Accurate Positioning...

Perfect hole location

Features
- HSS Co material
- TiN coated
- Precise point geometry

Benefits
- Perfect hole location
- Offers spotting and chamfering with one tool

SPOTTING DRILL

100% Australian Owned
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AUSTRALIAN MADE AND OWNED SINCE 1917

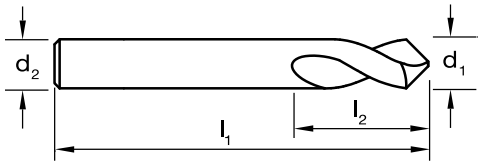
Sutton Tools

Drills NC Spotting

- Precision drill for machine use
- Rigid design for “seat” position accuracy
- 90º offers hole chamfering & spotting with the one tool
- 120º for spotting, matching a typical drill point
- Only drill to the depth of the point

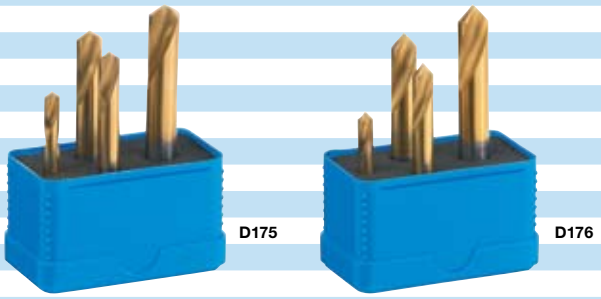
Sutton Tools

DIN 1897



	D175	D176
Catalogue Code	D175	D176
Discount Group	A1124	A1124
Material	HSS Co	HSS Co
Surface Finish	TiN	TiN
Colour Ring & Application	NC	NC
Geometry	-	-
Point Type	90º	120º
Shank Tolerance	h9	h9

d_1	l_1	l_2	Item #	Item #
3.0	46	16	D175 0300	D176 0300
4.0	55	22	D175 0400	D176 0400
5.0	62	26	D175 0500	D176 0500
6.0	63	25	D175 0600	D176 0600
8.0	80	29	D175 0800	D176 0800
10.0	90	32	D175 1000	D176 1000
12.0	100	32	D175 1200	D176 1200
16.0	114	35	D175 1600	D176 1600
20.0	130	37	D175 2000	D176 2000
25.0	130	37	D175 2500	D176 2500
SETS	**Contents:**			
4 piece	6.0, 8.0, 10.0, 12.0		D175 0004	D176 0004



Materials	HB	N/mm²	% Elong.	Material eg.	Vc	Feed No.	Vc	Feed No.
1.0 Steels								
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	RFe100	35	4	35	4
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	C10, C15, ST37, ST52	25	4	25	4
1.3 Plain carbon, low allowed	<300	>350 <850	20	C45, C92D, D95-S	20	4	20	4
1.4 Alloy steels harden. / tempered	<250	>500 <850	30		15	4	15	4
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30		15	3	15	3
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12	41CrMo4, 36CrNiMo4, X155CrVMo12-1, 90MnV8	12	3	12	3
1.7 Hardened Steel 45-50 Rc	<550		<12		10	3	10	3
2.0 Stainless Steels								
2.1 Free machining	<250	<850	25	X8CrNiS18-9	10	3	10	3
2.2 Austenitic	<250	<850	20	X5CrNi18-10	15	2	15	2
2.3 Ferritic + martensitic	<250	<850	20	X20Cr13	10	2	10	2
3.0 Cast Irons								
3.1 Lamellar graphite (Grey soft)	<150	<500	10	GG10, GG40	30	5	30	5
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	GGG40,	20	4	20	4
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	GGG80	20	4	20	4
6.0 Coppers								
6.1 Pure Copper (electrolitic copper)	<120	<400	12	SF-Cu	50	4	50	4
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	G-CuSn12Ni	30	4	30	4
6.3 Long chip Brass, Bronze	<200	<700	12	G-CuPb20Sn	40	4	40	4
7.0 Aluminiums								
7.1 Aluminium unalloyed	<100	<350	15	Al99.5	50	5	50	5
7.2 Magnesium unalloyed	<150	<350	15	Al99.85Mg0.5	50	4	50	4
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	AlMg1.5	50	4	50	4
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	AlSi10Mg	35	4	35	4
7.5 Al Alloyed > 10% Si	-	<400	N	AlSi17Cu4	30	4	30	4
7.6 Magnesium alloys	-	<400	N	MgAl3Zn	30	4	30	4
8.0 Plastics								
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	ABS, PVC, Polycarbonate	30	4	30	4

Feed No.	Feed Table (f) (mm/rev) Ø								
	3.0	**4.0**	**5.0**	**6.0**	**8.0**	**10.0**	**12.0**	**16.0**	**20.0**
1	0.030	0.040	0.045	0.050	0.060	0.080	0.080	0.100	0.150
2	0.040	0.050	0.055	0.060	0.080	0.100	0.100	0.120	0.200
3	0.050	0.060	0.065	0.080	0.100	0.120	0.120	0.150	0.250
4	0.060	0.080	0.085	0.100	0.120	0.150	0.150	0.200	0.300
5	0.080	0.100	0.110	0.120	0.150	0.200	0.200	0.250	0.400

Notes: For calculating revolutions per minute, apply hole diameter
For calculating feed, apply large end diameter

LEGEND

n = rev. per minute
v_c = cutting speed (m/min)
f = feed (mm/rev)
v_f = feed rate (mm/min)
z = no. cutting edges

FORMULAS

$n = (v_c \times 1000) / (Ø \times \pi)$
$v_c = (Ø \times \pi \times n) / 1000$
$v_f = f \times n$

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