suttontools

REAMERS

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

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

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

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

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

Extraordinary performance gains have been demonstrated in dry and wet machining processes involving:
- Unalloyed steels
- High strength steels
- High hardness steels (up to 54 HRC)

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

suttontools

ISO	VDI	Material Group	Sutton	
P	A	Steel	N	UNI
M	R	Stainless Steel	VA	UNI
K	F	Cast Iron	GG	UNI
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al / W	UNI
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.

For expert tooling recommendations, go to:
www.suttontools.com/expert-tool-selector

Page	156	158	161	162	163	164	164	165	166
Catalogue Code	R100	R101	R102	R104	R105	R106	R107	R108	R109
Material	HSS	HSS	HSS Co	HSS	HSS	HSS	HSS	HSS	TCA
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N	N	Roughing	Finishing	Tapered Pipe	N
Standard	DIN 206 / ISO 236	DIN 208	DIN 212 / ISO 521	–	–	–	–	–	–
Geometry	L10	L10	L10	L15	L7	L7	L7	L15	Straight

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										

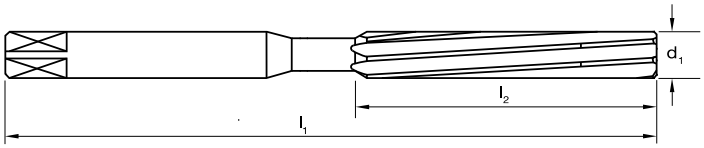
Condition: A (Annealed), **AH** (Age Hardened), **C** (Cast), **HT** (Hardened & Tempered), **QT** (Quenched & Tempered)

● Optimal ○ Effective

suttontools

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

DIN 206 | ISO 236 | H7



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

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	Item #	List Price
0300	3.000		62	31	-	-	6	R100 0300	$75.14
0318	3.175	1/8	66	33	-	-	6	R100 0318	$63.51
0350	3.500		71	35	-	-	6	R100 0350	$68.24
0357	3.572	9/64	71	35	-	-	6	R100 0357	$63.51
0397	3.969	5/32	76	38	-	-	6	R100 0397	$75.41
0400	4.000		76	38	-	-	6	R100 0400	$68.24
0437	4.366	11/64	81	41	-	-	6	R100 0437	$75.41
0450	4.500		81	41	-	-	6	R100 0450	$68.24
0476	4.762	3/16	87	44	-	-	6	R100 0476	$75.14
0500	5.000		87	44	-	-	6	R100 0500	$68.24
0516	5.159	13/64	87	44	-	-	6	R100 0516	$64.75
0550	5.500		93	47	-	-	6	R100 0550	$68.24
0556	5.556	7/32	93	47	-	-	6	R100 0556	$68.24
0595	5.953	15/64	93	47	-	-	6	R100 0595	$68.24
0600	6.000		93	47	-	-	6	R100 0600	$68.24
0635	6.350	1/4	100	50	-	-	6	R100 0635	$68.24
0650	6.500		100	50	-	-	6	R100 0650	$71.97
0675	6.747	17/64	100	50	-	-	6	R100 0675	$71.67
0700	7.000		107	54	-	-	6	R100 0700	$71.97
0714	7.144	9/32	107	54	-	-	6	R100 0714	$71.67
0750	7.500		107	54	-	-	6	R100 0750	$75.69
0754	7.541	19/64	107	54	-	-	6	R100 0754	$75.14
0794	7.938	5/16	115	58	-	-	6	R100 0794	$75.14
0800	8.000		115	58	-	-	6	R100 0800	$75.69
0833	8.334	21/64	115	58	-	-	6	R100 0833	$75.14
0850	8.500		115	58	-	-	6	R100 0850	$82.62
0873	8.731	11/32	124	62	-	-	6	R100 0873	$93.25
0900	9.000		124	62	-	-	6	R100 0900	$93.25
0913	9.128	23/64	124	62	-	-	8	R100 0913	$93.25
0950	9.500		124	62	-	-	6	R100 0950	$93.25
0953	9.525	3/8	133	66	-	-	8	R100 0953	$99.92
0992	9.922	25/64	133	66	-	-	8	R100 0992	$99.92
1000	10.000		133	66	-	-	6	R100 1000	$93.25
1032	10.319	13/32	133	66	-	-	8	R100 1032	$99.92
1050	10.500		133	66	-	-	6	R100 1050	$109.30
1100	11.000		142	71	-	-	6	R100 1100	$114.32
1111	11.112	7/16	142	71	-	-	8	R100 1111	$113.41
1150	11.500		142	71	-	-	6	R100 1150	$129.42
1151	11.509	29/64	142	71	-	-	8	R100 1151	$129.71
1191	11.906	15/32	152	76	-	-	8	R100 1191	$121.21

