

ENDMILLS > 2 FLUTE



**suttontools**

**E100 - 2 FLUTE ENDMILLS - Sutton Tools**

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**Features:**

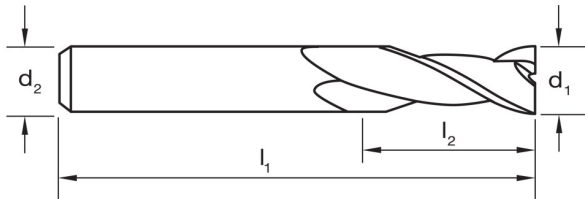
- 2 Flute Slot Drill R30 N
  - Suitable for materials up to 1000 N/mm<sup>2</sup>
  - For soft steels & non-ferrous material
  - TiCN for longer tool life
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**Specifications:**

<b>Designation:</b>	N
<b>Material:</b>	HSS Co.8
<b>Finish:</b>	Brt
<b>Shank Form:</b>	A
<b>Helix Angle:</b>	R30
<b>Point Tolerance:</b>	e8
<b>Shank Tolerance:</b>	h6
<b>Point Form:</b>	Square End
<b>Type:</b>	N (finishing)
<b>Standard:</b>	JIS

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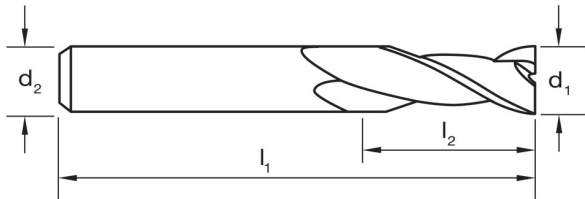
Range:



Item #	d1	l1	l2	l3	d2	d3	z
E1000100	1	50	3	-	6	-	2
E1000150	1.5	50	4.5	-	6	-	2
E1000159	1/16	50	3.2	-	1/4	-	2
E1000200	2	50	7	-	6	-	2
E1000238	3/32	50	4.75	-	1/4	-	2
E1000250	2.5	50	7	-	6	-	2
E1000300	3	50	9	-	6	-	2
E1000318	1/8	50	5.5	-	1/4	-	2
E1000350	3.5	60	12	-	8	-	2
E1000397	5/32	60	8	-	1/4	-	2
E1000400	4	60	12	-	8	-	2
E1000450	4.5	60	15	-	8	-	2
E1000476	3/16	60	9.5	-	1/4	-	2
E1000500	5	60	15	-	8	-	2
E1000550	5.5	60	15	-	8	-	2
E1000600	6	60	15	-	8	-	2
E1000635	1/4	65	14	-	1/4	-	2
E1000650	6.5	65	20	-	10	-	2
E1000700	7	65	20	-	10	-	2
E1000750	7.5	65	20	-	10	-	2
E1000794	5/16	65	14	-	3/8	-	2
E1000800	8	65	20	-	10	-	2
E1000850	8.5	75	25	-	10	-	2
E1000900	9	75	25	-	10	-	2
E1000950	9.5	75	25	-	10	-	2
E1000953	3/8	70	18	-	3/8	-	2
E1001000	10	75	25	-	10	-	2
E1001100	11	80	30	-	12	-	2
E1001200	12	80	30	-	12	-	2
E1001270	1/2	90	25.5	-	1/2	-	2
E1001300	13	90	35	-	16	-	2
E1001400	14	90	35	-	16	-	2
E1001500	15	95	40	-	16	-	2
E1001588	5/8	95	30	-	5/8	-	2
E1001600	16	95	40	-	16	-	2

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Range:



Item #	d1	l1	l2	l3	d2	d3	z
E1001700	17	105	40	-	20	-	2
E1001800	18	105	40	-	20	-	2
E1001900	19	110	45	-	20	-	2
E1001905	3/4	110	39.5	-	3/4	-	2
E1002000	20	110	45	-	20	-	2
E1002100	21	110	45	-	20	-	2
E1002200	22	110	45	-	20	-	2
E1002223	7/8	115	44.5	-	3/4	-	2
E1002400	24	120	50	-	25	-	2
E1002500	25	120	50	-	25	-	2
E1002540	1	120	51	-	3/4	-	2
E1002800	28	125	55	-	25	-	2
E1003000	30	125	55	-	25	-	2
E1003200	32	145	60	-	32	-	2
E1003500	35	145	60	-	32	-	2
E1004000	40	150	65	-	32	-	2
E1004500	45	155	70	-	32	-	2
E1005000	50	155	70	-	32	-	2

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### Applications:

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

### KEY

● Optimal ○ Effective

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