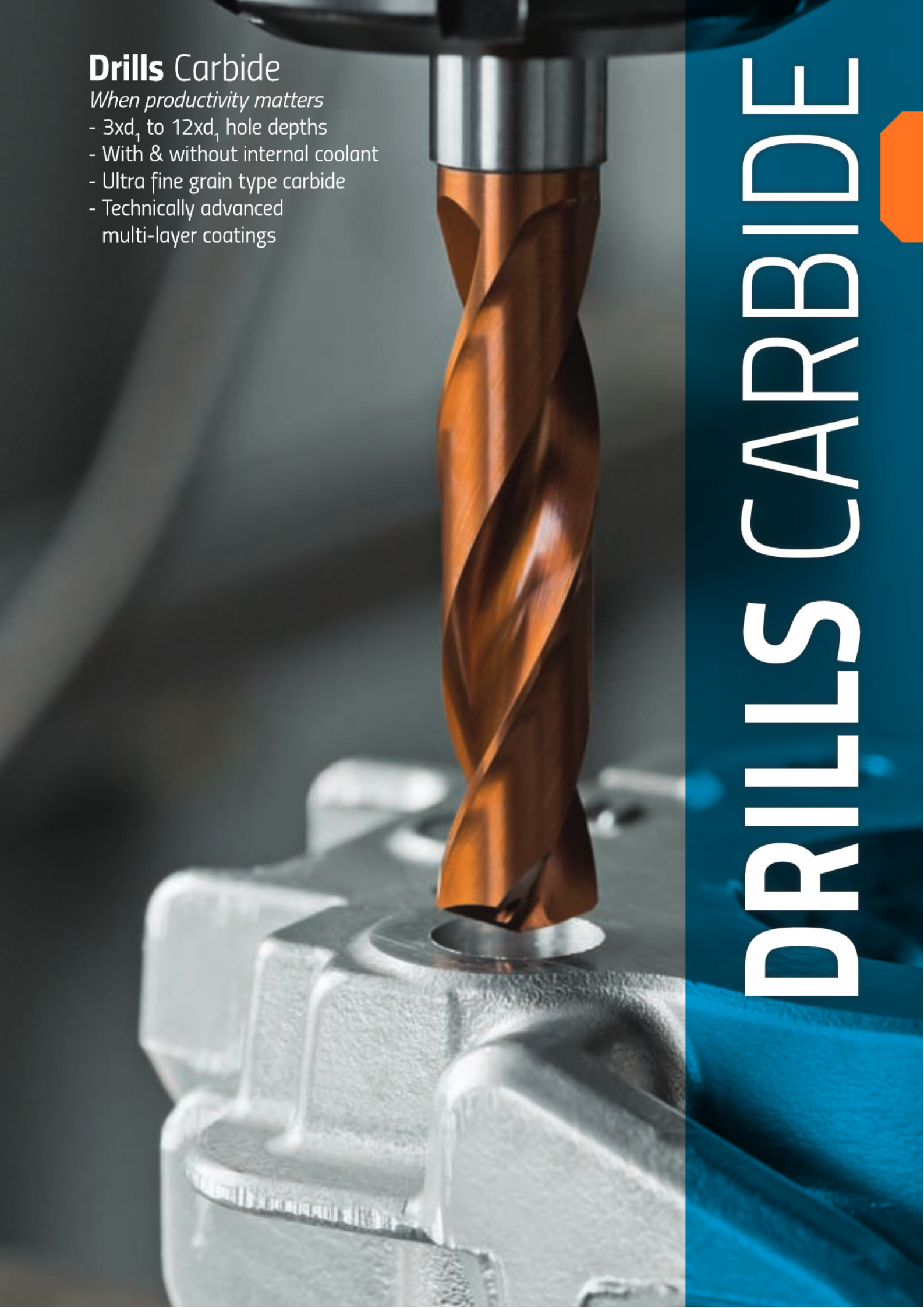

Drills Carbide

When productivity matters

- 3xd$_1$ to 12xd$_1$ hole depths
- With & without internal coolant
- Ultra fine grain type carbide
- Technically advanced multi-layer coatings

DRILLS CARBIDE

suttontools

ISO	VDI	Material Group	Sutton	
P	A	Steel	N	DIN
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.

Page	24	24	24	28	28	28	32	32	36	36	37	37
Catalogue Code	D323	D324	D325	D329	D330	D331	D356	D357	D300	D306	D304	D310
Material	VHM			VHM			VHM		VHM		VHM	
Surface Finish	AlCrN			AlCrN			Helica		Brt	TiCN	Brt	TiCN
Sutton Designation	N			N			VA		GG		NH	
Standard	DIN 6537			DIN 6537			DIN 6537		-		-	
Depth of Cut	3 x D			3 x D			3 x D		3 x D		3 x D	
Shank Form (DIN 6535)	HA	HB	HE	HA	HB	HE	HA	HE	-		-	

ISO	VDI^ 3323	Material		Condition	HB	N/mm²											
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●	●	●				
	2		~ 0.45 %C	A	190	640	●	●	●	●	●	●	●	●				
	3			QT	250	840	●	●	●	●	●	●	●	●			●	●
	4		~ 0.75 %C	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	Cast Iron - Malleable	Ferritic		130	460	●	●	●	●	●	●			●	●	●	●
	20		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

38	40	40	40	44	44	44	48	48	52	52	52	56	59	59	60	60	60	60		
D368	D326	D327	D328	D332	D333	D334	D358	D359	D335	D336	D337	D371	D318	D319	D355	D364	D365	D366		
VHM	VHM			VHM			VHM		VHM			VHM	VHM		VHM		VHM			
Brt	AlCrN			AlCrN			Helica		AlCrN			AlCrN	Brt	TiCN	Brt	AlCrN	Brt	AlCrN		
N	N			N			VA		N			N	N		NC		NC			
DIN 338	DIN 6537			DIN 6537			DIN 6537		-			-	ANSI B94-11		-		-			
5 x D	5 x D			5 x D			5 x D		8 x D			12 x D	-		-		-			
HA	HA	HB	HE	HA	HB	HE	HA	HE	HA	HB	HE	HA	HA		-		-			
																			VDI^ 3323	ISO
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	●	●	●	●	●	●			●	●	●			●		●		●	9	
	●	●	●	●	●	●	◕	◕	●	●	●	●	◕	●	◕	●	◕	●	10	
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				◕	◕	◕	●	●					◕	◕	◕	◕	◕	◕	37.3	
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				◕	◕	◕	●	●					◕	◕	◕	◕	◕	◕	37.5	
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													◕	◕	◕	◕	◕	◕	38.2	
													◕	◕	◕	◕	◕	◕	39.1	
													◕	◕	◕	◕	◕	◕	39.2	
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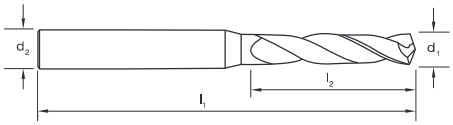
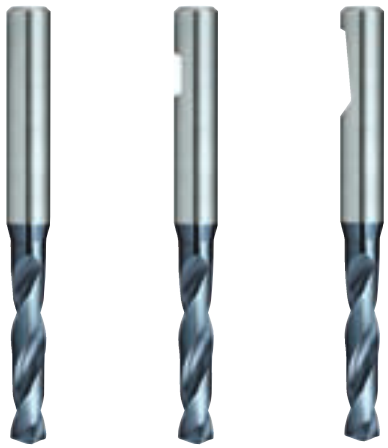
													◕	◕	◕	◕	◕	◕	41	

Drills Carbide, 3 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D323	D324	D325
Catalogue Code	D323	D324	D325
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0100	1.0		55	7	4	D323 0100		
0110	1.1		55	7	4	D323 0110		
0120	1.2		55	7	4	D323 0120		
0130	1.3		55	7	4	D323 0130		
0140	1.4		55	7	4	D323 0140		
0150	1.5		55	14	4	D323 0150		
0160	1.6		55	14	4	D323 0160		
0170	1.7		55	14	4	D323 0170		
0180	1.8		55	14	4	D323 0180		
0190	1.9		55	14	4	D323 0190		
0200	2.0		55	20	4	D323 0200		
0210	2.1		55	20	4	D323 0210		
0220	2.2		55	20	4	D323 0220		
0230	2.3		55	20	4	D323 0230		
0240	2.4		55	20	4	D323 0240		
0250	2.5		55	20	4	D323 0250		
0260	2.6		55	20	4	D323 0260		
0270	2.7		55	20	4	D323 0270		
0280	2.8		55	20	4	D323 0280		
0290	2.9		55	20	4	D323 0290		
0300	3.0		62	20	6	D323 0300	D324 0300	D325 0300
0310	3.1		62	20	6	D323 0310	D324 0310	D325 0310
0318	3.18	1/8	62	20	6	D323 0318	D324 0318	D325 0318
0320	3.2		62	20	6	D323 0320	D324 0320	D325 0320
0330	3.3		62	20	6	D323 0330	D324 0330	D325 0330
0340	3.4		62	20	6	D323 0340	D324 0340	D325 0340
0350	3.5		62	20	6	D323 0350	D324 0350	D325 0350
0357	3.57	9/64	62	20	6	D323 0357	D324 0357	D325 0357
0360	3.6		62	20	6	D323 0360	D324 0360	D325 0360
0370	3.7		62	20	6	D323 0370	D324 0370	D325 0370
0380	3.8		66	24	6	D323 0380	D324 0380	D325 0380
0390	3.9		66	24	6	D323 0390	D324 0390	D325 0390
0397	3.97	5/32	66	24	6	D323 0397	D324 0397	D325 0397
0400	4.0		66	24	6	D323 0400	D324 0400	D325 0400
0410	4.1		66	24	6	D323 0410	D324 0410	D325 0410
0420	4.2		66	24	6	D323 0420	D324 0420	D325 0420
0430	4.3		66	24	6	D323 0430	D324 0430	D325 0430
0437	4.37	11/64	66	24	6	D323 0437	D324 0437	D325 0437
0440	4.4		66	24	6	D323 0440	D324 0440	D325 0440
0450	4.5		66	24	6	D323 0450	D324 0450	D325 0450

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
D323	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉		◉			○	◉	◉	◉	◉	◉	◉															○	○	○		○		○				◉	

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

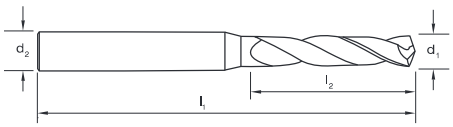
◉ Optimal ○ Effective

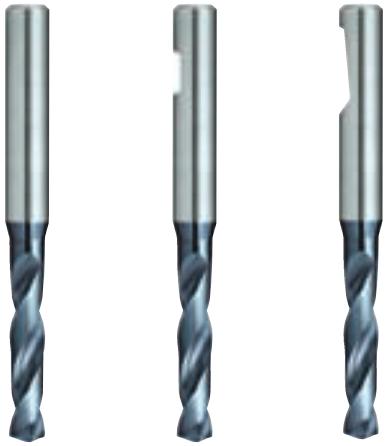
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





Catalogue Code	D323	D324	D325
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0460	4.6		66	24	6	D323 0460	D324 0460	D325 0460
0470	4.7		66	24	6	D323 0470	D324 0470	D325 0470
0476	4.76	3/16	66	28	6	D323 0476	D324 0476	D325 0476
0480	4.8		66	28	6	D323 0480	D324 0480	D325 0480
0490	4.9		66	28	6	D323 0490	D324 0490	D325 0490
0500	5.0		66	28	6	D323 0500	D324 0500	D325 0500
0510	5.1		66	28	6	D323 0510	D324 0510	D325 0510
0516	5.16	13/64	66	28	6	D323 0516	D324 0516	D325 0516
0520	5.2		66	28	6	D323 0520	D324 0520	D325 0520
0530	5.3		66	28	6	D323 0530	D324 0530	D325 0530
0540	5.4		66	28	6	D323 0540	D324 0540	D325 0540
0550	5.5		66	28	6	D323 0550	D324 0550	D325 0550
0556	5.56	7/32	66	28	6	D323 0556	D324 0556	D325 0556
0560	5.6		66	28	6	D323 0560	D324 0560	D325 0560
0570	5.7		66	28	6	D323 0570	D324 0570	D325 0570
0580	5.8		66	28	6	D323 0580	D324 0580	D325 0580
0590	5.9		66	28	6	D323 0590	D324 0590	D325 0590
0595	5.95	15/64	66	28	6	D323 0595	D324 0595	D325 0595
0600	6.0		66	28	6	D323 0600	D324 0600	D325 0600
0610	6.1		79	34	8	D323 0610	D324 0610	D325 0610
0620	6.2		79	34	8	D323 0620	D324 0620	D325 0620
0630	6.3		79	34	8	D323 0630	D324 0630	D325 0630
0635	6.35	1/4	79	34	8	D323 0635	D324 0635	D325 0635
0640	6.4		79	34	8	D323 0640	D324 0640	D325 0640
0650	6.5		79	34	8	D323 0650	D324 0650	D325 0650
0660	6.6		79	34	8	D323 0660	D324 0660	D325 0660
0670	6.7		79	34	8	D323 0670	D324 0670	D325 0670
0676	6.76	17/64	79	34	8	D323 0676	D324 0676	D325 0676
0680	6.8		79	34	8	D323 0680	D324 0680	D325 0680
0690	6.9		79	34	8	D323 0690	D324 0690	D325 0690
0700	7.0		79	34	8	D323 0700	D324 0700	D325 0700
0710	7.1		79	41	8	D323 0710	D324 0710	D325 0710
0714	7.14	9/32	79	41	8	D323 0714	D324 0714	D325 0714
0720	7.2		79	41	8	D323 0720	D324 0720	D325 0720
0730	7.3		79	41	8	D323 0730	D324 0730	D325 0730
0740	7.4		79	41	8	D323 0740	D324 0740	D325 0740
0750	7.5		79	41	8	D323 0750	D324 0750	D325 0750
0754	7.54	19/64	79	41	8	D323 0754	D324 0754	D325 0754
0760	7.6		79	41	8	D323 0760	D324 0760	D325 0760
0770	7.7		79	41	8	D323 0770	D324 0770	D325 0770

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
D323	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●																○	○	○		○		○				●			

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

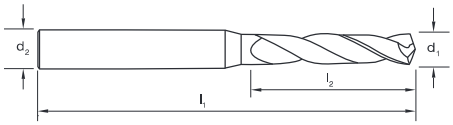
● Optimal ○ Effective

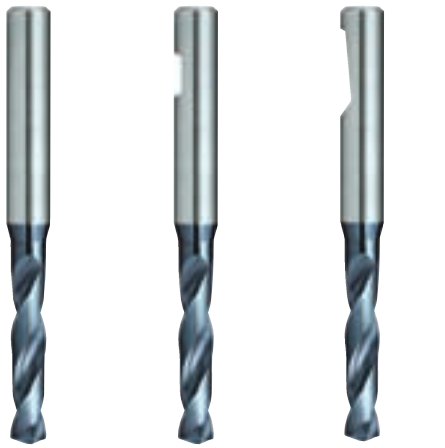
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D323	D324	D325
Catalogue Code	D323	D324	D325
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0780	7.8		79	41	8	D323 0780	D324 0780	D325 0780
0790	7.9		79	41	8	D323 0790	D324 0790	D325 0790
0794	7.94	5/16	79	41	8	D323 0794	D324 0794	D325 0794
0800	8.0		79	41	8	D323 0800	D324 0800	D325 0800
0810	8.1		89	47	10	D323 0810	D324 0810	D325 0810
0820	8.2		89	47	10	D323 0820	D324 0820	D325 0820
0830	8.3		89	47	10	D323 0830	D324 0830	D325 0830
0833	8.33	21/64	89	47	10	D323 0833	D324 0833	D325 0833
0840	8.4		89	47	10	D323 0840	D324 0840	D325 0840
0850	8.5		89	47	10	D323 0850	D324 0850	D325 0850
0860	8.6		89	47	10	D323 0860	D324 0860	D325 0860
0870	8.7		89	47	10	D323 0870	D324 0870	D325 0870
0873	8.73	11/32	89	47	10	D323 0873	D324 0873	D325 0873
0880	8.8		89	47	10	D323 0880	D324 0880	D325 0880
0890	8.9		89	47	10	D323 0890	D324 0890	D325 0890
0900	9.0		89	47	10	D323 0900	D324 0900	D325 0900
0910	9.1		89	47	10	D323 0910	D324 0910	D325 0910
0913	9.13	23/64	89	47	10	D323 0913	D324 0913	D325 0913
0920	9.2		89	47	10	D323 0920	D324 0920	D325 0920
0930	9.3		89	47	10	D323 0930	D324 0930	D325 0930
0940	9.4		89	47	10	D323 0940	D324 0940	D325 0940
0950	9.5		89	47	10	D323 0950	D324 0950	D325 0950
0953	9.53	3/8	89	47	10	D323 0953	D324 0953	D325 0953
0960	9.6		89	47	10	D323 0960	D324 0960	D325 0960
0970	9.7		89	47	10	D323 0970	D324 0970	D325 0970
0980	9.8		89	47	10	D323 0980	D324 0980	D325 0980
0990	9.9		89	47	10	D323 0990	D324 0990	D325 0990
0992	9.92	25/64	89	47	10	D323 0992	D324 0992	D325 0992
1000	10.0		89	47	10	D323 1000	D324 1000	D325 1000
1010	10.1		102	55	12	D323 1010	D324 1010	D325 1010
1020	10.2		102	55	12	D323 1020	D324 1020	D325 1020
1030	10.3		102	55	12	D323 1030	D324 1030	D325 1030
1032	10.32	13/32	102	55	12	D323 1032	D324 1032	D325 1032
1040	10.4		102	55	12	D323 1040	D324 1040	D325 1040
1050	10.5		102	55	12	D323 1050	D324 1050	D325 1050
1060	10.6		102	55	12	D323 1060	D324 1060	D325 1060
1070	10.7		102	55	12	D323 1070	D324 1070	D325 1070
1080	10.8		102	55	12	D323 1080	D324 1080	D325 1080
1090	10.9		102	55	12	D323 1090	D324 1090	D325 1090
1100	11.0		102	55	12	D323 1100	D324 1100	D325 1100