ISO	P													M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R100	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

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

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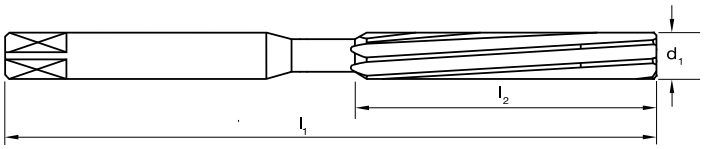
DIN 208 | ISO 236 | H7



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

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	Item #	List Price
1200	12.000		152	76	-	-	6	R100 1200	$121.21
1230	12.303	31/64	152	76	-	-	8	R100 1230	$139.91
1250	12.500		152	76	-	-	6	R100 1250	$140.62
1270	12.700	1/2	152	76	-	-	8	R100 1270	$122.93
1300	13.000		152	76	-	-	6	R100 1300	$140.62
1310	13.097	33/64	152	76	-	-	8	R100 1310	$160.37
1349	13.494	17/32	163	81	-	-	8	R100 1349	$146.82
1389	13.891	35/64	163	81	-	-	8	R100 1389	$176.21
1350	13.500		163	81	-	-	6	R100 1350	$165.54
1400	14.000		163	81	-	-	8	R100 1400	$147.13
1429	14.288	9/16	163	81	-	-	8	R100 1429	$146.82
1450	14.500		163	81	-	-	8	R100 1450	$181.96
1468	14.684	37/64	163	81	-	-	8	R100 1468	$198.08
1500	15.000		163	81	-	-	8	R100 1500	$181.96
1508	15.081	19/32	175	87	-	-	8	R100 1508	$187.71
1548	15.478	39/64	175	87	-	-	8	R100 1548	$207.00
1588	15.875	5/8	175	87	-	-	8	R100 1588	$155.45
1600	16.000		175	87	-	-	8	R100 1600	$187.71
1627	16.272	41/64	175	87	-	-	8	R100 1627	$215.94
1667	16.669	21/32	175	87	-	-	8	R100 1667	$210.19
1700	17.000		175	87	-	-	8	R100 1700	$180.80
1707	17.066	43/64	188	93	-	-	8	R100 1707	$249.05
1746	17.463	11/16	188	93	-	-	8	R100 1746	$189.71
1800	18.000		188	93	-	-	8	R100 1800	$218.48
1826	18.256	23/32	188	93	-	-	8	R100 1826	$231.22
1900	19.000		188	93	-	-	8	R100 1900	$211.58
1905	19.050	3/4	201	100	-	-	10	R100 1905	$210.19
1984	19.844	25/32	201	100	-	-	10	R100 1984	$225.67
2000	20.000		201	100	-	-	8	R100 2000	$218.48
2064	20.638	13/16	201	100	-	-	10	R100 2064	$228.88
2100	21.000		201	100	-	-	8	R100 2100	$296.57
2143	21.431	27/32	215	107	-	-	10	R100 2143	$345.48
2200	22.000		215	107	-	-	8	R100 2200	$262.85
2223	22.225	7/8	215	107	-	-	10	R100 2223	$279.80
2300	23.000		215	107	-	-	8	R100 2300	$328.21
2302	23.019	29/32	215	107	-	-	10	R100 2302	$374.29
2381	23.813	15/16	231	115	-	-	10	R100 2381	$331.10
2400	24.000		231	115	-	-	8	R100 2400	$328.21
2461	24.606	31/32	231	115	-	-	10	R100 2461	$457.76
2500	25.000		231	115	-	-	10	R100 2500	$362.76
2540	25.400	1	231	115	-	-	10	R100 2540	$368.52

ISO	P												M			K						N								S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R100	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																	○	

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

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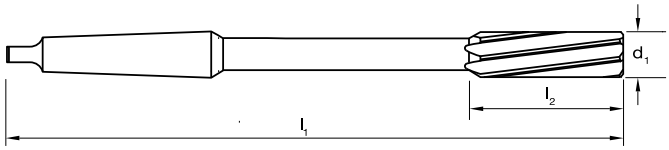
DIN 208 | H7



