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D188 -Reduced Shank Drills - 1/2" Shank -Sutton Tools

Sutton Tools Reduced Shank Drills are designed to increase the drilling capacity of drill chucks and for slow speed (350 RPM or less), large scale boring. Reduced shanks suit 13mm drill chucks. All drills have a 152mm overall length and 86mm flute length.

Features:

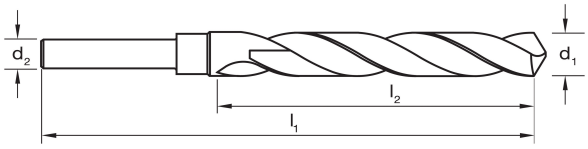
- Common Length 6" (152mm) overall length with a 3-3/8" (86mm) flute length
- Reduced shanks suit 13mm drill chucks
- 118° standard point for general purpose applications
- Made from M2 High Speed Steel (HSS) offering the best combination of strength, heat & wear resistance
- Blue surface finish for ferrous applications. The steam oxide finish prevents chip build-up on the cutting edges and reduces cutting friction, especially in low carbon steels

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Range:

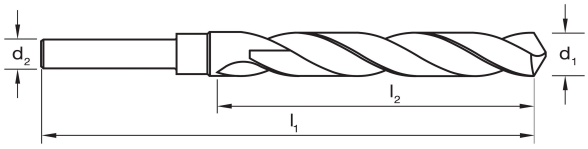


Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)
D1881310	13.10	33/64	152	86	12.70
D1881349	13.49	17/32	152	86	12.70
D1881350	13.50	-	152	86	12.70
D1881389	13.89	35/64	152	86	12.70
D1881400	14.00	-	152	86	12.70
D1881429	14.29	9/16	152	86	12.70
D1881450	14.50	-	152	86	12.70
D1881468	14.68	37/64	152	86	12.70
D1881500	15.00	-	152	86	12.70
D1881508	15.08	19/32	152	86	12.70
D1881548	15.48	39/64	152	86	12.70
D1881550	15.50	-	152	86	12.70
D1881588	15.88	5/8	152	86	12.70
D1881600	16.00	-	152	86	12.70
D1881627	16.27	41/64	152	86	12.70
D1881650	16.50	-	152	86	12.70
D1881667	16.67	21/32	152	86	12.70
D1881700	17.00	-	152	86	12.70
D1881707	17.07	43/64	152	86	12.70
D1881746	17.46	11/16	152	86	12.70
D1881750	17.50	-	152	86	12.70
D1881786	17.86	45/64	152	86	12.70
D1881800	18.00	-	152	86	12.70
D1881826	18.26	23/32	152	86	12.70
D1881850	18.50	-	152	86	12.70
D1881865	18.65	47/64	152	86	12.70
D1881900	19.00	-	152	86	12.70
D1881905	19.05	3/4	152	86	12.70
D1881945	19.45	49/64	152	86	12.70
D1881950	19.50	-	152	86	12.70
D1881984	19.84	25/32	152	86	12.70
D1882000	20.00	-	152	86	12.70
D1882024	20.24	51/64	152	86	12.70
D1882050	20.50	-	152	86	12.70
D1882064	20.64	13/16	152	86	12.70

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Range:



Item #	Diameter d1 (mm)	Diameter d1 (inch)	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)
D1882100	21.00	-	152	86	12.70
D1882143	21.43	27/32	152	86	12.70
D1882150	21.50	-	152	86	12.70
D1882200	22.00	-	152	86	12.70
D1882223	22.23	7/8	152	86	12.70
D1882250	22.50	-	152	86	12.70
D1882300	23.00	-	152	86	12.70
D1882302	23.02	29/32	152	86	12.70
D1882350	23.50	-	152	86	12.70
D1882381	23.81	15/16	152	86	12.70
D1882400	24.00	-	152	86	12.70
D1882450	24.50	-	152	86	12.70
D1882461	24.61	31/32	152	86	12.70
D1882500	25.00	-	152	86	12.70
D1882540	25.40	1	152	86	12.70
D1882600	26.00	-	152	86	12.70
D1882699	26.99	1-1/16	152	86	12.70
D1882800	28.00	-	152	86	12.70
D1882858	28.58	1-1/8	152	86	12.70
D1883000	30.00	-	152	86	12.70
D1883016	30.16	1-3/16	152	86	12.70
D1883175	31.75	1-1/4	152	86	12.70

