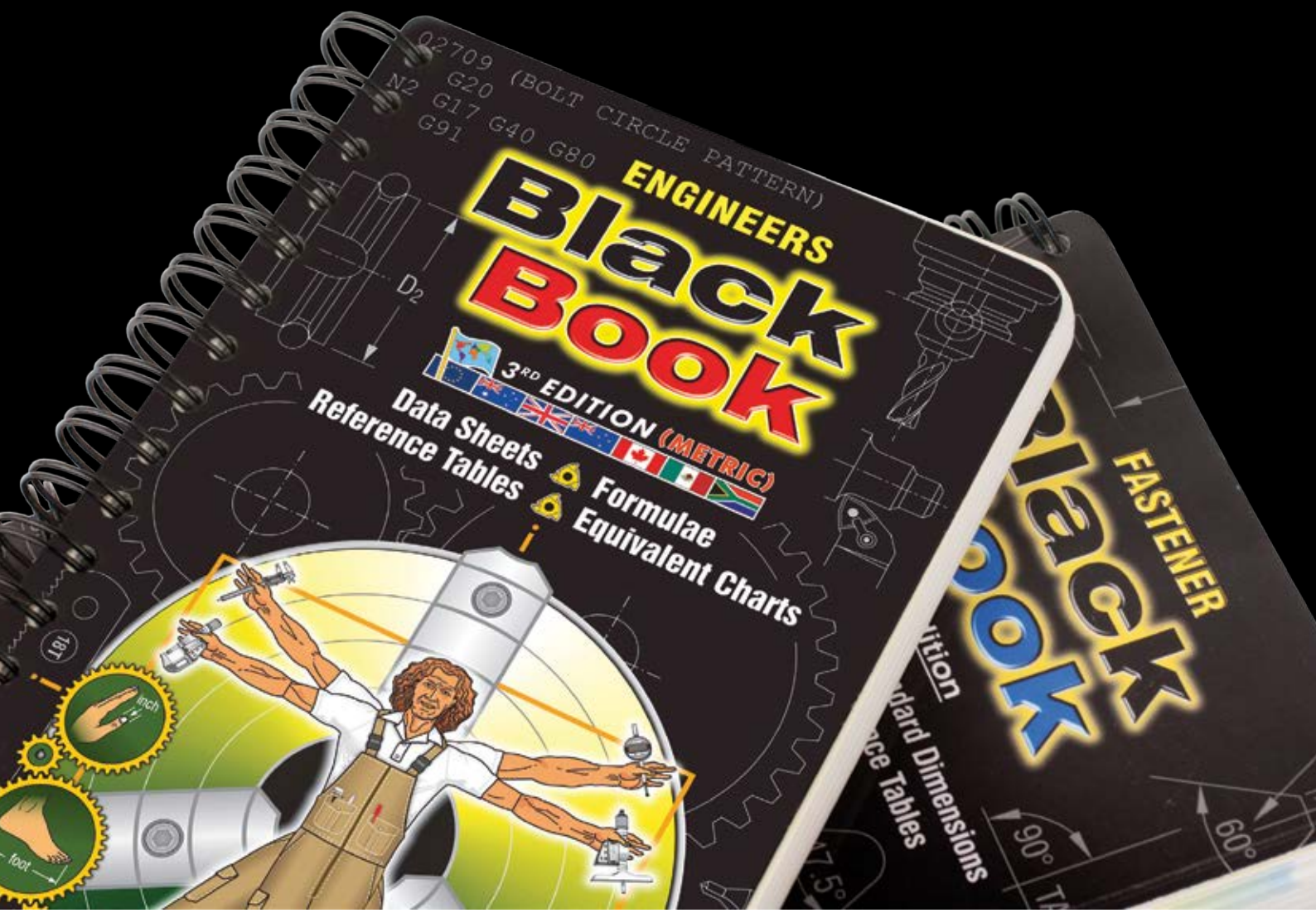
sutton®

REAMING

• Hand • Machine (Morse Taper & Chucking) • Bridge • Taper Pin

AVAILABLE IN MULTIPLE LANGUAGES

L100 V3EN L100 V2NL L100 V2FR L100 V2DE



Engineers Black Book
The Ultimate Reference Book is here...

The easy to use pocket-size reference tools containing a wealth of detailed and updated information for the industry and trade.