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

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	MT #	Item #	List Price
0600	**6.000**		138	26	-	-	6	1	R101 0600	**$95.62**
0635	6.350	**1/4**	144	28	-	-	6	1	R101 0635	**$96.60**
0650	**6.500**		144	28	-	-	6	1	R101 0650	**$100.05**
0675	6.747	**17/64**	144	28	-	-	6	1	R101 0675	**$100.05**
0700	**7.000**		150	31	-	-	6	1	R101 0700	**$100.05**
0714	7.144	**9/32**	150	31	-	-	6	1	R101 0714	**$100.05**
0750	**7.500**		150	31	-	-	6	1	R101 0750	**$100.05**
0754	7.541	**19/64**	150	31	-	-	6	1	R101 0754	**$100.05**
0794	7.938	**5/16**	156	33	-	-	6	1	R101 0794	**$100.05**
0800	**8.000**		156	33	-	-	6	1	R101 0800	**$100.05**
0833	8.334	**21/64**	156	33	-	-	6	1	R101 0833	**$100.05**
0850	**8.500**		156	33	-	-	6	1	R101 0850	**$106.52**
0873	8.731	**11/32**	162	36	-	-	6	1	R101 0873	**$106.52**
0900	**9.000**		162	36	-	-	6	1	R101 0900	**$106.52**
0913	9.128	**23/64**	162	36	-	-	6	1	R101 0913	**$109.30**
0950	**9.500**		162	36	-	-	6	1	R101 0950	**$102.50**
0953	9.525	**3/8**	162	36	-	-	6	1	R101 0953	**$109.30**
0992	9.922	**25/64**	168	38	-	-	6	1	R101 0992	**$112.55**
1000	**10.000**		168	38	-	-	6	1	R101 1000	**$102.50**
1032	10.319	**13/32**	168	38	-	-	6	1	R101 1032	**$113.41**
1050	**10.500**		168	38	-	-	6	1	R101 1050	**$129.71**
1072	10.716	**27/64**	175	41	-	-	6	1	R101 1072	**$146.52**
1100	**11.000**		175	41	-	-	6	1	R101 1100	**$129.71**
1111	11.112	**7/16**	175	41	-	-	6	1	R101 1111	**$115.02**
1150	**11.500**		175	41	-	-	6	1	R101 1150	**$139.91**
1151	11.509	**29/64**	175	41	-	-	6	1	R101 1151	**$129.71**
1191	11.906	**15/32**	175	41	-	-	6	1	R101 1191	**$119.47**
1200	**12.000**		182	44	-	-	6	1	R101 1200	**$123.95**
1230	12.303	**31/64**	182	44	-	-	6	1	R101 1230	**$169.01**
1250	**12.500**		182	44	-	-	6	1	R101 1250	**$134.48**
1270	12.700	**1/2**	182	44	-	-	6	1	R101 1270	**$119.47**
1300	**13.000**		182	44	-	-	6	1	R101 1300	**$149.66**
1310	13.097	**33/64**	182	44	-	-	6	1	R101 1310	**$169.01**
1349	13.494	**17/32**	189	47	-	-	6	1	R101 1349	**$135.19**
1350	**13.500**		189	47	-	-	6	1	R101 1350	**$182.82**
1389	13.891	**35/64**	189	47	-	-	6	1	R101 1389	**$182.51**
1400	**14.000**		189	47	-	-	8	1	R101 1400	**$149.66**
1429	14.288	**9/16**	204	50	-	-	8	2	R101 1429	**$150.31**
1450	**14.500**		204	50	-	-	8	2	R101 1450	**$201.52**
1468	14.684	**37/64**	204	50	-	-	8	2	R101 1468	**$201.52**

ISO	P													M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R101	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

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

● Optimal ○ Effective

Reamers Machine

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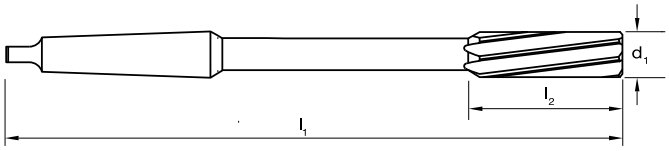
- Machine use
- Suitable for toolroom & workshop use
- Produces clean, accurate holes, to a H7 tolerance