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
D323	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●															○	○	○		○		○				●	

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

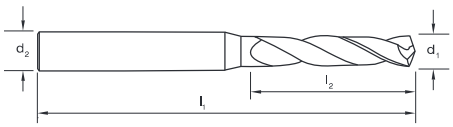
● Optimal ○ Effective

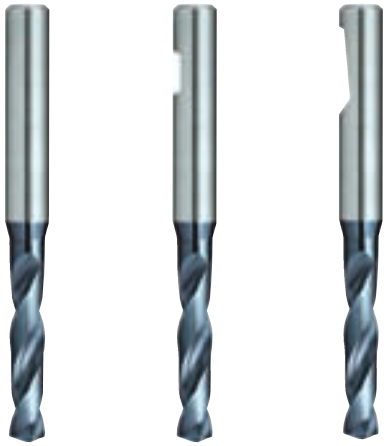
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D323	D324	D325
Catalogue Code	D323	D324	D325
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
1110	11.1		102	55	12	D323 1110	D324 1110	D325 1110
1111	11.11	7/16	102	55	12	D323 1111	D324 1111	D325 1111
1120	11.2		102	55	12	D323 1120	D324 1120	D325 1120
1130	11.3		102	55	12	D323 1130	D324 1130	D325 1130
1140	11.4		102	55	12	D323 1140	D324 1140	D325 1140
1150	11.5		102	55	12	D323 1150	D324 1150	D325 1150
1160	11.6		102	55	12	D323 1160	D324 1160	D325 1160
1170	11.7		102	55	12	D323 1170	D324 1170	D325 1170
1180	11.8		102	55	12	D323 1180	D324 1180	D325 1180
1190	11.9		102	55	12	D323 1190	D324 1190	D325 1190
1191	11.91	15/32	102	55	12	D323 1191	D324 1191	D325 1191
1200	12.0		102	55	12	D323 1200	D324 1200	D325 1200
1250	12.5		107	60	14	D323 1250	D324 1250	D325 1250
1269	12.70	1/2	107	60	14	D323 1269	D324 1269	D325 1269
1280	12.8		107	60	14	D323 1280	D324 1280	D325 1280
1300	13.0		107	60	14	D323 1300	D324 1300	D325 1300
1349	13.49	17/32	107	60	14	D323 1349	D324 1349	D325 1349
1350	13.5		107	60	14	D323 1350	D324 1350	D325 1350
1380	13.8		107	60	14	D323 1380	D324 1380	•
1400	14.0		107	60	14	D323 1400	D324 1400	D325 1400
1429	14.29	9/16	115	65	16	D323 1429	D324 1429	D325 1429
1450	14.5		115	65	16	D323 1450	D324 1450	D325 1450
1480	14.8		115	65	16	D323 1480	D324 1480	D325 1480
1500	15.0		115	65	16	D323 1500	D324 1500	D325 1500
1550	15.5		115	65	16	D323 1550	D324 1550	D325 1550
1580	15.8		115	65	16	D323 1580	D324 1580	D325 1580
1588	15.88	5/8	115	65	16	D323 1588	D324 1588	D325 1588
1600	16.0		115	65	16	D323 1600	D324 1600	D325 1600
1650	16.5		123	73	18	D323 1650	D324 1650	D325 1650
1680	16.8		123	73	18	D323 1680	D324 1680	D325 1680
1700	17.0		123	73	18	D323 1700	D324 1700	D325 1700
1746	17.46	11/16	123	73	18	D323 1746	D324 1746	D325 1746
1750	17.5		123	73	18	D323 1750	D324 1750	D325 1750
1780	17.8		123	73	18	D323 1780	D324 1780	D325 1780
1800	18.0		123	73	18	D323 1800	D324 1800	D325 1800
1850	18.5		131	79	20	D323 1850	D324 1850	D325 1850
1900	19.0		131	79	20	D323 1900	D324 1900	D325 1900
1905	19.05	3/4	131	79	20	D323 1905	D324 1905	D325 1905
1950	19.5		131	79	20	D323 1950	D324 1950	D325 1950
2000	20.0		131	79	20	D323 2000	D324 2000	D325 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
D323	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓		◓			○	◓	◓	◓	◓	◓	◓																○	○	○		○		○				◓			◓		

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

◓ Optimal ○ Effective

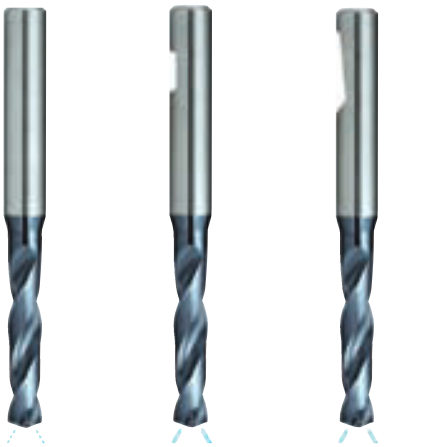
• Available on request as special manufacture. Subject to lead time.

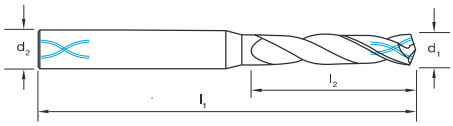
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D329	D330	D331
Catalogue Code	D329	D330	D331
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0300	3.0		62	20	6	D329 0300	D330 0300	D331 0300
0310	3.1		62	20	6	D329 0310	D330 0310	D331 0310
0318	3.18	1/8	62	20	6	D329 0318	D330 0318	D331 0318
0320	3.2		62	20	6	D329 0320	D330 0320	D331 0320
0330	3.3		62	20	6	D329 0330	D330 0330	D331 0330
0340	3.4		62	20	6	D329 0340	D330 0340	D331 0340
0350	3.5		62	20	6	D329 0350	D330 0350	D331 0350
0357	3.57	9/64	62	20	6	D329 0357	D330 0357	D331 0357
0360	3.6		62	20	6	D329 0360	D330 0360	D331 0360
0370	3.7		62	20	6	D329 0370	D330 0370	D331 0370
0380	3.8		66	24	6	D329 0380	D330 0380	D331 0380
0390	3.9		66	24	6	D329 0390	D330 0390	D331 0390
0397	3.97	5/32	66	24	6	D329 0397	D330 0397	D331 0397
0400	4.0		66	24	6	D329 0400	D330 0400	D331 0400
0410	4.1		66	24	6	D329 0410	D330 0410	D331 0410
0420	4.2		66	24	6	D329 0420	D330 0420	D331 0420
0430	4.3		66	24	6	D329 0430	D330 0430	D331 0430
0437	4.37	11/64	66	24	6	D329 0437	D330 0437	D331 0437
0440	4.4		66	24	6	D329 0440	D330 0440	D331 0440
0450	4.5		66	24	6	D329 0450	D330 0450	D331 0450
0460	4.6		66	24	6	D329 0460	D330 0460	D331 0460
0470	4.7		66	24	6	D329 0470	D330 0470	D331 0470
0476	4.76	3/16	66	28	6	D329 0476	D330 0476	D331 0476
0480	4.8		66	28	6	D329 0480	D330 0480	D331 0480
0490	4.9		66	28	6	D329 0490	D330 0490	D331 0490
0500	5.0		66	28	6	D329 0500	D330 0500	D331 0500
0510	5.1		66	28	6	D329 0510	D330 0510	D331 0510
0516	5.16	13/64	66	28	6	D329 0516	D330 0516	D331 0516
0520	5.2		66	28	6	D329 0520	D330 0520	D331 0520
0530	5.3		66	28	6	D329 0530	D330 0530	D331 0530
0540	5.4		66	28	6	D329 0540	D330 0540	D331 0540
0550	5.5		66	28	6	D329 0550	D330 0550	D331 0550
0556	5.56	7/32	66	28	6	D329 0556	D330 0556	D331 0556
0560	5.6		66	28	6	D329 0560	D330 0560	D331 0560
0570	5.7		66	28	6	D329 0570	D330 0570	D331 0570
0580	5.8		66	28	6	D329 0580	D330 0580	D331 0580
0590	5.9		66	28	6	D329 0590	D330 0590	D331 0590
0595	5.95	15/64	66	28	6	D329 0595	D330 0595	D331 0595
0600	6.0		66	28	6	D329 0600	D330 0600	D331 0600
0610	6.1		79	34	8	D329 0610	D330 0610	D331 0610

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
D329	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	●	●	●	●	●	●	●					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	○	●				●	

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

● Optimal ● Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N, IK

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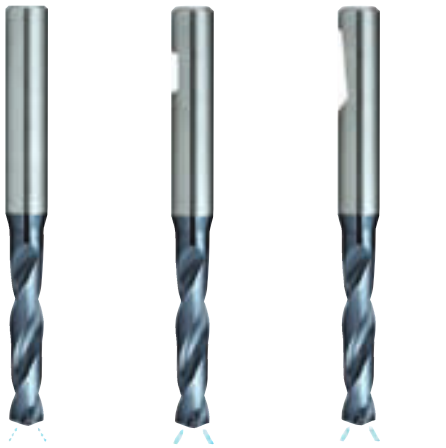
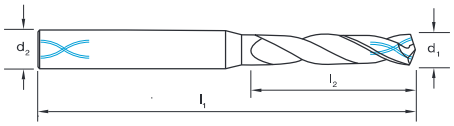




	D329	D330	D331
Catalogue Code	D329	D330	D331
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0620	6.2		79	34	8	D329 0620	D330 0620	D331 0620
0630	6.3		79	34	8	D329 0630	D330 0630	D331 0630
0635	6.35	1/4	79	34	8	D329 0635	D330 0635	D331 0635
0640	6.4		79	34	8	D329 0640	D330 0640	D331 0640
0650	6.5		79	34	8	D329 0650	D330 0650	D331 0650
0660	6.6		79	34	8	D329 0660	D330 0660	D331 0660
0670	6.7		79	34	8	D329 0670	D330 0670	D331 0670
0676	6.75	17/64	79	34	8	D329 0676	D330 0676	D331 0676
0680	6.8		79	34	8	D329 0680	D330 0680	D331 0680
0690	6.9		79	34	8	D329 0690	D330 0690	D331 0690
0700	7.0		79	34	8	D329 0700	D330 0700	D331 0700
0710	7.1		79	41	8	D329 0710	D330 0710	D331 0710
0714	7.14	9/32	79	41	8	D329 0714	D330 0714	D331 0714
0720	7.2		79	41	8	D329 0720	D330 0720	D331 0720
0730	7.3		79	41	8	D329 0730	D330 0730	D331 0730
0740	7.4		79	41	8	D329 0740	D330 0740	D331 0740
0750	7.5		79	41	8	D329 0750	D330 0750	D331 0750
0754	7.54	19/64	79	41	8	D329 0754	D330 0754	D331 0754
0760	7.6		79	41	8	D329 0760	D330 0760	D331 0760
0770	7.7		79	41	8	D329 0770	D330 0770	D331 0770
0780	7.8		79	41	8	D329 0780	D330 0780	D331 0780
0790	7.9		79	41	8	D329 0790	D330 0790	D331 0790
0794	7.94	5/16	79	41	8	D329 0794	D330 0794	D331 0794
0800	8.0		79	41	8	D329 0800	D330 0800	D331 0800
0810	8.1		89	47	10	D329 0810	D330 0810	D331 0810
0820	8.2		89	47	10	D329 0820	D330 0820	D331 0820
0830	8.3		89	47	10	D329 0830	D330 0830	D331 0830
0833	8.33	21/64	89	47	10	D329 0833	D330 0833	D331 0833
0840	8.4		89	47	10	D329 0840	D330 0840	D331 0840
0850	8.5		89	47	10	D329 0850	D330 0850	D331 0850
0860	8.6		89	47	10	D329 0860	D330 0860	D331 0860
0870	8.7		89	47	10	D329 0870	D330 0870	D331 0870
0873	8.73	11/32	89	47	10	D329 0873	D330 0873	D331 0873
0880	8.8		89	47	10	D329 0880	D330 0880	D331 0880
0890	8.9		89	47	10	D329 0890	D330 0890	D331 0890
0900	9.0		89	47	10	D329 0900	D330 0900	D331 0900
0910	9.1		89	47	10	D329 0910	D330 0910	D331 0910
0913	9.13	23/64	89	47	10	D329 0913	D330 0913	D331 0913
0920	9.2		89	47	10	D329 0920	D330 0920	D331 0920
0930	9.3		89	47	10	D329 0930	D330 0930	D331 0930

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
D329	◒	◒	◒	◒	◒	◒	◒	◒	◒	◒	◒	◒	◒	○	○	○	◒	◒	◒	◒	◒	◒					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	◒				◒	

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

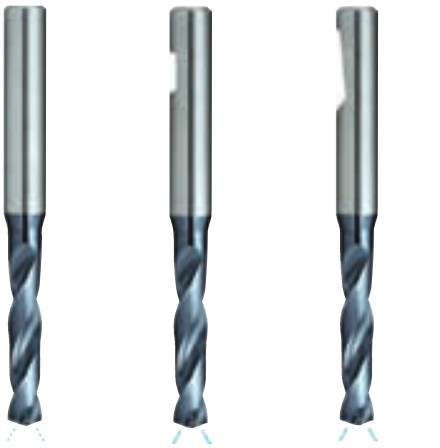
● Optimal ◒ Effective

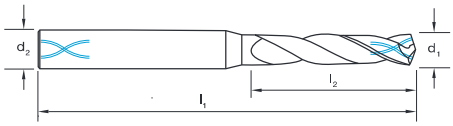
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D329	D330	D331
Catalogue Code	D329	D330	D331
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0940	9.4		89	47	10	D329 0940	D330 0940	D331 0940
0950	9.5		89	47	10	D329 0950	D330 0950	D331 0950
0953	9.53	3/8	89	47	10	D329 0953	D330 0953	D331 0953
0960	9.6		89	47	10	D329 0960	D330 0960	D331 0960
0970	9.7		89	47	10	D329 0970	D330 0970	D331 0970
0980	9.8		89	47	10	D329 0980	D330 0980	D331 0980
0990	9.9		89	47	10	D329 0990	D330 0990	D331 0990
0992	9.92	25/64	89	47	10	D329 0992	D330 0992	D331 0992
1000	10.0		89	47	10	D329 1000	D330 1000	D331 1000
1010	10.1		102	55	12	D329 1010	D330 1010	D331 1010
1020	10.2		102	55	12	D329 1020	D330 1020	D331 1020
1030	10.3		102	55	12	D329 1030	D330 1030	D331 1030
1032	10.32	13/32	102	55	12	D329 1032	D330 1032	D331 1032
1040	10.4		102	55	12	D329 1040	D330 1040	D331 1040
1050	10.5		102	55	12	D329 1050	D330 1050	D331 1050
1060	10.6		102	55	12	D329 1060	D330 1060	D331 1060
1070	10.7		102	55	12	D329 1070	D330 1070	D331 1070
1080	10.8		102	55	12	D329 1080	D330 1080	D331 1080
1090	10.9		102	55	12	D329 1090	D330 1090	D331 1090
1100	11.0		102	55	12	D329 1100	D330 1100	D331 1100
1110	11.1		102	55	12	D329 1110	D330 1110	D331 1110
1111	11.11	7/16	102	55	12	D329 1111	D330 1111	D331 1111
1120	11.2		102	55	12	D329 1120	D330 1120	D331 1120
1130	11.3		102	55	12	D329 1130	D330 1130	D331 1130
1140	11.4		102	55	12	D329 1140	D330 1140	D331 1140
1150	11.5		102	55	12	D329 1150	D330 1150	D331 1150
1160	11.6		102	55	12	D329 1160	D330 1160	D331 1160
1170	11.7		102	55	12	D329 1170	D330 1170	D331 1170
1180	11.8		102	55	12	D329 1180	D330 1180	D331 1180
1190	11.9		102	55	12	D329 1190	D330 1190	D331 1190
1191	11.91	15/32	102	55	12	D329 1191	D330 1191	D331 1191
1200	12.0		102	55	12	D329 1200	D330 1200	D331 1200
1250	12.5		107	60	14	D329 1250	D330 1250	D331 1250
1269	12.70	1/2	107	60	14	D329 1269	D330 1269	D331 1269
1280	12.8		107	60	14	D329 1280	D330 1280	D331 1280
1300	13.0		107	60	14	D329 1300	D330 1300	D331 1300
1349	13.49	17/32	107	60	14	D329 1349	D330 1349	D331 1349
1350	13.5		107	60	14	D329 1350	D330 1350	D331 1350
1380	13.8		107	60	14	•	•	•
1400	14.0		107	60	14	D329 1400	D330 1400	D331 1400

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
D329	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	●	●	●	●	●	●	●					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	○	●				●	

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

● Optimal ● Effective

• Available on request as special manufacture. Subject to lead time.

