (Age Hardened), C (Cast), HT (Hardened & Tempered), QT (Quenched & Tempered)

● Optimal ○ Effective



Page

Page	291	292	293	294	295	296	297	298	299
Catalogue Code	E310	E459	E462	E348	E434	E562	E564	E566	E568
Type of Cut:									
Slotting	●	●	●			●	●		
Finishing				●	●				
Universal	●	●	●	●	●	●	●	●	●
Roughing	●								
Profiling				●					
Material	VHM	VHM-ULTRA	VHM	VHM	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA	VHM-ULTRA
Surface Finish	Brt	HELICA	TIAIN	TIAIN	AICrN	AICrN	Aldura	Aldura	Aldura
Sutton Designation	AI	VA	VA	NH	NH	NH	VH	VH	VH
Standard	DIN 6527L			-	-	DIN 6527L			
Shank Tolerance	h6			-	h5	h6			

ISO	VDI	Material Group	Sutton
P	A	Steel	N
M	R	Stainless Steel	VA
K	F	Cast Iron	GG
N	N	Non-Ferrous Metals, Aluminiums & Coppers	AI W
S	S	Titaniums & Super Alloys	TI
H	H	Hard Materials (≥ 45 HRC)	H

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.

ISO	VDI ³³²³	Material	Condition	HB	N/mm ²							VDI ³³²³	ISO			
P	1	Steel - Non-alloy, cast & free cutting		~ 0.15 %C	A	125	440					○	1			
	2			~ 0.45 %C	A	190	640					○	2			
	3				QT	250	840					●	3			
	4			~ 0.75 %C	A	270	910					●	4			
	5				QT	300	1010			●	●	●	●	5		
	6	Steel - Low alloy & cast < 5% of alloying elements		A	180	610					○		6			
	7			QT	275	930					●		7			
	8			QT	300	1010			●	●	●	●	8			
	9			QT	350	1180			●	●	●	●	9			
	10	Steel - High alloy, cast & tool		A	200	680					●		10			
	11			HT	325	1100			●	●	●	●	11			
12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680			○				12				
13			QT	240	810			○		●	●	13				
M	14.1	Stainless Steel	Austenitic	AH	180	610			●	●			14.1			
	14.2			Duplex	250	840			●	●			14.2			
	14.3			Precipitation Hardening	250	840			●	●			14.3			
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610				●			15			
	16			Pearlitic	260	880			●	●	●		16			
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570			●	●			17			
	18			Pearlitic	250	840			●	●	●		18			
	19			Cast Iron - Malleable	Ferritic		130	460			●				19	
20	Pearlitic	230	780					●				20				
N	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210	●						21			
	22			Heat Treatable	AH	100	360	●					22			
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270	●						23			
	24			Heat Treatable	AH	90	320	●					24			
	25	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460	●						25			
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390	●							26		
	27			Brass (CuZn, CuSnZn)	90	320	●							27		
	28			Bronze (CuSn)	100	360	●							28		
	29	Non-metallic - Thermosetting & fiber-reinforced plastics												29		
30	Non-metallic - Hard rubber, wood etc.												30			
S	31	High temp. alloys	Fe based	A	200	680			○	○				31		
	32			AH	280	950			●	●		○	●	●	32	
	33		Ni / Co based		A	250	840			○	○				33	
	34				AH	350	1180			●	●	●	●	●	●	34
	35				C	320	1080			●	●	○	○	●	●	35
	36	Titanium & Ti alloys	CP Titanium		400 MPa				○	○					36	
	37.1			Alpha alloys	860 MPa					●	●					37.1
	37.2			Alpha / Beta alloys	A	960 MPa					●	●				37.2
37.3	AH				1170 MPa					●	●				37.3	
37.4	Beta alloys			A	830 MPa					○	○	●	●		37.4	
37.5		AH	1400 MPa					○	○	●	●		37.5			
H	38.1	Hardened steel		HT	45 HRC					●	●	○	○		38.1	
	38.2			HT	55 HRC						●		●	●	38.2	
	39.1			HT	58 HRC						○		●	●	39.1	
	39.2			HT	62 HRC								●	●	39.2	
	40	Cast Iron	Chilled	C	400	1350				●	●	●			40	
41	HT			55 HRC						○		●	●	41		

Condition: A (Annealed), AH (Age Hardened), C (Cast), HT (Hardened & Tempered), QT (Quenched & Tempered)

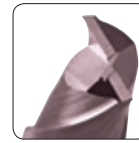
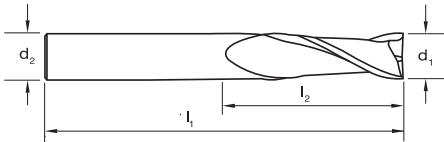
● Optimal ○ Effective

Slot Drills Carbide, 2 Flute, R30 N, Regular

suttontools

TECLINE

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



Catalogue Code	E600	E603
Discount Group	B0212	B0214
Material	VHM	VHM
Surface Finish	Brt	TiAlN
Sutton Designation	N	N
Geometry	R30	R30
Shank Form (DIN 6535)	HA	HA
Shank Tolerance	h6	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #	Item #
0100	1.0	38	4	3	2	E600 0100	E603 0100
0150	1.5	38	4.5	3	2	E600 0150	E603 0150
0200	2.0	38	6	3	2	E600 0200	E603 0200
0250	2.5	38	9.5	3	2	E600 0250	E603 0250
0300	3.0	38	12	3	2	E600 0300	E603 0300
0350	3.5	50	12	4	2	E600 0350	E603 0350
0400	4.0	50	14	4	2	E600 0400	E603 0400
0450	4.5	50	16	6	2	E600 0450	E603 0450
0500	5.0	50	16	6	2	E600 0500	E603 0500
0600	6.0	50	19	6	2	E600 0600	E603 0600
0700	7.0	63	19	8	2	E600 0700	E603 0700
0800	8.0	63	20	8	2	E600 0800	E603 0800
0900	9.0	75	22	10	2	E600 0900	E603 0900
1000	10.0	75	22	10	2	E600 1000	E603 1000
1100	11.0	75	25	12	2	E600 1100	E603 1100
1200	12.0	75	25	12	2	E600 1200	E603 1200
1400	14.0	89	32	14	2	E600 1400	E603 1400
1600	16.0	89	32	16	2	E600 1600	E603 1600
1800	18.0	100	38	18	2	E600 1800	E603 1800
2000	20.0	100	38	20	2	E600 2000	E603 2000
2500	25.0	100	38	25	2	E600 2500	E603 2500
						E304	E307
0159	1/16	1-1/2	3/16	1/8	2	E304 0159	E307 0159
0238	3/32	1-1/2	5/16	1/8	2	E304 0238	E307 0238
0318	1/8	1-1/2	1/2	1/8	2	E304 0318	E307 0318
0397	5/32	2	9/16	3/16	2	E304 0397	E307 0397
0476	3/16	2	5/8	3/16	2	E304 0476	E307 0476
0556	7/32	2-1/2	5/8	1/4	2	E304 0556	E307 0556
0635	1/4	2-1/2	3/4	1/4	2	E304 0635	E307 0635
0794	5/16	2-1/2	13/16	5/16	2	E304 0794	E307 0794
0953	3/8	2-1/2	7/8	3/8	2	E304 0953	E307 0953
1111	7/16	2-3/4	1	7/16	2	E304 1111	E307 1111
1270	1/2	3	1	1/2	2	E304 1270	E307 1270
1588	5/8	3-1/2	1-1/4	5/8	2	E304 1588	E307 1588
1905	3/4	4	1-1/2	3/4	2	E304 1905	E307 1905
2223	7/8	4	1-1/2	7/8	2	E304 2223	E307 2223
2540	1	4	1-1/2	1	2	E304 2540	E307 2540