DIN 208 | H7



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

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	MT #	Item #	List Price
1500	15.000		204	50	-	-	8	2	R101 1500	$194.64
1508	15.081	19/32	210	52	-	-	8	2	R101 1508	$189.43
1550	15.500		210	52	-	-	8	2	R101 1550	$221.69
1548	15.478	39/64	210	52	-	-	8	2	R101 1548	$218.48
1588	15.875	5/8	210	52	-	-	8	2	R101 1588	$159.18
1600	16.000		210	52	-	-	8	2	R101 1600	$198.08
1627	16.272	41/64	214	54	-	-	8	2	R101 1627	$228.88
1650	16.500		214	54	-	-	8	2	R101 1650	$228.88
1667	16.669	21/32	214	54	-	-	8	2	R101 1667	$197.23
1700	17.000		214	54	-	-	8	2	R101 1700	$198.08
1707	17.066	43/64	219	56	-	-	8	2	R101 1707	$228.88
1746	17.463	11/16	219	56	-	-	8	2	R101 1746	$181.37
1750	17.500		219	56	-	-	8	2	R101 1750	$255.90
1786	17.859	45/64	219	56	-	-	8	2	R101 1786	$255.90
1800	18.000		219	56	-	-	8	2	R101 1800	$235.51
1826	18.256	23/32	219	56	-	-	8	2	R101 1826	$232.05
1850	18.500		223	58	-	-	8	2	R101 1850	$269.75
1900	19.000		223	58	-	-	8	2	R101 1900	$252.48
1905	19.050	3/4	223	58	-	-	8	2	R101 1905	$210.19
1950	19.500		228	60	-	-	8	2	R101 1950	$286.73
2000	20.000		228	60	-	-	8	2	R101 2000	$252.48
2050	20.500		232	62	-	-	8	2	R101 2050	$251.74
2064	20.638	13/16	232	62	-	-	8	2	R101 2064	$225.44
2100	21.000		232	62	-	-	8	2	R101 2100	$299.44
2143	21.431	27/32	232	62	-	-	8	2	R101 2143	$299.44
2150	21.500		237	64	-	-	8	2	R101 2150	$299.09
2200	22.000		237	64	-	-	8	2	R101 2200	$273.23
2223	22.225	7/8	237	64	-	-	8	2	R101 2223	$252.78
2250	22.500		241	66	-	-	8	2	R101 2250	$274.21
2300	23.000		241	66	-	-	8	2	R101 2300	$328.21
2302	23.019	29/32	237	64	-	-	8	2	R101 2302	$328.21
2350	23.500		241	66	-	-	8	3	R101 2350	$329.04
2381	23.813	15/16	268	68	-	-	8	3	R101 2381	$345.48
2400	24.000		268	68	-	-	8	3	R101 2400	$345.48
2450	24.500		268	68	-	-	8	3	R101 2450	$346.50
2461	24.606	31/32	268	68	-	-	8	3	R101 2461	$400.21
2500	25.000		268	68	-	-	10	3	R101 2500	$359.89
2540	25.400	1	268	68	-	-	8	3	R101 2540	$400.21
2550	25.500		273	70	-	-	10	3	R101 2550	$361.43
2600	26.000		273	70	-	-	10	3	R101 2600	$411.29

ISO	P												M			K						N								S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R101	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

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

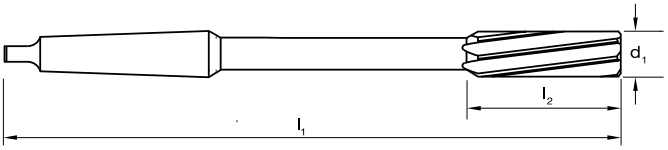
● Optimal ○ Effective

Reamers Machine

suttontools

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

DIN 208 | H7



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

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	MT #	Item #	List Price
2650	26.500		273	70	-	-	10	3	R101 2650	$411.29
2699	26.987	1-1/16	277	71	-	-	10	3	R101 2699	$411.70
2700	27.000		277	71	-	-	10	3	R101 2700	$411.29
2750	27.500		277	71	-	-	10	3	R101 2750	$411.29
2800	28.000		277	71	-	-	10	3	R101 2800	$411.29
2850	28.500		281	73	-	-	10	3	R101 2850	$411.29
2858	28.575	1-1/8	281	73	-	-	10	3	R101 2858	$443.35
2900	29.000		281	73	-	-	10	3	R101 2900	$411.29
2950	29.500		281	73	-	-	10	3	R101 2950	$443.67
3000	30.000		281	73	-	-	10	3	R101 3000	$515.97
3016	30.162	1-3/16	285	75	-	-	10	3	R101 3016	$515.32
3050	30.500		285	75	-	-	10	3	R101 3050	$515.97
3100	31.000		285	75	-	-	10	3	R101 3100	$515.97
3150	31.500		285	75	-	-	10	3	R101 3150	$515.97
3175	31.750	1-1/4	290	77	-	-	10	3	R101 3175	$549.90
3200	32.000		317	77	-	-	10	4	R101 3200	$550.86
3300	33.000		317	77	-	-	10	4	R101 3300	$550.86
3334	33.338	1-5/16	317	77	-	-	10	4	R101 3334	$621.83
3400	34.000		321	78	-	-	10	4	R101 3400	$623.14
3493	34.925	1-3/8	321	78	-	-	10	4	R101 3493	$667.94
3500	35.000		321	78	-	-	10	4	R101 3500	$665.52
3600	36.000		325	79	-	-	12	4	R101 3600	$665.52
3651	36.512	1-7/16	325	79	-	-	12	4	R101 3651	$719.71
3700	37.000		325	79	-	-	12	4	R101 3700	$720.37
3800	38.000		329	81	-	-	12	4	R101 3800	$720.37
3810	38.100	1-1/2	329	83	-	-	12	4	R101 3810	$840.64
3900	39.000		329	81	-	-	12	4	R101 3900	$842.51
4000	40.000		329	81	-	-	12	4	R101 4000	$842.51
4128	41.275	1-5/8	333	82	-	-	12	4	R101 4128	$944.33
4445	44.450	1-3/4	336	83	-	-	12	4	R101 4445	$1,200.57
4763	47.625	1-7/8	344	86	-	-	12	4	R101 4763	$1,465.42
5080	50.800	2	344	86	-	-	12	4	R101 5080	$1,540.25