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 3 x D, R30 N, IK

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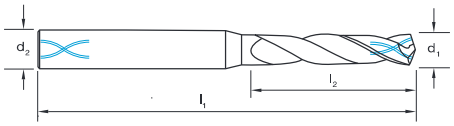

Catalogue Code	D329	D330	D331
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
1429	14.29	9/16	115	65	16	D329 1429	D330 1429	D331 1429
1450	14.5		115	65	16	D329 1450	D330 1450	D331 1450
1480	14.8		115	65	16	•	•	•
1500	15.0		115	65	16	D329 1500	D330 1500	D331 1500
1550	15.5		115	65	16	D329 1550	D330 1550	D331 1550
1580	15.8		115	65	16	•	•	•
1588	15.88	5/8	115	65	16	D329 1588	D330 1588	D331 1588
1600	16.0		115	65	16	D329 1600	D330 1600	D331 1600
1650	16.5		123	73	18	D329 1650	D330 1650	D331 1650
1700	17.0		123	73	18	D329 1700	D330 1700	D331 1700
1746	17.46	11/16	123	73	18	D329 1746	D330 1746	D331 1746
1750	17.5		123	73	18	D329 1750	D330 1750	D331 1750
1800	18.0		123	73	18	D329 1800	D330 1800	D331 1800
1850	18.5		131	79	20	D329 1850	D330 1850	D331 1850
1900	19.0		131	79	20	D329 1900	D330 1900	D331 1900
1905	19.05	3/4	131	79	20	D329 1905	D330 1905	D331 1905
1950	19.5		131	79	20	D329 1950	D330 1950	D331 1950
2000	20.0		131	79	20	D329 2000	D330 2000	D331 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
D329	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓	◓	○	○	◓	◓	◓	◓	◓	◓	◓					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	◓				◓	

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

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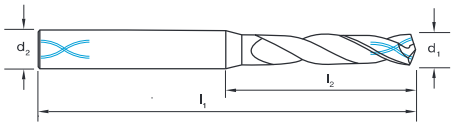
watch the video

DIN 6537 | 3xd1 | HA | HE | MICRO



	D356	D357
Catalogue Code	D356	D357
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #
0300	3.0		62	20	6	D356 0300	D357 0300
0310	3.1		62	20	6	D356 0310	D357 0310
0318	3.18	1/8	62	20	6	D356 0318	D357 0318
0320	3.2		62	20	6	D356 0320	D357 0320
0330	3.3		62	20	6	D356 0330	D357 0330
0340	3.4		62	20	6	D356 0340	D357 0340
0350	3.5		62	20	6	D356 0350	D357 0350
0357	3.57	9/64	62	20	6	D356 0357	D357 0357
0360	3.6		62	20	6	D356 0360	D357 0360
0370	3.7		62	20	6	D356 0370	D357 0370
0380	3.8		66	24	6	D356 0380	D357 0380
0390	3.9		66	24	6	D356 0390	D357 0390
0397	3.97	5/32	66	24	6	D356 0397	D357 0397
0400	4.0		66	24	6	D356 0400	D357 0400
0410	4.1		66	24	6	D356 0410	D357 0410
0420	4.2		66	24	6	D356 0420	D357 0420
0430	4.3		66	24	6	D356 0430	D357 0430
0437	4.37	11/64	66	24	6	D356 0437	D357 0437
0440	4.4		66	24	6	D356 0440	D357 0440
0450	4.5		66	24	6	D356 0450	D357 0450
0460	4.6		66	24	6	D356 0460	D357 0460
0470	4.7		66	24	6	D356 0470	D357 0470
0476	4.76	3/16	66	28	6	D356 0476	D357 0476
0480	4.8		66	28	6	D356 0480	D357 0480
0490	4.9		66	28	6	D356 0490	D357 0490
0500	5.0		66	28	6	D356 0500	D357 0500
0510	5.1		66	28	6	D356 0510	D357 0510
0516	5.16	13/64	66	28	6	D356 0516	D357 0516
0520	5.2		66	28	6	D356 0520	D357 0520
0530	5.3		66	28	6	D356 0530	D357 0530
0540	5.4		66	28	6	D356 0540	D357 0540
0550	5.5		66	28	6	D356 0550	D357 0550
0556	5.56	7/32	66	28	6	D356 0556	D357 0556
0560	5.6		66	28	6	D356 0560	D357 0560
0570	5.7		66	28	6	D356 0570	D357 0570
0580	5.8		66	28	6	D356 0580	D357 0580
0590	5.9		66	28	6	D356 0590	D357 0590
0595	5.95	15/64	66	28	6	D356 0595	D357 0595
0600	6.0		66	28	6	D356 0600	D357 0600
0610	6.1		79	34	8	D356 0610	D357 0610

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
D356	●	●	●	●	◐	●	◐	◐		◐		●	◐	●	●	●							●	●	●	●	●						●	◐	●	◐	●	●	●	●	●	●	●						

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

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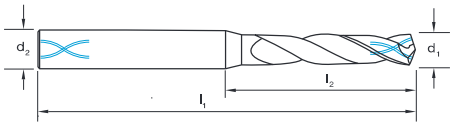

	D356	D357
Catalogue Code	D356	D357
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #
0620	6.2		79	34	8	D356 0620	D357 0620
0630	6.3		79	34	8	D356 0630	D357 0630
0635	6.35	1/4	79	34	8	D356 0635	D357 0635
0640	6.4		79	34	8	D356 0640	D357 0640
0650	6.5		79	34	8	D356 0650	D357 0650
0660	6.6		79	34	8	D356 0660	D357 0660
0670	6.7		79	34	8	D356 0670	D357 0670
0676	6.76	17/64	79	34	8	D356 0676	D357 0676
0680	6.8		79	34	8	D356 0680	D357 0680
0690	6.9		79	34	8	D356 0690	D357 0690
0700	7.0		79	34	8	D356 0700	D357 0700
0710	7.1		79	41	8	D356 0710	D357 0710
0714	7.14	9/32	79	41	8	D356 0714	D357 0714
0720	7.2		79	41	8	D356 0720	D357 0720
0730	7.3		79	41	8	D356 0730	D357 0730
0740	7.4		79	41	8	D356 0740	D357 0740
0750	7.5		79	41	8	D356 0750	D357 0750
0754	7.54	19/64	79	41	8	D356 0754	D357 0754
0760	7.6		79	41	8	D356 0760	D357 0760
0770	7.7		79	41	8	D356 0770	D357 0770
0780	7.8		79	41	8	D356 0780	D357 0780
0790	7.9		79	41	8	D356 0790	D357 0790
0794	7.94	5/16	79	41	8	D356 0794	D357 0794
0800	8.0		79	41	8	D356 0800	D357 0800
0810	8.1		89	47	10	D356 0810	D357 0810
0820	8.2		89	47	10	D356 0820	D357 0820
0830	8.3		89	47	10	D356 0830	D357 0830
0833	8.33	21/64	89	47	10	D356 0833	D357 0833
0840	8.4		89	47	10	D356 0840	D357 0840
0850	8.5		89	47	10	D356 0850	D357 0850
0860	8.6		89	47	10	D356 0860	D357 0860
0870	8.7		89	47	10	D356 0870	D357 0870
0873	8.73	11/32	89	47	10	D356 0873	D357 0873
0880	8.8		89	47	10	D356 0880	D357 0880
0890	8.9		89	47	10	D356 0890	D357 0890
0900	9.0		89	47	10	D356 0900	D357 0900
0910	9.1		89	47	10	D356 0910	D357 0910
0913	9.13	23/64	89	47	10	D356 0913	D357 0913
0920	9.2		89	47	10	D356 0920	D357 0920
0930	9.3		89	47	10	D356 0930	D357 0930

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
D356	●	●	●	●	●	●	●	●		●		●	●	●	●	●							●	●	●	●	●						●	●	●	●	●	●	●	●	●	●						

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

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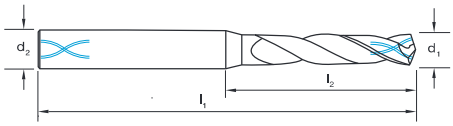


	D356	D357
Catalogue Code	D356	D357
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #
0940	9.4		89	47	10	D356 0940	D357 0940
0950	9.5		89	47	10	D356 0950	D357 0950
0953	9.53	3/8	89	47	10	D356 0953	D357 0953
0960	9.6		89	47	10	D356 0960	D357 0960
0970	9.7		89	47	10	D356 0970	D357 0970
0980	9.8		89	47	10	D356 0980	D357 0980
0990	9.9		89	47	10	D356 0990	D357 0990
0992	9.92	25/64	89	47	10	D356 0992	D357 0992
1000	10.0		89	47	10	D356 1000	D357 1000
1010	10.1		102	55	12	D356 1010	D357 1010
1020	10.2		102	55	12	D356 1020	D357 1020
1030	10.3		102	55	12	D356 1030	D357 1030
1032	10.32	13/32	102	55	12	D356 1032	D357 1032
1040	10.4		102	55	12	D356 1040	D357 1040
1050	10.5		102	55	12	D356 1050	D357 1050
1060	10.6		102	55	12	D356 1060	D357 1060
1070	10.7		102	55	12	D356 1070	D357 1070
1072	10.72	27/64	102	55	12	D356 1072	D357 1072
1080	10.8		102	55	12	D356 1080	D357 1080
1090	10.9		102	55	12	D356 1090	D357 1090
1100	11.0		102	55	12	D356 1100	D357 1100
1110	11.1		102	55	12	D356 1110	D357 1110
1111	11.11	7/16	102	55	12	D356 1111	D357 1111
1120	11.2		102	55	12	D356 1120	D357 1120
1130	11.3		102	55	12	D356 1130	D357 1130
1140	11.4		102	55	12	D356 1140	D357 1140
1150	11.5		102	55	12	D356 1150	D357 1150
1151	11.51	29/64	102	55	12	D356 1151	D357 1151
1160	11.6		102	55	12	D356 1160	D357 1160
1170	11.7		102	55	12	D356 1170	D357 1170
1180	11.8		102	55	12	D356 1180	D357 1180
1190	11.9		102	55	12	D356 1190	D357 1190
1191	11.91	15/32	102	55	12	D356 1191	D357 1191
1200	12.0		102	55	12	D356 1200	D357 1200
1231	12.30	31/64	107	60	14	D356 1231	D357 1231
1250	12.5		107	60	14	D356 1250	D357 1250
1269	12.70	1/2	107	60	14	D356 1269	D357 1269
1280	12.8		107	60	14	D356 1280	D357 1280
1300	13.0		107	60	14	D356 1300	D357 1300
1310	13.10	33/64	107	60	14	D356 1310	D357 1310

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
D356	●	●	●	●	◐	●	◐	◐		◐		●	◐	●	●	●							●	●	●	●	●						●	◐	●	◐	●	●	●	●	●	●	●						

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

● Optimal ◐ Effective

NOTE: HE shanks available, subject to lead time.

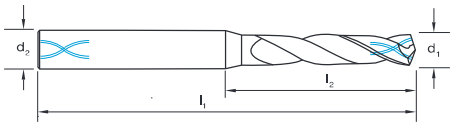
Drills Carbide 3 x D, R30 VA Black Magic

suttontools BLACKMAGIC

- Excellent solution for stainless steels and difficult super alloy type materials
- Optimised geometry ensures no work hardening and high productivity
- HELICA for outstanding oxidation resistance and hot hardness

watch the video

DIN 6537 | 3xd1 | HA | HE | MICRO



	D356	D357
Catalogue Code	D356	D357
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #
1349	13.49	17/32	107	60	14	D356 1349	D357 1349
1350	13.5		107	60	14	D356 1350	D357 1350
1389	13.89	35/64	107	60	14	D356 1389	D357 1389
1400	14.0		107	60	14	D356 1400	D357 1400
1429	14.29	9/16	115	65	16	D356 1429	D357 1429
1450	14.5		115	65	16	D356 1450	D357 1450
1468	14.68	37/64	115	65	16	D356 1468	D357 1468
1500	15.0		115	65	16	D356 1500	D357 1500
1508	15.08	19/32	115	65	16	D356 1508	D357 1508
1548	15.48	39/64	115	65	16	D356 1548	D357 1548
1550	15.5		115	65	16	D356 1550	D357 1550
1588	15.88	5/8	115	65	16	D356 1588	D357 1588
1600	16.0		115	65	16	D356 1600	D357 1600
1650	16.5		123	73	18	D356 1650	D357 1650
1667	16.67	21/32	123	73	18	D356 1667	D357 1667
1700	17.0		123	73	18	D356 1700	D357 1700
1746	17.46	11/16	123	73	18	D356 1746	D357 1746
1750	17.5		123	73	18	D356 1750	D357 1750
1800	18.0		123	73	18	D356 1800	D357 1800
1826	18.26	23/32	131	79	20	D356 1826	D357 1826
1850	18.5		131	79	20	D356 1850	D357 1850
1900	19.0		131	79	20	D356 1900	D357 1900
1905	19.05	3/4	131	79	20	D356 1905	D357 1905
1950	19.5		131	79	20	D356 1950	D357 1950
2000	20.0		131	79	20	D356 2000	D357 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
D356	●	●	●	●	○	●	○	○		○		●	○	●	●	●							●	●	●	●	●						●	○	●	○	●	●	●	●	●	●						

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

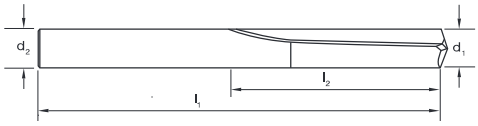
● Optimal ○ Effective

NOTE: HE shanks available, subject to lead time.