ISO	P										M					K					N										S										H														
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41						
E600	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
E603	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

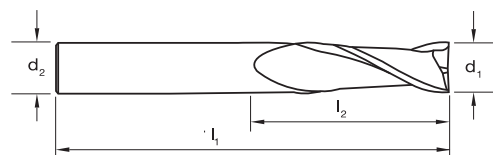
● Optimal ○ Effective

Slot Drills Carbide, 2 Flute, R30 N, Long

suttontools

TECLINE

- For long reach milling of slots & cavities
- Suitable for materials up to 1300 N/mm²



Catalogue Code	E308
Discount Group	B0208
Material	VHM
Surface Finish	Brt
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	60	19	3	2	E308 0300
0400	4.0	60	19	4	2	E308 0400
0500	5.0	60	25	5	2	E308 0500
0600	6.0	75	31	6	2	E308 0600
0800	8.0	75	31	8	2	E308 0800
1000	10.0	75	31	10	2	E308 1000
1200	12.0	100	50	12	2	E308 1200
1400	14.0	125	57	14	2	E308 1400
1600	16.0	125	57	16	2	E308 1600
1800	18.0	125	57	18	2	E308 1800
2000	20.0	125	57	20	2	E308 2000

ISO	P													M		K						N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E308	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○						

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

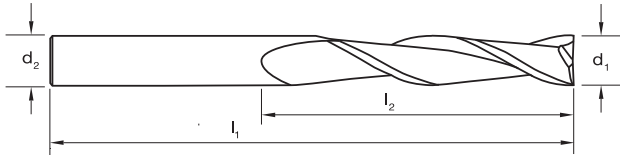
● Optimal ○ Effective

Slot Drills Carbide, 2 Flute, R30N, Extra Long

suttontools

TECLINE

- For extra long reach milling of slots & cavities
- Suitable for materials up to 1300 N/mm²



Catalogue Code	E309
Discount Group	B0208
Material	VHM
Surface Finish	BrT
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	76	25	3	2	E309 0300
0400	4.0	76	28	4	2	E309 0400
0500	5.0	76	32	5	2	E309 0500
0600	6.0	102	38	6	2	E309 0600
0800	8.0	102	42	8	2	E309 0800
1000	10.0	102	45	10	2	E309 1000
1200	12.0	153	76	12	2	E309 1200
1400	14.0	153	76	14	2	E309 1400
1600	16.0	153	76	16	2	E309 1600
1800	18.0	153	76	18	2	E309 1800
2000	20.0	153	76	20	2	E309 2000

ISO	P								M				K				N								S								H																	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41	
E309	●	●	○	○	○	●	○							○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																		

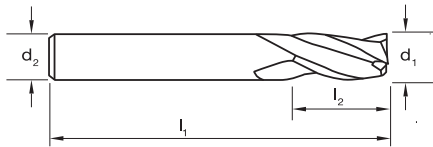
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials ● Optimal ○ Effective

Endmills Carbide, 3 Flute, R30N

suttontools

TECLINE

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



Catalogue Code	E513	E515
Discount Group	B0208	B0210
Material	VHM	VHM
Surface Finish	BrT	TiAlN
Sutton Designation	N	N
Geometry	R30	R30
Shank Form (DIN 6535)	HA	HA
Shank Tolerance	h6	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #	Item #
0300	3.0	57	7	6	3	E513 0300	E515 0300
0400	4.0	57	8	6	3	E513 0400	E515 0400
0500	5.0	57	10	6	3	E513 0500	E515 0500
0600	6.0	57	10	6	3	E513 0600	E515 0600
0700	7.0	63	13	8	3	E513 0700	E515 0700
0800	8.0	63	16	8	3	E513 0800	E515 0800
0900	9.0	72	16	10	3	E513 0900	E515 0900
1000	10.0	72	19	10	3	E513 1000	E515 1000
1200	12.0	83	22	12	3	E513 1200	E515 1200
1400	14.0	83	22	14	3	E513 1400	E515 1400
1600	16.0	92	26	16	3	E513 1600	E515 1600
1800	18.0	92	26	18	3	E513 1800	E515 1800
2000	20.0	104	32	20	3	E513 2000	E515 2000

ISO	P													M			K						N										S										H													
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41							
E513	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●											●	●	●	●	●	●	●	●	●	●	●	●												
E515	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●											●	●	●	●	●	●	●	●	●	●	●	●												

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

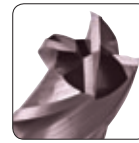
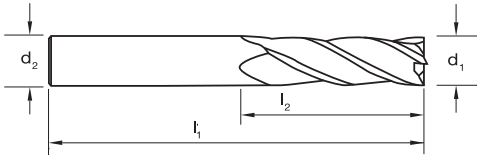
● Optimal ○ Effective

Endmills Carbide, 4 Flute, R30 N, Regular

suttontools

TECLINE

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



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

E601	E604
B0212	B0214
VHM	VHM
Brt	TiAlN
N	N
R30	R30
HA	HA
h6	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #	Item #
0100	1.0	38	4	3	4	E601 0100	E604 0100
0150	1.5	38	4.5	3	4	E601 0150	E604 0150
0200	2.0	38	6	3	4	E601 0200	E604 0200
0250	2.5	38	9.5	3	4	E601 0250	E604 0250
0300	3.0	38	12	3	4	E601 0300	E604 0300
0400	4.0	50	14	4	4	E601 0400	E604 0400
0500	5.0	50	16	6	4	E601 0500	E604 0500
0600	6.0	50	19	6	4	E601 0600	E604 0600
0700	7.0	63	19	8	4	E601 0700	E604 0700
0800	8.0	63	20	8	4	E601 0800	E604 0800
0900	9.0	75	22	10	4	E601 0900	E604 0900
1000	10.0	75	22	10	4	E601 1000	E604 1000
1100	11.0	75	25	12	4	E601 1100	E604 1100
1200	12.0	75	25	12	4	E601 1200	E604 1200
1400	14.0	89	32	14	4	E601 1400	E604 1400
1600	16.0	89	32	16	4	E601 1600	E604 1600
1800	18.0	100	38	18	4	E601 1800	E604 1800
2000	20.0	100	38	20	4	E601 2000	E604 2000
2500	25.0	100	38	25	4	E601 2500	E604 2500
						E333	E336
0159	1/16	1-1/2	3/16	1/8	4	E333 0159	E336 0159
0238	3/32	1-1/2	5/16	1/8	4	E333 0238	E336 0238
0318	1/8	1-1/2	1/2	1/8	4	E333 0318	E336 0318
0397	5/32	2	9/16	5/32	4	E333 0397	E336 0397
0476	3/16	2	5/8	3/16	4	E333 0476	E336 0476
0556	7/32	2-1/2	5/8	7/32	4	E333 0556	E336 0556
0635	1/4	2-1/2	3/4	1/4	4	E333 0635	E336 0635
0794	5/16	2-1/2	13/16	5/16	4	E333 0794	E336 0794
0953	3/8	2-1/2	7/8	3/8	4	E333 0953	E336 0953
1270	1/2	3	1	1/2	4	E333 1270	E336 1270
1588	5/8	3-1/2	1-1/4	5/8	4	E333 1588	E336 1588
1905	3/4	4	1-1/2	3/4	4	E333 1905	E336 1905

ISO	P										M			K				N										S							H																					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41							
E601	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
E604	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