The Black Book series includes the Engineer and Fastener editions. The high quality matt laminated grease proof page ensures long life and glare-free reading. It is wire bound to ensure the book stays flat on workbench when you are reading.

The book also comes with a FREE set of bookmarking tabs (Engineer), and thread pitch identification gauge (Fastener).

Black Books are the ultimate reference books for engineers, trades people, apprentices, machine shops, tool rooms, technical colleges and purchasing officers.

- Tables
- Standards
- Illustrations
- Conversion factors
- Lubricants-coolants
- Tolerances
- Weights of metal
- Geometrical construction
- Formulae
- Engineering drawing standards
- Tapping drill sizes
- Speeds & feeds
- Equivalent charts
- Sharpening information

Reaming Finder

sutton

ISO	VDI	Material Group	Sutton	
P	A	Steel	N	UNI
M	R	Stainless Steel	VA	
K	F	Cast Iron	GG	
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W	
S	S	Titaniums & Super Alloys	Ti	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	390	393	397	399	400	400	401
Catalogue Code	R100	R101	R102	R105	R106	R107	R108
Material	HSS	HSS	HSS Co	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N	Roughing	Finishing	Tapered Pipe
Standard	DIN 206 / ISO 236	DIN 208	DIN 212 / ISO 521	–	–	–	–
Geometry	L10	L10	L10	L7	L7	L7	L15

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		230	780	○	○	○	○	○	○	○
	14.3		Precipitation Hardening		300	780	○	○	○	○	○	○	○
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

sutton

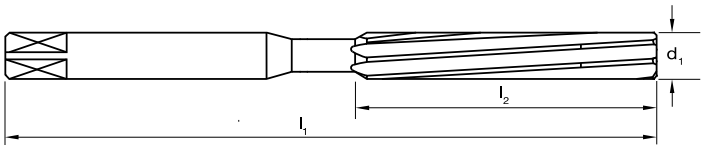
- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs à main
- Pour utilisation universelle à main
- Tolérance H7

Alesatori a Mano
- Per uso manuale con propria chiave di trascinamento
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Manuales
- Para usar a mano con llave adecuada
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
0300	**3.000**		62	31	-	-	6	R100 0300
0318	3.175	**1/8**	66	33	-	-	6	R100 0318
0350	**3.500**		71	35	-	-	6	R100 0350
0357	3.572	**9/64**	71	35	-	-	6	R100 0357
0397	3.969	**5/32**	76	38	-	-	6	R100 0397
0400	**4.000**		76	38	-	-	6	R100 0400
0437	4.366	**11/64**	81	41	-	-	6	R100 0437
0450	**4.500**		81	41	-	-	6	R100 0450
0476	4.762	**3/16**	87	44	-	-	6	R100 0476
0500	**5.000**		87	44	-	-	6	R100 0500
0516	5.159	**13/64**	87	44	-	-	6	R100 0516
0550	**5.500**		93	47	-	-	6	R100 0550
0556	5.556	**7/32**	93	47	-	-	6	R100 0556
0595	5.953	**15/64**	93	47	-	-	6	R100 0595
0600	**6.000**		93	47	-	-	6	R100 0600
0635	6.350	**1/4**	100	50	-	-	6	R100 0635
0650	**6.500**		100	50	-	-	6	R100 0650
0675	6.747	**17/64**	100	50	-	-	6	R100 0675
0700	**7.000**		107	54	-	-	6	R100 0700
0714	7.144	**9/32**	107	54	-	-	6	R100 0714
0750	**7.500**		107	54	-	-	6	R100 0750
0754	7.541	**19/64**	107	54	-	-	6	R100 0754
0794	7.938	**5/16**	115	58	-	-	6	R100 0794
0800	**8.000**		115	58	-	-	6	R100 0800
0833	8.334	**21/64**	115	58	-	-	6	R100 0833
0850	**8.500**		115	58	-	-	6	R100 0850
0873	8.731	**11/32**	124	62	-	-	6	R100 0873
0900	**9.000**		124	62	-	-	6	R100 0900

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

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

● Optimal ○ Effective

sutton

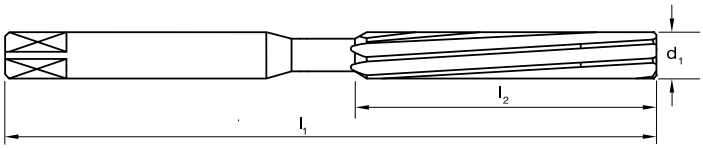
- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs à main
- Pour utilisation universelle à main
- Tolérance H7