Drills Carbide, 3 x D Straight Flute

suttontools

- Suitable for steels 50-60 HRC
- Rigid twist drill with straight flutes
- For drilling short chipping or abrasive materials
- Straight flutes for increased strength and chip control
- TiCN coated for longer tool life



	D300	D306
Catalogue Code	D300	D306
Discount Group	A0202	A0206
Material	VHM	VHM
Surface Finish	Brt	TiCN
Sutton Designation	H	H
Geometry	Straight Flute	Straight Flute
Point Type	140° Type C(Facet)	140° Type C(Facet)
Shank Tolerance	-0.025	-0.025

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2	Item #	Item #
0150	1.5		38	12.7	1.5	D300 0150	D306 0150
0159	1.59	1/16	41	16	1.59	D300 0159	D306 0159
0200	2.0		44	19	2.0	D300 0200	D306 0200
0250	2.5		46	21	2.5	D300 0250	D306 0250
0300	3.0		48	22	3.0	D300 0300	D306 0300
0318	3.18	1/8	48	22	3.18	D300 0318	D306 0318
0350	3.5		49	24	3.5	D300 0350	D306 0350
0400	4.0		54	27	4.0	D300 0400	D306 0400
0450	4.5		56	29	4.5	D300 0450	D306 0450
0476	4.76	3/16	56	29	4.76	D300 0476	D306 0476
0500	5.0		57	30	5.0	D300 0500	D306 0500
0550	5.5		60	32	5.5	D300 0550	D306 0550
0600	6.0		62	33	6.0	D300 0600	D306 0600
0635	6.35	1/4	64	35	6.35	D300 0635	D306 0635
0650	6.5		64	35	6.5	D300 0650	D306 0650
0700	7.0		68	38	7.0	D300 0700	D306 0700
0750	7.5		70	40	7.5	D300 0750	D306 0750
0794	7.94	5/16	71	41	7.94	D300 0794	D306 0794
0800	8.0		71	41	8.0	D300 0800	D306 0800
0850	8.5		76	43	8.5	D300 0850	D306 0850
0900	9.0		78	44	9.0	D300 0900	D306 0900
0953	9.53	3/8	79	46	9.53	D300 0953	D306 0953
1000	10.0		83	48	10.0	D300 1000	D306 1000
1100	11.0		87	52	11.0	D300 1100	D306 1100
1111	11.11	7/16	57	52	11.11	D300 1111	D306 1111
1200	12.0		92	54	12.0	D300 1200	D306 1200
1269	12.7	1/2	98	57	12.7	D300 1269	D306 1269

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
D300									○		○		○				◕	◕	◕	◕	◕	◕			○	○	◕	○	○															○				◕	
D306									○		○		○				◕	◕	◕	◕	◕	◕			○	○	◕	○	○															○				◕	

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

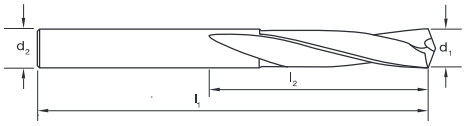
● Optimal ◕ Effective

Drills Carbide, 3 x D, R15 NH

suttontools

- Rigid twist drill with slow spiral 15 degree flutes
- Suitable for martensitic & precipitation hardening, stainless steels & tool steels
- For drilling short chipping or abrasive materials

	D304	D310
Catalogue Code	D304	D310
Discount Group	A0202	A0206
Material	VHM	VHM
Surface Finish	Brt	TiCN
Sutton Designation	NH	NH
Geometry	R15	R15
Point Type	135° 4 Facet Form C	135° 4 Facet Form C
Shank Tolerance	-0.025	-0.025



Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2	Item #	Item #
0100	1.0		38	13	1.0	D304 0100	D310 0100
0150	1.5		38	13	1.5	D304 0150	D310 0150
0159	1.59	1/16	41	16	1.59		D310 0159
0160	1.6		43	18	1.6	D304 0160	D310 0160
0200	2.0		44	19	2.0	D304 0200	D310 0200
0238	2.38	3/32	44	19	2.38		D310 0238
0250	2.5		46	21	2.5	D304 0250	D310 0250
0300	3.0		48	22	3.0	D304 0300	D310 0300
0318	3.18	1/8	48	22	3.18		D310 0318
0330	3.3		52	24	3.3	D304 0330	D310 0330
0350	3.5		52	24	3.5	D304 0350	D310 0350
0397	3.97	5/32	53	27	3.97		D310 0397
0400	4.0		53	27	4.0	D304 0400	D310 0400
0420	4.2		53	27	4.2	D304 0420	D310 0420
0450	4.5		56	29	4.5	D304 0450	D310 0450
0476	4.76	3/16	56	29	4.76		D310 0476
0500	5.0		57	30	5.0	D304 0500	D310 0500
0550	5.5		60	32	5.5	D304 0550	D310 0550
0556	5.56	7/32	60	32	5.56		D310 0556
0600	6.0		62	33	6.0	D304 0600	D310 0600
0635	6.35	1/4	64	35	6.35		D310 0635
0650	6.5		64	35	6.5	D304 0650	D310 0650
0680	6.8		68	38	6.8	D304 0680	D310 0680
0700	7.0		68	38	7.0	D304 0700	D310 0700
0714	7.14	9/32	68	38	7.14		D310 0714
0750	7.5		70	40	7.5	D304 0750	D310 0750
0794	7.94	5/16	71	41	7.94		D310 0794
0800	8.0		71	41	8.0	D304 0800	D310 0800
0850	8.5		76	43	8.5	D304 0850	D310 0850
0873	8.73	11/32	76	43	8.73		D310 0873
0900	9.0		78	44	9.0	D304 0900	D310 0900
0950	9.5		79	46	9.5	D304 0950	D310 0950
0953	9.53	3/8	79	46	9.53		D310 0953
1000	10.0		83	48	10.0	D304 1000	D310 1000
1032	10.32	13/32	64	49	10.32		D310 1032
1050	10.5		86	51	10.5	D304 1050	D310 1050
1100	11.0		87	52	11.0	D304 1100	D310 1100
1111	11.11	7/16	87	52	11.11		D310 1111
1150	11.5		90	54	11.5	D304 1150	D310 1150
1191	11.91	15/32	92	54	11.91		D310 1191
1200	12.0		92	54	12.0	D304 1200	D310 1200
1269	12.7	1/2	98	57	12.7		D310 1269

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
D304			●	●	●		●	●	●	●	●	●	●		○	●	●	●	●	●	●	●	○	○	○	○	●	○	●	○	○													●	○			●	
D310			●	●	●		●	●	●	●	●	●	●		○	●	●	●	●	●	●	●	○	○	○	○	●	○	●	○	○													●	○			●	

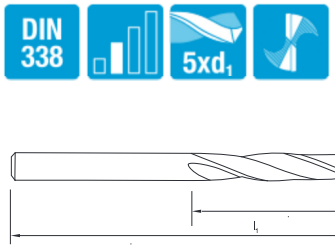
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

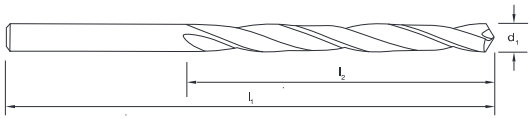
● Optimal ● Effective

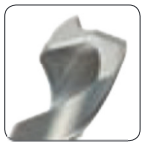
Drills Carbide, 5 x D, R25 N

suttontools TECLINE

- Suitable for steels and abrasive applications
- Designed to allow high feed rates with good chip flow
- Four facet point ensures accurate holes







Catalogue Code	D368
Discount Group	A0208
Material	VHM
Surface Finish	Brt
Sutton Designation	N
Geometry	R25
Point Type	118° Form C
Shank Form (DIN 6535)	HA

Size Ref.	d_1 (h8)	l_1	l_2	Item #
0100	1.0	34	13	D368 0100
0110	1.1	36	15	D368 0110
0120	1.2	38	17	D368 0120
0130	1.3	38	17	D368 0130
0140	1.4	40	19	D368 0140
0150	1.5	40	19	D368 0150
0160	1.6	43	21	D368 0160
0170	1.7	43	21	D368 0170
0180	1.8	46	23	D368 0180
0190	1.9	46	23	D368 0190
0200	2.0	49	24	D368 0200
0210	2.1	49	24	D368 0210
0220	2.2	53	28	D368 0220
0230	2.3	53	28	D368 0230
0240	2.4	57	31	D368 0240
0250	2.5	57	31	D368 0250
0260	2.6	57	31	D368 0260
0270	2.7	61	34	D368 0270
0280	2.8	61	34	D368 0280
0290	2.9	61	34	D368 0290
0300	3.0	61	33	D368 0300
0310	3.1	65	36	D368 0310
0320	3.2	65	36	D368 0320
0330	3.3	65	36	D368 0330
0340	3.4	70	39	D368 0340
0350	3.5	70	39	D368 0350
0360	3.6	70	39	D368 0360
0370	3.7	70	39	D368 0370
0380	3.8	75	43	D368 0380
0390	3.9	75	43	D368 0390
0400	4.0	75	43	D368 0400
0410	4.1	75	43	D368 0410
0420	4.2	75	43	D368 0420
0430	4.3	80	47	D368 0430
0440	4.4	80	47	D368 0440
0450	4.5	80	47	D368 0450
0460	4.6	80	47	D368 0460
0470	4.7	80	47	D368 0470
0480	4.8	86	52	D368 0480
0490	4.9	86	52	D368 0490

Size Ref.	d_1 (h8)	l_1	l_2	Item #
0500	5.0	86	52	D368 0500
0510	5.1	86	52	D368 0510
0520	5.2	86	52	D368 0520
0530	5.3	86	52	D368 0530
0540	5.4	93	57	D368 0540
0550	5.5	93	57	D368 0550
0560	5.6	93	57	D368 0560
0570	5.7	93	57	D368 0570
0580	5.8	93	57	D368 0580
0590	5.9	93	57	D368 0590
0600	6.0	93	57	D368 0600
0610	6.1	101	63	D368 0610
0620	6.2	101	63	D368 0620
0630	6.3	101	63	D368 0630
0640	6.4	101	63	D368 0640
0650	6.5	101	63	D368 0650
0660	6.6	101	63	D368 0660
0670	6.7	101	63	D368 0670
0680	6.8	109	69	D368 0680
0690	6.9	109	69	D368 0690
0700	7.0	109	69	D368 0700
0710	7.1	109	69	D368 0710
0720	7.2	109	69	D368 0720
0730	7.3	109	69	D368 0730
0740	7.4	109	69	D368 0740
0750	7.5	109	69	D368 0750
0760	7.6	117	75	D368 0760
0770	7.7	117	75	D368 0770
0780	7.8	117	75	D368 0780
0790	7.9	117	75	D368 0790
0800	8.0	117	75	D368 0800
0810	8.1	117	75	D368 0810
0820	8.2	117	75	D368 0820
0830	8.3	117	75	D368 0830
0840	8.4	117	75	D368 0840
0850	8.5	117	75	D368 0850
0860	8.6	125	81	D368 0860
0870	8.7	125	81	D368 0870
0880	8.8	125	81	D368 0880
0890	8.9	125	81	D368 0890

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
D368	●	●	●	●	●	●	●	●									●	●	●	●			●	●	●	●	●				●																	

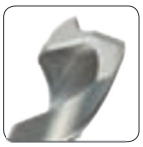
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ● Effective

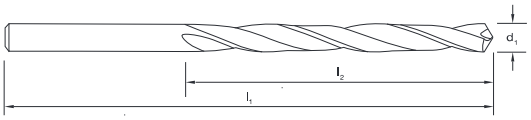
Drills Carbide, 5 x D, R25 N

suttontools TECLINE

- Suitable for steels and abrasive applications
- Designed to allow high feed rates with good chip flow
- Four facet point ensures accurate holes



DIN 338 | 5xd$_1$



Catalogue Code	D368
Discount Group	A0208
Material	VHM
Surface Finish	Brt
Sutton Designation	N
Geometry	R25
Point Type	118° Form C
Shank Form (DIN 6535)	HA

Size Ref.	d$_1$ (h8)	l$_1$	l$_2$	Item #
0900	9.0	125	81	D368 0900
0910	9.1	125	81	D368 0910
0920	9.2	125	81	D368 0920
0930	9.3	125	81	D368 0930
0940	9.4	125	81	D368 0940
0950	9.5	125	81	D368 0950
0960	9.6	133	87	D368 0960
0970	9.7	133	87	D368 0970
0980	9.8	133	87	D368 0980
0990	9.9	133	87	D368 0990
1000	10.0	133	87	D368 1000
1010	10.1	133	87	D368 1010
1020	10.2	133	87	D368 1020
1030	10.3	133	87	D368 1030
1040	10.4	133	87	D368 1040
1050	10.5	133	87	D368 1050
1060	10.6	133	87	D368 1060
1070	10.7	142	94	D368 1070
1080	10.8	142	94	D368 1080
1090	10.9	142	94	D368 1090
1100	11.0	142	94	D368 1100
1110	11.1	142	94	D368 1110
1120	11.2	142	94	D368 1120
1130	11.3	142	94	D368 1130
1140	11.4	142	94	D368 1140
1150	11.5	142	94	D368 1150
1160	11.6	142	94	D368 1160
1170	11.7	142	94	D368 1170
1180	11.8	142	94	D368 1180
1190	11.9	151	101	D368 1190
1200	12.0	151	101	D368 1200
1210	12.1	151	101	D368 1210
1220	12.2	151	101	D368 1220
1230	12.3	151	101	D368 1230
1240	12.4	151	101	D368 1240
1250	12.5	151	101	D368 1250
1260	12.6	151	101	D368 1260
1270	12.7	151	101	D368 1270
1280	12.8	151	101	D368 1280
1290	12.9	151	101	D368 1290
1300	13.0	151	101	D368 1300

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
D368	◕	◕	○	○	○	○	○	○									◕	○	○	○			◕	◕	◕	◕	◕				○																			

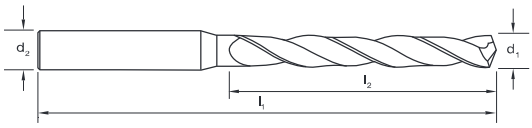
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

◕ Optimal ○ Effective

Drills Carbide, 5 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



	D326	D327	D328
Catalogue Code	D326	D327	D328
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0100	1.0		57	8	4	D326 0100		
0110	1.1		57	12	4	D326 0110		
0120	1.2		57	12	4	D326 0120		
0130	1.3		57	12	4	D326 0130		
0140	1.4		57	12	4	D326 0140		
0150	1.5		57	12	4	D326 0150		
0160	1.6		57	16	4	D326 0160		
0170	1.7		57	16	4	D326 0170		
0180	1.8		57	16	4	D326 0180		
0190	1.9		57	16	4	D326 0190		
0200	2.0		57	21	4	D326 0200		
0210	2.1		57	21	4	D326 0210		
0200	2.2		57	21	4	D326 0200		
0230	2.3		57	21	4	D326 0230		
0240	2.4		57	21	4	D326 0240		
0250	2.5		57	21	4	D326 0250		
0260	2.6		57	21	4	D326 0260		
0270	2.7		57	21	4	D326 0270		
0280	2.8		57	21	4	D326 0280		
0290	2.9		57	21	4	D326 0290		
0300	3.0		66	28	6	D326 0300	D327 0300	D328 0300
0310	3.1		66	28	6	D326 0310	D327 0310	D328 0310
0318	3.18	1/8	66	28	6	D326 0318	D327 0318	D328 0318
0320	3.2		66	28	6	D326 0320	D327 0320	D328 0320
0330	3.3		66	28	6	D326 0330	D327 0330	D328 0330
0340	3.4		66	28	6	D326 0340	D327 0340	D328 0340
0350	3.5		66	28	6	D326 0350	D327 0350	D328 0350
0357	3.57	9/64	66	28	6	D326 0357	D327 0357	D328 0357
0360	3.6		66	28	6	D326 0360	D327 0360	D328 0360
0370	3.7		66	28	6	D326 0370	D327 0370	D328 0370
0380	3.8		74	36	6	D326 0380	D327 0380	D328 0380
0390	3.9		74	36	6	D326 0390	D327 0390	D328 0390
0397	3.97	5/32	74	36	6	D326 0397	D327 0397	D328 0397
0400	4.0		74	36	6	D326 0400	D327 0400	D328 0400
0410	4.1		74	36	6	D326 0410	D327 0410	D328 0410
0420	4.2		74	36	6	D326 0420	D327 0420	D328 0420
0430	4.3		74	36	6	D326 0430	D327 0430	D328 0430
0437	4.37	11/64	74	36	6	D326 0437	D327 0437	D328 0437
0440	4.4		74	36	6	D326 0440	D327 0440	D328 0440
0450	4.5		74	36	6	D326 0450	D327 0450	D328 0450

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
D326	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●																○	○	○		○		○				●	

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

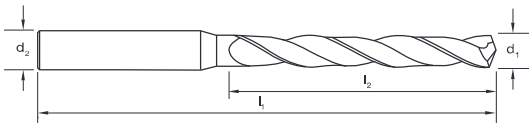
● Optimal ○ Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