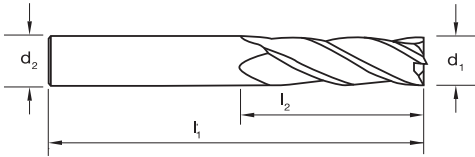
● Optimal ○ Effective

Endmills Carbide, 4 Flute, R30N, Long

suttontools

TECLINE

- For long-reach finish milling applications
- Suitable for materials up to 1300 N/mm²
- TiAlN for longer tool life



Catalogue Code	E337	E340
Discount Group	B0202	B0204
Material	VHM	VHM
Surface Finish	BrT	TiAlN
Sutton Designation	N	N
Geometry	R30	R30
Shank Form (DIN 6535)	HA	HA
Shank Tolerance	h6	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #	Item #
0300	3.0	60	19	3	4	E337 0300	E340 0300
0400	4.0	60	19	4	4	E337 0400	E340 0400
0500	5.0	60	19	5	4	E337 0500	E340 0500
0600	6.0	75	31	6	4	E337 0600	E340 0600
0800	8.0	75	31	8	4	E337 0800	E340 0800
1000	10.0	75	31	10	4	E337 1000	E340 1000
1200	12.0	100	50	12	4	E337 1200	E340 1200
1400	14.0	125	57	14	4	E337 1400	E340 1400
1600	16.0	125	57	16	4	E337 1600	E340 1600
1800	18.0	125	57	18	4	E337 1800	E340 1800
2000	20.0	125	57	20	4	E337 2000	E340 2000
0318	1/8	2-1/4	3/4	1/8	4	E337 0318	E340 0318
0635	1/4	3	1-1/8	1/4	4	E337 0635	E340 0635
0794	5/16	3	1-1/8	5/16	4	E337 0794	E340 0794
0953	3/8	3	1-1/8	3/8	4	E337 0953	E340 0953
1270	1/2	4	2	1/2	4	E337 1270	E340 1270
1588	5/8	5	2-1/4	5/8	4	E337 1588	E340 1588
1905	3/4	5	2-1/4	3/4	4	E337 1905	E340 1905

ISO	P										M			K							N										S										H												
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41				
E337	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
E340	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

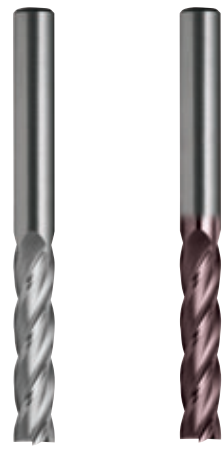
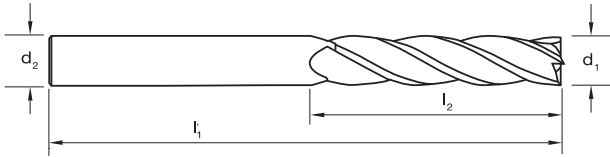
● Optimal ○ Effective

Endmills Carbide, 4 Flute, R30 N, Extra Long

suttontools



- For extra long-reach finish milling applications
- Suitable for materials up to 1300 N/mm²
- TiAlN for longer tool life



Catalogue Code	E341	E344
Discount Group	B0208	B0210
Material	VHM	VHM
Surface Finish	BrT	TiAlN
Sutton Designation	N	N
Geometry	R30	R30
Shank Form (DIN 6535)	HA	HA
Shank Tolerance	h6	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #	Item #
0300	3.0	75	25	3	4	E341 0300	E344 0300
0400	4.0	75	28	4	4	E341 0400	E344 0400
0500	5.0	75	32	5	4	E341 0500	E344 0500
0600	6.0	100	38	6	4	E341 0600	E344 0600
0800	8.0	100	41	8	4	E341 0800	E344 0800
1000	10.0	100	44	10	4	E341 1000	E344 1000
1200	12.0	150	75	12	4	E341 1200	E344 1200
1400	14.0	150	75	14	4	E341 1400	E344 1400
1600	16.0	150	75	16	4	E341 1600	E344 1600
1800	18.0	150	75	18	4	E341 1800	E344 1800
2000	20.0	150	75	20	4	E341 2000	E344 2000

ISO	P											M			K					N										S										H														
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41					
E341	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
E344	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials

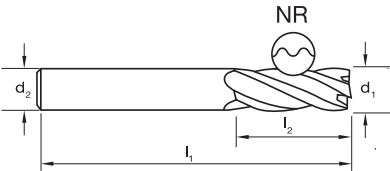
● Optimal ○ Effective

Roughers Carbide, NR (normal), R30 N

suttontools

TECLINE

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



Size Ref.	d ₁ (js14)	l ₁	l ₂	d ₂	z	Item #
0400	4.0	57	11	6	3	E547 0400
0500	5.0	57	13	6	3	E547 0500
0600	6.0	57	13	6	3	E547 0600
0800	8.0	63	19	8	3	E547 0800
1000	10.0	72	22	10	4	E547 1000
1200	12.0	83	26	12	4	E547 1200
1600	16.0	92	32	16	4	E547 1600
2000	20.0	104	38	20	4	E547 2000



Catalogue Code	E547
Discount Group	B0210
Material	VHM
Surface Finish	TiAlN
Sutton Designation	N
Geometry	R30 NR
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E547	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

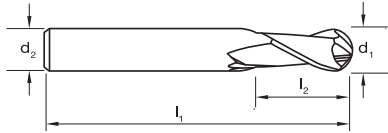
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials ● Optimal ○ Effective

Slot Drills Carbide, Ballnose, 2 Flute, R30 N, Regular

suttontools

TECLINE

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



Catalogue Code	E602	E605
Discount Group	B0212	B0214
Material	VHM	VHM
Surface Finish	BrT	TiAlN
Sutton Designation	N	N
Geometry	R30	R30
Shank Form (DIN 6535)	HA	HA
Shank Tolerance	h6	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #	Item #
0100	1.0	38	4	3	2	E602 0100	E605 0100
0150	1.5	38	4.5	3	2	E602 0150	E605 0150
0200	2.0	38	6	3	2	E602 0200	E605 0200
0250	2.5	38	9.5	3	2	E602 0250	E605 0250
0300	3.0	38	12	3	2	E602 0300	E605 0300
0350	3.5	50	12	4	2	E602 0350	E605 0350
0400	4.0	50	14	4	2	E602 0400	E605 0400
0500	5.0	50	16	6	2	E602 0500	E605 0500
0600	6.0	50	19	6	2	E602 0600	E605 0600
0700	7.0	63	19	8	2	E602 0700	E605 0700
0800	8.0	63	20	8	2	E602 0800	E605 0800
0900	9.0	75	20	10	2	E602 0900	E605 0900
1000	10.0	75	22	10	2	E602 1000	E605 1000
1100	11.0	75	25	12	2	E602 1100	E605 1100
1200	12.0	75	25	12	2	E602 1200	E605 1200
1400	14.0	89	32	14	2	E602 1400	E605 1400
1600	16.0	89	32	16	2	E602 1600	E605 1600
1800	18.0	100	38	18	2	E602 1800	E605 1800
2000	20.0	100	38	20	2	E602 2000	E605 2000
2500	25.0	100	38	25	2	E602 2500	E605 2500
						E311	E314
0159	1/16	1-1/2	3/16	1/8	2	E311 0159	E314 0159
0238	3/32	1-1/2	5/16	1/8	2	E311 0238	E314 0238
0318	1/8	1-1/2	1/2	1/8	2	E311 0318	E314 0318
0397	5/32	2	9/16	3/16	2	E311 0397	E314 0397
0476	3/16	2	5/8	3/16	2	E311 0476	E314 0476
0635	1/4	2-1/2	3/4	1/4	2	E311 0635	E314 0635
0794	5/16	2-1/2	13/16	5/16	2	E311 0794	E314 0794
0953	3/8	2-1/2	7/8	3/8	2	E311 0953	E314 0953
1111	7/16	2-3/4	1	7/16	2	E311 1111	E314 1111
1270	1/2	3	1	1/2	2	E311 1270	E314 1270
1588	5/8	3-1/2	1-1/4	5/8	2	E311 1588	E314 1588
1905	3/4	4	1-1/2	3/4	2	E311 1905	E314 1905