Alesatori a Mano
- Per uso manuale con propria chiave di trascinamento
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Manuales
- Para usar a mano con llave adecuada
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
0913	9.128	23/64	124	62	-	-	8	R100 0913
0950	9.500		124	62	-	-	6	R100 0950
0953	9.525	3/8	133	66	-	-	8	R100 0953
0992	9.922	25/64	133	66	-	-	8	R100 0992
1000	10.000		133	66	-	-	6	R100 1000
1032	10.319	13/32	133	66	-	-	8	R100 1032
1050	10.500		133	66	-	-	6	R100 1050
1100	11.000		142	71	-	-	6	R100 1100
1111	11.112	7/16	142	71	-	-	8	R100 1111
1150	11.500		142	71	-	-	6	R100 1150
1151	11.509	29/64	142	71	-	-	8	R100 1151
1191	11.906	15/32	152	76	-	-	8	R100 1191
1200	12.000		152	76	-	-	6	R100 1200
1230	12.303	31/64	152	76	-	-	8	R100 1230
1250	12.500		152	76	-	-	6	R100 1250
1270	12.700	1/2	152	76	-	-	8	R100 1270
1300	13.000		152	76	-	-	6	R100 1300
1310	13.097	33/64	152	76	-	-	8	R100 1310
1349	13.494	17/32	163	81	-	-	8	R100 1349
1389	13.891	35/64	163	81	-	-	8	R100 1389
1350	13.500		163	81	-	-	6	R100 1350
1400	14.000		163	81	-	-	8	R100 1400
1429	14.288	9/16	163	81	-	-	8	R100 1429
1450	14.500		163	81	-	-	8	R100 1450
1468	14.684	37/64	163	81	-	-	8	R100 1468
1500	15.000		163	81	-	-	8	R100 1500
1508	15.081	19/32	175	87	-	-	8	R100 1508
1548	15.478	39/64	175	87	-	-	8	R100 1548

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

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

● Optimal ○ Effective

sutton

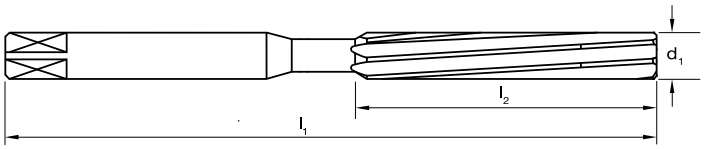
- For use by hand with suitable wrench
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs à main
- Pour utilisation universelle à main
- Tolérance H7

Alesatori a Mano
- Per uso manuale con propria chiave di trascinamento
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Manuales
- Para usar a mano con llave adecuada
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
1588	15.875	5/8	175	87	-	-	8	R100 1588
1600	16.000		175	87	-	-	8	R100 1600
1627	16.272	41/64	175	87	-	-	8	R100 1627
1667	16.669	21/32	175	87	-	-	8	R100 1667
1700	17.000		175	87	-	-	8	R100 1700
1707	17.066	43/64	188	93	-	-	8	R100 1707
1746	17.463	11/16	188	93	-	-	8	R100 1746
1800	18.000		188	93	-	-	8	R100 1800
1826	18.256	23/32	188	93	-	-	8	R100 1826
1900	19.000		188	93	-	-	8	R100 1900
1905	19.050	3/4	201	100	-	-	10	R100 1905
1984	19.844	25/32	201	100	-	-	10	R100 1984
2000	20.000		201	100	-	-	8	R100 2000
2064	20.638	13/16	201	100	-	-	10	R100 2064
2100	21.000		201	100	-	-	8	R100 2100
2143	21.431	27/32	215	107	-	-	10	R100 2143
2200	22.000		215	107	-	-	8	R100 2200
2223	22.225	7/8	215	107	-	-	10	R100 2223
2300	23.000		215	107	-	-	8	R100 2300
2302	23.019	29/32	215	107	-	-	10	R100 2302
2381	23.813	15/16	231	115	-	-	10	R100 2381
2400	24.000		231	115	-	-	8	R100 2400
2461	24.606	31/32	231	115	-	-	10	R100 2461
2500	25.000		231	115	-	-	10	R100 2500
2540	25.400	1	231	115	-	-	10	R100 2540

