

Performance Unequaled...

...stabilising your process



End teeth clearance
optimized for ramping



Optimised Edge
Conditioning

Dual Stepped Core for
optimal chip evacuation and
reinforced tool strength

Balzers Oerlikon
AlCrN & Aldura PVD
coating for longer life



VHM-Ultra solid
carbide, ultra-micro
grain base material

Sutton Tools Harmony **DUO** Endmills are specifically designed for the mould and die industry and purposely designed to optimise the machining of tool-grade steels and alloys.

Harmony DUO NH – for machining pre-heat treated metals up to a hardness of 48 HRc

Harmony DUO VH – for machining post-heat treated metals up to a hardness rating of 63 HRc.

Tool Design – Dual-stepped core

The rigid construction of the thickened core section delivers enhanced tool stability and minimised vibration during the machining process, while the deeper flute profile towards the front of the endmill provides excellent chip-evacuation properties.

These features optimise performance to maximise both tool life and cutting accuracy.

HARMONY

DUO ENDMILLS

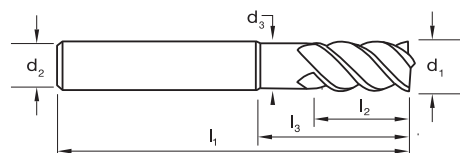


suttontools
world class cutting tools

HARMONY DUO DIN6527L, 4 Flute, R50-NH

suttontools

- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for pocket milling in MQL & HSC
- Suitable for materials up to 48HRc
- AlCrN for longer tool life



Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z
0600	6.0	57	13	21	6	5.5	4
0800	8.0	63	19	27	8	7.5	4
1000	10.0	72	22	32	10	9.5	4
1200	12.0	83	26	38	12	11.2	4
1400	14.0	83	26	38	14	13.0	4
1600	16.0	92	32	44	16	15.0	4
2000	20.0	104	38	54	20	19.0	4

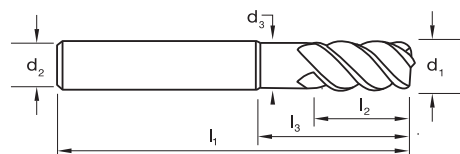


Catalogue Code	E562	E563
Discount Group	B0210	B0210
Material	VHM-ULTRA	VHM-ULTRA
Surface Finish	AlCrN	AlCrN
Colour Ring & Application	NH	NH
Geometry	R50	R50
Shank Form (DIN 6535)	HA	HB
Shank Tolerance	h6	h6
Item #	Item #	Item #
E562 0600	E563 0600	
E562 0800	E563 0800	
E562 1000	E563 1000	
E562 1200	E563 1200	
E562 1400	E563 1400	
E562 1600	E563 1600	
E562 2000	E563 2000	

HARMONY DUO DIN6527L, 4 Flute, R50-NH Corner Rad

suttontools

- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for pocket milling in MQL & HSC
- Suitable for materials up to 48HRc
- AlCrN for longer tool life



Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Rad
0610	6.0	57	13	21	6	5.5	4	1.0
0820	8.0	63	19	27	8	7.5	4	2.0
1020	10.0	72	22	32	10	9.5	4	2.0
1230	12.0	83	26	38	12	11.2	4	3.0
1430	14.0	83	26	38	14	13.0	4	3.0
1640	16.0	92	32	44	16	15.0	4	4.0
2040	20.0	104	38	54	20	19.0	4	4.0



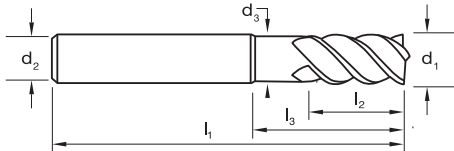
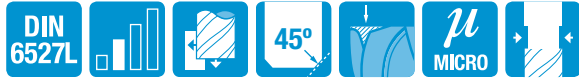
Catalogue Code	E564	E565
Discount Group	B0210	B0210
Material	VHM-ULTRA	VHM-ULTRA
Surface Finish	AlCrN	AlCrN
Colour Ring & Application	NH	NH
Geometry	R50	R50
Shank Form (DIN 6535)	HA	HB
Shank Tolerance	h6	h6
Item #	Item #	Item #
E564 0610	E565 0610	
E564 0820	E565 0820	
E564 1020	E565 1020	
E564 1230	E565 1230	
E564 1430	E565 1430	
E564 1640	E565 1640	
E564 2040	E565 2040	

Radius available 0,3 – 4,0mm. Refer to main catalogue for complete range.

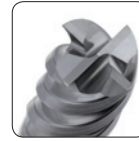
HARMONY DUO DIN6527L, 4 Flute, R50-VH

suttontools

- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for hard machining
- Suitable for materials up to 63HRc
- Aldura for longer tool life



Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z
0600	6.0	57	13	21	6	5.5	4
0800	8.0	63	19	27	8	7.5	4
1000	10.0	72	22	32	10	9.5	4
1200	12.0	83	26	38	12	11.2	4
1400	14.0	83	26	38	14	13.0	4
1600	16.0	92	32	44	16	15.0	4
2000	20.0	104	38	54	20	19.0	4

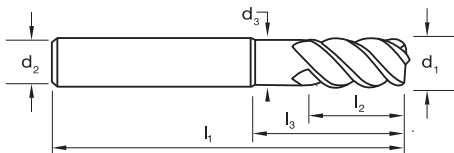


Catalogue Code	E566	E567
Discount Group	B0210	B0210
Material	VHM-ULTRA	VHM-ULTRA
Surface Finish	Aldura	Aldura
Colour Ring & Application	VH	VH
Geometry	R50	R50
Shank Form (DIN 6535)	HA	HB
Shank Tolerance	h6	h6
Item #	Item #	Item #
E566 0600	E567 0600	
E566 0800	E567 0800	
E566 1000	E567 1000	
E566 1200	E567 1200	
E566 1400	E567 1400	
E566 1600	E567 1600	
E566 2000	E567 2000	

HARMONY DUO DIN6527L, 4 Flute, R50-VH Corner Rad

suttontools

- VHM-ULTRA grade of carbide for high performance
- Dual stepped core for optimal stability
- Ideal design for hard machining
- Suitable for materials up to 63HRc
- Aldura for longer tool life



Size Ref.	d ₁ (h10)	l ₁	l ₂	l ₃	d ₂	d ₃	z	Rad
0610	6.0	57	13	21	6	5.5	4	1.0
0820	8.0	63	19	27	8	7.5	4	2.0
1020	10.0	72	22	32	10	9.5	4	2.0
1230	12.0	83	26	38	12	11.2	4	3.0
1430	14.0	83	26	38	14	13.0	4	3.0
1640	16.0	92	32	44	16	15.0	4	4.0
2040	20.0	104	38	54	20	19.0	4	4.0



Catalogue Code	E568	E569
Discount Group	B0210	B0210
Material	VHM-ULTRA	VHM-ULTRA
Surface Finish	Aldura	Aldura
Colour Ring & Application	VH	VH
Geometry	R50	R50
Shank Form (DIN 6535)	HA	HB
Shank Tolerance	h6	h6
Item #	Item #	Item #
E568 0610	E569 0610	
E568 0820	E569 0820	
E568 1020	E569 1020	
E568 1230	E569 1230	
E568 1430	E569 1430	
E568 1640	E569 1640	
E568 2040	E569 2040	