ISO	P											M			K							N										S													H						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41		
E602	●	●	●	●	●	●	○							○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○			
E605	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○			

P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials

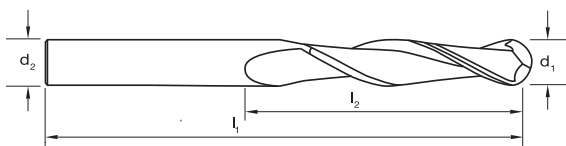
● Optimal
 ○ Effective

Slot Drills Carbide, Ballnose, 2 Flute, R30 N, Extra Long

suttontools

TECLINE

- For profile & contour milling in extra long reach applications
- Suitable for materials up to 1300 N/mm²



Catalogue Code	E315
Discount Group	B0208
Material	VHM
Surface Finish	Brt
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	76	25	3	2	E315 0300
0400	4.0	76	28	4	2	E315 0400
0500	5.0	76	32	5	2	E315 0500
0600	6.0	102	38	6	2	E315 0600
0800	8.0	102	42	8	2	E315 0800
1000	10.0	102	45	10	2	E315 1000
1200	12.0	153	76	12	2	E315 1200
1400	14.0	153	76	14	2	E315 1400
1600	16.0	153	76	16	2	E315 1600
1800	18.0	153	76	18	2	E315 1800
2000	20.0	153	76	20	2	E315 2000

ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E315	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

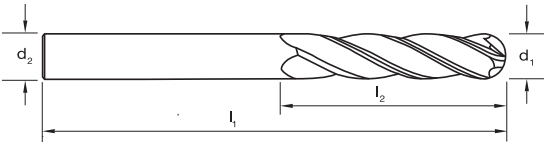
● Optimal ○ Effective

Endmills Carbide, Ballnose, 4 Flute, R30N, Extra Long

suttontools

TECLINE

- For profile & contour milling in extra long reach applications
- Suitable for materials up to 1300 N/mm²
- Minimal deflection due to strong/larger core



Catalogue Code	E320
Discount Group	B0208
Material	VHM
Surface Finish	Brt
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	76	25	3	4	E320 0300
0400	4.0	76	28	4	4	E320 0400
0500	5.0	76	32	5	4	E320 0500
0600	6.0	102	38	6	4	E320 0600
0800	8.0	102	42	8	4	E320 0800
1000	10.0	102	45	10	4	E320 1000
1200	12.0	153	76	12	4	E320 1200
1400	14.0	153	76	14	4	E320 1400
1600	16.0	153	76	16	4	E320 1600
1800	18.0	153	76	18	4	E320 1800
2000	20.0	153	76	20	4	E320 2000

ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E320	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

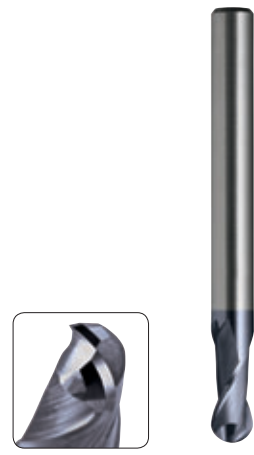
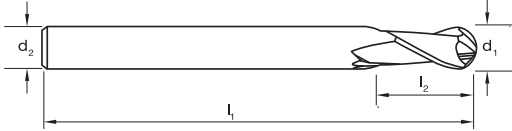
● Optimal ○ Effective

Slot Drills Carbide, Ballnose, 2 Flute, R30UNI, Long Reach

suttontools

TECLINE

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



Catalogue Code	E555
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	UNI
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #
0200	2.0	50	5	6	2	E555 0200
0300	3.0	60	8	6	2	E555 0300
0400	4.0	70	8	6	2	E555 0400
0500	5.0	80	10	6	2	E555 0500
0600	6.0	90	12	6	2	E555 0600
0800	8.0	100	14	8	2	E555 0800
1000	10.0	100	18	10	2	E555 1000
1200	12.0	110	22	12	2	E555 1200

ISO	P										M					K					N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41	
E555	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

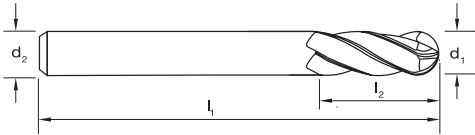
● Optimal ○ Effective

Endmills Carbide, Ballnose, 4 Flute, R30UNI, Long Reach

suttontools

TECLINE

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



Catalogue Code	E557
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	UNI
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #
0200	2.0	50	5	6	4	E557 0200
0300	3.0	60	8	6	4	E557 0300
0400	4.0	70	8	6	4	E557 0400
0500	5.0	80	10	6	4	E557 0500
0600	6.0	90	12	6	4	E557 0600
0800	8.0	100	14	8	4	E557 0800
1000	10.0	100	18	10	4	E557 1000
1200	12.0	110	22	12	4	E557 1200
1400	14.0	110	26	14	4	E557 1400
1600	16.0	140	30	16	4	E557 1600
1800	18.0	140	34	16	4	E557 1800
2000	20.0	160	38	20	4	E557 2000

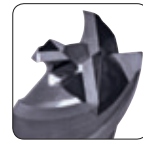
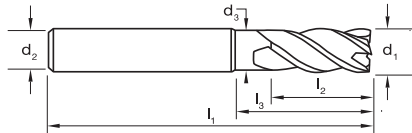
ISO	P													M			K						N										S										H													
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41							
E557	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective



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



Catalogue Code	E535
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	UNI
Geometry	R35 / 38
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

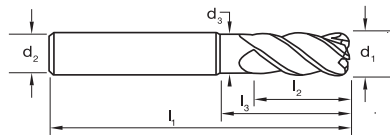
Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item #
0300	3.0	57	8	19	6	2.8	4	E535 0300
0400	4.0	57	11	19	6	3.7	4	E535 0400
0500	5.0	57	13	20	6	4.6	4	E535 0500
0600	6.0	57	13	21	6	5.5	4	E535 0600
0800	8.0	63	19	27	8	7.5	4	E535 0800
1000	10.0	72	22	32	10	9.5	4	E535 1000
1200	12.0	83	26	38	12	11.2	4	E535 1200
1400	14.0	83	26	38	14	13.0	4	E535 1400
1600	16.0	92	32	44	16	15.0	4	E535 1600
1800	18.0	92	32	44	18	17.0	4	E535 1800
2000	20.0	104	38	54	20	19.0	4	E535 2000
2500	25.0	120	45	64	25	24.0	4	E535 2500

ISO	P										M	K										N										S										H											
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41				
E535	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

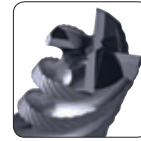
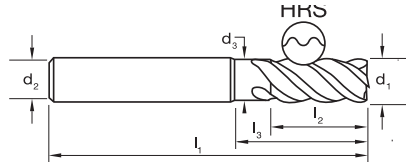
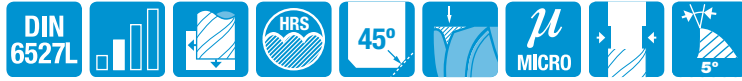
E559
B0210
VHM-ULTRA
AlCrN
UNI
R35 / 38
HA
h6