ISO	P													M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R101	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

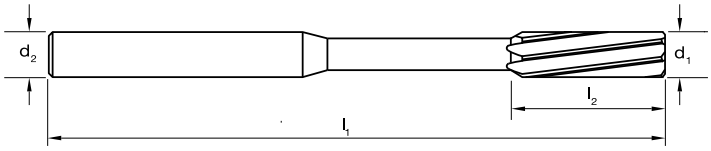
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

suttontools

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

DIN 212 | ISO 521 | H7



Catalogue Code	R102
Discount Group	B0302
Material	HSS Co
Surface Finish	*Brt*
Sutton Designation	N
Geometry	L10

Size Ref.	d_1		l_1	l_2	l_3	d_2	z	Item #	List Price
0200	2.000		49	11	-	2.0	3	R102 0200	$26.19
0250	2.500		57	14	-	2.5	5	R102 0250	$26.19
0300	3.000		61	15	-	3.0	5	R102 0300	$26.92
0318	3.175	1/8	65	16	-	3.2	5	R102 0318	$49.88
0350	3.500		70	18	-	3.5	5	R102 0350	$27.41
0357	3.572	9/64	70	18	-	3.6	5	R102 0357	$49.88
0397	3.969	5/32	75	19	-	4.0	6	R102 0397	$49.88
0400	4.000		75	19	-	4.0	6	R102 0400	$43.09
0450	4.500		80	21	-	4.5	6	R102 0450	$47.38
0476	4.762	3/16	86	23	-	5.0	6	R102 0476	$49.88
0500	5.000		86	23	-	5.0	6	R102 0500	$48.89
0516	5.159	13/64	86	23	-	5.0	6	R102 0516	$52.30
0550	5.500		93	26	-	5.6	6	R102 0550	$49.88
0595	5.953	15/64	93	26	-	5.6	6	R102 0595	$52.30
0600	6.000		93	26	-	5.6	6	R102 0600	$52.30
0635	6.350	1/4	101	28	-	6.3	6	R102 0635	$52.30
0650	6.500		101	28	-	6.3	6	R102 0650	$54.81
0700	7.000		109	31	-	7.1	6	R102 0700	$54.81
0750	7.500		109	31	-	7.1	6	R102 0750	$57.33
0794	7.938	5/16	117	31	-	8.0	6	R102 0794	$59.84
0800	8.000		117	33	-	8.0	6	R102 0800	$59.84
0850	8.500		117	33	-	8.0	6	R102 0850	$65.55
0900	9.000		125	36	-	9.0	6	R102 0900	$66.05
0950	9.500		125	36	-	9.0	6	R102 0950	$73.02
0953	9.525	3/8	133	38	-	10.0	6	R102 0953	$84.77
1000	10.000		133	38	-	10.0	6	R102 1000	$82.27
1050	10.500		133	38	-	10.0	6	R102 1050	$84.77
1100	11.000		142	41	-	10.0	6	R102 1100	$92.22
1111	11.112	7/16	142	41	-	10.0	6	R102 1111	$92.22
1150	11.500		142	41	-	10.0	6	R102 1150	$92.22
1200	12.000		151	44	-	10.0	6	R102 1200	$102.12
1250	12.500		151	44	-	10.0	6	R102 1250	$107.16
1270	12.700	1/2	151	44	-	10.0	6	R102 1270	$107.16
1300	13.000		151	44	-	10.0	6	R102 1300	$107.16
1350	13.500		160	47	-	12.5	6	R102 1350	$112.19
1400	14.000		160	47	-	12.5	8	R102 1400	$117.16
1429	14.288	9/16	162	50	-	12.5	8	R102 1429	$132.08
1450	14.500		162	50	-	12.5	8	R102 1450	$132.08
1500	15.000		162	50	-	12.5	8	R102 1500	$132.08
1550	15.500		170	52	-	12.5	8	R102 1550	$139.60
1588	15.875	5/8	170	52	-	12.5	8	R102 1588	$139.60
1600	16.000		170	52	-	12.5	8	R102 1600	$142.10

