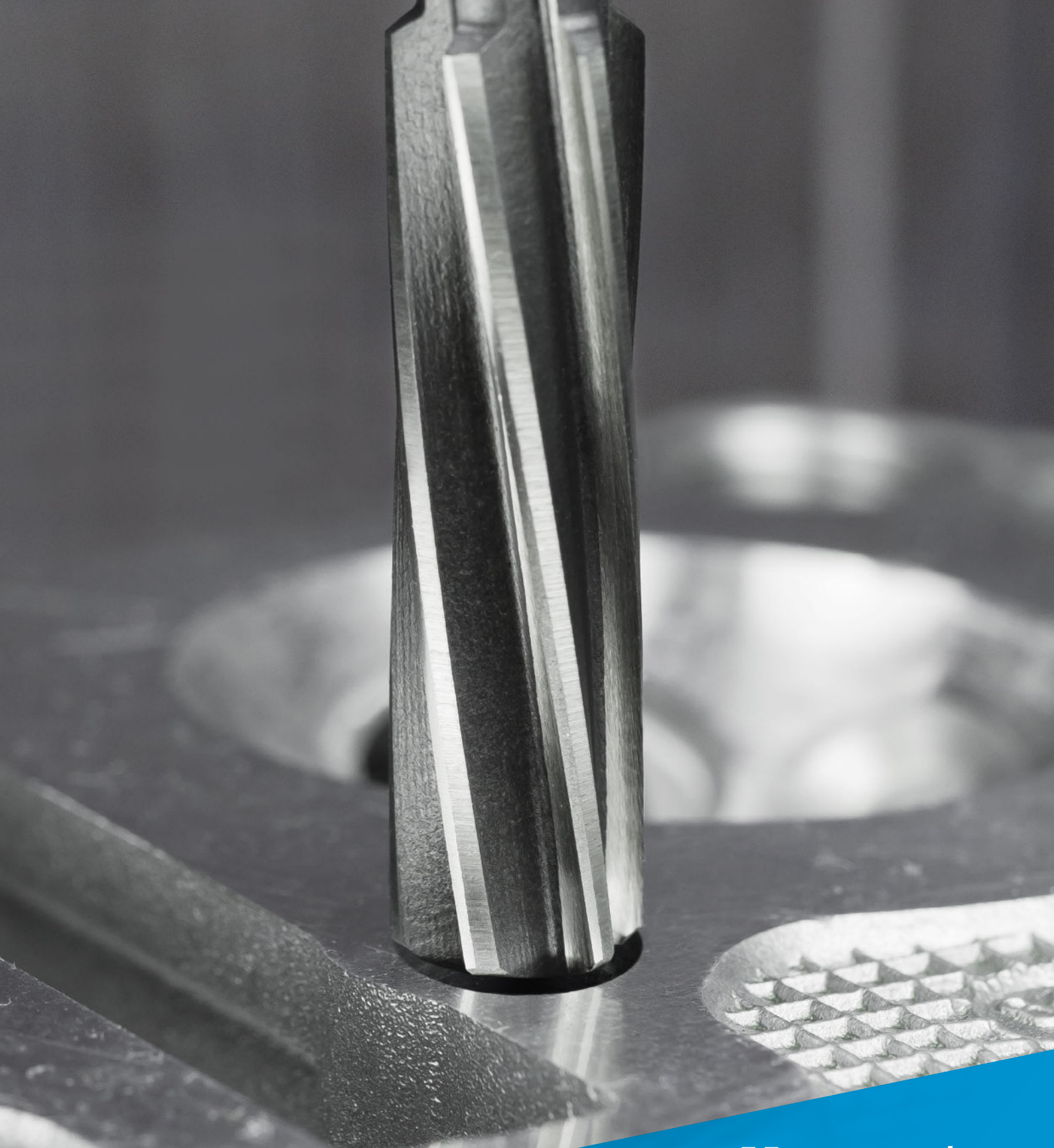




suttontools
REAMERS

- Hand ▪ Machine (Morse Taper & Chucking) ▪ Bridge ▪ Taper Pin
- Morse Taper Socket ▪ Taper Pipe ▪ Adjustable



AlCrN: G6 generation coatings... a quantum leap in tool wear resistance

Aluminium Chromium Nitride

The latest tool coating formula is Aluminium Chromium Nitride (AlCrN). Coatings of this G6 generation developed, markedly expand the performance envelope versus conventional titanium based coatings (such as TiAlN, AlTiN or TiCN).

