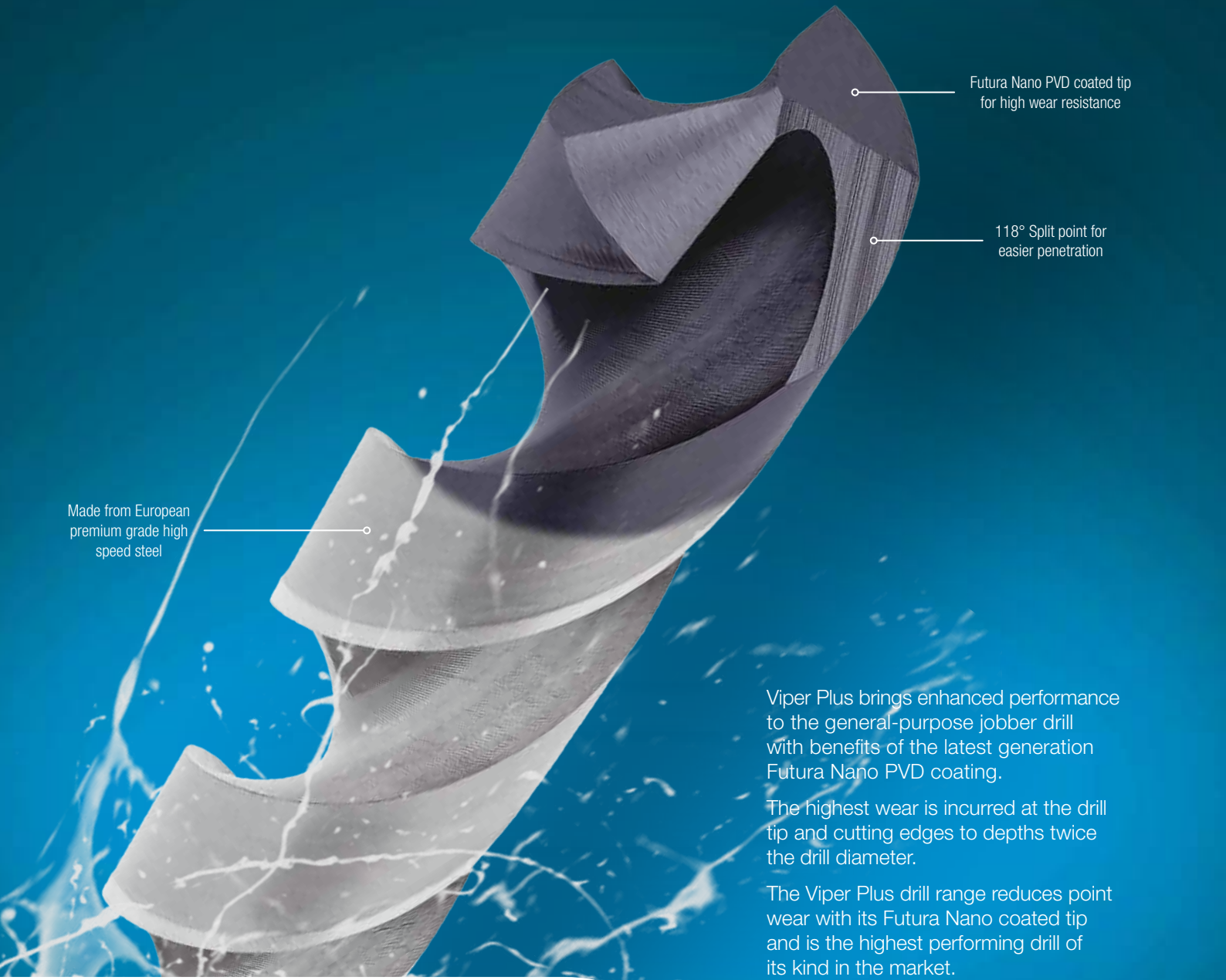


Drill bits with EXTRA bite



Futura Nano PVD coated tip for high wear resistance

118° Split point for easier penetration

Made from European premium grade high speed steel

Viper Plus brings enhanced performance to the general-purpose jobber drill with benefits of the latest generation Futura Nano PVD coating.

The highest wear is incurred at the drill tip and cutting edges to depths twice the drill diameter.

The Viper Plus drill range reduces point wear with its Futura Nano coated tip and is the highest performing drill of its kind in the market.