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

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

● Optimal ○ Effective

Reamers Machine

sutton

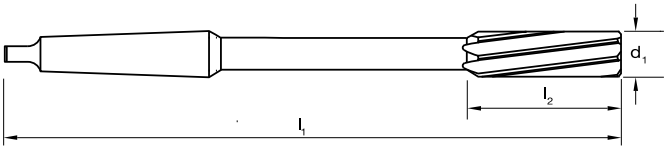
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs machine cône morse
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Macchina
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Cono Morse
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
0600	**6.000**		138	26	-	-	6	1	R101 0600
0635	6.350	**1/4**	144	28	-	-	6	1	R101 0635
0650	**6.500**		144	28	-	-	6	1	R101 0650
0675	6.747	**17/64**	144	28	-	-	6	1	R101 0675
0700	**7.000**		150	31	-	-	6	1	R101 0700
0714	7.144	**9/32**	150	31	-	-	6	1	R101 0714
0750	**7.500**		150	31	-	-	6	1	R101 0750
0754	7.541	**19/64**	150	31	-	-	6	1	R101 0754
0794	7.938	**5/16**	156	33	-	-	6	1	R101 0794
0800	**8.000**		156	33	-	-	6	1	R101 0800
0833	8.334	**21/64**	156	33	-	-	6	1	R101 0833
0850	**8.500**		156	33	-	-	6	1	R101 0850
0873	8.731	**11/32**	162	36	-	-	6	1	R101 0873
0900	**9.000**		162	36	-	-	6	1	R101 0900
0913	9.128	**23/64**	162	36	-	-	6	1	R101 0913
0950	**9.500**		162	36	-	-	6	1	R101 0950
0953	9.525	**3/8**	162	36	-	-	6	1	R101 0953
0992	9.922	**25/64**	168	38	-	-	6	1	R101 0992
1000	**10.000**		168	38	-	-	6	1	R101 1000
1032	10.319	**13/32**	168	38	-	-	6	1	R101 1032
1050	**10.500**		168	38	-	-	6	1	R101 1050
1072	10.716	**27/64**	175	41	-	-	6	1	R101 1072
1100	**11.000**		175	41	-	-	6	1	R101 1100
1111	11.112	**7/16**	175	41	-	-	6	1	R101 1111
1150	**11.500**		175	41	-	-	6	1	R101 1150
1151	11.509	**29/64**	175	41	-	-	6	1	R101 1151
1191	11.906	**15/32**	175	41	-	-	6	1	R101 1191
1200	**12.000**		182	44	-	-	6	1	R101 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
R101	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

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

● Optimal ○ Effective

sutton

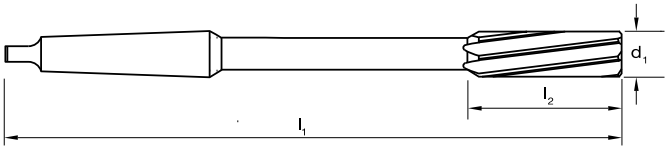
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs machine cône morse
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Macchina
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Cono Morse
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
1230	12.303	**31/64**	182	44	-	-	6	1	R101 1230
1250	**12.500**		182	44	-	-	6	1	R101 1250
1270	12.700	**1/2**	182	44	-	-	6	1	R101 1270
1300	**13.000**		182	44	-	-	6	1	R101 1300
1310	13.097	**33/64**	182	44	-	-	6	1	R101 1310
1349	13.494	**17/32**	189	47	-	-	6	1	R101 1349
1350	**13.500**		189	47	-	-	6	1	R101 1350
1389	13.891	**35/64**	189	47	-	-	6	1	R101 1389
1400	**14.000**		189	47	-	-	8	1	R101 1400
1429	14.288	**9/16**	204	50	-	-	8	2	R101 1429
1450	**14.500**		204	50	-	-	8	2	R101 1450
1468	14.684	**37/64**	204	50	-	-	8	2	R101 1468
1500	**15.000**		204	50	-	-	8	2	R101 1500
1508	15.081	**19/32**	210	52	-	-	8	2	R101 1508
1550	**15.500**		210	52	-	-	8	2	R101 1550
1548	15.478	**39/64**	210	52	-	-	8	2	R101 1548
1588	15.875	**5/8**	210	52	-	-	8	2	R101 1588
1600	**16.000**		210	52	-	-	8	2	R101 1600
1627	16.272	**41/64**	214	54	-	-	8	2	R101 1627
1650	**16.500**		214	54	-	-	8	2	R101 1650
1667	16.669	**21/32**	214	54	-	-	8	2	R101 1667
1700	**17.000**		214	54	-	-	8	2	R101 1700
1707	17.066	**43/64**	219	56	-	-	8	2	R101 1707
1746	17.463	**11/16**	219	56	-	-	8	2	R101 1746
1750	**17.500**		219	56	-	-	8	2	R101 1750
1786	17.859	**45/64**	219	56	-	-	8	2	R101 1786
1800	**18.000**		219	56	-	-	8	2	R101 1800
1826	18.256	**23/32**	219	56	-	-	8	2	R101 1826