Unique coating properties

The AlCrN coating exhibits until now, an unmatched degree of oxidation resistance and hot hardness. These properties have triggered a quantum leap in tool wear resistance.

The bottom line: greater productivity!

Tools coated with AlCrN let you choose noticeably higher cutting speeds and allow you to more effectively exploit the potential of modern machine tools. You can produce more parts per time / unit to decisively boost the productivity of your manufacturing resources and hone your competitive edge.

Extraordinary performance gains have been demonstrated in dry and wet machining processes involving:

- Unalloyed steels
- High strength steels
- High hardness steels (up to 54 HRC)

Coating properties:

- Very high abrasion resistance
- High and constant temperature resistance
- Unrivalled oxidation resistance
- Titanium free coating

ISO VDI Material Group

Sutton

P	A	Steel	N	UNI
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	
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.

For expert tooling recommendations, go to:

www.suttontools.com/expert-tool-selector

Page

150	152	155	156	157	158	158	159	160
								
R100	R101	R102	R104	R105	R106	R107	R108	R109
HSS	HSS	HSS Co	HSS	HSS	HSS	HSS	HSS	TCA
Brt	Brt	Brt	Brt	Brt	Brt	Brt	Brt	Brt
N	N	N	N	N	Roughing	Finishing	Tapered Pipe	N
DIN 206 / ISO 236	DIN 208	DIN 212 / ISO 521	-	-	-	-	-	-
L10	L10	L10	L15	L7	L7	L7	L15	Straight

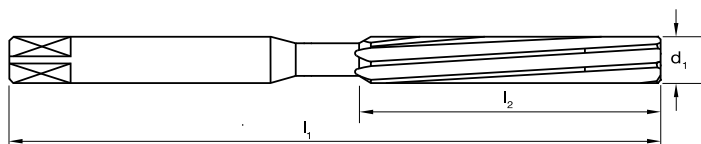
Catalogue Code
Material
Surface Finish
Sutton Designation
Standard
Geometry

ISO	VDI ³³²³	Material	Condition	HB	N/mm ²									
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									
M	12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680	○	○	○	○	○	○	○	○
	13		Martensitic	QT	240	810								
	14.1	Stainless Steel	Austenitic	AH	180	610	○	○	○	○	○	○	○	○
K	14.2	Cast Iron - Grey (GG)	Duplex		250	840	○	○	○	○	○	○	○	○
	14.3		Precipitation Hardening		250	840	○	○	○	○	○	○	○	○
	15	Cast Iron - Nodular (GGG)	Ferritic / Pearlitic		180	610	●	●	●	●	●	●	●	○
N	16	Cast Iron - Malleable	Pearlitic		260	880	○	○	○	○	○	○	○	○
	17		Ferritic		160	570	○	○	○	○	○	○	○	○
	18	Aluminum & Magnesium - wrought alloy	Pearlitic		250	840	○	○	○	○	○	○	○	○
	19		Ferritic		130	460	○	○	○	○	○	○	○	○
	20		Pearlitic		230	780	○	○	○	○	○	○	○	○
S	21	Aluminum & Magnesium - cast alloy ≤ 12% Si	Non Heat Treatable		60	210	○	○	○	○	○	○	○	○
	22		Heat Treatable	AH	100	360	○	○	○	○	○	○	○	○
	23	Al & Mg - cast alloy > 12% Si	Non Heat Treatable		75	270	○	○	○	○	○	○	○	○
	24		Heat Treatable	AH	90	320	○	○	○	○	○	○	○	○
	25	Copper & Cu alloys (Brass/Bronze)	Non Heat Treatable		130	460								
	26		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.												
H	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				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

- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance



Catalogue Code	R100
Discount Group	B0302
Material	HSS
Surface Finish	Br
Sutton Designation	N
Geometry	L10