VIPER PLUS

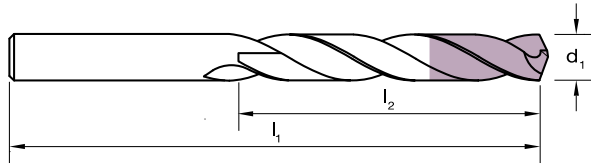
HSS DRILLS



suttontools
world class cutting tools

suttontools

- General purpose drill
- Split point for easier penetration
- Designed for machine and hand held drilling



Size Ref.	d ₁ (h8)	Gauge	L ₁	L ₂	Pck Qty	Item #
0100	1.00		34	12	10	D179 0100
0110	1.10		36	14	10	D179 0110
0119	1.19	3/64	44	19	10	D179 0119
0120	1.20		38	16	10	D179 0120
0130	1.30		38	16	10	D179 0130
0140	1.40		40	18	10	D179 0140
0150	1.50		40	18	10	D179 0150
0151	1.51	53	48	22	10	D179 0151
0159	1.59	1/16	48	22	10	D179 0159
0160	1.60		43	20	10	D179 0160
0170	1.70		43	20	10	D179 0170
0180	1.80		46	22	10	D179 0180
0190	1.90		46	22	10	D179 0190
0198	1.98	5/64	51	25	10	D179 0198
0200	2.00		49	24	10	D179 0200
0210	2.10		49	24	10	D179 0210
0220	2.20		53	27	10	D179 0220
0230	2.30		53	27	10	D179 0230
0238	2.38	3/32	57	32	10	D179 0238
0240	2.40		57	30	10	D179 0240
0250	2.50		57	30	10	D179 0250
0260	2.60		57	30	10	D179 0260
0270	2.70		61	33	10	D179 0270
0278	2.78	7/64	67	38	10	D179 0278
0280	2.80		61	33	10	D179 0280
0290	2.90		61	33	10	D179 0290
0294	2.95	32	70	41	10	D179 0294
0300	3.00		61	33	10	D179 0300
0310	3.10		65	36	10	D179 0310
0318	3.18	1/8	70	41	10	D179 0318
0320	3.20		65	36	10	D179 0320
0330	3.30		65	36	10	D179 0330
0340	3.40		70	39	10	D179 0340
0345	3.45	29	73	44	10	D179 0345
0350	3.50		70	39	10	D179 0350
0357	3.57	9/64	73	44	10	D179 0357
0360	3.60		70	39	10	D179 0360
0370	3.70		70	39	10	D179 0370
0373	3.73	26	76	48	10	D179 0373
0380	3.80		75	43	10	D179 0380
0390	3.90		75	43	10	D179 0390
0391	3.91	23	79	51	10	D179 0391
0397	3.97	5/32	79	51	10	D179 0397
0400	4.00		75	43	10	D179 0400

Size Ref.	d ₁ (h8)	Gauge	L ₁	L ₂	Pck Qty	Item #
0410	4.10		75	43	10	D179 0410
0420	4.20		75	43	10	D179 0420
0430	4.30		80	47	10	D179 0430
0437	4.37	11/64	83	54	10	D179 0437
0440	4.40		80	47	10	D179 0440
0450	4.50		80	47	10	D179 0450
0460	4.60		80	47	10	D179 0460
0470	4.70		80	47	10	D179 0470
0476	4.76	3/16	89	59	10	D179 0476
0480	4.80		86	52	10	D179 0480
0490	4.90		86	52	10	D179 0490
0500	5.00		86	52	10	D179 0500
0510	5.10		86	52	10	D179 0510
0511	5.10	7	92	62	10	D179 0511
0516	5.16	13/64	92	62	10	D179 0516
0520	5.20		86	52	10	D179 0520
0530	5.30		86	52	10	D179 0530
0540	5.40		93	57	10	D179 0540
0541	5.41	3	95	64	10	D179 0541
0550	5.50		93	57	10	D179 0550
0556	5.56	7/32	95	64	10	D179 0556
0560	5.60		93	57	10	D179 0560
0570	5.70		93	57	10	D179 0570
0580	5.80		93	57	10	D179 0580
0590	5.90		93	57	10	D179 0590
0595	5.95	15/64	98	67	10	D179 0595
0600	6.00		93	57	10	D179 0600
0610	6.10		101	63	10	D179 0610
0620	6.20		101	63	10	D179 0620
0624	6.25	D	102	70	10	D179 0624
0630	6.30		101	63	10	D179 0630
0635	6.35	1/4	102	70	10	D179 0635
0640	6.40		101	63	10	D179 0640
0650	6.50		101	63	10	D179 0650
0652		F	102	70	10	D179 0652
0660	6.60		101	63	10	D179 0660
0670	6.70		101	63	10	D179 0670
0676	6.75	17/64	105	73	10	D179 0676
0680	6.80		109	69	10	D179 0680
0690	6.90		109	69	10	D179 0690
0700	7.00		109	69	10	D179 0700
0710	7.10		109	69	10	D179 0710
0714	7.14	9/32	108	75	10	D179 0714
0720	7.20		109	69	10	D179 0720