Size Ref.	d ₁ (h10)	L ₁	L ₂	L ₃	d ₂	d ₃	z	rad	Item #
0303	3.0	57	8	19	6	3.7	4	0.3	E559 0303
0305		57	8	19	6	3.7	4	0.5	E559 0305
0403	4.0	57	11	19	6	3.7	4	0.3	E559 0403
0405		57	11	19	6	3.7	4	0.5	E559 0405
0410		57	11	19	6	3.7	4	1.0	E559 0410
0503	5.0	57	13	20	6	4.6	4	0.3	E559 0503
0505		57	13	20	6	4.6	4	0.5	E559 0505
0510		57	13	20	6	4.6	4	1.0	E559 0510
0603	6.0	57	13	21	6	5.5	4	0.3	E559 0603
0605		57	13	21	6	5.5	4	0.5	E559 0605
0610		57	13	21	6	5.5	4	1.0	E559 0610
0803	8.0	63	19	27	8	7.5	4	0.3	E559 0803
0805		63	19	27	8	7.5	4	0.5	E559 0805
0810		63	19	27	8	7.5	4	1.0	E559 0810
0815		63	19	27	8	7.5	4	1.5	E559 0815
0820		63	19	27	8	7.5	4	2.0	E559 0820
1003	10.0	72	22	32	10	9.5	4	0.3	E559 1003
1005		72	22	32	10	9.5	4	0.5	E559 1005
1010		72	22	32	10	9.5	4	1.0	E559 1010
1015		72	22	32	10	9.5	4	1.5	E559 1015
1020		72	22	32	10	9.5	4	2.0	E559 1020
1203	12.0	83	26	38	12	11.2	4	0.3	E559 1203
1205		83	26	38	12	11.2	4	0.5	E559 1205
1210		83	26	38	12	11.2	4	1.0	E559 1210
1215		83	26	38	12	11.2	4	1.5	E559 1215
1220		83	26	38	12	11.2	4	2.0	E559 1220
1230		83	26	38	12	11.2	4	3.0	E559 1230
1605	16.0	92	32	44	16	15.0	4	0.5	E559 1605
1610		92	32	44	16	15.0	4	1.0	E559 1610
1615		92	32	44	16	15.0	4	1.5	E559 1615
1620		92	32	44	16	15.0	4	2.0	E559 1620
1630		92	32	44	16	15.0	4	3.0	E559 1630
2005	20.0	104	38	54	20	19.0	4	0.5	E559 2005
2010		104	38	54	20	19.0	4	1.0	E559 2010
2015		104	38	54	20	19.0	4	1.5	E559 2015
2020		104	38	54	20	19.0	4	2.0	E559 2020
2030		104	38	54	20	19.0	4	3.0	E559 2030

ISO	P										M					K					N					S										H													
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E559	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	P	Steel	M	Stainless Steel	K	Cast Iron	N	Non-Ferrous Metals	S	Titanium & Super Alloys	H	Hard Materials																																					

● Optimal ○ Effective

- 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/mm²
- AlCrN for longer tool life



Catalogue Code	E549
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	UNI
Geometry	R45 HRS
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item #
0400	4.0	57	11	19	6	3.7	3	E549 0400
0500	5.0	57	13	20	6	4.6	4	E549 0500
0600	6.0	57	16	21	6	5.5	4	E549 0600
0800	8.0	63	19	27	8	7.5	4	E549 0800
1000	10.0	72	22	32	10	9.5	4	E549 1000
1200	12.0	83	26	38	12	11.2	4	E549 1200
1600	16.0	92	32	44	16	15.0	5	E549 1600
2000	20.0	104	38	54	20	19.0	6	E549 2000

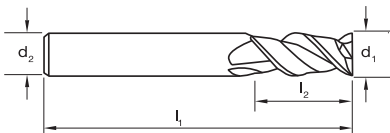
ISO	P													M			K							N										S										H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E549	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

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

suttontools

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

DIN 6527L



Catalogue Code

E310

Discount Group

B0208

Material

VHM

Surface Finish

BrT

Sutton Designation

AI

Geometry

R40

Shank Form (DIN 6535)

HA

Shank Tolerance

h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	d ₂	z	Item #
0300	3.0	57	8	6	2	E310 0300
0400	4.0	57	11	6	2	E310 0400
0500	5.0	57	13	6	2	E310 0500
0600	6.0	57	13	6	2	E310 0600
0800	8.0	63	19	8	2	E310 0800
1000	10.0	72	22	10	2	E310 1000
1200	12.0	83	26	12	2	E310 1200
1600	16.0	92	32	16	2	E310 1600
2000	20.0	104	38	20	2	E310 2000

ISO	P											M			K							N							S										H														
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41				
E310																							●	●	●	●	●	●	●	●																							

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

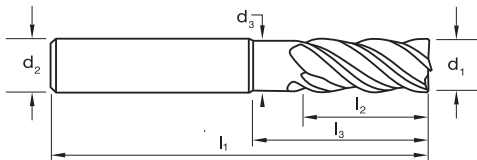
● Optimal ○ Effective

Endmills Carbide, 4 Flute, R40/42VA, Cnr Rad, Harmony



suttontools **HARMONY**

- Excellent solution for stainless steels & difficult super alloy type materials
- Optimised geometry with variable helix design ensures high productivity
- Suitable for slotting, side cutting and finishing applications with the one tool
- HELICA for outstanding oxidation resistance and hot hardness
- VHM-ULTRA grade of carbide for high performance



Catalogue Code	E462
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	HELICA
Sutton Designation	VA
Geometry	R40/42
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

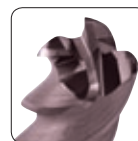
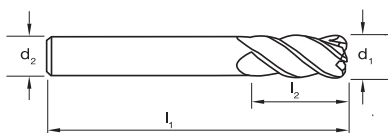
Size Ref.	d ₁ (e8)	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad	Item #
0603	6.0	57	13	21	6	5.5	4	0.3	E462 0603
0605		57	13	21	6	5.5	4	0.5	E462 0605
0610		57	13	21	6	5.5	4	1.0	E462 0610
0803	8.0	63	19	27	8	7.5	4	0.3	E462 0803
0805		63	19	27	8	7.5	4	0.5	E462 0805
0810		63	19	27	8	7.5	4	1.0	E462 0810
0815		63	19	27	8	7.5	4	1.5	E462 0815
0820		63	19	27	8	7.5	4	2.0	E462 0820
1003	10.0	72	22	32	10	9.5	4	0.3	E462 1003
1005		72	22	32	10	9.5	4	0.5	E462 1005
1010		72	22	32	10	9.5	4	1.0	E462 1010
1015		72	22	32	10	9.5	4	1.5	E462 1015
1020		72	22	32	10	9.5	4	2.0	E462 1020
1203	12.0	83	26	38	12	11.2	4	0.3	E462 1203
1205		83	26	38	12	11.2	4	0.5	E462 1205
1210		83	26	38	12	11.2	4	1.0	E462 1210
1215		83	26	38	12	11.2	4	1.5	E462 1215
1220		83	26	38	12	11.2	4	2.0	E462 1220
1230		83	26	38	12	11.2	4	3.0	E462 1230
1605	16.0	92	32	44	16	15.0	4	0.5	E462 1605
1610		92	32	44	16	15.0	4	1.0	E462 1610
1615		92	32	44	16	15.0	4	1.5	E462 1615
1620		92	32	44	16	15.0	4	2.0	E462 1620
1630		92	32	44	16	15.0	4	3.0	E462 1630
2005	20.0	104	38	54	20	19.0	4	0.5	E462 2005
2010		104	38	54	20	19.0	4	1.0	E462 2010
2015		104	38	54	20	19.0	4	1.5	E462 2015
2020		104	38	54	20	19.0	4	2.0	E462 2020
2030		104	38	54	20	19.0	4	3.0	E462 2030