Size Ref.	d ₁		l ₁	l ₂	l ₃	d ₂	z	Item #
0300	3.000		62	31	-	-	6	R100 0300
0318	3.175	1/8	66	33	-	-	6	R100 0318
0350	3.500		71	35	-	-	6	R100 0350
0357	3.572	9/64	71	35	-	-	6	R100 0357
0397	3.969	5/32	76	38	-	-	6	R100 0397
0400	4.000		76	38	-	-	6	R100 0400
0437	4.366	11/64	81	41	-	-	6	R100 0437
0450	4.500		81	41	-	-	6	R100 0450
0476	4.762	3/16	87	44	-	-	6	R100 0476
0500	5.000		87	44	-	-	6	R100 0500
0516	5.159	13/64	87	44	-	-	6	R100 0516
0550	5.500		93	47	-	-	6	R100 0550
0556	5.556	7/32	93	47	-	-	6	R100 0556
0595	5.953	15/64	93	47	-	-	6	R100 0595
0600	6.000		93	47	-	-	6	R100 0600
0635	6.350	1/4	100	50	-	-	6	R100 0635
0650	6.500		100	50	-	-	6	R100 0650
0675	6.747	17/64	100	50	-	-	6	R100 0675
0700	7.000		107	54	-	-	6	R100 0700
0714	7.144	9/32	107	54	-	-	6	R100 0714
0750	7.500		107	54	-	-	6	R100 0750
0754	7.541	19/64	107	54	-	-	6	R100 0754
0794	7.938	5/16	115	58	-	-	6	R100 0794
0800	8.000		115	58	-	-	6	R100 0800
0833	8.334	21/64	115	58	-	-	6	R100 0833
0850	8.500		115	58	-	-	6	R100 0850
0873	8.731	11/32	124	62	-	-	6	R100 0873
0900	9.000		124	62	-	-	6	R100 0900
0913	9.128	23/64	124	62	-	-	8	R100 0913
0950	9.500		124	62	-	-	6	R100 0950
0953	9.525	3/8	133	66	-	-	8	R100 0953
0992	9.922	25/64	133	66	-	-	8	R100 0992
1000	10.000		133	66	-	-	6	R100 1000
1032	10.319	13/32	133	66	-	-	8	R100 1032
1050	10.500		133	66	-	-	6	R100 1050
1100	11.000		142	71	-	-	6	R100 1100
1111	11.112	7/16	142	71	-	-	8	R100 1111
1150	11.500		142	71	-	-	6	R100 1150
1151	11.509	29/64	142	71	-	-	8	R100 1151
1191	11.906	15/32	152	76	-	-	8	R100 1191

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
R100	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

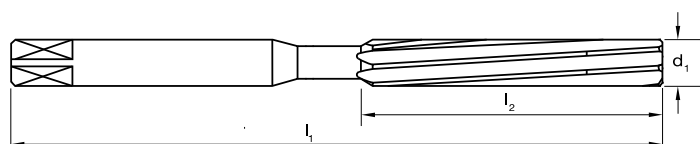
S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance



Catalogue Code	R100
Discount Group	B0302
Material	HSS
Surface Finish	Brt
Sutton Designation	N
Geometry	L10

Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	z	Item #
1200	12.000	152	76	-	-	6	R100 1200
1230	12.303 31/64	152	76	-	-	8	R100 1230
1250	12.500	152	76	-	-	6	R100 1250
1270	12.700 1/2	152	76	-	-	8	R100 1270
1300	13.000	152	76	-	-	6	R100 1300
1310	13.097 33/64	152	76	-	-	8	R100 1310
1349	13.494 17/32	163	81	-	-	8	R100 1349
1389	13.891 35/64	163	81	-	-	8	R100 1389
1350	13.500	163	81	-	-	6	R100 1350
1400	14.000	163	81	-	-	8	R100 1400
1429	14.288 9/16	163	81	-	-	8	R100 1429
1450	14.500	163	81	-	-	8	R100 1450
1468	14.684 37/64	163	81	-	-	8	R100 1468
1500	15.000	163	81	-	-	8	R100 1500
1508	15.081 19/32	175	87	-	-	8	R100 1508
1548	15.478 39/64	175	87	-	-	8	R100 1548
1588	15.875 5/8	175	87	-	-	8	R100 1588
1600	16.000	175	87	-	-	8	R100 1600
1627	16.272 41/64	175	87	-	-	8	R100 1627
1667	16.669 21/32	175	87	-	-	8	R100 1667
1700	17.000	175	87	-	-	8	R100 1700
1707	17.066 43/64	188	93	-	-	8	R100 1707
1746	17.463 11/16	188	93	-	-	8	R100 1746
1800	18.000	188	93	-	-	8	R100 1800
1826	18.256 23/32	188	93	-	-	8	R100 1826
1900	19.000	188	93	-	-	8	R100 1900
1905	19.050 3/4	201	100	-	-	10	R100 1905
1984	19.844 25/32	201	100	-	-	10	R100 1984
2000	20.000	201	100	-	-	8	R100 2000
2064	20.638 13/16	201	100	-	-	10	R100 2064
2100	21.000	201	100	-	-	8	R100 2100
2143	21.431 27/32	215	107	-	-	10	R100 2143
2200	22.000	215	107	-	-	8	R100 2200
2223	22.225 7/8	215	107	-	-	10	R100 2223
2300	23.000	215	107	-	-	8	R100 2300
2302	23.019 29/32	215	107	-	-	10	R100 2302
2381	23.813 15/16	231	115	-	-	10	R100 2381
2400	24.000	231	115	-	-	8	R100 2400
2461	24.606 31/32	231	115	-	-	10	R100 2461
2500	25.000	231	115	-	-	10	R100 2500
2540	25.400 1	231	115	-	-	10	R100 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					
R100	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○						
P	Steel			M			Stainless Steel			K			Cast Iron			N			Non-Ferrous Metals			S			Titanium & Super Alloys			H			Hard Materials																		●	Optimal		○	Effective	

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

● Optimal ○ Effective

- Machine use
- Suitable for toolroom & workshop use
- Produces clean, accurate holes, to a H7 tolerance



Catalogue Code	R101
Discount Group	B0302
Material	HSS
Surface Finish	Br
Sutton Designation	N
Geometry	L10

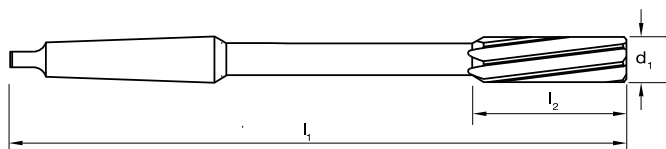
Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	z	MT #	Item #
0600	6.000	138	26	-	-	6	1	R101 0600
0635	6.350	144	28	-	-	6	1	R101 0635
0650	6.500	144	28	-	-	6	1	R101 0650
0675	6.747	144	28	-	-	6	1	R101 0675
0700	7.000	150	31	-	-	6	1	R101 0700
0714	7.144	150	31	-	-	6	1	R101 0714
0750	7.500	150	31	-	-	6	1	R101 0750
0754	7.541	150	31	-	-	6	1	R101 0754
0794	7.938	156	33	-	-	6	1	R101 0794
0800	8.000	156	33	-	-	6	1	R101 0800
0833	8.334	156	33	-	-	6	1	R101 0833
0850	8.500	156	33	-	-	6	1	R101 0850
0873	8.731	162	36	-	-	6	1	R101 0873
0900	9.000	162	36	-	-	6	1	R101 0900
0913	9.128	162	36	-	-	6	1	R101 0913
0950	9.500	162	36	-	-	6	1	R101 0950
0953	9.525	162	36	-	-	6	1	R101 0953
0992	9.922	168	38	-	-	6	1	R101 0992
1000	10.000	168	38	-	-	6	1	R101 1000
1032	10.319	168	38	-	-	6	1	R101 1032
1050	10.500	168	38	-	-	6	1	R101 1050
1072	10.716	175	41	-	-	6	1	R101 1072
1100	11.000	175	41	-	-	6	1	R101 1100
1111	11.112	175	41	-	-	6	1	R101 1111
1150	11.500	175	41	-	-	6	1	R101 1150
1151	11.509	175	41	-	-	6	1	R101 1151
1191	11.906	175	41	-	-	6	1	R101 1191
1200	12.000	182	44	-	-	6	1	R101 1200
1230	12.303	182	44	-	-	6	1	R101 1230
1250	12.500	182	44	-	-	6	1	R101 1250
1270	12.700	182	44	-	-	6	1	R101 1270
1300	13.000	182	44	-	-	6	1	R101 1300
1310	13.097	182	44	-	-	6	1	R101 1310
1349	13.494	189	47	-	-	6	1	R101 1349
1350	13.500	189	47	-	-	6	1	R101 1350
1389	13.891	189	47	-	-	6	1	R101 1389
1400	14.000	189	47	-	-	8	1	R101 1400
1429	14.288	204	50	-	-	8	2	R101 1429
1450	14.500	204	50	-	-	8	2	R101 1450
1468	14.684	204	50	-	-	8	2	R101 1468