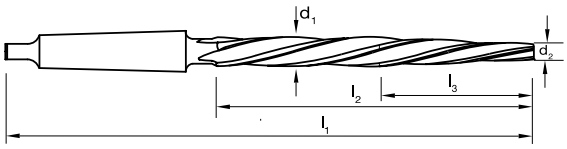
ISO	P												M			K						N								S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R102	●	●	●	●	○	●	●	○		○		○		○	○	○	●	○	●	○	●	○	○	○	○	○		○	○	○																		○	

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

● Optimal ○ Effective

suttontools

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



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

Size Ref.	d_1	l_1	l_2	l_3	d_2	z	MT #	Item #	List Price
1300	**13.0**	199	105	42	8.8	5	2	R104 1300	**$225.16**
1400	**14.0**	209	115	46	9.4	5	2	R104 1400	**$239.30**
1600	**16.0**	229	135	54	10.6	5	2	R104 1600	**$266.99**
1700	**17.0**	251	135	54	11.6	5	3	R104 1700	**$272.53**
1800	**18.0**	261	145	58	12.2	5	3	R104 1800	**$278.06**
1900	**19.0**	261	145	58	13.2	5	3	R104 1900	**$331.58**
2000	**20.0**	271	155	62	13.8	5	3	R104 2000	**$342.66**
2100	**21.0**	271	155	62	14.8	5	3	R104 2100	**$351.89**
2200	**22.0**	281	165	66	15.4	5	3	R104 2200	**$356.81**
2300	**23.0**	281	165	66	16.4	5	3	R104 2300	**$356.81**
2500	**25.0**	296	180	72	17.8	5	3	R104 2500	**$393.72**
2600	**26.0**	296	180	72	18.8	5	3	R104 2600	**$393.72**
2800	**28.0**	311	195	78	20.2	5	3	R104 2800	**$444.16**
3000	**30.0**	311	195	78	22.2	5	3	R104 3000	**$516.74**
3200	**32.0**	354	210	84	23.6	5	4	R104 3200	**$600.41**

ISO	P													M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R104	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

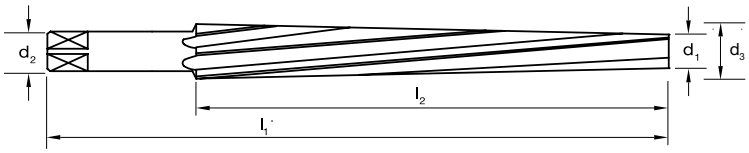
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

Reamers Taper Pin

suttontools

- For use by hand with suitable wrench
- For opening out parallel holes to suit 1:48 taper pins



Catalogue Code	R105
Discount Group	B0302
Material	HSS
Surface Finish	*Brt*
Sutton Designation	N
Geometry	L7

Size Ref.	BS Size	Series	l_1	l_2	d_1	d_2	d_3	z	Item #	List Price
0238	3/32	#5/0	57	32	1.75	3.0	2.41	4	R105 0238	$83.65
0278	7/64	#4/0	57	32	2.23	3.0	2.89	4	R105 0278	$83.65
0318	1/8	#3/0	62	35	2.56	3.5	3.29	4	R105 0318	$83.65
0357	9/64	#2/0	70	38	2.89	4.0	3.68	4	R105 0357	$83.65
0397	5/32	#0	70	42	3.22	4.5	4.10	6	R105 0397	$86.92
0437	11/64	#1	75	45	3.70	5.0	4.64	6	R105 0437	$86.92
0476	3/16	#2	82	52	4.11	5.5	5.19	6	R105 0476	$86.92
0556	7/32	#3	90	58	4.64	6.0	5.85	6	R105 0556	$86.92
0635	1/4	#4	105	65	5.28	6.5	6.63	6	R105 0635	$90.38
0714	9/32	#5	115	78	6.09	6.5	7.72	6	R105 0714	$95.62
0873	11/32	#6	130	92	7.08	7.5	9.00	6	R105 0873	$104.23
1032	13/32	#7	155	115	8.40	9.0	10.80	6	R105 1032	$129.71
1270	1/2	#8	175	135	10.11	11.0	12.92	6	R105 1270	$211.58
1429	9/16	#9	205	155	12.24	14.5	15.47	6	R105 1429	$333.99
1905	3/4	#10	230	180	14.75	16.0	18.50	6	R105 1905	$463.53
2223	7/8	#11	285	210	17.93	19.0	22.31	6	R105 2223	$598.82

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
R105	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