ISO	P												M				K				N										S										H										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41		
E462													○	●	●	●	●																					○		○	○	○	○	○	○						

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

suttontools

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



Catalogue Code	E348
Discount Group	B0210
Material	VHM
Surface Finish	TiAlN
Sutton Designation	NH
Geometry	R40
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ (e8)	l ₁	l ₂	d ₂	z	rad	Item #
0303	3.0	40	9	3	4	0.3	E348 0303
0305		40	9	3	4	0.5	E348 0305
0403	4.0	50	12	4	4	0.3	E348 0403
0405		50	12	4	4	0.5	E348 0405
0410		50	12	4	4	1.0	E348 0410
0503	5.0	50	15	5	4	0.3	E348 0503
0505		50	15	5	4	0.5	E348 0505
0510		50	15	5	4	1.0	E348 0510
0603	6.0	60	20	6	4	0.3	E348 0603
0605		60	20	6	4	0.5	E348 0605
0610		60	20	6	4	1.0	E348 0610
0803	8.0	64	20	8	4	0.3	E348 0803
0805		64	20	8	4	0.5	E348 0805
0810		64	20	8	4	1.0	E348 0810
0815		64	20	8	4	1.5	E348 0815
0820		64	20	8	4	2.0	E348 0820
1003	10.0	70	22	10	4	0.3	E348 1003
1005		70	22	10	4	0.5	E348 1005
1010		70	22	10	4	1.0	E348 1010
1015		70	22	10	4	1.5	E348 1015
1020		70	22	10	4	2.0	E348 1020
1203	12.0	75	25	12	4	0.3	E348 1203
1205		75	25	12	4	0.5	E348 1205
1210		75	25	12	4	1.0	E348 1210
1215		75	25	12	4	1.5	E348 1215
1220		75	25	12	4	2.0	E348 1220
1230		75	25	12	4	3.0	E348 1230
1605	16.0	90	32	16	4	0.5	E348 1605
1610		90	32	16	4	1.0	E348 1610
1615		90	32	16	4	1.5	E348 1615
1620		90	32	16	4	2.0	E348 1620
1630		90	32	16	4	3.0	E348 1630
2005	20.0	100	38	20	4	0.5	E348 2005
2010		100	38	20	4	1.0	E348 2010
2015		100	38	20	4	1.5	E348 2015
2020		100	38	20	4	2.0	E348 2020
2030		100	38	20	4	3.0	E348 2030

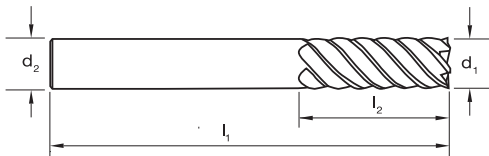
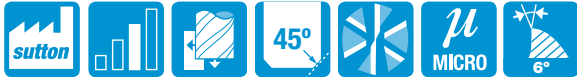
ISO	P													M				K				N										S										H										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41			
E348					●			●	●		●	●	●							●																	●					●	●									
P Steel	M Stainless Steel													K Cast Iron				N Non-Ferrous Metals										S Titanium & Super Alloys										H Hard Materials														

● Optimal ○ Effective



suttontools HARMONY

- VHM-ULTRA grade of carbide for high performance
- For super fine finishing applications
- 50/35° variable flute helix for chatter free milling
- Suitable for hard, short chipping materials up to 67HRc
- AlCrN for longer tool life



Catalogue Code	E434
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	NH
Geometry	R50/35
Shank Form (DIN 6535)	HA
Shank Tolerance	h5

Size Ref.	d ₁ (e8)	l ₁	l ₂	d ₂	z	Item #
0600	6.0	62	18	6	6	E434 0600
0800	8.0	68	24	8	6	E434 0800
1000	10.0	80	30	10	6	E434 1000
1200	12.0	93	36	12	6	E434 1200
1600	16.0	108	48	16	6	E434 1600
2000	20.0	126	60	20	8	E434 2000
2500	25.0	150	85	25	8	E434 2500

ISO	P												M			K						N						S						H															
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E434	○	○	○	○	○	○	○	○	○	○	○	○	○				●	●	●	●	●	●	●											○	○	○	○	○	○	○	○	○	○	○	○	○	○		

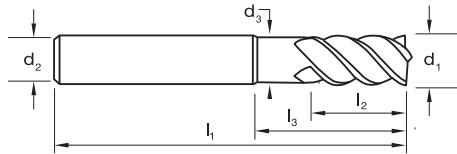
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials ● Optimal ○ Effective

Endmills Carbide, 4 Flute, R50 NH DUO, *Harmony*



suttontools **HARMONY**

- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for pocket milling in MQL & HSC
- Suitable for materials up to 48HRC
- AlCrN for longer tool life



Catalogue Code	E562
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	NH
Geometry	R50
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

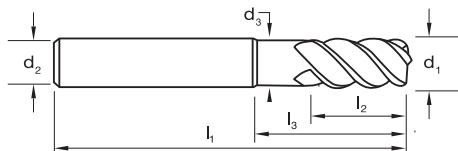
Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item #
0600	6.0	57	13	21	6	5.5	4	E562 0600
0800	8.0	63	19	27	8	7.5	4	E562 0800
1000	10.0	72	22	32	10	9.5	4	E562 1000
1200	12.0	83	26	38	12	11.2	4	E562 1200
1400	14.0	83	26	38	14	13.0	4	E562 1400
1600	16.0	92	32	44	16	15.0	4	E562 1600
2000	20.0	104	38	54	20	19.0	4	E562 2000

ISO	P													M			K					N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41	
E562					●			●	●	●				●	●	●	●	●	●	●	●												●	●	●	●	●	●	●	●	●	●	●	○						●

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



- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for pocket milling in MQL & HSC
- Suitable for materials up to 48HRc
- AlCrN for longer tool life



Catalogue Code	E564
Discount Group	B0210
Material	VHM-ULTRA
Surface Finish	AlCrN
Sutton Designation	NH
Geometry	R50
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Rad	Item #
0603	6.0	57	13	21	6	5.5	4	0.3	E564 0603
0605		57	13	21	6	5.5	4	0.5	E564 0605
0610		57	13	21	6	5.5	4	1.0	E564 0610
0803	8.0	63	19	27	8	7.5	4	0.3	E564 0803
0805		63	19	27	8	7.5	4	0.5	E564 0805
0810		63	19	27	8	7.5	4	1.0	E564 0810
0815		63	19	27	8	7.5	4	1.5	E564 0815
0820		63	19	27	8	7.5	4	2.0	E564 0820
1003	10.0	72	22	32	10	9.5	4	0.3	E564 1003
1005		72	22	32	10	9.5	4	0.5	E564 1005
1010		72	22	32	10	9.5	4	1.0	E564 1010
1015		72	22	32	10	9.5	4	1.5	E564 1015
1020		72	22	32	10	9.5	4	2.0	E564 1020
1203	12.0	83	26	38	12	11.2	4	0.3	E564 1203
1205		83	26	38	12	11.2	4	0.5	E564 1205
1210		83	26	38	12	11.2	4	1.0	E564 1210
1215		83	26	38	12	11.2	4	1.5	E564 1215
1220		83	26	38	12	11.2	4	2.0	E564 1220
1230		83	26	38	12	11.2	4	3.0	E564 1230
1403	14.0	83	26	38	14	13.0	4	0.3	E564 1403
1405		83	26	38	14	13.0	4	0.5	E564 1405
1410		83	26	38	14	13.0	4	1.0	E564 1410
1415		83	26	38	14	13.0	4	1.5	E564 1415
1420		83	26	38	14	13.0	4	2.0	E564 1420
1430		83	26	38	14	13.0	4	3.0	E564 1430
1605	16.0	92	32	44	16	15.0	4	0.5	E564 1605
1610		92	32	44	16	15.0	4	1.0	E564 1610
1615		92	32	44	16	15.0	4	1.5	E564 1615
1620		92	32	44	16	15.0	4	2.0	E564 1620
1630		92	32	44	16	15.0	4	3.0	E564 1630
1640		92	32	44	16	15.0	4	4.0	E564 1640
2005	20.0	104	38	54	20	19.0	4	0.5	E564 2005
2010		104	38	54	20	19.0	4	1.0	E564 2010
2015		104	38	54	20	19.0	4	1.5	E564 2015
2020		104	38	54	20	19.0	4	2.0	E564 2020
2030		104	38	54	20	19.0	4	3.0	E564 2030
2040		104	38	54	20	19.0	4	4.0	E564 2040