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	
R101	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials														●	Optimal			○	Effective										

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

● Optimal ○ Effective

- Machine use
- Suitable for toolroom & workshop use
- Produces clean, accurate holes, to a H7 tolerance



Catalogue Code	R101
Discount Group	B0302
Material	HSS
Surface Finish	Br
Sutton Designation	N
Geometry	L10

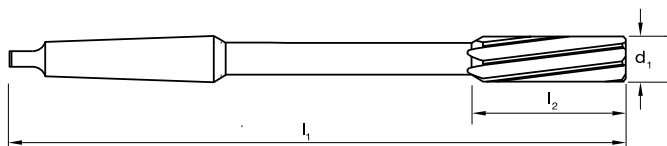
Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	z	MT #	Item #
1500	15.000	204	50	-	-	8	2	R101 1500
1508	15.081	19/32	210	52	-	8	2	R101 1508
1550	15.500	210	52	-	-	8	2	R101 1550
1548	15.478	39/64	210	52	-	8	2	R101 1548
1588	15.875	5/8	210	52	-	8	2	R101 1588
1600	16.000	210	52	-	-	8	2	R101 1600
1627	16.272	41/64	214	54	-	8	2	R101 1627
1650	16.500	214	54	-	-	8	2	R101 1650
1667	16.669	21/32	214	54	-	8	2	R101 1667
1700	17.000	214	54	-	-	8	2	R101 1700
1707	17.066	43/64	219	56	-	8	2	R101 1707
1746	17.463	11/16	219	56	-	8	2	R101 1746
1750	17.500	219	56	-	-	8	2	R101 1750
1786	17.859	45/64	219	56	-	8	2	R101 1786
1800	18.000	219	56	-	-	8	2	R101 1800
1826	18.256	23/32	219	56	-	8	2	R101 1826
1850	18.500	223	58	-	-	8	2	R101 1850
1900	19.000	223	58	-	-	8	2	R101 1900
1905	19.050	3/4	223	58	-	8	2	R101 1905
1950	19.500	228	60	-	-	8	2	R101 1950
2000	20.000	228	60	-	-	8	2	R101 2000
2050	20.500	232	62	-	-	8	2	R101 2050
2064	20.638	13/16	232	62	-	8	2	R101 2064
2100	21.000	232	62	-	-	8	2	R101 2100
2143	21.431	27/32	232	62	-	8	2	R101 2143
2150	21.500	237	64	-	-	8	2	R101 2150
2200	22.000	237	64	-	-	8	2	R101 2200
2223	22.225	7/8	237	64	-	8	2	R101 2223
2250	22.500	241	66	-	-	8	2	R101 2250
2300	23.000	241	66	-	-	8	2	R101 2300
2302	23.019	29/32	237	64	-	8	2	R101 2302
2350	23.500	241	66	-	-	8	3	R101 2350
2381	23.813	15/16	268	68	-	8	3	R101 2381
2400	24.000	268	68	-	-	8	3	R101 2400
2450	24.500	268	68	-	-	8	3	R101 2450
2461	24.606	31/32	268	68	-	8	3	R101 2461
2500	25.000	268	68	-	-	10	3	R101 2500
2540	25.400	1	268	68	-	8	3	R101 2540
2550	25.500	273	70	-	-	10	3	R101 2550
2600	26.000	273	70	-	-	10	3	R101 2600

