



**suttontools**

## **B204 - DOUBLE CUT CARBIDE BURS - Sutton Tools**

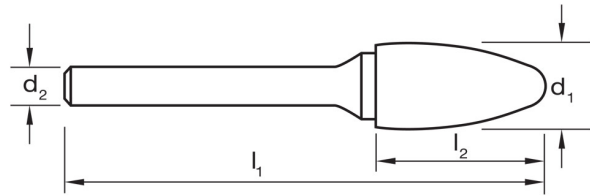
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### Features:

- Tree Shape Carbide Burs
- The chisel tooth pattern not only minimises tool chatter but reduces the chip to a granular shape, in most materials.
- AI Cut for rapid material removal of soft materials such as: Aluminium, Brass, Copper, Plastics that would normally load other cuts

CARBIDE BURS > DOUBLE CUT

Range:



Item #	d1	d1 (mm)	l1	l2	d2
B204SF100	1/4	6.4	2	5/8	1/4
B204SF140	3/4	19.1	2-3/4	1 - 1/4	1/4
B204SF150	3/4	19.1	3-1/4	1 - 1/2	1/4
B204SF300	3/8	9.6	2-1/2	3/4	1/4
B204SF400	7/16	11.2	2-3/4	1	1/4
B204SF410	1/8	3.2	1-1/2	1/4	1/8
B204SF420	1/8	3.2	1-1/2	1/2	1/8
B204SF500	1/2	12.7	2-3/4	1	1/4
B204SF510	1/4	6.4	2	1/2	1/8
B204SF600	5/8	15.9	2-3/4	1	1/4
B204SF700	3/4	19.1	2-3/4	1	1/4

## CARBIDE BURS > DOUBLE CUT

### Applications:

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

**S** Titanium & Super Alloys

**H** Hard Materials