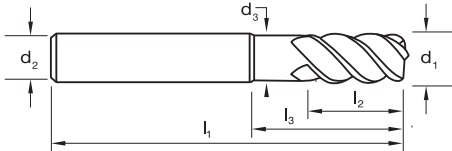
ISO	P													M			K			N							S					H																	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E564					●				●		●			●	●	●	●	●	●	●	●														●	●	●	●	●	●	○					●			

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

Endmills Carbide, 4 Flute, R50VH DUO, Cnr Rad, Harmony



- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal strength
- Ideal design for hard machining
- Suitable for materials up to 63HRc
- Aldura for longer tool life



Catalogue Code E568

Discount Group B0210

Material VHM-ULTRA

Surface Finish Aldura

Sutton Designation VH

Geometry R50

Shank Form (DIN 6535) HA

Shank Tolerance h6

Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Rad	Item #
0610	6.0	57	13	21	6	5.5	4	1.0	E568 0610
0820	8.0	63	19	27	8	7.5	4	2.0	E568 0820
1020	10.0	72	22	32	10	9.5	4	2.0	E568 1020
1230	12.0	83	26	38	12	11.2	4	3.0	E568 1230
1430	14.0	83	26	38	14	13.0	4	3.0	E568 1430
1640	16.0	92	32	44	16	15.0	4	4.0	E568 1640
2040	20.0	104	38	54	20	19.0	4	4.0	E568 2040

ISO	P													M			K					N							S							H																		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41					
E568																																																						

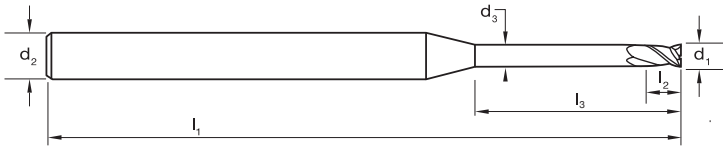
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

● Optimal ○ Effective



suttontools

- For precision milling of cavities
- Suitable for materials up to 35-52 HRC
- TiSiN for high speed machining



Catalogue Code	E580
Discount Group	B0218
Material	VHM
Surface Finish	TiSiN
Application	NH
Geometry	R40
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ *	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item #
0021	0.2	50	0.2	0.5	4	0.16	2	•
0022		50	0.2	1	4	0.16	2	•
0023		50	0.2	1.5	4	0.16	2	•
0041	0.4	50	0.4	2	4	0.37	2	•
0042		50	0.4	4	4	0.37	2	•
0051	0.5	50	0.7	2	4	0.45	2	•
0052		50	0.7	4	4	0.45	2	•
0053		50	0.7	6	4	0.45	2	•
0061	0.6	50	0.9	4	4	0.55	2	•
0062		50	0.9	8	4	0.55	2	•
0081	0.8	50	1.2	4	4	0.75	2	•
0082		50	1.2	6	4	0.75	2	•
0083		50	1.2	8	4	0.75	2	•
0101	1	50	1.5	6	4	0.95	2	•
0102		50	1.5	8	4	0.95	2	•
0103		50	1.5	10	4	0.95	2	•
0104		50	1.5	12	4	0.95	2	•
0105		50	1.5	16	4	0.95	2	•
0121	1.2	50	1.8	6	4	1.15	2	•
0122		50	1.8	10	4	1.15	2	•
0123		50	1.8	12	4	1.15	2	•
0151	1.5	50	2.3	6	4	1.45	2	•
0152		50	2.3	8	4	1.45	2	•
0153		50	2.3	12	4	1.45	2	•
0154		50	2.3	16	4	1.45	2	•
0155		60	2.3	20	4	1.45	2	•
0201	2	50	3.0	6	4	1.95	2	•
0202		50	3.0	8	4	1.95	2	•
0203		50	3.0	10	4	1.95	2	•
0204		50	3.0	12	4	1.95	2	•
0205		50	3.0	16	4	1.95	2	•
0206		60	3.0	20	4	1.95	2	•
0207		75	3.0	25	4	1.95	2	•
0251	2.5	50	3.7	8	4	2.40	2	•
0252		50	3.7	12	4	2.40	2	•
0301	3	60	4.5	16	6	2.85	2	•
0302		60	4.5	20	6	2.85	2	•
0303		75	4.5	25	6	2.85	2	•

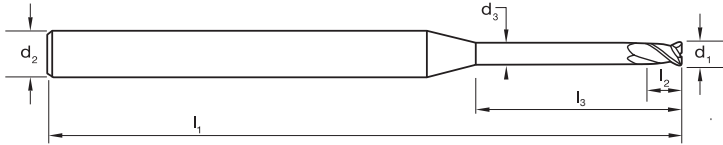
ISO	P										M			K					N										S										H										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E580									•		•		○	○	•																						•					•	•						

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials • Optimal ○ Effective

*Cutting Ø tolerance: d₁ < 0.7 = 0 / -0.012 d₁ > 0.7 = 0 / -0.020 • Available on request as special manufacture. Subject to lead time.



- For precision milling of cavities
- Suitable for materials up to 35-52 HRC
- TiSiN for high speed machining