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
R101	●	●	●	●	●	●	○			○		○		○		○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials																							●	Optimal		○	Effective	

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

● Optimal ○ Effective

- Machine use
- Suitable for toolroom & workshop use
- Produces clean, accurate holes, to a H7 tolerance



Catalogue Code	R101
Discount Group	B0302
Material	HSS
Surface Finish	Brf
Sutton Designation	N
Geometry	L10

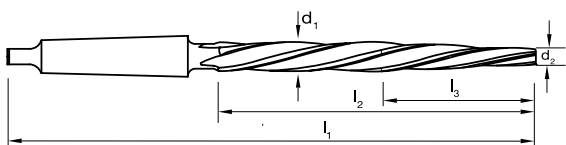
Size Ref.	d ₁		l ₁	l ₂	l ₃	d ₂	z	MT #	Item #
2650	26.500		273	70	-	-	10	3	R101 2650
2699	26.987	1-1/16	277	71	-	-	10	3	R101 2699
2700	27.000		277	71	-	-	10	3	R101 2700
2750	27.500		277	71	-	-	10	3	R101 2750
2800	28.000		277	71	-	-	10	3	R101 2800
2850	28.500		281	73	-	-	10	3	R101 2850
2858	28.575	1-1/8	281	73	-	-	10	3	R101 2858
2900	29.000		281	73	-	-	10	3	R101 2900
2950	29.500		281	73	-	-	10	3	R101 2950
3000	30.000		281	73	-	-	10	3	R101 3000
3016	30.162	1-3/16	285	75	-	-	10	3	R101 3016
3050	30.500		285	75	-	-	10	3	R101 3050
3100	31.000		285	75	-	-	10	3	R101 3100
3150	31.500		285	75	-	-	10	3	R101 3150
3175	31.750	1-1/4	290	77	-	-	10	3	R101 3175
3200	32.000		317	77	-	-	10	4	R101 3200
3300	33.000		317	77	-	-	10	4	R101 3300
3334	33.338	1-5/16	317	77	-	-	10	4	R101 3334
3400	34.000		321	78	-	-	10	4	R101 3400
3493	34.925	1-3/8	321	78	-	-	10	4	R101 3493
3500	35.000		321	78	-	-	10	4	R101 3500
3600	36.000		325	79	-	-	12	4	R101 3600
3651	36.512	1-7/16	325	79	-	-	12	4	R101 3651
3700	37.000		325	79	-	-	12	4	R101 3700
3800	38.000		329	81	-	-	12	4	R101 3800
3810	38.100	1-1/2	329	83	-	-	12	4	R101 3810
3900	39.000		329	81	-	-	12	4	R101 3900
4000	40.000		329	81	-	-	12	4	R101 4000
4128	41.275	1-5/8	333	82	-	-	12	4	R101 4128
4445	44.450	1-3/4	336	83	-	-	12	4	R101 4445
4763	47.625	1-7/8	344	86	-	-	12	4	R101 4763
5080	50.800	2	344	86	-	-	12	4	R101 5080

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
R101	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials																							●	Optimal		●	Effective	

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

● Optimal ○ Effective

- Machine use
- For opening out existing holes
- Ideal for alignment in fabrication & construction work



Catalogue Code	R104
Discount Group	B0302
Material	HSS
Surface Finish	Brt
Sutton Designation	N
Geometry	L15

Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	z	MT #	Item #
1300	13.0	199	105	42	8.8	5	2	R104 1300
1400	14.0	209	115	46	9.4	5	2	R104 1400
1600	16.0	229	135	54	10.6	5	2	R104 1600
1700	17.0	251	135	54	11.6	5	3	R104 1700
1800	18.0	261	145	58	12.2	5	3	R104 1800
1900	19.0	261	145	58	13.2	5	3	R104 1900
2000	20.0	271	155	62	13.8	5	3	R104 2000
2100	21.0	271	155	62	14.8	5	3	R104 2100
2200	22.0	281	165	66	15.4	5	3	R104 2200
2300	23.0	281	165	66	16.4	5	3	R104 2300
2500	25.0	296	180	72	17.8	5	3	R104 2500
2600	26.0	296	180	72	18.8	5	3	R104 2600
2800	28.0	311	195	78	20.2	5	3	R104 2800
3000	30.0	311	195	78	22.2	5	3	R104 3000
3200	32.0	354	210	84	23.6	5	4	R104 3200