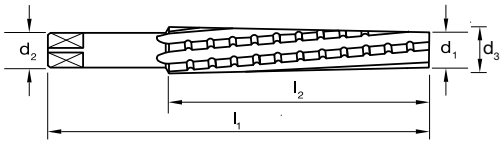
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

Reamers Morse Taper Socket

suttontools

- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Rougher, opens out existing parallel holes
- Finishing, to be used after rougher for final sizing



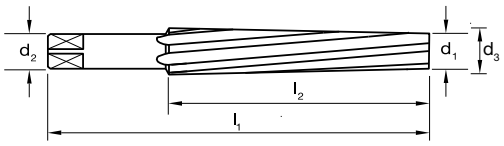
Catalogue Code	**R106**
Discount Group	B0302
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**Roughing**
Geometry	L7

Size Ref.	MT #	l_1	l_2	d_1	d_2	d_3	z	Item #	List Price
0000	**0**	83	57	6.59	8.72	9.24	6	R106 0000	**$221.97**
0001	**1**	95	64	9.63	11.90	12.52	6	R106 0001	**$273.23**
0002	**2**	114	76	14.79	16.65	18.27	6	R106 0002	**$403.07**
0003	**3**	140	95	19.98	22.22	24.44	8	R106 0003	**$627.63**
0004	**4**	175	117	26.14	25.40	31.90	8	R106 0004	**$1,016.29**
0005	**5**	216	152	37.69	34.92	45.27	10	R106 0005	**$1,980.70**

Reamers Morse Taper Socket

suttontools

- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Rougher, opens out existing parallel holes
- Finishing, to be used after rougher for final sizing



Catalogue Code	**R107**
Discount Group	B0302
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**Finishing**
Geometry	L7

Size Ref.	MT #	l_1	l_2	d_1	d_2	d_3	z	Item #	List Price
0000	**0**	83	57	6.59	8.72	9.24	6	R107 0000	**$211.58**
0001	**1**	95	64	9.63	11.90	12.52	6	R107 0001	**$249.31**
0002	**2**	114	76	14.79	16.65	18.27	6	R107 0002	**$382.93**
0003	**3**	140	95	19.98	22.22	24.44	8	R107 0003	**$575.78**
0004	**4**	175	117	26.14	25.40	31.90	8	R107 0004	**$996.12**
0005	**5**	216	152	37.69	34.92	45.27	10	R107 0005	**$1,951.96**

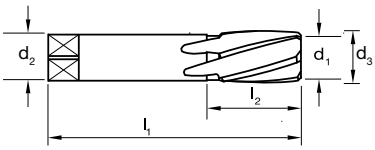
ISO	P												M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R106	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	
R107	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

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

● Optimal ○ Effective

suttontools

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



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

Size Ref.	Size	d_1	l_1	l_2	d_2	d_3	z	Item #	List Price
0803	1/8	8.00	60	15	8.00	8.97	6	R108 0803	$82.27
1031	1/4	10.31	67	20	10.00	11.50	6	R108 1031	$89.75
1372	3/8	13.72	75	22	12.50	15.63	6	R108 1372	$137.09
1689	1/2	16.89	87	26	16.00	18.52	6	R108 1689	$154.56
2225	3/4	22.25	96	29	20.00	24.00	6	R108 2225	$191.94
2802	1	28.00	110	33	25.00	30.08	6	R108 2802	$274.21
3668	1-1/4	36.58	119	37	31.50	38.83	6	R108 3668	$441.21
4277	1-1/2	42.77	125	37	35.50	45.08	8	R108 4277	$583.27
5484	2	54.84	140	41	40.00	57.40	8	R108 5484	$952.22

ISO	P												M			K						N								S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R108	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																	○	

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

● Optimal ○ Effective

Reamers Adjustable

suttontools

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

	R109	R110
Catalogue Code	R109	R110
Discount Group	B0304	B0304
Material	TCA	TCA
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	-
Geometry	Reamer	Blade Sets