Catalogue Code	D326	D327	D328
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0460	4.6		74	36	6	D326 0460	D327 0460	D328 0460
0470	4.7		74	36	6	D326 0470	D327 0470	D328 0470
0476	4.76	3/16	82	44	6	D326 0476	D327 0476	D328 0476
0480	4.8		82	44	6	D326 0480	D327 0480	D328 0480
0490	4.9		82	44	6	D326 0490	D327 0490	D328 0490
0500	5.0		82	44	6	D326 0500	D327 0500	D328 0500
0510	5.1		82	44	6	D326 0510	D327 0510	D328 0510
0516	5.16	13/64	82	44	6	D326 0516	D327 0516	D328 0516
0520	5.2		82	44	6	D326 0520	D327 0520	D328 0520
0530	5.3		82	44	6	D326 0530	D327 0530	D328 0530
0540	5.4		82	44	6	D326 0540	D327 0540	D328 0540
0550	5.5		82	44	6	D326 0550	D327 0550	D328 0550
0556	5.56	7/32	82	44	6	D326 0556	D327 0556	D328 0556
0560	5.6		82	44	6	D326 0560	D327 0560	D328 0560
0570	5.7		82	44	6	D326 0570	D327 0570	D328 0570
0580	5.8		82	44	6	D326 0580	D327 0580	D328 0580
0590	5.9		82	44	6	D326 0590	D327 0590	D328 0590
0595	5.95	15/64	82	44	6	D326 0595	D327 0595	D328 0595
0600	6.0		82	44	6	D326 0600	D327 0600	D328 0600
0610	6.1		91	53	8	D326 0610	D327 0610	D328 0610
0620	6.2		91	53	8	D326 0620	D327 0620	D328 0620
0630	6.3		91	53	8	D326 0630	D327 0630	D328 0630
0635	6.35	1/4	91	53	8	D326 0635	D327 0635	D328 0635
0640	6.4		91	53	8	D326 0640	D327 0640	D328 0640
0650	6.5		91	53	8	D326 0650	D327 0650	D328 0650
0660	6.6		91	53	8	D326 0660	D327 0660	D328 0660
0670	6.7		91	53	8	D326 0670	D327 0670	D328 0670
0676	6.76	17/64	91	53	8	D326 0676	D327 0676	D328 0676
0680	6.8		91	53	8	D326 0680	D327 0680	D328 0680
0690	6.9		91	53	8	D326 0690	D327 0690	D328 0690
0700	7.0		91	53	8	D326 0700	D327 0700	D328 0700
0710	7.1		91	53	8	D326 0710	D327 0710	D328 0710
0714	7.14	9/32	91	53	8	D326 0714	D327 0714	D328 0714
0720	7.2		91	53	8	D326 0720	D327 0720	D328 0720
0730	7.3		91	53	8	D326 0730	D327 0730	D328 0730
0740	7.4		91	53	8	D326 0740	D327 0740	D328 0740
0750	7.5		91	53	8	D326 0750	D327 0750	D328 0750
0754	7.54	19/64	91	53	8	D326 0754	D327 0754	D328 0754
0760	7.6		91	53	8	D326 0760	D327 0760	D328 0760
0770	7.7		91	53	8	D326 0770	D327 0770	D328 0770

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
D326	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●															○	○	○		○		○					●		

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

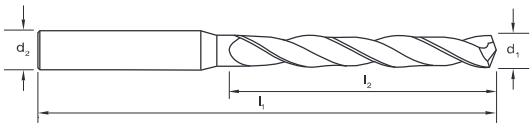
● Optimal ○ Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



	D326	D327	D328
Catalogue Code	D326	D327	D328
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0780	7.8		91	53	8	D326 0780	D327 0780	D328 0780
0790	7.9		91	53	8	D326 0790	D327 0790	D328 0790
0794	7.94	5/16	91	53	8	D326 0794	D327 0794	D328 0794
0800	8.0		91	53	8	D326 0800	D327 0800	D328 0800
0810	8.1		103	61	10	D326 0810	D327 0810	D328 0810
0820	8.2		103	61	10	D326 0820	D327 0820	D328 0820
0830	8.3		103	61	10	D326 0830	D327 0830	D328 0830
0833	8.33	21/64	103	61	10	D326 0833	D327 0833	D328 0833
0840	8.4		103	61	10	D326 0840	D327 0840	D328 0840
0850	8.5		103	61	10	D326 0850	D327 0850	D328 0850
0860	8.6		103	61	10	D326 0860	D327 0860	D328 0860
0870	8.7		103	61	10	D326 0870	D327 0870	D328 0870
0873	8.73	11/32	103	61	10	D326 0873	D327 0873	D328 0873
0880	8.8		103	61	10	D326 0880	D327 0880	D328 0880
0890	8.9		103	61	10	D326 0890	D327 0890	D328 0890
0900	9.0		103	61	10	D326 0900	D327 0900	D328 0900
0910	9.1		103	61	10	D326 0910	D327 0910	D328 0910
0913	9.13	23/64	103	61	10	D326 0913	D327 0913	D328 0913
0920	9.2		103	61	10	D326 0920	D327 0920	D328 0920
0930	9.3		103	61	10	D326 0930	D327 0930	D328 0930
0940	9.4		103	61	10	D326 0940	D327 0940	D328 0940
0950	9.5		103	61	10	D326 0950	D327 0950	D328 0950
0953	9.53	3/8	103	61	10	D326 0953	D327 0953	D328 0953
0960	9.6		103	61	10	D326 0960	D327 0960	D328 0960
0970	9.7		103	61	10	D326 0970	D327 0970	D328 0970
0980	9.8		103	61	10	D326 0980	D327 0980	D328 0980
0990	9.9		103	61	10	D326 0990	D327 0990	D328 0990
0992	9.92	25/64	103	61	10	D326 0992	D327 0992	D328 0992
1000	10.0		103	61	10	D326 1000	D327 1000	D328 1000
1010	10.1		118	71	12	D326 1010	D327 1010	D328 1010
1020	10.2		118	71	12	D326 1020	D327 1020	D328 1020
1030	10.3		118	71	12	D326 1030	D327 1030	D328 1030
1032	10.32	13/32	118	71	12	D326 1032	D327 1032	D328 1032
1040	10.4		118	71	12	D326 1040	D327 1040	D328 1040
1050	10.5		118	71	12	D326 1050	D327 1050	D328 1050
1060	10.6		118	71	12	D326 1060	D327 1060	D328 1060
1070	10.7		118	71	12	D326 1070	D327 1070	D328 1070
1080	10.8		118	71	12	D326 1080	D327 1080	D328 1080
1090	10.9		118	71	12	D326 1090	D327 1090	D328 1090
1100	11.0		118	71	12	D326 1100	D327 1100	D328 1100

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
D326	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●																○	○	○		○		○				●	

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

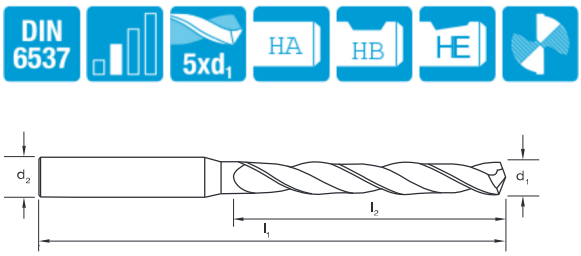
● Optimal ○ Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



	D326	D327	D328
Catalogue Code	D326	D327	D328
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
1110	11.1		118	71	12	D326 1110	D327 1110	D328 1110
1111	11.11	7/16	118	71	12	D326 1111	D327 1111	D328 1111
1120	11.2		118	71	12	D326 1120	D327 1120	D328 1120
1130	11.3		118	71	12	D326 1130	D327 1130	D328 1130
1140	11.4		118	71	12	D326 1140	D327 1140	D328 1140
1150	11.5		118	71	12	D326 1150	D327 1150	D328 1150
1160	11.6		118	71	12	D326 1160	D327 1160	D328 1160
1170	11.7		118	71	12	D326 1170	D327 1170	D328 1170
1180	11.8		118	71	12	D326 1180	D327 1180	D328 1180
1190	11.9		118	71	12	D326 1190	D327 1190	D328 1190
1191	11.91	15/32	118	71	12	D326 1191	D327 1191	D328 1191
1200	12.0		118	71	12	D326 1200	D327 1200	D328 1200
1250	12.5		124	77	14	D326 1250	D327 1250	D328 1250
1269	12.70	1/2	124	77	14	D326 1269	D327 1269	D328 1269
1280	12.8		124	77	14	D326 1280	D327 1280	D328 1280
1300	13.0		124	77	14	D326 1300	D327 1300	D328 1300
1349	13.49	17/32	124	77	14	D326 1349	D327 1349	D328 1349
1350	13.5		124	77	14	D326 1350	D327 1350	D328 1350
1380	13.8		124	77	14	D326 1380	•	•
1400	14.0		124	77	14	D326 1400	D327 1400	D328 1400
1429	14.29	9/16	133	83	16	D326 1429	D327 1429	D328 1429
1450	14.5		133	83	16	D326 1450	D327 1450	D328 1450
1480	14.8		133	83	16	D326 1480	D327 1480	D328 1480
1500	15.0		133	83	16	D326 1500	D327 1500	D328 1500
1550	15.5		133	83	16	D326 1550	D327 1550	D328 1550
1580	15.8		133	83	16	D326 1580	D327 1580	D328 1580
1588	15.88	5/8	133	83	16	D326 1588	D327 1588	D328 1588
1600	16.0		133	83	16	D326 1600	D327 1600	D328 1600
1650	16.5		143	93	18	D326 1650	D327 1650	D328 1650
1680	16.8		143	93	18	D326 1680	D327 1680	D328 1680
1700	17.0		143	93	18	D326 1700	D327 1700	D328 1700
1746	17.46	11/16	143	93	18	D326 1746	D327 1746	D328 1746
1750	17.5		143	93	18	D326 1750	D327 1750	D328 1750
1780	17.8		143	93	18	D326 1780	D327 1780	D328 1780
1800	18.0		143	93	18	D326 1800	D327 1800	D328 1800
1850	18.5		153	101	20	D326 1850	D327 1850	D328 1850
1900	19.0		153	101	20	D326 1900	D327 1900	D328 1900
1905	19.05	3/4	153	101	20	D326 1905	D327 1905	D328 1905
1950	19.5		153	101	20	D326 1950	D327 1950	D328 1950
1980	19.8		153	101	20	•	•	•
2000	20.0		153	101	20	D326 2000	D327 2000	D328 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
D326	●	●	●	●	●	●	●	●	●	●	●		●			○	●	●	●	●	●	●																○	○	○		○		○			●		

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

● Optimal ○ Effective

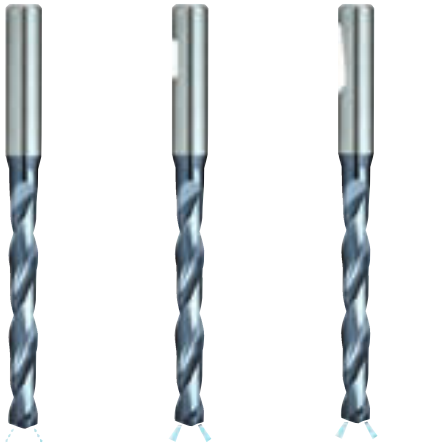
• Available on request as special manufacture. Subject to lead time.

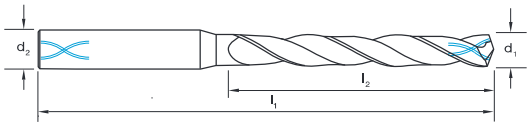
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D332	D333	D334
Catalogue Code	D332	D333	D334
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0300	3.0		66	28	6	D332 0300	D333 0300	D334 0300
0310	3.1		66	28	6	D332 0310	D333 0310	D334 0310
0318	3.18	1/8	66	28	6	D332 0318	D333 0318	D334 0318
0320	3.2		66	28	6	D332 0320	D333 0320	D334 0320
0330	3.3		66	28	6	D332 0330	D333 0330	D334 0330
0340	3.4		66	28	6	D332 0340	D333 0340	D334 0340
0350	3.5		66	28	6	D332 0350	D333 0350	D334 0350
0357	3.57	9/64	66	28	6	D332 0357	D333 0357	D334 0357
0360	3.6		66	28	6	D332 0360	D333 0360	D334 0360
0370	3.7		66	28	6	D332 0370	D333 0370	D334 0370
0380	3.8		74	36	6	D332 0380	D333 0380	D334 0380
0390	3.9		74	36	6	D332 0390	D333 0390	D334 0390
0397	3.97	5/32	74	36	6	D332 0397	D333 0397	D334 0397
0400	4.0		74	36	6	D332 0400	D333 0400	D334 0400
0410	4.1		74	36	6	D332 0410	D333 0410	D334 0410
0420	4.2		74	36	6	D332 0420	D333 0420	D334 0420
0430	4.3		74	36	6	D332 0430	D333 0430	D334 0430
0437	4.37	11/64	74	36	6	D332 0437	D333 0437	D334 0437
0440	4.4		74	36	6	D332 0440	D333 0440	D334 0440
0450	4.5		74	36	6	D332 0450	D333 0450	D334 0450
0460	4.6		74	36	6	D332 0460	D333 0460	D334 0460
0470	4.7		74	36	6	D332 0470	D333 0470	D334 0470
0476	4.76	3/16	82	44	6	D332 0476	D333 0476	D334 0476
0480	4.8		82	44	6	D332 0480	D333 0480	D334 0480
0490	4.9		82	44	6	D332 0490	D333 0490	D334 0490
0500	5.0		82	44	6	D332 0500	D333 0500	D334 0500
0510	5.1		82	44	6	D332 0510	D333 0510	D334 0510
0516	5.16	13/64	82	44	6	D332 0516	D333 0516	D334 0516
0520	5.2		82	44	6	D332 0520	D333 0520	D334 0520
0530	5.3		82	44	6	D332 0530	D333 0530	D334 0530
0540	5.4		82	44	6	D332 0540	D333 0540	D334 0540
0550	5.5		82	44	6	D332 0550	D333 0550	D334 0550
0556	5.56	7/32	82	44	6	D332 0556	D333 0556	D334 0556
0560	5.6		82	44	6	D332 0560	D333 0560	D334 0560
0570	5.7		82	44	6	D332 0570	D333 0570	D334 0570
0580	5.8		82	44	6	D332 0580	D333 0580	D334 0580
0590	5.9		82	44	6	D332 0590	D333 0590	D334 0590
0595	5.95	15/64	82	44	6	D332 0595	D333 0595	D334 0595
0600	6.0		82	44	6	D332 0600	D333 0600	D334 0600
0610	6.1		91	53	8	D332 0610	D333 0610	D334 0610

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
D332	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	●	●	●	●	●	●	●					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	○	●				●	

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

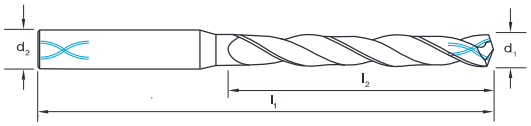
● Optimal ● Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



Catalogue Code	D332	D333	D334
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0620	6.2		91	53	8	D332 0620	D333 0620	D334 0620
0630	6.3		91	53	8	D332 0630	D333 0630	D334 0630
0635	6.35	1/4	91	53	8	D332 0635	D333 0635	D334 0635
0640	6.4		91	53	8	D332 0640	D333 0640	D334 0640
0650	6.5		91	53	8	D332 0650	D333 0650	D334 0650
0660	6.6		91	53	8	D332 0660	D333 0660	D334 0660
0670	6.7		91	53	8	D332 0670	D333 0670	D334 0670
0676	6.76	17/64	91	53	8	D332 0676	D333 0676	D334 0676
0680	6.8		91	53	8	D332 0680	D333 0680	D334 0680
0690	6.9		91	53	8	D332 0690	D333 0690	D334 0690
0700	7.0		91	53	8	D332 0700	D333 0700	D334 0700
0710	7.1		91	53	8	D332 0710	D333 0710	D334 0710
0714	7.14	9/32	91	53	8	D332 0714	D333 0714	D334 0714
0720	7.2		91	53	8	D332 0720	D333 0720	D334 0720
0730	7.3		91	53	8	D332 0730	D333 0730	D334 0730
0740	7.4		91	53	8	D332 0740	D333 0740	D334 0740
0750	7.5		91	53	8	D332 0750	D333 0750	D334 0750
0754	7.54	19/64	91	53	8	D332 0754	D333 0754	D334 0754
0760	7.6		91	53	8	D332 0760	D333 0760	D334 0760
0770	7.7		91	53	8	D332 0770	D333 0770	D334 0770
0780	7.8		91	53	8	D332 0780	D333 0780	D334 0780
0790	7.9		91	53	8	D332 0790	D333 0790	D334 0790
0794	7.94	5/16	91	53	8	D332 0794	D333 0794	D334 0794
0800	8.0		91	53	8	D332 0800	D333 0800	D334 0800
0810	8.1		103	61	10	D332 0810	D333 0810	D334 0810
0820	8.2		103	61	10	D332 0820	D333 0820	D334 0820
0830	8.3		103	61	10	D332 0830	D333 0830	D334 0830
0833	8.33	21/64	103	61	10	D332 0833	D333 0833	D334 0833
0840	8.4		103	61	10	D332 0840	D333 0840	D334 0840
0850	8.5		103	61	10	D332 0850	D333 0850	D334 0850
0860	8.6		103	61	10	D332 0860	D333 0860	D334 0860
0870	8.7		103	61	10	D332 0870	D333 0870	D334 0870
0873	8.73	11/32	103	61	10	D332 0873	D333 0873	D334 0873
0880	8.8		103	61	10	D332 0880	D333 0880	D334 0880
0890	8.9		103	61	10	D332 0890	D333 0890	D334 0890
0900	9.0		103	61	10	D332 0900	D333 0900	D334 0900
0910	9.1		103	61	10	D332 0910	D333 0910	D334 0910
0913	9.13	23/64	103	61	10	D332 0913	D333 0913	D334 0913
0920	9.2		103	61	10	D332 0920	D333 0920	D334 0920
0930	9.3		103	61	10	D332 0930	D333 0930	D334 0930