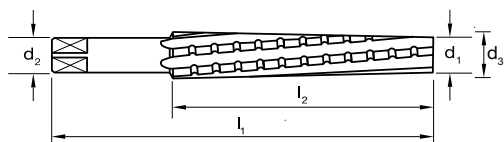
ISO	P													M	K					N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R104	●	●	●	●	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials													●	Optimal		○	Effective											

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

● Optimal ○ Effective

suttontools

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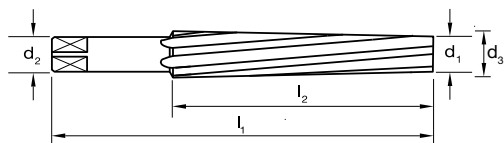


Catalogue Code	R106
Discount Group	B0302
Material	HSS
Surface Finish	Brt
Sutton Designation	Roughing
Geometry	L10



suttontools

- ## Section Finder



Catalogue Code	R107
Discount Group	B0302
Material	HSS
Surface Finish	<i>Brt</i>
Sutton Designation	Finishing
Geometry	L10



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
R106	●	●	●	●	●	●	●	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○																○		
R107	●	●	●	●	●	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○																	○	
P	Steel	M	Stainless Steel		K	Cast Iron		N	Non-Ferrous Metals					S	Titanium & Super Alloys										H	Hard Materials										●	Optimal		○	Effective									

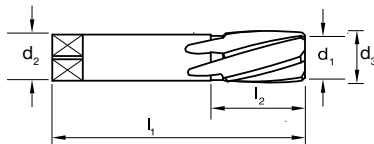
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

● Optimal ○ Effective

Reamers Taper Pipe

suttontools

- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Used prior to tapping tapered thread forms 1:16 taper (BSPT, NPT)
- Prolongs tap life, especially in tough materials



Catalogue Code	R108
Discount Group	B0302
Material	HSS
Surface Finish	Brt
Sutton Designation	Tapered Pipe
Geometry	L15

Size Ref.	Size	d ₁	l ₁	l ₂	d ₂	d ₃	z	Item #
0803	1/8	8.00	60	15	8.00	8.97	6	R108 0803
1031	1/4	10.31	67	20	10.00	11.50	6	R108 1031
1372	3/8	13.72	75	22	12.50	15.63	6	R108 1372
1689	1/2	16.89	87	26	16.00	18.52	6	R108 1689
2225	3/4	22.25	96	29	20.00	24.00	6	R108 2225
2802	1	28.00	110	33	25.00	30.08	6	R108 2802
3668	1-1/4	36.58	119	37	31.50	38.83	6	R108 3668
4277	1-1/2	42.77	125	37	35.50	45.08	8	R108 4277
5484	2	54.84	140	41	40.00	57.40	8	R108 5484

Section
Finder

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		
R108	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
P	Steel	M	Stainless Steel		K	Cast Iron		N	Non-Ferrous Metals		S	Titanium & Super Alloys		H	Hard Materials																											●	Optimal		○	Effective					

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

● Optimal ○ Effective

Reamers Adjustable

suttontools

- For use by hand with suitable wrench
- General purpose
- Adjustable size range
- TCA (Tungsten Chrome Alloy)



