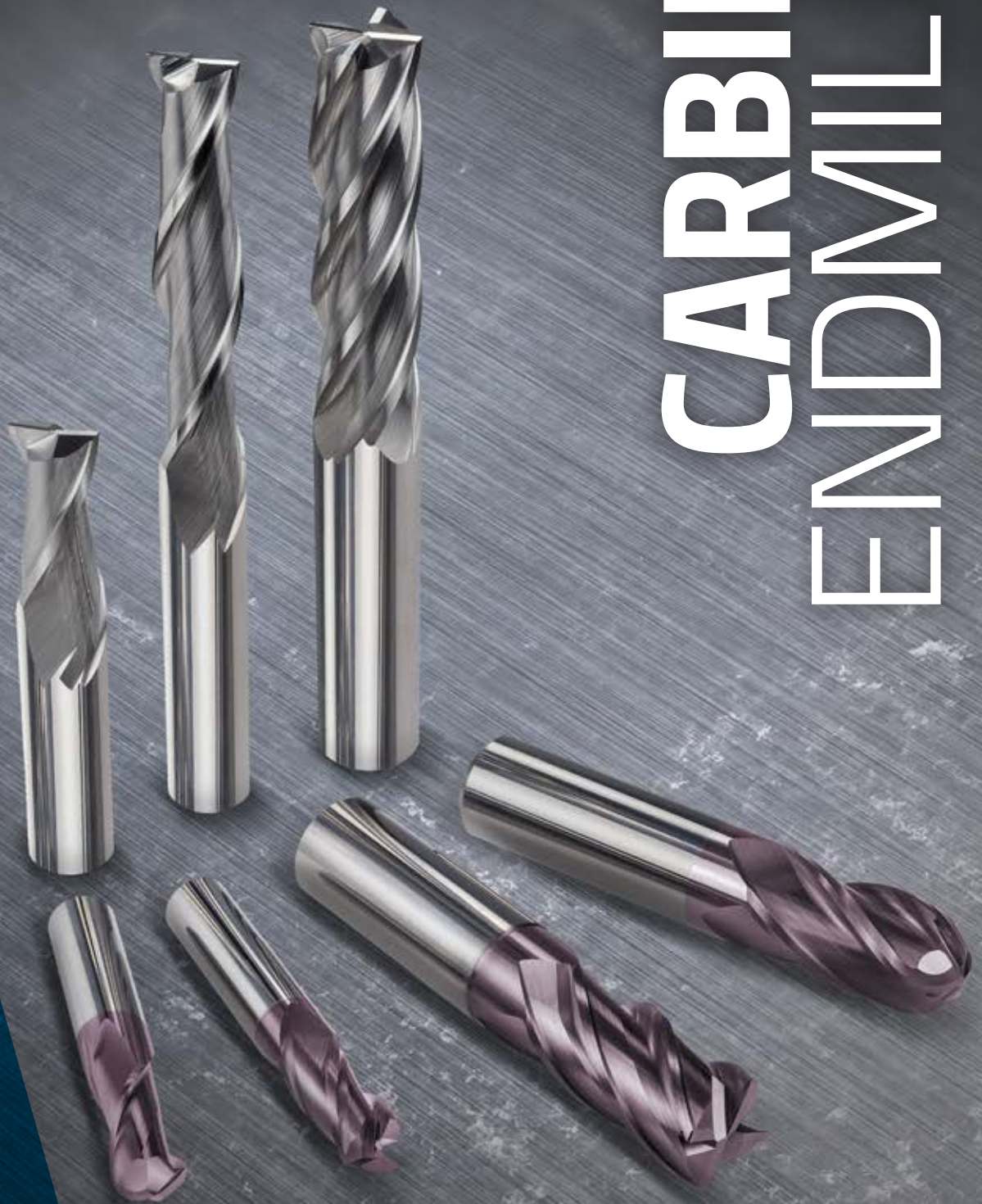


***sutton*tools**
world class cutting tools

CARBIDE ENDMILLS



TECLINE

Performance Series

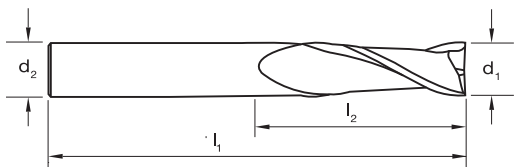
Lowest production costs

Endmills Carbide, 2 Flute, R30 N, Regular

suttontools

TECLINE

- For precision milling of slots & cavities
- Suitable for materials up to 1600 N/mm²
- TiAlN for longer tool life



Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #	Item #
0100	1.0	38	4	3	2	E600 0100	E603 0100
0150	1.5	38	4.5	3	2	E600 0150	E603 0150
0200	2.0	38	6	3	2	E600 0200	E603 0200
0250	2.5	38	9.5	3	2	E600 0250	E603 0250
0300	3.0	38	12	3	2	E600 0300	E603 0300
0350	3.5	50	12	4	2	E600 0350	E603 0350
0400	4.0	50	14	4	2	E600 0400	E603 0400
0450	4.5	50	16	6	2	E600 0450	E603 0450
0500	5.0	50	16	6	2	E600 0500	E603 0500
0600	6.0	50	19	6	2	E600 0600	E603 0600
0700	7.0	63	19	8	2	E600 0700	E603 0700
0800	8.0	63	20	8	2	E600 0800	E603 0800
0900	9.0	75	22	10	2	E600 0900	E603 0900
1000	10.0	75	22	10	2	E600 1000	E603 1000
1100	11.0	75	25	12	2	E600 1100	E603 1100
1200	12.0	75	25	12	2	E600 1200	E603 1200
1400	14.0	89	32	14	2	E600 1400	E603 1400
1600	16.0	89	32	16	2	E600 1600	E603 1600
1800	18.0	100	38	18	2	E600 1800	E603 1800
