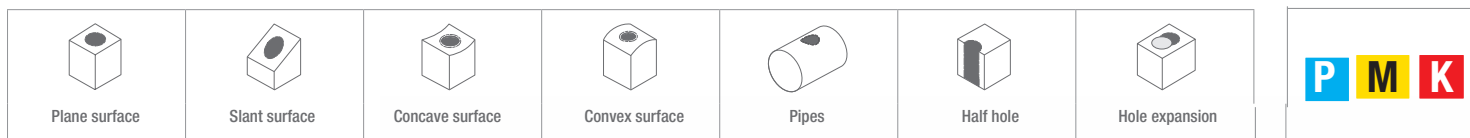


DEX DRILL ACTION

Sistema di foratura ad alte prestazioni con cuspidi intercambiabili



Acquista 3 cuspidi e ottieni il corpo punta allo sconto speciale del 60%

Cuspidi: DEX

Corpi punta: NT-DEX (da Ø 10 mm a Ø 26 mm)

nikkoTOOLS

uemme
TOOLS for EQUIPMENT

VALIDITA': 31/12/2024

DEX DRILLS

High productivity indexable drilling system with exchangeable heads

APPLICATION

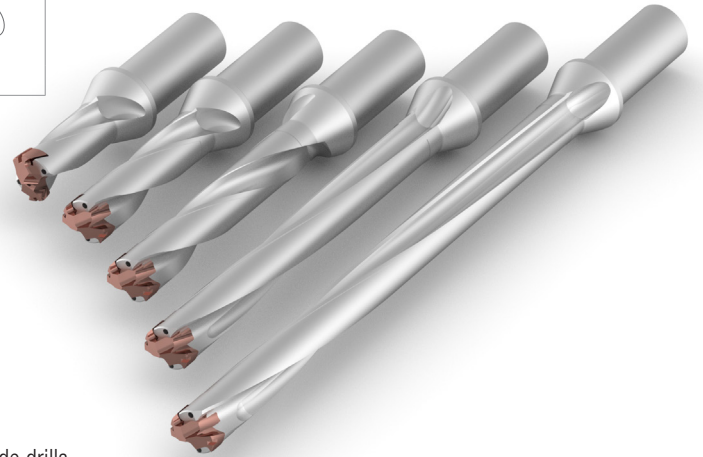


ISO APPLICATION FIELDS

P M K

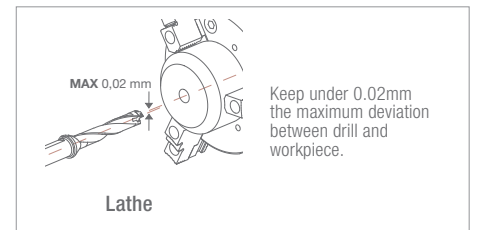
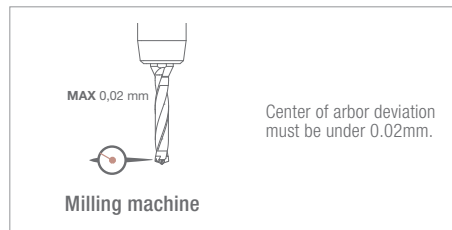
ADVANTAGES AND CHARACTERISTICS

- High reliable quick change indexable drilling system
- Solid drill head with 3D geometry, adapted for high feed rate and provides high efficiency in machining
- Attracting cost efficiency per hole, good replacement for regrind solid carbide drills



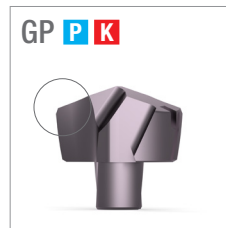
● Drilling bodies

- Weldon shank with internal coolant
- 3xD and 5xD available from D10 to D26
- Special length (1.5D, 8D and 12D) and stepped body available upon request

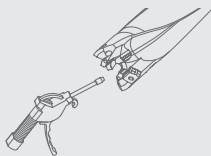


● Inserts

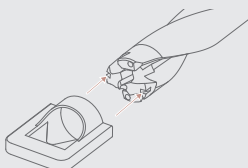
- Available D10-26, can make special diameters or stepped type
- Cemented carbide grades with PVD coatings
- Geometries: GP, SC, TE, FT (flat)



DRILLING HEADS INSTALLATION



Clean pocket with air blast.
Put insert into drill holder.