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry

R109

B0304

TCA

Brt

N

Straight

R110

B0304

TCA

Brt

-

Blade Sets

Size Ref.	Size	Range (mm)	Range (inch)	Sq	Item #	Item #
0635	MA8	6.35–7.15	1/4–9/32	2.8	R109 0635	
0715	MA7	7.15–7.95	9/32–5/16	3.2	R109 0715	
0795	MA6	7.95–8.70	5/16–11/32	4	R109 0795	
0870	MA5	8.70–9.50	11/32–3/8	4	R109 0870	
0950	MA4	9.50–10.25	3/8–13/32	4	R109 0950	
1025	MA3	10.25–11.00	13/32–7/16	4.5	R109 1025	
1100	MA2	11.00–12.00	7/16–15/32	5.5	R109 1100	
1200	MA	12.00–13.50	15/32–17/32	5.5	R109 1200	R110 1200
1350	MB	13.50–15.00	17/32–19/32	6.5	R109 1350	R110 1350
1500	MC	15.00–16.75	19/32–21/32	7	R109 1500	R110 1500
1675	MD	16.75–18.25	21/32–23/32	8	R109 1675	R110 1675
1825	ME	18.25–19.75	23/32–25/32	9	R109 1825	R110 1825
1975	MF	19.75–21.50	25/32–27/32	10	R109 1975	R110 1975
2150	MG	21.50–23.75	27/32–15/16	12	R109 2150	R110 2150
2375	MH	23.75–27.00	15/16–1-1/16	13	R109 2375	R110 2375
2700	MI	27.00–30.25	1-1/16–1-3/16	15	R109 2700	R110 2700
3025	MJ	30.25–34.25	1-3/16–1-11/32	15	R109 3025	R110 3025
3425	MK	34.25–38.00	1-11/32–1-1/2	17	R109 3425	R110 3425
3800	ML	38.00–46.00	1-1/2–1-13/16	21	R109 3800	R110 3800
4600	MM	46.00–56.00	1-13/16–2-7/32	26	R109 4600	R110 4600
5600	MN	56.00–69.75	2-7/32–2-3/4	32	R109 5600	R110 5600
6975	MO	69.75–85.00	2-3/4–3-11/32	38	R109 6975	R110 6975

Adjustable Reamer Set

Pieces

M1	MA4 to ME (Reamers Only)	8	R109 M1
M2P	MA to MH (Reamers & Pilots)	16	R109 M2P
M3	MA4 to MH (Reamers Only)	11	R109 M3
M6	MA8 to MK (Reamers Only)	18	R109 M6
M8	MA to MI (Reamers Only)	9	R109 M8



R109 M8

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
R109	●	●	●	○		●				○				○			○						○	○	○	○	○	○		○																			
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials																				●	Optimal		○	Effective				

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

● Optimal ○ Effective

Reamers Adjustable

suttontools

- For use by hand with suitable wrench
- General purpose
- Adjustable size range
- TCA (Tungsten Chrome Alloy)



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry

R111	R112
B0304	B0304
TCA	TCA
Brt	Brt
-	-
Pilots	Nuts

Size Ref.	Size	Range (mm)	Range (inch)	Item #	Item #
1200	MA	12.00–13.50	15/32–17/32	R111 1200	R112 1200
1350	MB	13.50–15.00	17/32–19/32	R111 1350	R112 1350
1500	MC	15.00–16.75	19/32–21/32	R111 1500	R112 1500
1675	MD	16.75–18.25	21/32–23/32	R111 1675	R112 1675
1825	ME	18.25–19.75	23/32–25/32	R111 1825	R112 1825
1975	MF	19.75–21.50	25/32–27/32	R111 1975	R112 1975
2150	MG	21.50–23.75	27/32–15/16	R111 2150	R112 2150
2375	MH	23.75–27.00	15/16–1-1/16	R111 2375	R112 2375
2700	MI	27.00–30.25	1-1/16–1-3/16	R111 2700	R112 2700
3025	MJ	30.25–34.25	1-3/16–1-11/32	R111 3025	R112 3025
3425	MK	34.25–38.00	1-11/32–1-1/2	R111 3425	R112 3425
3800	ML	38.00–46.00	1-1/2–1-13/16	R111 3800	R112 3800
4600	MM	46.00–56.00	1-13/16–2-7/32		R112 4600
5600	MN	56.00–69.75	2-7/32–2-3/4		R112 5600
6975	MO	69.75–85.00	2-3/4–3-11/32		R112 6975

MA1 Adjustable Reamer Pilot Set

MA to MI (Pilots Only)

Pieces

9 R111 MA1



R111 MA1