2000	20.0	100	38	20	2	E600 2000	E603 2000
2500	25.0	100	38	25	2	E600 2500	E603 2500



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

E600
B0212
VHM
Brt
N
R30
HA
h6

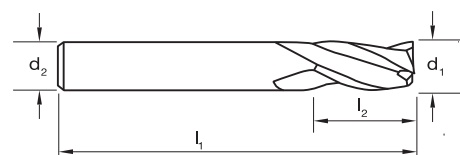
E603
B0214
VHM
TiAlN
N
R30
HA
h6

Endmills Carbide, 3 Flute, R30 N, Regular

suttontools

TECLINE

- For precision milling of slots & cavities
- For precision universal milling application
- Suitable for materials up to 1600 N/mm²
- TiAlN for longer tool life



Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #	Item #
0300	3.0	38	12	3	3	E610 0300	E611 0300
0400	4.0	50	14	4	3	E610 0400	E611 0400
0500	5.0	50	16	6	3	E610 0500	E611 0500
0600	6.0	50	19	6	3	E610 0600	E611 0600
0800	8.0	63	20	8	3	E610 0800	E611 0800
1000	10.0	75	22	10	3	E610 1000	E611 1000
1200	12.0	75	25	12	3	E610 1200	E611 1200
1600	16.0	89	32	16	3	E610 1600	E611 1600



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

E610
B0212
VHM
Brt
N
R30
HA
h6

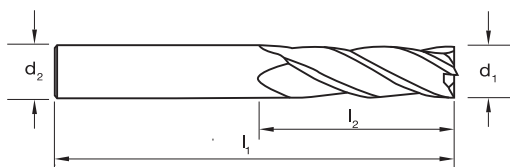
E611
B0214
VHM
TiAlN
N
R30
HA
h6

Endmills Carbide, 4 Flute, R30 N, Regular

suttontools

TECLINE

- For precision finish milling applications
- Suitable for materials up to 1600 N/mm²
- TiAlN for longer tool life