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

sutton

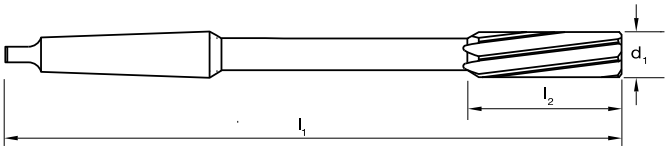
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs machine cône morse
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Macchina
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Cono Morse
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
1850	18.500		223	58	-	-	8	2	R101 1850
1900	19.000		223	58	-	-	8	2	R101 1900
1905	19.050	3/4	223	58	-	-	8	2	R101 1905
1950	19.500		228	60	-	-	8	2	R101 1950
2000	20.000		228	60	-	-	8	2	R101 2000
2050	20.500		232	62	-	-	8	2	R101 2050
2064	20.638	13/16	232	62	-	-	8	2	R101 2064
2100	21.000		232	62	-	-	8	2	R101 2100
2143	21.431	27/32	232	62	-	-	8	2	R101 2143
2150	21.500		237	64	-	-	8	2	R101 2150
2200	22.000		237	64	-	-	8	2	R101 2200
2223	22.225	7/8	237	64	-	-	8	2	R101 2223
2250	22.500		241	66	-	-	8	2	R101 2250
2300	23.000		241	66	-	-	8	2	R101 2300
2302	23.019	29/32	237	64	-	-	8	2	R101 2302
2350	23.500		241	66	-	-	8	3	R101 2350
2381	23.813	15/16	268	68	-	-	8	3	R101 2381
2400	24.000		268	68	-	-	8	3	R101 2400
2450	24.500		268	68	-	-	8	3	R101 2450
2461	24.606	31/32	268	68	-	-	8	3	R101 2461
2500	25.000		268	68	-	-	10	3	R101 2500
2540	25.400	1	268	68	-	-	8	3	R101 2540
2550	25.500		273	70	-	-	10	3	R101 2550
2600	26.000		273	70	-	-	10	3	R101 2600
2650	26.500		273	70	-	-	10	3	R101 2650
2699	26.987	1-1/16	277	71	-	-	10	3	R101 2699
2700	27.000		277	71	-	-	10	3	R101 2700
2750	27.500		277	71	-	-	10	3	R101 2750

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

sutton

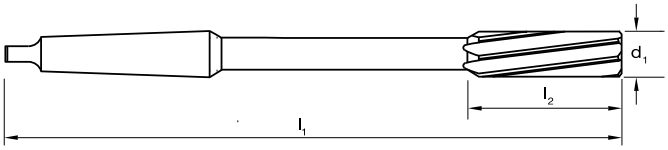
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs machine cône morse
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Macchina
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escariadores Cono Morse
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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