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
D332	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	●	●	●	●	●	●					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	●				●	

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

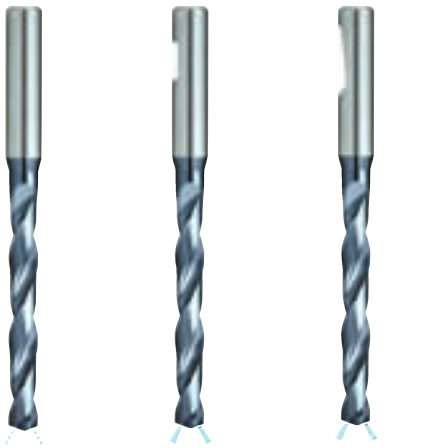
● Optimal ○ Effective

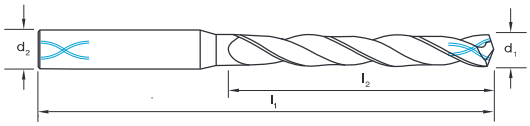
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D332	D333	D334
Catalogue Code	D332	D333	D334
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0940	9.4		103	61	10	D332 0940	D333 0940	D334 0940
0950	9.5		103	61	10	D332 0950	D333 0950	D334 0950
0953	9.53	3/8	103	61	10	D332 0953	D333 0953	D334 0953
0960	9.6		103	61	10	D332 0960	D333 0960	D334 0960
0970	9.7		103	61	10	D332 0970	D333 0970	D334 0970
0980	9.8		103	61	10	D332 0980	D333 0980	D334 0980
0990	9.9		103	61	10	D332 0990	D333 0990	D334 0990
0992	9.92	25/64	103	61	10	D332 0992	D333 0992	D334 0992
1000	10.0		103	61	10	D332 1000	D333 1000	D334 1000
1010	10.1		118	71	12	D332 1010	D333 1010	D334 1010
1020	10.2		118	71	12	D332 1020	D333 1020	D334 1020
1030	10.3		118	71	12	D332 1030	D333 1030	D334 1030
1032	10.32	13/32	118	71	12	D332 1032	D333 1032	D334 1032
1040	10.4		118	71	12	D332 1040	D333 1040	D334 1040
1050	10.5		118	71	12	D332 1050	D333 1050	D334 1050
1060	10.6		118	71	12	D332 1060	D333 1060	D334 1060
1070	10.7		118	71	12	D332 1070	D333 1070	D334 1070
1080	10.8		118	71	12	D332 1080	D333 1080	D334 1080
1090	10.9		118	71	12	D332 1090	D333 1090	D334 1090
1100	11.0		118	71	12	D332 1100	D333 1100	D334 1100
1110	11.1		118	71	12	D332 1110	D333 1110	D334 1110
1111	11.11	7/16	118	71	12	D332 1111	D333 1111	D334 1111
1120	11.2		118	71	12	D332 1120	D333 1120	D334 1120
1130	11.3		118	71	12	D332 1130	D333 1130	D334 1130
1140	11.4		118	71	12	D332 1140	D333 1140	D334 1140
1150	11.5		118	71	12	D332 1150	D333 1150	D334 1150
1160	11.6		118	71	12	D332 1160	D333 1160	D334 1160
1170	11.7		118	71	12	D332 1170	D333 1170	D334 1170
1180	11.8		118	71	12	D332 1180	D333 1180	D334 1180
1190	11.9		118	71	12	D332 1190	D333 1190	D334 1190
1191	11.91	15/32	118	71	12	D332 1191	D333 1191	D334 1191
1200	12.0		118	71	12	D332 1200	D333 1200	D334 1200
1250	12.5		124	77	14	D332 1250	D333 1250	D334 1250
1269	12.70	1/2	124	77	14	D332 1269	D333 1269	D334 1269
1280	12.8		124	77	14	D332 1280	D333 1280	D334 1280
1300	13.0		124	77	14	D332 1300	D333 1300	D334 1300
1349	13.49	17/32	124	77	14	D332 1349	D333 1349	D334 1349
1350	13.5		124	77	14	D332 1350	D333 1350	D334 1350
1380	13.8		124	77	14	•	•	•
1400	14.0		124	77	14	D332 1400	D333 1400	D334 1400

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
D332	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	●	●	●	●	●	●	●					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	○	●				●	

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

● Optimal ● Effective

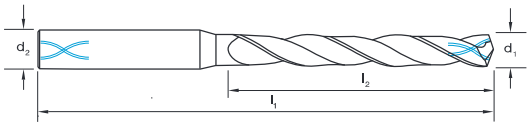
• Available on request as special manufacture. Subject to lead time.

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 5 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life



Catalogue Code	D332	D333	D334
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30	R30	R30
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
1429	14.29	9/16	133	83	16	D332 1429	D333 1429	D334 1429
1450	14.5		133	83	16	D332 1450	D333 1450	D334 1450
1480	14.8		133	83	16	•	•	•
1500	15.0		133	83	16	D332 1500	D333 1500	D334 1500
1550	15.5		133	83	16	D332 1550	D333 1550	D334 1550
1580	15.8		133	83	16	•	•	•
1588	15.88	5/8	133	83	16	D332 1588	D333 1588	D334 1588
1600	16.0		133	83	16	D332 1600	D333 1600	D334 1600
1650	16.5		143	93	18	D332 1650	D333 1650	D334 1650
1680	16.8		143	93	18	•	•	•
1700	17.0		143	93	18	D332 1700	D333 1700	D334 1700
1746	17.46	11/16	143	93	18	D332 1746	D333 1746	D334 1746
1750	17.5		143	93	18	D332 1750	D333 1750	D334 1750
1780	17.8		143	93	18	•	•	•
1800	18.0		143	93	18	D332 1800	D333 1800	D334 1800
1850	18.5		153	101	20	D332 1850	D333 1850	D334 1850
1900	19.0		153	101	20	D332 1900	D333 1900	D334 1900
1905	19.05	3/4	153	101	20	D332 1905	D333 1905	D334 1905
1950	19.5		153	101	20	D332 1950	D333 1950	D334 1950
1980	19.8		153	101	20	•	•	•
2000	20.0		153	101	20	D332 2000	D333 2000	D334 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
D332	◕	◕	◕	◕	◕	◕	◕	◕	◕	◕	◕	◕	◕	○	◕	◕	◕	◕	◕	◕	◕	◕					○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	◕				◕	

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

● Optimal ◕ Effective

• Available on request as special manufacture. Subject to lead time.

NOTE: HB & HE shanks available, subject to lead time.

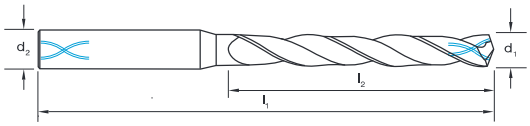
Drills Carbide 5 x D, R30 VA Black Magic

suttontools BLACKMAGIC

- Excellent solution for stainless steels and difficult super alloy type materials
- Optimised geometry ensures no work hardening and high productivity
- HELICA for outstanding oxidation resistance and hot hardness

watch the video

DIN 6537 | 5xd1 | HA | HE | MICRO



	D358	D359
Catalogue Code	D358	D359
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #
0300	3.0		66	28	6	D358 0300	D359 0300
0310	3.1		66	28	6	D358 0310	D359 0310
0318	3.18	1/8	66	28	6	D358 0318	D359 0318
0320	3.2		66	28	6	D358 0320	D359 0320
0330	3.3		66	28	6	D358 0330	D359 0330
0340	3.4		66	28	6	D358 0340	D359 0340
0350	3.5		66	28	6	D358 0350	D359 0350
0357	3.57	9/64	66	28	6	D358 0357	D359 0357
0360	3.6		66	28	6	D358 0360	D359 0360
0370	3.7		66	28	6	D358 0370	D359 0370
0380	3.8		74	36	6	D358 0380	D359 0380
0390	3.9		74	36	6	D358 0390	D359 0390
0397	3.97	5/32	74	36	6	D358 0397	D359 0397
0400	4.0		74	36	6	D358 0400	D359 0400
0410	4.1		74	36	6	D358 0410	D359 0410
0420	4.2		74	36	6	D358 0420	D359 0420
0430	4.3		74	36	6	D358 0430	D359 0430
0437	4.37	11/64	74	36	6	D358 0437	D359 0437
0440	4.4		74	36	6	D358 0440	D359 0440
0450	4.5		74	36	6	D358 0450	D359 0450
0460	4.6		74	36	6	D358 0460	D359 0460
0470	4.7		74	36	6	D358 0470	D359 0470
0476	4.76	3/16	82	44	6	D358 0476	D359 0476
0480	4.8		82	44	6	D358 0480	D359 0480
0490	4.9		82	44	6	D358 0490	D359 0490
0500	5.0		82	44	6	D358 0500	D359 0500
0510	5.1		82	44	6	D358 0510	D359 0510
0516	5.16	13/64	82	44	6	D358 0516	D359 0516
0520	5.2		82	44	6	D358 0520	D359 0520
0530	5.3		82	44	6	D358 0530	D359 0530
0540	5.4		82	44	6	D358 0540	D359 0540
0550	5.5		82	44	6	D358 0550	D359 0550
0556	5.56	7/32	82	44	6	D358 0556	D359 0556
0560	5.6		82	44	6	D358 0560	D359 0560
0570	5.7		82	44	6	D358 0570	D359 0570
0580	5.8		82	44	6	D358 0580	D359 0580
0590	5.9		82	44	6	D358 0590	D359 0590
0595	5.95	15/64	82	44	6	D358 0595	D359 0595
0600	6.0		82	44	6	D358 0600	D359 0600
0610	6.1		91	53	8	D358 0610	D359 0610

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
D358	●	●	●	●	◐	●	◐	◐		◐		●	◐	●	●	●							●	●	●	●	●						●	◐	●	◐	●	●	●	●	●	●	●						

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

● Optimal ◐ Effective

NOTE: HE shanks available, subject to lead time.

Drills Carbide 5 x D, R30 VA Black Magic

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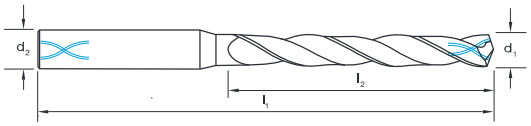

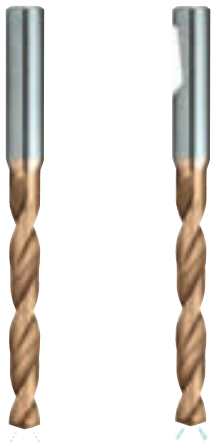

Catalogue Code	D358	D359
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #
0620	6.2		91	53	8	D358 0620	D359 0620
0630	6.3		91	53	8	D358 0630	D359 0630
0635	6.35	1/4	91	53	8	D358 0635	D359 0635
0640	6.4		91	53	8	D358 0640	D359 0640
0650	6.5		91	53	8	D358 0650	D359 0650
0660	6.6		91	53	8	D358 0660	D359 0660
0670	6.7		91	53	8	D358 0670	D359 0670
0676	6.76	17/64	91	53	8	D358 0676	D359 0676
0680	6.8		91	53	8	D358 0680	D359 0680
0690	6.9		91	53	8	D358 0690	D359 0690
0700	7.0		91	53	8	D358 0700	D359 0700
0710	7.1		91	53	8	D358 0710	D359 0710
0714	7.14	9/32	91	53	8	D358 0714	D359 0714
0720	7.2		91	53	8	D358 0720	D359 0720
0730	7.3		91	53	8	D358 0730	D359 0730
0740	7.4		91	53	8	D358 0740	D359 0740
0750	7.5		91	53	8	D358 0750	D359 0750
0754	7.54	19/64	91	53	8	D358 0754	D359 0754
0760	7.6		91	53	8	D358 0760	D359 0760
0770	7.7		91	53	8	D358 0770	D359 0770
0780	7.8		91	53	8	D358 0780	D359 0780
0790	7.9		91	53	8	D358 0790	D359 0790
0794	7.94	5/16	91	53	8	D358 0794	D359 0794
0800	8.0		91	53	8	D358 0800	D359 0800
0810	8.1		103	61	10	D358 0810	D359 0810
0820	8.2		103	61	10	D358 0820	D359 0820
0830	8.3		103	61	10	D358 0830	D359 0830
0833	8.33	21/64	103	61	10	D358 0833	D359 0833
0840	8.4		103	61	10	D358 0840	D359 0840
0850	8.5		103	61	10	D358 0850	D359 0850
0860	8.6		103	61	10	D358 0860	D359 0860
0870	8.7		103	61	10	D358 0870	D359 0870
0873	8.73	11/32	103	61	10	D358 0873	D359 0873
0880	8.8		103	61	10	D358 0880	D359 0880
0890	8.9		103	61	10	D358 0890	D359 0890
0900	9.0		103	61	10	D358 0900	D359 0900
0910	9.1		103	61	10	D358 0910	D359 0910
0913	9.13	23/64	103	61	10	D358 0913	D359 0913
0920	9.2		103	61	10	D358 0920	D359 0920
0930	9.3		103	61	10	D358 0930	D359 0930

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
D358	●	●	●	●	○	●	○	○		○		●	○	●	●	●							●	●	●	●	●						●	○	●	○	●	○	●	○	●	●	●						

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

● Optimal ○ Effective

NOTE: HE shanks available, subject to lead time.

Drills Carbide 5 x D, R30 VA Black Magic

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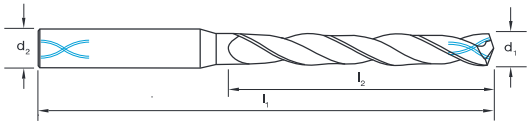

Catalogue Code	D358	D359
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #
0940	9.4		103	61	10	D358 0940	D359 0940
0950	9.5		103	61	10	D358 0950	D359 0950
0953	9.53	3/8	103	61	10	D358 0953	D359 0953
0960	9.6		103	61	10	D358 0960	D359 0960
0970	9.7		103	61	10	D358 0970	D359 0970
0980	9.8		103	61	10	D358 0980	D359 0980
0990	9.9		103	61	10	D358 0990	D359 0990
0992	9.92	25/64	103	61	10	D358 0992	D359 0992
1000	10.0		103	61	10	D358 1000	D359 1000
1010	10.1		118	71	12	D358 1010	D359 1010
1020	10.2		118	71	12	D358 1020	D359 1020
1030	10.3		118	71	12	D358 1030	D359 1030
1032	10.32	13/32	118	71	12	D358 1032	D359 1032
1040	10.4		118	71	12	D358 1040	D359 1040
1050	10.5		118	71	12	D358 1050	D359 1050
1060	10.6		118	71	12	D358 1060	D359 1060
1070	10.7		118	71	12	D358 1070	D359 1070
1072	10.72	27/64	118	71	12	D358 1072	D359 1072
1080	10.8		118	71	12	D358 1080	D359 1080
1090	10.9		118	71	12	D358 1090	D359 1090
1100	11.0		118	71	12	D358 1100	D359 1100
1110	11.1		118	71	12	D358 1110	D359 1110
1111	11.11	7/16	118	71	12	D358 1111	D359 1111
1120	11.2		118	71	12	D358 1120	D359 1120
1130	11.3		118	71	12	D358 1130	D359 1130
1140	11.4		118	71	12	D358 1140	D359 1140
1150	11.5		118	71	12	D358 1150	D359 1150
1151	11.51	29/64	118	71	12	D358 1151	D359 1151
1160	11.6		118	71	12	D358 1160	D359 1160
1170	11.7		118	71	12	D358 1170	D359 1170
1180	11.8		118	71	12	D358 1180	D359 1180
1190	11.9		118	71	12	D358 1190	D359 1190
1191	11.91	15/32	118	71	12	D358 1191	D359 1191
1200	12.0		118	71	12	D358 1200	D359 1200
1231	12.30	31/64	124	77	14	D358 1231	D359 1231
1250	12.5		124	77	14	D358 1250	D359 1250
1269	12.70	1/2	124	77	14	D358 1269	D359 1269
1280	12.8		124	77	14	D358 1280	D359 1280
1300	13.0		124	77	14	D358 1300	D359 1300
1310	13.10	33/64	124	77	14	D358 1310	D359 1310

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
D358	●	●	●	●	◐	◐	◐	◐		◐		●	◐	●	●	●							●	●	●	●	●	●					●	◐	●	◐	◐	●	●	●	●	●						

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

● Optimal ◐ Effective

NOTE: HE shanks available, subject to lead time.