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

E601	E604
B0212	B0214
VHM	VHM
BrT	TiAlN
N	N
R30	R30
HA	HA
h6	h6

Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #	Item #
0100	1.0	38	4	3	4	E601 0100	E604 0100
0150	1.5	38	4.5	3	4	E601 0150	E604 0150
0200	2.0	38	6	3	4	E601 0200	E604 0200
0250	2.5	38	9.5	3	4	E601 0250	E604 0250
0300	3.0	38	12	3	4	E601 0300	E604 0300
0350	3.5	50	12	4	4	E601 0350	E604 0350
0400	4.0	50	14	4	4	E601 0400	E604 0400
0450	4.5	50	16	6	4	E601 0450	E604 0450
0500	5.0	50	16	6	4	E601 0500	E604 0500
0600	6.0	50	19	6	4	E601 0600	E604 0600
0700	7.0	63	19	8	4	E601 0700	E604 0700
0800	8.0	63	20	8	4	E601 0800	E604 0800
0900	9.0	75	22	10	4	E601 0900	E604 0900
1000	10.0	75	22	10	4	E601 1000	E604 1000
1100	11.0	75	25	12	4	E601 1100	E604 1100
1200	12.0	75	25	12	4	E601 1200	E604 1200
1400	14.0	89	32	14	4	E601 1400	E604 1400
1600	16.0	89	32	16	4	E601 1600	E604 1600
1800	18.0	100	38	18	4	E601 1800	E604 1800
2000	20.0	100	38	20	4	E601 2000	E604 2000
2500	25.0	100	38	25	4	E601 2500	E604 2500

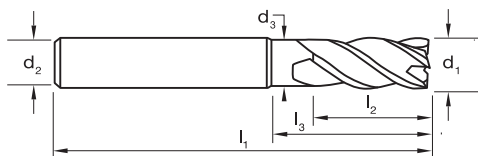
Endmills Carbide, 4 Flute, R35/38, Regular



suttontools

TECLINE

- VHM-ULTRA grade of carbide for high performance
- 35/38° variable flute helix for chatter free milling
- Suitable for materials up to 1600 N/mm²
- TiAlN for longer tool life



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

E635	E636
B0214	B0214
VHM	VHM
TiAlN	TiAlN
N	N
R35/38	R35/38
HA	HB
h6	h6

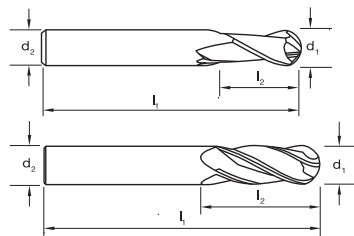
Size Ref.	d ₁	l ₁	l ₂	l ₃	d ₂	d ₃	z	Item #	Item #
0300	3.0	57	8	19	6	2.8	4	E635 0300	E636 0300
0400	4.0	57	11	19	6	3.7	4	E635 0400	E636 0400
0500	5.0	57	13	20	6	4.6	4	E635 0500	E636 0500
0600	6.0	57	13	21	6	5.5	4	E635 0600	E636 0600
0800	8.0	63	19	27	8	7.5	4	E635 0800	E636 0800
1000	10.0	72	22	32	10	9.5	4	E635 1000	E636 1000
1200	12.0	83	26	38	12	11.2	4	E635 1200	E636 1200
1400	14.0	83	26	38	14	13.0	4	E635 1400	E636 1400
1600	16.0	92	32	44	16	15.0	4	E635 1600	E636 1600
1800	18.0	92	32	44	18	17.0	4	E635 1800	E636 1800
2000	20.0	104	38	54	20	19.0	4	E635 2000	E636 2000

Endmills Carbide, Ballnose, 2/4 Flute, R30 N, Regular

suttontools

TECLINE

- For profile and contour milling applications
- Suitable for materials up to 1600 N/mm²
- TiAlN for longer tool life