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

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

● Optimal ○ Effective

Reamers Chucking

sutton

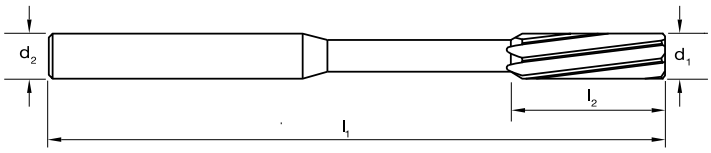
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs à machine queue cylindrique
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Mandrino
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escaradores Máquina
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
0200	**2.000**		49	11	-	2.0	3	R102 0200
0250	**2.500**		57	14	-	2.5	5	R102 0250
0300	**3.000**		61	15	-	3.0	5	R102 0300
0318	3.175	**1/8**	65	16	-	3.2	5	R102 0318
0350	**3.500**		70	18	-	3.5	5	R102 0350
0357	3.572	**9/64**	70	18	-	3.6	5	R102 0357
0397	3.969	**5/32**	75	19	-	4.0	6	R102 0397
0400	**4.000**		75	19	-	4.0	6	R102 0400
0450	**4.500**		80	21	-	4.5	6	R102 0450
0476	4.762	**3/16**	86	23	-	5.0	6	R102 0476
0500	**5.000**		86	23	-	5.0	6	R102 0500
0516	5.159	**13/64**	86	23	-	5.0	6	R102 0516
0550	**5.500**		93	26	-	5.6	6	R102 0550
0595	5.953	**15/64**	93	26	-	5.6	6	R102 0595
0600	**6.000**		93	26	-	5.6	6	R102 0600
0635	6.350	**1/4**	101	28	-	6.3	6	R102 0635
0650	**6.500**		101	28	-	6.3	6	R102 0650
0700	**7.000**		109	31	-	7.1	6	R102 0700
0750	**7.500**		109	31	-	7.1	6	R102 0750
0794	7.938	**5/16**	117	31	-	8.0	6	R102 0794
0800	**8.000**		117	33	-	8.0	6	R102 0800
0850	**8.500**		117	33	-	8.0	6	R102 0850
0900	**9.000**		125	36	-	9.0	6	R102 0900
0950	**9.500**		125	36	-	9.0	6	R102 0950
0953	9.525	**3/8**	133	38	-	10.0	6	R102 0953
1000	**10.000**		133	38	-	10.0	6	R102 1000
1050	**10.500**		133	38	-	10.0	6	R102 1050
1100	**11.000**		142	41	-	10.0	6	R102 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
R102	●	●	●	●	○	●	●	○		○		○		○	○	○	●	○	●	○	●	○	○	○	○	○		○	○	○																			○	

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

● Optimal ○ Effective

sutton

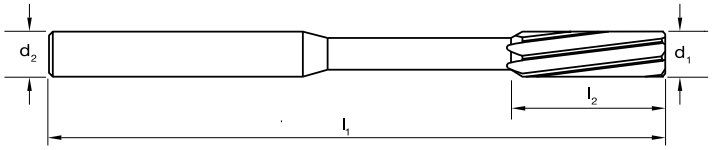
- Machine use
- Suitable for tool rooms & workshop use
- Produces clean, accurate holes, to a H7 tolerance

Alésoirs à machine queue cylindrique
- Pour utilisation universelle sur machines
- Tolérance H7

Alesatori Mandrino
- Adatto a operazioni su macchine CN
- Ideale per uso in Tool rooms & reparto produttivo
- Produce fori puliti e precisi, a una tolleranza H7

Escaradores Máquina
- Para usar a máquina
- Adecuado para mantenimiento y uso en talleres
- Produce agujeros de precisión, hasta tolerancia H7

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 #
1111	11.112	**7/16**	142	41	-	10.0	6	R102 1111
1150	**11.500**		142	41	-	10.0	6	R102 1150
1200	**12.000**		151	44	-	10.0	6	R102 1200
1250	**12.500**		151	44	-	10.0	6	R102 1250
1270	12.700	**1/2**	151	44	-	10.0	6	R102 1270
1300	**13.000**		151	44	-	10.0	6	R102 1300
1350	**13.500**		160	47	-	12.5	6	R102 1350
1400	**14.000**		160	47	-	12.5	8	R102 1400
1429	14.288	**9/16**	162	50	-	12.5	8	R102 1429
1450	**14.500**		162	50	-	12.5	8	R102 1450
1500	**15.000**		162	50	-	12.5	8	R102 1500
1550	**15.500**		170	52	-	12.5	8	R102 1550
1588	15.875	**5/8**	170	52	-	12.5	8	R102 1588
1600	**16.000**		170	52	-	12.5	8	R102 1600