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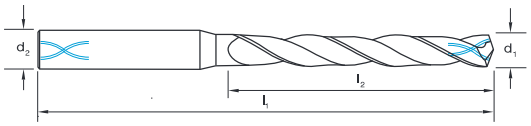

	D358	D359
Catalogue Code	D358	D359
Discount Group	A0210	A0210
Material	VHM	VHM
Surface Finish	HELICA	HELICA
Sutton Designation	VA	VA
Geometry	R30 - IK	R30 - IK
Point Type	140° 4 Facet Form C	140° 4 Facet Form C
Shank Form (DIN 6535)	HA	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #
1349	13.49	17/32	124	77	14	D358 1349	D359 1349
1350	13.5		124	77	14	D358 1350	D359 1350
1389	13.89	35/64	124	77	14	D358 1389	D359 1389
1400	14.0		124	77	14	D358 1400	D359 1400
1429	14.29	9/16	133	83	16	D358 1429	D359 1429
1450	14.5		133	83	16	D358 1450	D359 1450
1468	14.68	37/64	133	83	16	D358 1468	D359 1468
1500	15.0		133	83	16	D358 1500	D359 1500
1508	15.08	19/32	133	83	16	D358 1508	D359 1508
1548	15.48	39/64	133	83	16	D358 1548	D359 1548
1550	15.5		133	83	16	D358 1550	D359 1550
1588	15.88	5/8	133	83	16	D358 1588	D359 1588
1600	16.0		133	83	16	D358 1600	D359 1600
1650	16.5		143	93	18	D358 1650	D359 1650
1667	16.67	21/32	143	93	18	D358 1667	D359 1667
1700	17.0		143	93	18	D358 1700	D359 1700
1746	17.46	11/16	143	93	18	D358 1746	D359 1746
1750	17.5		143	93	18	D358 1750	D359 1750
1800	18.0		143	93	18	D358 1800	D359 1800
1826	18.26	23/32	153	101	20	D358 1826	D359 1826
1850	18.5		153	101	20	D358 1850	D359 1850
1900	19.0		153	101	20	D358 1900	D359 1900
1905	19.05	3/4	153	101	20	D358 1905	D359 1905
1950	19.5		153	101	20	D358 1950	D359 1950
2000	20.0		153	101	20	D358 2000	D359 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
D358	●	●	●	●	○	●	○	○		○		●	○	●	●	●							●	●	●	●	●						●	○	●	○	●	○	●	○	●	●	●						

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

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NOTE: HE shanks available, subject to lead time.

Drills Carbide, 8 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
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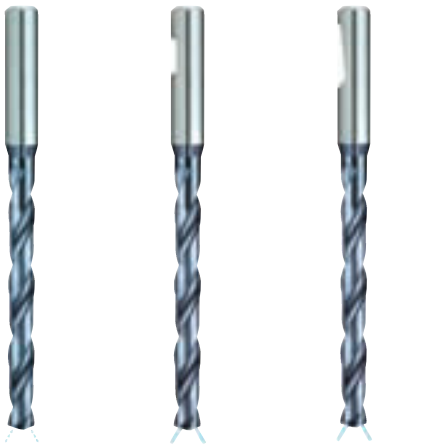
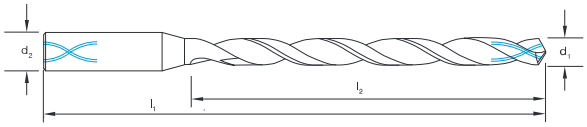
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D335	D336	D337
Catalogue Code	D335	D336	D337
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0300	3.0		72	34	6	D335 0300	D336 0300	D337 0300
0310	3.1		72	34	6	D335 0310	D336 0310	D337 0310
0318	3.18	1/8	72	34	6	D335 0318	D336 0318	D337 0318
0320	3.2		72	34	6	D335 0320	D336 0320	D337 0320
0330	3.3		72	34	6	D335 0330	D336 0330	D337 0330
0340	3.4		72	34	6	D335 0340	D336 0340	D337 0340
0350	3.5		72	34	6	D335 0350	D336 0350	D337 0350
0357	3.57	9/64	72	34	6	D335 0357	D336 0357	D337 0357
0360	3.6		72	34	6	D335 0360	D336 0360	D337 0360
0370	3.7		72	34	6	D335 0370	D336 0370	D337 0370
0380	3.8		81	43	6	D335 0380	D336 0380	D337 0380
0390	3.9		81	43	6	D335 0390	D336 0390	D337 0390
0397	3.97	5/32	81	43	6	D335 0397	D336 0397	D337 0397
0400	4.0		81	43	6	D335 0400	D336 0400	D337 0400
0410	4.1		81	43	6	D335 0410	D336 0410	D337 0410
0420	4.2		81	43	6	D335 0420	D336 0420	D337 0420
0430	4.3		81	43	6	D335 0430	D336 0430	D337 0430
0437	4.37	11/64	81	43	6	D335 0437	D336 0437	D337 0437
0440	4.4		81	43	6	D335 0440	D336 0440	D337 0440
0450	4.5		81	43	6	D335 0450	D336 0450	D337 0450
0460	4.6		81	43	6	D335 0460	D336 0460	D337 0460
0470	4.7		81	43	6	D335 0470	D336 0470	D337 0470
0476	4.76	3/16	95	57	6	D335 0476	D336 0476	D337 0476
0480	4.8		95	57	6	D335 0480	D336 0480	D337 0480
0490	4.9		95	57	6	D335 0490	D336 0490	D337 0490
0500	5.0		95	57	6	D335 0500	D336 0500	D337 0500
0510	5.1		95	57	6	D335 0510	D336 0510	D337 0510
0516	5.16	13/64	95	57	6	D335 0516	D336 0516	D337 0516
0520	5.2		95	57	6	D335 0520	D336 0520	D337 0520
0530	5.3		95	57	6	D335 0530	D336 0530	D337 0530
0540	5.4		95	57	6	D335 0540	D336 0540	D337 0540
0550	5.5		95	57	6	D335 0550	D336 0550	D337 0550
0556	5.56	7/32	95	57	6	D335 0556	D336 0556	D337 0556
0560	5.6		95	57	6	D335 0560	D336 0560	D337 0560
0570	5.7		95	57	6	D335 0570	D336 0570	D337 0570
0580	5.8		95	57	6	D335 0580	D336 0580	D337 0580
0590	5.9		95	57	6	D335 0590	D336 0590	D337 0590
0595	5.95	15/64	95	57	6	D335 0595	D336 0595	D337 0595
0600	6.0		95	57	6	D335 0600	D336 0600	D337 0600
0610	6.1		114	76	8	D335 0610	D336 0610	D337 0610

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
D335	●	●	●	●	●	●	●	●	●	●	●		●	◐			●	●	●	●	●	●																												

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

● Optimal ◐ Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 8 x D, R30 N, IK

suttontools

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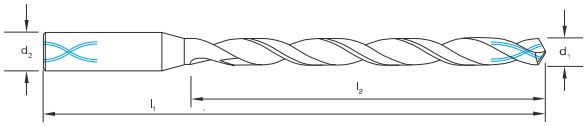
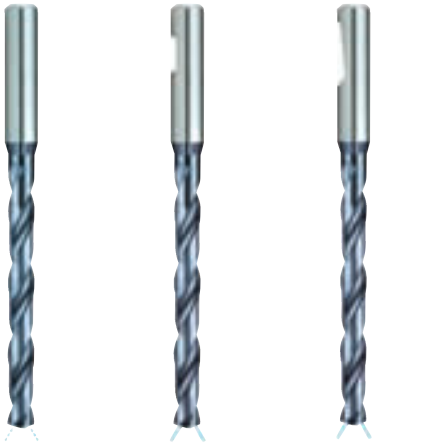
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





Catalogue Code	D335	D336	D337
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0620	6.2		114	76	8	D335 0620	D336 0620	D337 0620
0630	6.3		114	76	8	D335 0630	D336 0630	D337 0630
0635	6.35	1/4	114	76	8	D335 0635	D336 0635	D337 0635
0640	6.4		114	76	8	D335 0640	D336 0640	D337 0640
0650	6.5		114	76	8	D335 0650	D336 0650	D337 0650
0660	6.6		114	76	8	D335 0660	D336 0660	D337 0660
0670	6.7		114	76	8	D335 0670	D336 0670	D337 0670
0676	6.76	17/64	114	76	8	D335 0676	D336 0676	D337 0676
0680	6.8		114	76	8	D335 0680	D336 0680	D337 0680
0690	6.9		114	76	8	D335 0690	D336 0690	D337 0690
0700	7.0		114	76	8	D335 0700	D336 0700	D337 0700
0710	7.1		114	76	8	D335 0710	D336 0710	D337 0710
0714	7.14	9/32	114	76	8	D335 0714	D336 0714	D337 0714
0720	7.2		114	76	8	D335 0720	D336 0720	D337 0720
0730	7.3		114	76	8	D335 0730	D336 0730	D337 0730
0740	7.4		114	76	8	D335 0740	D336 0740	D337 0740
0750	7.5		114	76	8	D335 0750	D336 0750	D337 0750
0754	7.54	19/64	114	76	8	D335 0754	D336 0754	D337 0754
0760	7.6		114	76	8	D335 0760	D336 0760	D337 0760
0770	7.7		114	76	8	D335 0770	D336 0770	D337 0770
0780	7.8		114	76	8	D335 0780	D336 0780	D337 0780
0790	7.9		114	76	8	D335 0790	D336 0790	D337 0790
0794	7.94	5/16	114	76	8	D335 0794	D336 0794	D337 0794
0800	8.0		114	76	8	D335 0800	D336 0800	D337 0800
0810	8.1		142	95	10	D335 0810	D336 0810	D337 0810
0820	8.2		142	95	10	D335 0820	D336 0820	D337 0820
0830	8.3		142	95	10	D335 0830	D336 0830	D337 0830
0833	8.33	21/64	142	95	10	D335 0833	D336 0833	D337 0833
0840	8.4		142	95	10	D335 0840	D336 0840	D337 0840
0850	8.5		142	95	10	D335 0850	D336 0850	D337 0850
0860	8.6		142	95	10	D335 0860	D336 0860	D337 0860
0870	8.7		142	95	10	D335 0870	D336 0870	D337 0870
0873	8.73	11/32	142	95	10	D335 0873	D336 0873	D337 0873
0880	8.8		142	95	10	D335 0880	D336 0880	D337 0880
0890	8.9		142	95	10	D335 0890	D336 0890	D337 0890
0900	9.0		142	95	10	D335 0900	D336 0900	D337 0900
0910	9.1		142	95	10	D335 0910	D336 0910	D337 0910
0913	9.13	23/64	142	95	10	D335 0913	D336 0913	D337 0913
0920	9.2		142	95	10	D335 0920	D336 0920	D337 0920
0930	9.3		142	95	10	D335 0930	D336 0930	D337 0930

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
D335	●	●	●	●	●	●	●	●	●	●	●		●	◐			●	●	●	●	●	●																												

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

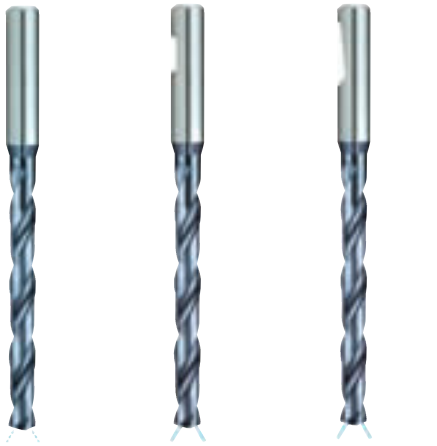
● Optimal ◐ Effective

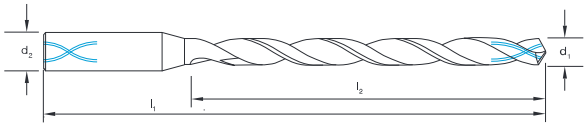
NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 8 x D, R30 N, IK

suttontools

- Suitable for materials up to 1400N/mm²
- Strong core with internal coolant supply
- Micro geometry & surface conditioning for optimal chip control
- AlCrN for maximum tool life





	D335	D336	D337
Catalogue Code	D335	D336	D337
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
0940	9.4		142	95	10	D335 0940	D336 0940	D337 0940
0950	9.5		142	95	10	D335 0950	D336 0950	D337 0950
0953	9.53	3/8	142	95	10	D335 0953	D336 0953	D337 0953
0960	9.6		142	95	10	D335 0960	D336 0960	D337 0960
0970	9.7		142	95	10	D335 0970	D336 0970	D337 0970
0980	9.8		142	95	10	D335 0980	D336 0980	D337 0980
0990	9.9		142	95	10	D335 0990	D336 0990	D337 0990
0992	9.92	25/64	142	95	10	D335 0992	D336 0992	D337 0992
1000	10.0		142	95	10	D335 1000	D336 1000	D337 1000
1010	10.1		162	114	12	D335 1010	D336 1010	D337 1010
1020	10.2		162	114	12	D335 1020	D336 1020	D337 1020
1030	10.3		162	114	12	D335 1030	D336 1030	D337 1030
1032	10.32	13/32	162	114	12	D335 1032	D336 1032	D337 1032
1040	10.4		162	114	12	D335 1040	D336 1040	D337 1040
1050	10.5		162	114	12	D335 1050	D336 1050	D337 1050
1060	10.6		162	114	12	D335 1060	D336 1060	D337 1060
1070	10.7		162	114	12	D335 1070	D336 1070	D337 1070
1080	10.8		162	114	12	D335 1080	D336 1080	D337 1080
1090	10.9		162	114	12	D335 1090	D336 1090	D337 1090
1100	11.0		162	114	12	D335 1100	D336 1100	D337 1100
1110	11.1		162	114	12	D335 1110	D336 1110	D337 1110
1111	11.11	7/16	162	114	12	D335 1111	D336 1111	D337 1111
1120	11.2		162	114	12	D335 1120	D336 1120	D337 1120
1130	11.3		162	114	12	D335 1130	D336 1130	D337 1130
1140	11.4		162	114	12	D335 1140	D336 1140	D337 1140
1150	11.5		162	114	12	D335 1150	D336 1150	D337 1150
1160	11.6		162	114	12	D335 1160	D336 1160	D337 1160
1170	11.7		162	114	12	D335 1170	D336 1170	D337 1170
1180	11.8		162	114	12	D335 1180	D336 1180	D337 1180
1190	11.9		162	114	12	D335 1190	D336 1190	D337 1190
1191	11.91	15/32	162	114	12	D335 1191	D336 1191	D337 1191
1200	12.0		162	114	12	D335 1200	D336 1200	D337 1200
1250	12.5		178	133	14	D335 1250	D336 1250	D337 1250
1269	12.70	1/2	178	133	14	D335 1269	D336 1269	D337 1269
1280	12.8		178	133	14	D335 1280	D336 1280	D337 1280
1300	13.0		178	133	14	D335 1300	D336 1300	D337 1300
1349	13.49	17/32	178	133	14	D335 1349	D336 1349	D337 1349
1350	13.5		178	133	14	D335 1350	D336 1350	D337 1350
1380	13.8		178	133	14	D335 1380	D336 1380	D337 1380
1400	14.0		178	133	14	D335 1400	D336 1400	D337 1400