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance



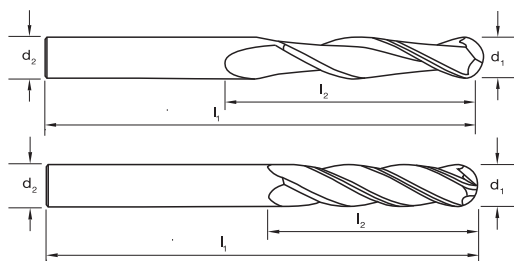
Size Ref.	d ₁	L ₁	L ₂	d ₂	z	z*	Item #	Item #	Item #	Item #
0100	1.0	38	4	3	2	4	E602 0100	E605 0100	E606 0100	E607 0100
0150	1.5	38	4.5	3	2	4	E602 0150	E605 0150	E606 0150	E607 0150
0200	2.0	38	6	3	2	4	E602 0200	E605 0200	E606 0200	E607 0200
0250	2.5	38	9.5	3	2	4	E602 0250	E605 0250	E606 0250	E607 0250
0300	3.0	38	12	3	2	4	E602 0300	E605 0300	E606 0300	E607 0300
0350	3.5	50	12	4	2	4		E605 0350		E607 0350
0400	4.0	50	14	4	2	4	E602 0400	E605 0400	E606 0400	E607 0400
0450	4.5	50	16	6		4				E607 0450
0500	5.0	50	16	6	2	4	E602 0500	E605 0500	E606 0500	E607 0500
0600	6.0	50	19	6	2	4	E602 0600	E605 0600	E606 0600	E607 0600
0700	7.0	63	19	8	2	4	E602 0700	E605 0700	•	•
0800	8.0	63	20	8	2	4	E602 0800	E605 0800	E606 0800	E607 0800
0900	9.0	75	22	10	2	4	E602 0900	E605 0900	•	•
1000	10.0	75	22	10	2	4	E602 1000	E605 1000	E606 1000	E607 1000
1100	11.0	75	25	12	2	4	E602 1100	E605 1100		E607 1100
1200	12.0	75	25	12	2	4	E602 1200	E605 1200	E606 1200	E607 1200
1400	14.0	89	32	14	2	4	E602 1400	E605 1400		E607 1400
1600	16.0	89	32	16	2	4	E602 1600	E605 1600	E606 1600	E607 1600
1800	18.0	100	38	18	2	4		E605 1800		E607 1800
2000	20.0	100	38	20	2	4	E602 2000	E605 2000	E606 2000	E607 2000
2500	25.0	100	38	25	2	4	E602 2500	E605 2500		E607 2500

Slot Drills Carbide, Ballnose, 2-4 Flute, R30 N, Extra Long

suttontools

TECLINE

- For profile & contour milling in extra long reach applications
- Suitable for materials up to 1300 N/mm²
- 4 Flute: Minimal deflection due to strong/larger core



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Shank Form (DIN 6535)
Shank Tolerance

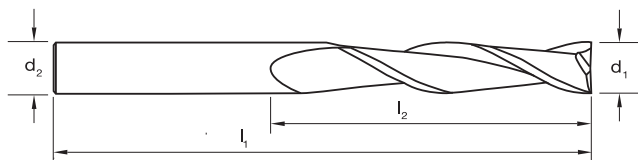
Size Ref.	d1 (h10)	L1	L2	d2	z	z*	Item #	Item #
0300	3.0	76	25	3	2	4	E315 0300	E320 0300
0400	4.0	76	28	4	2	4	E315 0400	E320 0400
0500	5.0	76	32	5	2	4	E315 0500	E320 0500
0600	6.0	102	38	6	2	4	E315 0600	E320 0600
0800	8.0	102	42	8	2	4	E315 0800	E320 0800
1000	10.0	102	45	10	2	4	E315 1000	E320 1000
1200	12.0	153	76	12	2	4	E315 1200	E320 1200
1400	14.0	153	76	14	2	4	E315 1400	E320 1400
1600	16.0	153	76	16	2	4	E315 1600	E320 1600
1800	18.0	153	76	18	2	4	E315 1800	E320 1800
2000	20.0	153	76	20	2	4	E315 2000	E320 2000