Catalogue Code	E581
Discount Group	B0218
Material	VHM
Surface Finish	TiSiN
Application	NH
Geometry	R40
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	d ₁ *	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad†	Item #
0021	0.2	50	0.3	0.5	4	0.16	2	0.02	•
0022		50	0.3	1	4	0.16	2	0.02	•
0023		50	0.3	1.5	4	0.16	2	0.02	•
0041	0.4	50	0.6	2	4	0.37	2	0.03	•
0042		50	0.6	4	4	0.37	2	0.03	•
0051	0.5	50	0.7	2	4	0.45	2	0.05	•
0052		50	0.7	4	4	0.45	2	0.05	•
0053		50	0.7	6	4	0.45	2	0.05	•
0061	0.6	50	0.9	4	4	0.55	2	0.05	•
0062		50	0.9	8	4	0.55	2	0.05	•
0081	0.8	50	1.2	6	4	0.75	2	0.08	•
0082		50	1.2	6	4	0.75	2	0.08	•
0083		50	1.2	8	4	0.75	2	0.08	•
0101	1	50	1.5	6	4	0.95	2	0.1	•
0102		50	1.5	8	4	0.95	2	0.1	•
0103		50	1.5	10	4	0.95	2	0.1	•
0104		50	1.5	12	4	0.95	2	0.1	•
0105		50	1.5	16	4	0.95	2	0.1	•
0121	1.2	50	1.8	6	4	1.15	2	0.1	•
0122		50	1.8	10	4	1.15	2	0.1	•
0123		50	1.8	12	4	1.15	2	0.1	•
0151	1.5	50	2.3	6	4	1.45	2	0.15	•
0152		50	2.3	8	4	1.45	2	0.15	•
0153		50	2.3	12	4	1.45	2	0.15	•
0154		50	2.3	16	4	1.45	2	0.15	•
0155		60	2.3	20	4	1.45	2	0.15	•
0201	2	50	3.0	6	4	1.95	2	0.2	•
0202		50	3.0	8	4	1.95	2	0.2	•
0203		50	3.0	10	4	1.95	2	0.2	•
0204		50	3.0	12	4	1.95	2	0.2	•
0205		50	3.0	16	4	1.95	2	0.2	•
0206		60	3.0	20	4	1.95	2	0.2	•
0207		75	3.0	25	4	1.95	2	0.2	•
0251	2.5	50	3.7	8	4	2.40	2	0.3	•
0252		50	3.7	12	4	2.40	2	0.3	•
0301	3	60	4.5	16	6	2.95	2	0.3	•
0302		60	4.5	20	6	2.95	2	0.3	•
0303		75	4.5	25	6	2.95	2	0.3	•

ISO	P													M			K			N							S							H																			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41				
E581										•	•	•	•	•	•	•	•	•	•																																		

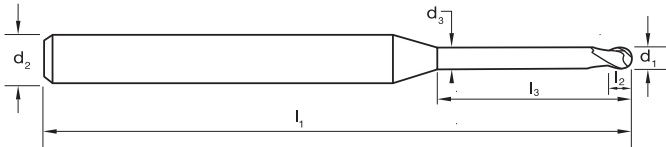
P Steel
 M Stainless Steel
 K Cast Iron
 N Non-Ferrous Metals
 S Titanium & Super Alloys
 H Hard Materials
 • Optimal ○ Effective

*Cutting Ø tolerance: d₁ < 0.7 = 0 / -0.012 d₁ > 0.7 = 0 / -0.020 †Radius tolerance: Rad = +/-0.01 • Available on request as special manufacture. Subject to lead time.



suttontools

- For profile & contour milling in long reach applications
- Suitable for materials up to 35-52 HRC
- TiSiN for high speed machining



Size Ref.	d ₁ *	l ₁	l ₂	l ₃	d ₂	d ₃	z	rad†	Item #
0021	0.2	50	0.2	0.5	4	0.15	2	0.1	•
0022		50	0.2	1	4	0.15	2	0.1	•
0023		50	0.2	1.5	4	0.15	2	0.1	•
0041	0.4	50	0.4	2	4	0.35	2	0.2	•
0042		50	0.4	4	4	0.35	2	0.2	•
0051	0.5	50	0.4	2	4	0.45	2	0.25	•
0052		50	0.4	6	4	0.45	2	0.25	•
0061	0.6	50	0.5	2	4	0.55	2	0.3	•
0062		50	0.5	4	4	0.55	2	0.3	•
0063		50	0.5	6	4	0.55	2	0.3	•
0064	0.6	50	0.5	8	4	0.55	2	0.3	•
0081	0.8	50	0.6	4	4	0.75	2	0.4	•
0082		50	0.6	8	4	0.75	2	0.4	•
0083		50	0.6	10	4	0.75	2	0.4	•
0101	1	50	0.8	4	4	0.95	2	0.5	•
0102		50	0.8	6	4	0.95	2	0.5	•
0103		50	0.8	8	4	0.95	2	0.5	•
0104		50	0.8	10	4	0.95	2	0.5	•
0105		50	0.8	12	4	0.95	2	0.5	•
0106		50	0.8	14	4	0.95	2	0.5	•
0107		60	0.8	20	4	0.95	2	0.5	•
0121	1.2	50	1.0	8	4	1.15	2	0.6	•
0123		50	1.0	10	4	1.15	2	0.6	•
0122		50	1.0	12	4	1.15	2	0.6	•
0151	1.5	50	1.2	8	4	1.45	2	0.75	•
0152		50	1.2	12	4	1.45	2	0.75	•
0153		50	1.2	16	4	1.45	2	0.75	•
0154		50	1.2	18	4	1.45	2	0.75	•
0201	2	50	1.6	6	4	1.95	2	1.0	•
0202		50	1.6	8	4	1.95	2	1.0	•
0203		50	1.6	12	4	1.95	2	1.0	•
0204		50	1.6	16	4	1.95	2	1.0	•
0205		60	1.6	20	4	1.95	2	1.0	•
0206		75	1.6	30	4	1.95	2	1.0	•
0301	3	50	2.4	10	6	2.85	2	1.5	•
0302		60	2.4	16	6	2.85	2	1.5	•
0303		75	2.4	25	6	2.85	2	1.5	•
0304		75	2.4	30	6	2.85	2	1.5	•



Catalogue Code	E582
Discount Group	B0218
Material	VHM
Surface Finish	TiSiN
Application	NH
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

ISO	P										M			K					N										S										H															
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41					
E582											•	•	•	•	•	•																																						

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

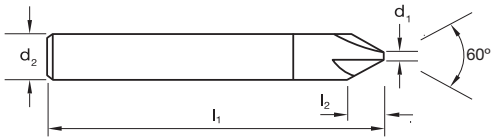
*Cutting Ø tolerance: d₁ < 0.7 = 0 / -0.012 d₁ > 0.7 = 0 / -0.020 †Radius tolerance: Rad = +-0.01 • Available on request as special manufacture. Subject to lead time.

Endmills Carbide, Chamfer, 4 Flute 60°



suttontools

- For chamfering & deburring component edges
- Straight flute for smooth cutting
- 60° form
- TiAlN for longer tool life



Catalogue Code	E457
Discount Group	B0210
Material	VHM
Surface Finish	TiAlN
Sutton Designation	N
Geometry	60°
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	l ₂	l ₁	d ₁	d ₂	z	Item #
0600	3.8	57	1.2	6	4	E457 0600
0800	5.5	63	1.6	8	4	E457 0800
1000	6.9	72	2.0	10	4	E457 1000
1200	8.3	83	2.4	12	4	E457 1200

ISO	P													M			K						N						S						H														
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E457	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

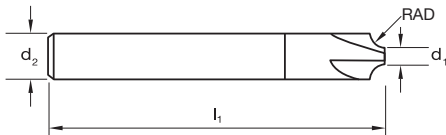
● Optimal ○ Effective

Endmills Carbide, Chamfer, 4 Flute, Corner Rad



suttontools

- For chamfering & deburring component edges
- Straight flute for smooth cutting
- Radius for corner rounding
- TiAIN for longer tool life



Catalogue Code	E458
Discount Group	B0210
Material	VHM
Surface Finish	TiAIN
Sutton Designation	N
Geometry	Rad
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Size Ref.	rad	d ₁	l ₁	d ₂	z	Item #
0605	0.5	5.0	57	6	4	E458 0605
0610	1	4.0	57	6	4	E458 0610
0815	1.5	5.0	63	8	4	E458 0815
0820	2	4.0	63	8	4	E458 0820
1025	2.5	5.0	72	10	4	E458 1025
1030	3	4.0	72	10	4	E458 1030
1235	3.5	5.0	83	12	4	E458 1235
1240	4	4.0	83	12	4	E458 1240

ISO	P										M				K						N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
E458	●	●	●	●	●	●	●	●	●	○	○	○	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	●

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