Catalogue Code	D179
Discount Group	A0420
Material	HSS
Surface Finish	TAIN Tip
Sutton Designation	N
Geometry	R30
Point Type	118° Form C

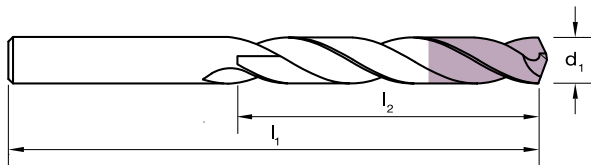
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D179	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○

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

● Optimal ○ Effective

suttontools

- General purpose drill
- Split point for easier penetration
- Designed for machine and hand held drilling



Catalogue Code	D179
Discount Group	A0420
Material	HSS
Surface Finish	TiAlN Tip
Sutton Designation	N
Geometry	R30
Point Type	118° Form C

Size Ref.	d ₁ (h8)	Gauge	l ₁	l ₂	Pck Qty	Item #
0730	7.30		109	69	10	D179 0730
0740	7.40		109	69	10	D179 0740
0750	7.50		109	69	10	D179 0750
0754	7.54	19/64	111	78	10	D179 0754
0760	7.60		117	75	5	D179 0760
0770	7.70		117	75	5	D179 0770
0780	7.80		117	75	5	D179 0780
0790	7.90		117	75	5	D179 0790
0794	7.94	5/16	114	81	5	D179 0794
0800	8.00		117	75	5	D179 0800
0810	8.10		117	75	5	D179 0810
0820	8.20		117	75	5	D179 0820
0830	8.30		117	75	5	D179 0830
0833	8.33	21/64	117	84	5	D179 0833
0840	8.40		117	75	5	D179 0840
0850	8.50		117	75	5	D179 0850
0860	8.60		125	81	5	D179 0860
0870	8.70		125	81	5	D179 0870
0873	8.73	11/32	121	87	5	D179 0873
0880	8.80		125	81	5	D179 0880
0890	8.90		125	81	5	D179 0890
0900	9.00		125	81	5	D179 0900
0910	9.10		125	81	5	D179 0910
0913	9.13	23/64	124	89	5	D179 0913
0920	9.20		125	81	5	D179 0920
0930	9.30		125	81	5	D179 0930
0940	9.40		125	81	5	D179 0940
0950	9.50		125	81	5	D179 0950
0953	9.52	3/8	127	92	5	D179 0953
0960	9.60		133	87	5	D179 0960
0970	9.70		133	87	5	D179 0970
0980	9.80		133	87	5	D179 0980
0990	9.90		133	87	5	D179 0990
0992	9.92	25/64	130	95	5	D179 0992
1000	10.00		133	87	5	D179 1000
1010	10.10		133	87	5	D179 1010
1020	10.20		133	87	5	D179 1020
1030	10.30		133	87	5	D179 1030
1032	10.32	13/32	133	98	5	D179 1032
1040	10.40		133	87	5	D179 1040
1050	10.50		133	87	5	D179 1050
1060	10.60		133	87	5	D179 1060
1070	10.70		142	94	5	D179 1070
1072	10.72	27/64	137	100	5	D179 1072