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

*Not available once current stock is depleted

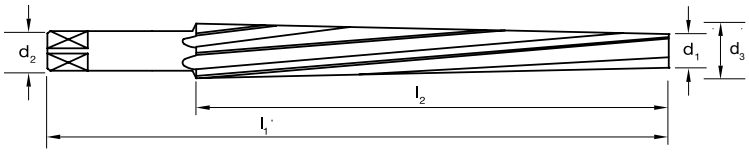
Reamers Taper Pin

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

Alésoirs à main conique en pouce
- Pour utilisation universelle à main, en reprise de trous
- Conicité 1:48

Alesatori Conico
- Per uso manuale con propria chiave di trascinamento
- Ideale per allargare conicamente 1:48 un foro già esistente

Escaradores Cónicos Guias
- Para usar a mano con llave adecuada
- Para abrir agujeros cónicos de 1:48



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

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

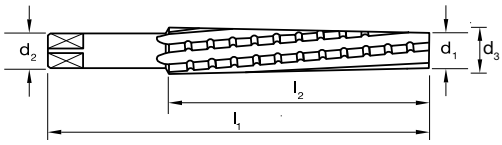
Reamers Morse Taper Socket

- 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

Alésoirs à main conique pour cônes morse
- Pour utilisation universelle à main
- Recommandé pour l'ébauche dans les matériaux difficiles ou en reprise de trous existants en mauvaise état.

Alesatori Presa Morse
- Per uso manuale con propria chiave di trascinamento
- Ideale per uso in Tool rooms & reparto produttivo
- Sgrossatura, allarga fori già esistenti
- Finitura,può essere usato per finire fori già sgrossati

Escaradores Cónicos Manuales
- Para usar a mano con llave adecuada
- Adecuado para salas mantenimiento y uso en talleres
- Más Basto, abre agujeros existentes
- Acabado, para ser utilizado después del desbaste para medida final



Catalogue Code	R106	R107
Discount Group	B0302	B0302
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	**Roughing**	**Finishing**
Geometry	L7	L7

Size Ref.	MT #	l_1	l_2	d_1	d_2	d_3	z	Item #	Item #
0000	0	83	57	6.59	8.72	9.24	6	R106 0000	R107 0000
0001	1	95	64	9.63	11.90	12.52	6	R106 0001	R107 0001
0002	2	114	76	14.79	16.65	18.27	6	R106 0002	R107 0002
0003	3	140	95	19.98	22.22	24.44	8	R106 0003	R107 0003
0004	4	175	117	26.14	25.40	31.90	8	R106 0004	R107 0004
0005	5	216	152	37.69	34.92	45.27	10	R106 0005	R107 0005

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

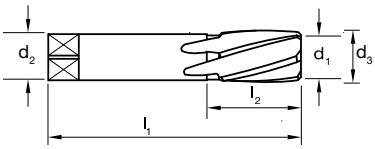
Reamers Taper Pipe

- 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

Alésoirs à main conique BSPT/NPT
- Pour utilisation universelle à main
- Recommandé avant taraudage des filetages BSPT & NPT pour prolonger la durée de vie

Alesatori Tubo Conico
- Per uso manuale con propria chiave di trascinamento
- Ideale per uso in Tool rooms & reparto produttivo
- Preparatore al foro conico 1:16 pre filettatura (BSPT,NPT)
- Aumenta la durata del maschio, specialmente su materiali difficili

Escaradores Cónicos Roscas
- Para usar a mano con llave adecuada
- Adecuado para mantenimiento y uso en talleres
- Se usa antes de hacer roscas cónicas 1:16 conicidad (BSPT, NPT)
- Prolonga la vida útil del macho, especialmente en materiales resistentes



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

Size Ref.	Size	d_1	l_1	l_2	d_2	d_3	z	Item #
0803	1/8	8.00	60	15	8.00	8.97	6	R108 0803
1031	1/4	10.31	67	20	10.00	11.50	6	R108 1031
1372	3/8	13.72	75	22	12.50	15.63	6	R108 1372
1689	1/2	16.89	87	26	16.00	18.52	6	R108 1689
2225	3/4	22.25	96	29	20.00	24.00	6	R108 2225
2802	1	28.00	110	33	25.00	30.08	6	R108 2802
3668	1-1/4	36.58	119	37	31.50	38.83	6	R108 3668
4277	1-1/2	42.77	125	37	35.50	15.08	8	R108 4277
5484	2	54.84	140	41	40.00	57.40	8	R108 5484

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