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
D335	●	●	●	●	●	●	●	●	●	●	●		●	●			●	●	●	●	●	●																											

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

● Optimal ● Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 8 x D, R30 N, IK

suttontools

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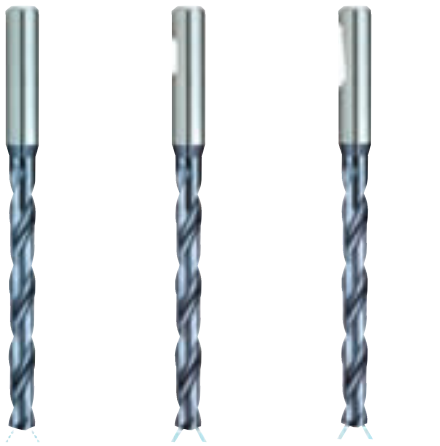
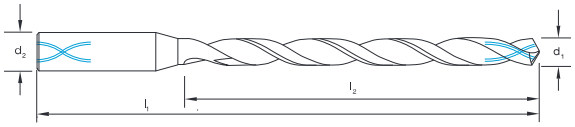
- AlCrN for maximum tool life





Catalogue Code	D335	D336	D337
Discount Group	A0210	A0210	A0210
Material	VHM	VHM	VHM
Surface Finish	AlCrN	AlCrN	AlCrN
Sutton Designation	N	N	N
Geometry	R30 - IK	R30 - IK	R30 - IK
Point Type	140° Form C	140° Form C	140° Form C
Shank Form (DIN 6535)	HA	HB	HE

Size Ref.	d_1 (m7) mm	d_1 (m7) inch	l_1	l_2	d_2 (h6)	Item #	Item #	Item #
1429	14.29	9/16	203	152	16	D335 1429	D336 1429	D337 1429
1450	14.5		203	152	16	D335 1450	D336 1450	D337 1450
1480	14.8		203	152	16	D335 1480	D336 1480	D337 1480
1500	15.0		203	152	16	D335 1500	D336 1500	D337 1500
1550	15.5		203	152	16	D335 1550	D336 1550	D337 1550
1580	15.8		203	152	16	D335 1580	D336 1580	D337 1580
1588	15.88	5/8	203	152	16	D335 1588	D336 1588	D337 1588
1600	16.0		203	152	16	D335 1600	D336 1600	D337 1600
1650	16.5		222	171	18	D335 1650	D336 1650	D337 1650
1680	16.8		222	171	18	D335 1680	D336 1680	D337 1680
1700	17.0		222	171	18	D335 1700	D336 1700	D337 1700
1746	17.46	11/16	222	171	18	D335 1746	D336 1746	D337 1746
1750	17.5		222	171	18	D335 1750	D336 1750	D337 1750
1780	17.8		222	171	18	D335 1780	D336 1780	D337 1780
1800	18.0		222	171	18	D335 1800	D336 1800	D337 1800
1850	18.5		243	190	18	D335 1850	D336 1850	D337 1850
1900	19.0		243	190	20	D335 1900	D336 1900	D337 1900
1905	19.05	3/4	243	190	20	D335 1905	D336 1905	D337 1905
1950	19.5		243	190	20	D335 1950	D336 1950	D337 1950
1980	19.8		243	190	20	D335 1980	D336 1980	D337 1980
2000	20.0		243	190	20	D335 2000	D336 2000	D337 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
D335	●	●	●	●	●	●	●	●	●	●	●		●	◐			●	●	●	●	●	●																												

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

● Optimal ◐ Effective

NOTE: HB & HE shanks available, subject to lead time.

Drills Carbide, 12 x D, R30 N, IK

suttontools

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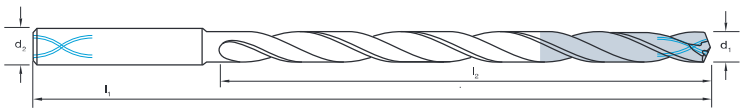

Catalogue Code	D371
Discount Group	A0210
Material	VHM
Surface Finish	AlCrN Tip
Sutton Designation	N
Geometry	R30 - IK
Point Type	135° Form C
Shank Form (DIN 6535)	HA

Size Ref.	d_1 (h7) mm	d_1 (h7) inch	l_1	l_2	d_2 (h6)	Item #
0300	3.0		90	50	6	D371 0300
0310	3.1		90	50	6	D371 0310
0318	3.18	1/8	90	50	6	•
0320	3.2		90	50	6	D371 0320
0330	3.3		90	50	6	D371 0330
0340	3.4		90	50	6	D371 0340
0350	3.5		90	50	6	D371 0350
0357	3.57	9/64	90	50	6	•
0360	3.6		90	50	6	D371 0360
0370	3.7		90	50	6	D371 0370
0380	3.8		102	64	6	D371 0380
0390	3.9		102	64	6	D371 0390
0397	3.97	5/32	102	64	6	•
0400	4.0		102	64	6	D371 0400
0410	4.1		102	64	6	D371 0410
0420	4.2		102	64	6	D371 0420
0430	4.3		102	64	6	D371 0430
0437	4.37	11/64	102	64	6	•
0440	4.4		102	64	6	D371 0440
0450	4.5		102	64	6	D371 0450
0460	4.6		102	64	6	D371 0460
0470	4.7		102	64	6	D371 0470
0476	4.76	3/16	102	64	6	D371 0476
0480	4.8		116	78	6	D371 0480
0490	4.9		116	78	6	D371 0490
0500	5.0		116	78	6	D371 0500
0510	5.1		116	78	6	D371 0510
0516	5.16	13/64	116	78	6	•
0520	5.2		116	78	6	D371 0520
0530	5.3		116	78	6	D371 0530
0540	5.4		116	78	6	D371 0540
0550	5.5		116	78	6	D371 0550
0556	5.56	7/32	116	78	6	•
0560	5.6		116	78	6	D371 0560
0570	5.7		116	78	6	D371 0570
0580	5.8		116	78	6	D371 0580
0590	5.9		116	78	6	D371 0590
0595	5.95	15/64	116	78	6	•
0600	6.0		116	78	6	D371 0600
0610	6.1		146	108	8	D371 0610

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
D371	◕	◕	◕	◕	◕	◕	◕	◕		◕				●	●		◕	◕	◕	◕	◕	◕																												●	

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

● Optimal ◕ Effective

• Available on request as special manufacture. Subject to lead time.

Drills Carbide, 12 x D, R30 N, IK

suttontools

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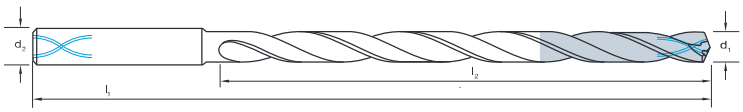

Catalogue Code	D371
Discount Group	A0210
Material	VHM
Surface Finish	AlCrN Tip
Sutton Designation	N
Geometry	R30 - IK
Point Type	135° Form C
Shank Form (DIN 6535)	HA

Size Ref.	d_1 (h7) mm	d_1 (h7) inch	l_1	l_2	d_2 (h6)	Item #
0620	6.2		146	108	8	D371 0620
0630	6.3		146	108	8	D371 0630
0635	6.35	1/4	146	108	8	•
0640	6.4		146	108	8	D371 0640
0650	6.5		146	108	8	D371 0650
0660	6.6		146	108	8	D371 0660
0670	6.7		146	108	8	D371 0670
0676	6.76	17/64	146	108	8	•
0680	6.8		146	108	8	D371 0680
0690	6.9		146	108	8	D371 0690
0700	7.0		146	108	8	D371 0700
0710	7.1		146	108	8	D371 0710
0714	7.14	9/32	146	108	8	•
0720	7.2		146	108	8	D371 0720
0730	7.3		146	108	8	D371 0730
0740	7.4		146	108	8	D371 0740
0750	7.5		146	108	8	D371 0750
0754	7.54	19/64	146	108	8	•
0760	7.6		146	108	8	D371 0760
0770	7.7		146	108	8	D371 0770
0780	7.8		146	108	8	D371 0780
0790	7.9		146	108	8	D371 0790
0794	7.94	5/16	146	108	8	•
0800	8.0		146	108	8	D371 0800
0810	8.1		162	120	10	D371 0810
0820	8.2		162	120	10	D371 0820
0830	8.3		162	120	10	D371 0830
0833	8.33	21/64	162	120	10	•
0840	8.4		162	120	10	D371 0840
0850	8.5		162	120	10	D371 0850
0860	8.6		162	120	10	D371 0860
0870	8.7		162	120	10	D371 0870
0873	8.73	11/32	162	120	10	•
0880	8.8		162	120	10	D371 0880
0890	8.9		162	120	10	D371 0890
0900	9.0		162	120	10	D371 0900
0910	9.1		162	120	10	D371 0910
0913	9.13	23/64	162	120	10	•
0920	9.2		162	120	10	D371 0920
0930	9.3		162	120	10	D371 0930

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
D371	●	●	●	●	●	●	●	●		●				○	○		●	●	●	○	○	○																												○	

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

● Optimal ○ Effective

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Drills Carbide, 12 x D, R30 N, IK

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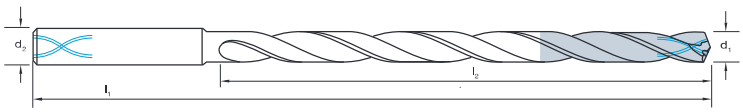


Catalogue Code	D371
Discount Group	A0210
Material	VHM
Surface Finish	AlCrN Tip
Sutton Designation	N
Geometry	R30 - IK
Point Type	135° Form C
Shank Form (DIN 6535)	HA

Size Ref.	d_1 (h7) mm	d_1 (h7) inch	l_1	l_2	d_2 (h6)	Item #
0940	9.4		162	120	10	D371 0940
0950	9.5		162	120	10	D371 0950
0952	9.52	3/8	162	120	10	•
0960	9.6		162	120	10	D371 0960
0970	9.7		162	120	10	D371 0970
0980	9.8		162	120	10	D371 0980
0990	9.9		162	120	10	D371 0990
0992	9.92	25/64	162	120	10	•
1000	10.0		162	120	10	D371 1000
1010	10.1		204	156	12	D371 1010
1020	10.2		204	156	12	D371 1020
1030	10.3		204	156	12	D371 1030
1032	10.32	13/32	204	156	12	•
1040	10.4		204	156	12	D371 1040
1050	10.5		204	156	12	D371 1050
1060	10.6		204	156	12	D371 1060
1070	10.7		204	156	12	D371 1070
1080	10.8		204	156	12	D371 1080
1090	10.9		204	156	12	D371 1090
1100	11.0		204	156	12	D371 1100
1110	11.1		204	156	12	D371 1110
1111	11.11	7/16	204	156	12	•
1120	11.2		204	156	12	•
1130	11.3		204	156	12	•
1140	11.4		204	156	12	D371 1140
1150	11.5		204	156	12	D371 1150
1160	11.6		204	156	12	D371 1160
1170	11.7		204	156	12	D371 1170
1180	11.8		204	156	12	D371 1180
1190	11.9		204	156	12	D371 1190
1191	11.91	15/32	204	156	12	•
1200	12.0		204	156	12	D371 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
D371	●	●	●	●	●	●	●	●	●	●				●	●		●	●	●	●	●	●																												●	

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

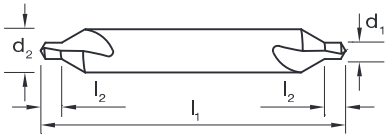
● Optimal ● Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- Used to drill female 60° centre holes in the end of shafts and components, which will later revolve between centres
- Designed to maintain accurate centre holes on long production runs
- Also used to ensure accurate starting and centring when precision drilling is required
- Suitable for materials up to 1600N/mm²

ANSI B94-11



	D318	D319
Catalogue Code	D318	D319
Discount Group	A0202	A0206
Material	VHM	VHM
Surface Finish	Brt	TiCN
Sutton Designation	N	N
Geometry	Plain Type	Plain Type
Point Type	60° Stepped	60° Stepped
Shank Form (DIN 6535)	HA	HA

Size Ref.	Size	d_1	l_1	l_2	d_2 (h6)	Item #	Item #
0001	1	3/64	1-1/4	1/16	1/8	D318 0001	D319 0001
0002	2	5/64	1-7/8	3/32	3/16	D318 0002	D319 0002
0003	3	7/64	2	9/64	1/4	D318 0003	D319 0003
0004	4	1/8	2-1/8	5/32	5/16	D318 0004	D319 0004
0005	5	3/16	2-3/4	1/4	7/16	D318 0005	D319 0005
0006	6	7/32	3	9/32	1/2	D318 0006	D319 0006

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
D318			○	○	○		●	●		○				○	○	○	●	●	●	●	●	●	◐	◐	◐	◐	◐	◐	◐									●	●	●	●	●	◐	◐	○	○	○	○
D319	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	○	◐	◐	◐	◐	◐	○	◐	○	◐	○										○	○	○	○	○	○	○	○	○	○	○	○	◐	○	○	○	○	○

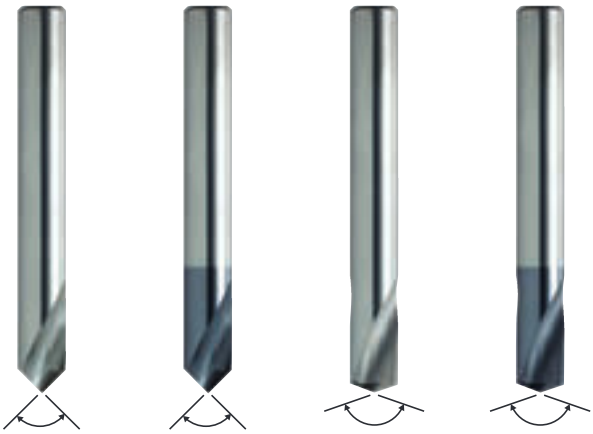
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

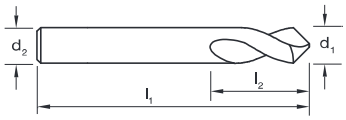
● Optimal ◐ Effective

NOTE: HB & HE shanks available, subject to lead time.

suttontools

- Precision drill for machine use
- Rigid design for "seat" position accuracy
- 90° offers hole chamfering & spotting with the one tool
- 142° for spotting, matching a typical drill point
- Only drill to the depth of the point
- Refer to HSS Drill section for HSS Spotting Drills.





	D355	D364	D365	D366
Catalogue Code	D355	D364	D365	D366
Discount Group	A0208	A0210	A0208	A0210
Material	VHM	VHM	VHM	VHM
Surface Finish	Brt	AlCrN	Brt	AlCrN
Sutton Designation	NC	NC	NC	NC
Geometry	-	-	-	-
Point Type	90° Form A	90° Form A	142° Form A	142° Form A
Shank Form (DIN 6535)	h9	h9	h9	h9

Size Ref.	d_1 (h6) mm	d_1 (h6) inch	l_1	l_2	d_2	Item #	Item #	Item #	Item #
0300	3.0		46	9	3.0	D355 0300	D364 0300	D365 0300	D366 0300
0400	4.0		55	12	4.0	D355 0400	D364 0400	D365 0400	D366 0400
0500	5.0		62	15	5.0	D355 0500	D364 0500	D365 0500	D366 0500
0600	6.0		66	18	6.0	D355 0600	D364 0600	D365 0600	D366 0600
0800	8.0		79	23	8.0	D355 0800	D364 0800	D365 0800	D366 0800
1000	10.0		89	24	10.0	D355 1000	D364 1000	D365 1000	D366 1000
1200	12.0		102	24	12.0	D355 1200	D364 1200	D365 1200	D366 1200
1600	16.0		115	26	16.0	D355 1600	D364 1600	D365 1600	D366 1600
2000	20.0		131	35	20.0	D355 2000	D364 2000	D365 2000	D366 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
D355			●	●	●		●	●		●				●	●	●	●	●	●	●	●	●	◐	◐	◐	◐	◐	◐	◐	◐								●	●	●	●	●		●	●	●	●	●
D364	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	●	◐	●	●	●											●	●	●	●	●	●	●	●	●	●	●	◐	●	●	●	●	●	●

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

● Optimal ◐ Effective

NOTE: HB & HE shanks available, subject to lead time.