

DRILLS > PANEL & RIVET



suttontools

**SILVER
BULLET**
TWIST DRILLS

D122 - PANEL & RIVET DRILLS - Silver Bullet

Sutton Tools Silver Bullet Panel Drills are developed to drill holes for rivets in flat and curved panels and used in sheet metal fabrication. The double ended design doubles the life of the drill bit. Note: Ensure the chuck jaws are fully tightened.

Features:

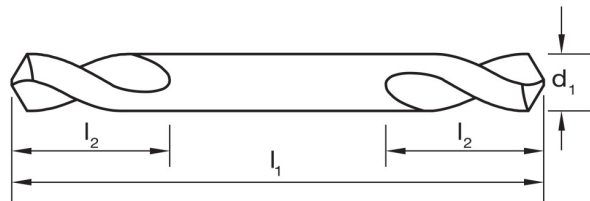
- 135° self centering point minimises wandering when starting and ideal for thin materials
- Flute length designed for shallow hole drilling no deeper than 1.25mm x diameter
- Double ended design increases drill life. Ensure that the chuck jaws are fully tightened
- Made from M2 High Speed Steel (HSS) offering the best combination of strength, heat & wear resistance
- Bright finish for general purpose applications, non-ferrous metals & plastics

Specifications:

Designation:	N
Material:	HSS
Finish:	Brt
Point Tolerance:	h8
Point Angle:	135°
Point Form:	Standard

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Range:



Item #	Diameter (inch)	Flute Length	O/A Length	Shank	Rivet Size
D1220318	1/8	19	54	-	3
D1220326	#30	19	54	3.26	1/8
D1220409	#20	19	54	4.09	4 & 5/32
D1220485	#11	19	54	4.85	3/16

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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 Treatable		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 Treatable		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-Ferous Metals
 S Titanium & Super Alloys
 H Hard Materials

Trade/DIY Applications:

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

KEY

● Optimal ○ Effective