Size Ref.	d ₁ (h8)	Gauge	l ₁	l ₂	Pck Qty	Item #
1080	10.80		142	94	5	D179 1080
1090	10.90		142	94	5	D179 1090
1100	11.00		142	94	5	D179 1100
1110	11.10		142	94	5	D179 1110
1111	11.11	7/16	140	103	5	D179 1111
1120	11.20		142	94	5	D179 1120
1130	11.30		142	94	5	D179 1130
1140	11.40		142	94	5	D179 1140
1150	11.50		142	94	5	D179 1150
1151	11.51	29/64	143	106	5	D179 1151
1160	11.60		142	94	5	D179 1160
1170	11.70		142	94	5	D179 1170
1180	11.80		142	94	5	D179 1180
1190	11.90		142	94	5	D179 1190
1191	11.91	15/32	146	110	5	D179 1191
1200	12.00		151	101	5	D179 1200
1210	12.10		151	101	5	D179 1210
1220	12.20		151	101	5	D179 1220
1230	12.30		151	101	5	D179 1230
1231	12.30	31/64	149	111	5	D179 1231
1240	12.40		151	101	5	D179 1240
1250	12.50		151	101	5	D179 1250
1260	12.60		151	101	5	D179 1260
1269	12.70	1/2	152	114	5	D179 1269
1270	12.70		151	101	5	D179 1270
1280	12.80		151	101	5	D179 1280
1290	12.90		151	101	5	D179 1290
1300	13.00		151	101	5	D179 1300
1310	13.10	33/64	151	101	1	D179 1310
1349	13.49	17/32	160	108	1	D179 1349
1350	13.50		160	108	1	D179 1350
1400	14.00		160	108	1	D179 1400
1429	14.29	9/16	169	114	1	D179 1429
1450	14.50		169	114	1	D179 1450
1500	15.00		169	114	1	D179 1500
1550	15.50		178	120	1	D179 1550
1588	15.88	5/8	178	120	1	D179 1588
1600	16.00		178	120	1	D179 1600
SM2	1.0 – 10mm x 0.5					D179 SM2
SM3	1.0 – 13mm x 0.5					D179 SM3
S2	1/16 – 3/8 x 64ths					D179 S2
S3	1/16 – 1/2 x 64ths					D179 S3

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			
D179	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○

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

● Optimal
 ○ Effective

Case Study Viper Plus Drills

TEST 1

Controlled CNC Testing
Speed Trial – 100 holes

Drill size: 6mm

Lubricant: Minimum quantity (MQL)

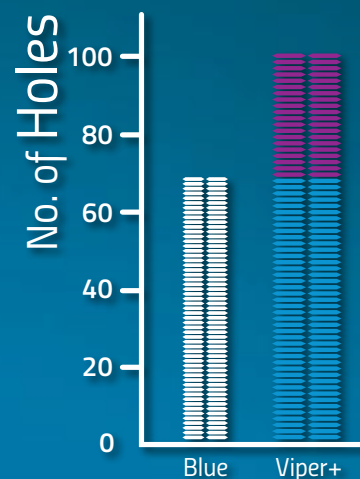
Material: A1S1 D2 approximately 18HRC (cold work steel)

**45%
GAIN IN
PRODUCTIVITY**



Item #	D102 0600	D179 0600
V _c :	12 m/min	18 m/min
N:	637 RPM	955 RPM
f _n :	0.1 mm/rev	0.1 mm/rev
V _f :	64 mm/min	95.5 mm/min
Depth:	2.5xD blind	2.5xD blind

(Recommended cutting conditions)



TEST 2

Controlled CNC Testing
Accelerated to Failure

Drill size: 6mm

Lubricant: Minimum quantity (MQL)

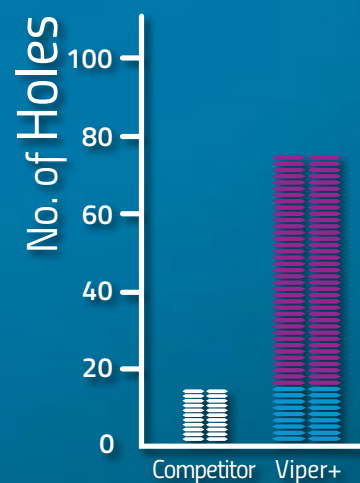
Material: A1S1 D2 approximately 18HRC (cold work steel)

**HIGHEST
PERFORMANCE
IN ITS CLASS**

Competitor



Item #	D179 0600	
V _c :	30 m/min	30 m/min
N:	1592 RPM	1592 RPM
f _n :	0.125 mm/rev	0.125 mm/rev
V _f :	199 mm/min	199 mm/min
Depth:	2.5xD blind	2.5xD blind



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