Endmills Carbide, 2 Flute, R30 N, Extra Long

suttontools

TECLINE

- For precision milling of slots & cavities
- Suitable for materials up to 1600 N/mm²



Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	100	40	3	2	E608 0300
0400	4.0	100	40	4	2	E608 0400
0500	5.0	100	40	5	2	E608 0500
0600	6.0	100	50	6	2	E608 0600
0800	8.0	100	50	8	2	E608 0800
1000	10.0	150	75	10	2	E608 1000
1200	12.0	150	75	12	2	E608 1200
1600	16.0	150	75	16	2	E608 1600
2000	20.0	150	75	20	2	E608 2000



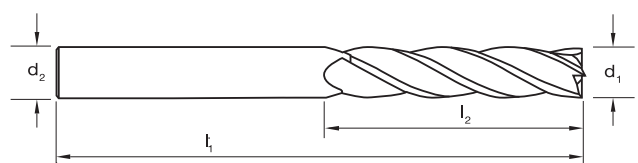
Catalogue Code	E608
Discount Group	B0212
Material	VHM
Surface Finish	Br
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

Endmills Carbide, 4 Flute, R30 N, Extra Long

suttontools

TECLINE

- For precision milling of slots & cavities
- Suitable for materials up to 1600 N/mm²



Size Ref.	d ₁	l ₁	l ₂	d ₂	z	Item #
0300	3.0	100	40	3	4	E609 0300
0400	4.0	100	40	4	4	E609 0400
0500	5.0	100	40	5	4	E609 0500
0600	6.0	100	50	6	4	E609 0600
0800	8.0	100	50	8	4	E609 0800
1000	10.0	150	75	10	4	E609 1000
1200	12.0	150	75	12	4	E609 1200
1600	16.0	150	75	16	4	E609 1600
2000	20.0	150	75	20	4	E609 2000



Catalogue Code	E609
Discount Group	B0212
Material	VHM
Surface Finish	Br
Sutton Designation	N
Geometry	R30
Shank Form (DIN 6535)	HA
Shank Tolerance	h6

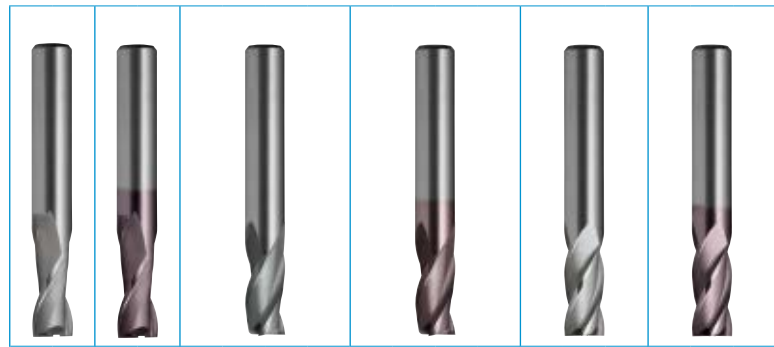
ISO VDI Material Group

Sutton

P	A	Steel	N	INN
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	
H	H	Hard Materials (≥ 45 HRC)	H	

^ VDI 3323 material groups can also be determined by referring to the workpiece material cross reference listing. Refer to main index of this section.