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
P	1	Steel - Non-alloy, cast & free cutting (~ 0.15 %C)	Annealed	125MPa	440MPa	●
P	2	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Annealed	190MPa	640MPa	●
P	3	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Quenched & Tempered	250MPa	840MPa	o
P	4	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Annealed	270MPa	910MPa	o
P	5	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Quenched & Tempered	300MPa	1010MPa	o
P	6	Steel - Low alloy & cast < 5% of alloying elements	Annealed	180MPa	610MPa	●
P	7	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	275MPa	930MPa	o
P	8	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	300MPa	1010MPa	o
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200MPa	680MPa	o
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	180MPa	610MPa	o
M	14.2	Stainless Steel - Duplex		250MPa	840MPa	o
M	14.3	Stainless Steel - Precipitation Hardening		250HB	840MPa	
K	15	Cast Iron, Grey (GG) - Ferritic / Pearlitic		180MPa	610MPa	o
K	16	Cast Iron, Grey (GG) - Pearlitic		260HB	880MPa	
K	17	Cast Iron, Nodular (GGG) - Ferritic		160MPa	570MPa	o
K	18	Cast Iron, Nodular (GGG) - Pearlitic		250HB	840MPa	
K	19	Cast Iron, Malleable - Ferritic		130MPa	460MPa	o
K	20	Cast Iron, Malleable - Pearlitic		230HB	780MPa	
N	21	Aluminum & Magnesium, wrought alloy - Non Heat Treatable		60MPa	210MPa	●
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100MPa	360MPa	●
N	23	Aluminum & Magnesium, cast alloy ?12% Si - Non Heat Treatable		75MPa	270MPa	o
N	24	Aluminum & Magnesium, cast alloy ?12% Si - Heat Treatable	Age Hardened	90MPa	320MPa	o
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatabl		130HB	460MPa	
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1%		110MPa	390MPa	o
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90MPa	320MPa	o
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100MPa	360MPa	o
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-Ferous Metals | S Titanium & Super Alloys | H Hard Materials

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
H	39.1	Hardened steel	Hardened & Tempered	58HRC		
H	39.2	Hardened steel	Hardened & Tempered	62HRC		
H	40	Cast Iron - Chilled	Cast	400MPa	1350MPa	o
H	41	Cast Iron	Hardened & Tempered	55HRC		

KEY

● Optimal ○ Effective | P Steel | M Stainless | K Cast Iron | N Non-Ferous Metals | S Titanium & Super Alloys | H Hard Materials

Trade/DIY Applications:

Wood		Metal		Specialty		Masonry
Soft Wood		Steel	●	PVC Plastic	○	Masonry
Hard Wood		Hard Steel		Acrylic		Plasterboard
Wood & Nails		Stainless Steel		mineral rock wool		Compressed Fibre Cement
Chipboard		Aluminium	○	foams (EPS, PUR), Polystyre		Cement Sheet
Plywood		Copper / Brass	○	Leather		Ceramic Tile
MDF		Cast Iron	○	Rubber		Hebel
Green Wood		Sheet Metal		Fibreglass		Brick
Sandwich Construction		Precious Metals		Carbon Fibre		Concrete
Pallet		Metal Pipe		Glass		Reinforced Concrete
Window Frame				Laminate		Stone
						Granite
						Marble

KEY

● Optimal ○ Effective