Size Ref.	Size	Range (mm)	Range (inch)	Sq	Item #	List Price	Item #	List Price
0635	MA8	6.35–7.15	1/4–9/32	2.8	R109 0635	$181.42		
0715	MA7	7.15–7.95	9/32–5/16	3.2	R109 0715	$181.42		
0795	MA6	7.95–8.70	5/16–11/32	4	R109 0795	$181.42		
0870	MA5	8.70–9.50	11/32–3/8	4	R109 0870	$181.42		
0950	MA4	9.50–10.25	3/8–13/32	4	R109 0950	$186.97		
1025	MA3	10.25–11.00	13/32–7/16	4.5	R109 1025	$186.97		
1100	MA2	11.00–12.00	7/16–15/32	5.5	R109 1100	$190.69		
1200	MA	12.00–13.50	15/32–17/32	5.5	R109 1200	$190.69	R110 1200	$135.67
1350	MB	13.50–15.00	17/32–19/32	6.5	R109 1350	$194.07	R110 1350	$139.09
1500	MC	15.00–16.75	19/32–21/32	7	R109 1500	$201.50	R110 1500	$142.80
1675	MD	16.75–18.25	21/32–23/32	8	R109 1675	$227.14	R110 1675	$160.73
1825	ME	18.25–19.75	23/32–25/32	9	R109 1825	$241.69	R110 1825	$173.08
1975	MF	19.75–21.50	25/32–27/32	10	R109 1975	$259.62	R110 1975	$182.37
2150	MG	21.50–23.75	27/32–15/16	12	R109 2150	$281.24	R110 2150	$197.79
2375	MH	23.75–27.00	15/16–1-1/16	13	R109 2375	$321.40	R110 2375	$228.71
2700	MI	27.00–30.25	1-1/16–1-3/16	15	R109 2700	$361.55	R110 2700	$256.52
3025	MJ	30.25–34.25	1-3/16–1-11/32	15	R109 3025	$448.17	R110 3025	$312.20
3425	MK	34.25–38.00	1-11/32–1-1/2	17	R109 3425	$528.49	R110 3425	$367.84
3800	ML	38.00–46.00	1-1/2–1-13/16	21	R109 3800	$769.59	R110 3800	$537.75
4600	MM	46.00–56.00	1-13/16–2-7/32	26	R109 4600	$1,257.90	R110 4600	$880.83
5600	MN	56.00–69.75	2-7/32–2-3/4	32	R109 5600	$1,780.16	R110 5600	$1,245.53
6975	MO	69.75–85.00	2-3/4–3-11/32	38	R109 6975	$2,747.51	R110 6975	$1,928.53

	Adjustable Reamer Set	Pieces		
M1	MA4 to ME (Reamers Only)	8	R109 M1	$1,659.66
M2P	MA to MH (Reamers & Pilots)	16	R109 M2P	$3,674.71
M3	MA4 to MH (Reamers Only)	11	R109 M3	$2,518.79
M6	MA8 to MK (Reamers Only)	18	R109 M6	$4,648.17
M8	MA to MI (Reamers Only)	9	R109 M8	$2,317.94

R109 M8

ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
R109	●	●	○	○		●				○				○			○						○	○	○	○		○		○																				

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

● Optimal ○ Effective

Reamers Adjustable

suttontools

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

Catalogue Code	R111	R112
Discount Group	B0304	B0304
Material	TCA	TCA
Surface Finish	*Brt*	*Brt*
Sutton Designation	-	-
Geometry	Pilots	Nuts

Size Ref.	Size	Range (mm)	Range (inch)	Item #	List Price	Item #	List Price
1200	MA	12.00–13.50	15/32–17/32	R111 1200	$179.24	R112 1200	$16.35
1350	MB	13.50–15.00	17/32–19/32	R111 1350	$191.61	R112 1350	$16.35
1500	MC	15.00–16.75	19/32–21/32	R111 1500	$197.79	R112 1500	$21.95
1675	MD	16.75–18.25	21/32–23/32	R111 1675	$210.09	R112 1675	$21.95
1825	ME	18.25–19.75	23/32–25/32	R111 1825	$219.43	R112 1825	$21.95
1975	MF	19.75–21.50	25/32–27/32	R111 1975	$228.71	R112 1975	$21.95
2150	MG	21.50–23.75	27/32–15/16	R111 2150	$241.06	R112 2150	$24.12
2375	MH	23.75–27.00	15/16–1-1/16	R111 2375	$253.43	R112 2375	$27.51
2700	MI	27.00–30.25	1-1/16–1-3/16	R111 2700	$268.91	R112 2700	$31.53
3025	MJ	30.25–34.25	1-3/16–1-11/32	R111 3025	$281.24	R112 3025	$38.01
3425	MK	34.25–38.00	1-11/32–1-1/2	R111 3425	$299.78	R112 3425	$45.71
3800	ML	38.00–46.00	1-1/2–1-13/16	R111 3800	$349.25	R112 3800	$65.79
4600	MM	46.00–56.00	1-13/16–2-7/32			R112 4600	$106.31
5600	MN	56.00–69.75	2-7/32–2-3/4			R112 5600	$153.93
6975	MO	69.75–85.00	2-3/4–3-11/32			R112 6975	$234.87

		Pieces		
MA1	**Adjustable Reamer Pilot Set**			
	MA to MI (Pilots Only)	9	R111 MA1	$2,064.48

R111 MA1