Catalogue Code
Material
Surface Finish
Sutton Designation
Type of Cut: **Slotting**
Finishing
Universal
Roughing
Profiling
↑ $ap \times \phi$
↔ $ae \times \phi$



E600	E603	E610	E611	E601	E604
VHM		VHM		VHM	
Brt	TiAlN	Brt	TiAlN	Brt	TiAlN
N		N		N	
•	•	•	•	•	•
0.75	0.75	0.5	1.5	1.5	1.75
1.0	1.0	1.0	0.2	0.2	0.2

ISO	VDI ³³²³	Material		Condition	HB	N/mm²	Vc	Feed #	Vc	Feed #	Vc	Feed #			Vc	Feed #			Vc	Feed #			Vc	Feed #		
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	100	7	144	8	125	7	7	13	180	8	8	14	100	7	10	144	8	11		
	2			A	190	640	100	7	144	8	125	7	7	13	180	8	8	14	100	7	10	144	8	11		
	3		~ 0.45 %C	QT	250	840	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11		
	4			A	270	910	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11		
	5		~ 0.75 %C	QT	300	1010	-	-	80	8	70	7	7	13	100	8	8	14	-	-	-	80	8	11		
	6	Steel - Low alloy & cast < 5% of alloying elements		A	180	610	100	7	144	8	125	7	7	13	180	8	8	14	100	7	10	144	8	11		
	7			QT	275	930	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11		
	8			QT	300	1010	-	-	80	8	70	7	7	13	100	8	8	14	-	-	-	80	8	11		
	9			QT	350	1180	-	-	64	8	-	-	-	-	80	8	8	14	-	-	-	64	8	11		
	10	Steel - High alloy, cast & tool		A	200	680	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11		
	11			HT	325	1100	-	-	64	8	-	-	-	-	80	8	8	14	-	-	-	64	8	11		
	12			Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680	-	-	-	-	65	7	7	13	90	8	8	14	-	-	-	-	-	-
	13	Martensitic	QT		240	810	-	-	-	-	55	7	7	13	80	8	8	14	-	-	-	-	-	-		
M	14.1	Stainless Steel	Austenitic	AH	180	610	52	7	72	8	65	7	7	13	90	8	8	14	52	7	10	72	8	11		
	14.2		Duplex		250	840	52	7	-	-	65	7	7	13	90	8	8	14	52	7	10	72	8	11		
	14.3		Precipitation Hardening		250	840	-	-	-	-	55	7	7	13	80	8	8	14	-	-	-	-	-	-		
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610	80	7	112	8	100	7	7	13	140	8	8	14	80	7	10	112	8	11		
	16		Pearlitic		260	880	80	7	112	8	100	7	7	13	140	8	8	14	80	7	10	112	8	11		
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570	80	7	112	8	100	7	7	13	140	8	8	14	80	7	10	112	8	11		
	18		Pearlitic		250	840	80	7	112	8	100	7	7	13	140	8	8	14	80	7	10	112	8	11		
	19	Cast Iron - Malleable	Ferritic		130	460	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11		
20		Pearlitic		230	780	56	7	80	8	70	7	7	13	100	8	8	14	56	7	10	80	8	11			
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	-	-	-	-	35	7	7	13	50	8	8	14	-	-	-	-	-	-		
	32			AH	280	950	-	-	-	-	35	7	7	13	50	8	8	14	-	-	-	-	-	-		
	33		Ni / Co based	A	250	840	-	-	-	-	35	7	7	13	50	8	8	14	-	-	-	-	-	-		
	34			AH	350	1180	-	-	-	-	35	7	7	13	50	8	8	14	-	-	-	-	-	-		
	35			C	320	1080	-	-	-	-	35	7	7	13	50	8	8	14	-	-	-	-	-	-		
	36	Titanium & Ti alloys	CP Titanium		400 MPa		-	-	-	-	50	7	7	13	70	8	8	14	-	-	-	-	-	-		
	37.1		Alpha alloys		860 MPa		-	-	-	-	50	7	7	13	70	8	8	14	-	-	-	-	-	-		
	37.2		Alpha / Beta alloys	A	960 MPa		-	-	-	-	50	7	7	13	70	8	8	14	-	-	-	-	-	-		
	37.3			AH	1170 MPa		-	-	-	-	50	7	7	13	70	8	8	14	-	-	-	-	-	-		
	37.4		Beta alloys	A	830 MPa		-	-	-	-	50	7	7	13	70	8	8	14	-	-	-	-	-	-		
	37.5			AH	1400 MPa		-	-	-	-	-	-	-	-	70	8	8	14	-	-	-	-	-	-		
H	38.1	Hardened steel		HT	45 HRC		-	-	-	-	-	-	-	-	80	8	8	14	-	-	-	-	-	-		
	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)

Bold = Optimal | Regular = Effective

Notes on Milling

- Above values are guidelines for the size and type of cut nominated.
- For long series tools, reduce speed by 40% and feed by 20%.

Feed Table (f _z) (mm/tooth)																				
Ø	Feed #																			
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
2	0.001	0.002	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.010	0.011	0.013	0.014	0.016	0.018	0.020	0.022	0.024	0.026	0.030
3	0.002	0.003	0.004	0.005	0.006	0.008	0.009	0.010	0.012	0.014	0.016	0.018	0.020	0.023	0.025	0.028	0.032	0.034	0.038	0.042
4	0.004	0.005	0.006	0.007	0.009	0.010	0.012	0.014	0.016	0.018	0.021	0.023	0.026	0.030	0.032	0.036	0.040	0.044	0.045	0.050
5	0.005	0.006	0.008	0.009	0.011	0.013	0.015	0.017	0.020	0.023	0.025	0.030	0.032	0.036	0.040	0.044	0.050	0.055	0.060	0.065
6	0.006	0.008	0.009	0.011	0.013	0.016	0.018	0.021	0.024	0.028	0.030	0.034	0.038	0.042	0.045	0.050	0.055	0.060	0.070	0.075
8	0.010	0.012	0.014	0.017	0.019	0.022	0.025	0.028	0.032	0.036	0.040	0.045	0.050	0.055	0.060	0.065	0.070	0.075	0.080	0.095
10	0.013	0.015	0.018	0.021	0.024	0.028	0.032	0.036	0.040	0.045	0.050	0.055	0.060	0.070	0.075	0.085	0.090	0.100	0.11	0.12
12	0.016	0.019	0.022	0.026	0.030	0.034	0.038	0.044	0.050	0.055	0.060	0.065	0.075	0.080	0.090	0.100	0.11	0.12	0.13	0.14
16	0.020	0.024	0.028	0.034	0.038	0.044	0.050	0.055	0.060	0.070	0.080	0.085	0.095	0.11	0.12	0.13	0.14	0.16	0.17	0.18
20	0.022	0.028	0.032	0.038	0.044	0.050	0.060	0.065	0.075	0.085	0.095	0.11	0.12	0.13	0.15	0.16	0.18	0.19	0.21	0.23
25	0.025	0.032	0.038	0.045	0.055	0.060	0.070	0.080	0.090	0.10	0.12	0.13	0.15	0.16	0.18	0.20	0.22	0.24	0.26	0.29

									
E635 / E636	E602	E605	E606	E607	E315	E320	E608	E609	
VHM-ULTRA	VHM		VHM		VHM		VHM	VHM	
TIAIN	BrT	TIAIN	BrT	TIAIN	BrT		BrT	BrT	
N	N		N		N		N	N	

METRIC ENDMILLS (mm size)

Ø	= nominal tool diameter (mm)	$n = \frac{v_c \times 1000}{\phi \times \pi} \approx \frac{v_c}{\phi} \times 318$
n	= Spindel speed (RPM)	
v _c	= Cutting speed (m/min)	
f _c	= Feed rate per tooth (mm/tooth)	$v_c = \frac{n \times \phi \times \pi}{1000} \approx \frac{n \times \phi}{318}$
v _f	= Feed rate (mm/min)	
z	= No. cutting edges	$f_z = \frac{v_f}{z \times n} \quad v_f = f_z \times z \times n$
Q	= Metal removal rate (cm³/min)	
a _p	= Cutting depth (mm)	
a _e	= Cutting width (mm)	$Q = \frac{a_p \times a_e \times v_f}{1000}$

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