Set wrench into slots on insert flanks.
Slowly turn the wrench clockwise until stop.

3xD

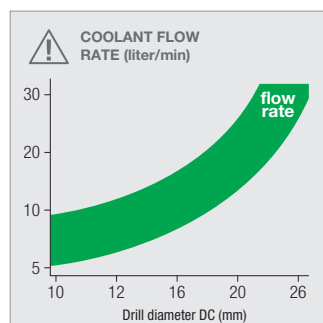
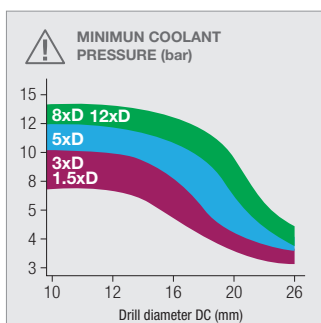
DEX drill

- 3xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fits into the same body, please check MIID column
- Special diameters or stepped type available upon requests

Designation	Stock	DC	DCON	OAL	LF	LB				MIID
NT-DEX-3D D10-S16F	●	10	16	95	47	38				DEX10 ^{oo}
NT-DEX-3D D11-S16F	●	11	16	98	50	39				DEX11 ^{oo}
NT-DEX-3D D12-S16F	●	12	16	104	56	44				DEX12 ^{oo}
NT-DEX-3D D13-S16F	●	13	16	108	60	47				DEX13 ^{oo}
NT-DEX-3D D14-S16F	●	14	16	112	64	50				DEX14 ^{oo}
NT-DEX-3D D15-S20F	●	15	20	118	68	53				DEX15 ^{oo}
NT-DEX-3D D16-S20F	●	16	20	122	72	56				DEX16 ^{oo}
NT-DEX-3D D17-S20F	●	17	20	126	76	59				DEX17 ^{oo}
NT-DEX-3D D18-S25F	●	18	25	136	80	62				DEX18 ^{oo}
NT-DEX-3D D19-S25F	●	19	25	140	84	65				DEX19 ^{oo}
NT-DEX-3D D20-S25F	●	20	25	144	88	68				DEX20 ^{oo}
NT-DEX-3D D21-S25F	●	21	25	152	96	75				DEX21 ^{oo}
NT-DEX-3D D22-S25F	●	22	25	157	101	81				DEX22 ^{oo}
NT-DEX-3D D23-S32F	●	23	32	165	105	82				DEX23 ^{oo}
NT-DEX-3D D24-S32F	●	24	32	170	110	86				DEX24 ^{oo}
NT-DEX-3D D25/26-S32F	●	25	32	175	115	89				DEX25/26 ^{oo}

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Head wrench
NT-DEX-3D (DC 10÷11)	NT-WR1011
NT-DEX-3D (DC 12÷17)	NT-WR1217
NT-DEX-3D (DC 18÷20)	NT-WR1820
NT-DEX-3D (DC 21÷25)	NT-WR2126

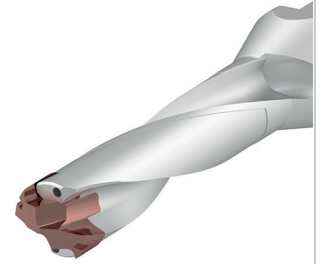
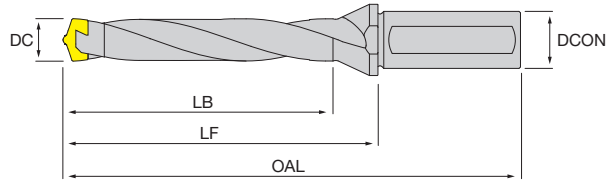


- A - TURNING
- B - THREADING
- C - GROOVING
- D - MILLING
- E - DRILLING
- F - ACCESSORIES
- G - SPARE PARTS

5xD

DEX drill

- 5xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fit into the same body, please check MIID column
- Special diameters or stepped type available upon requests



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

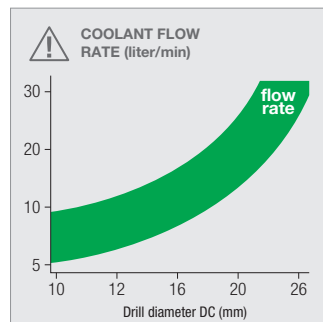
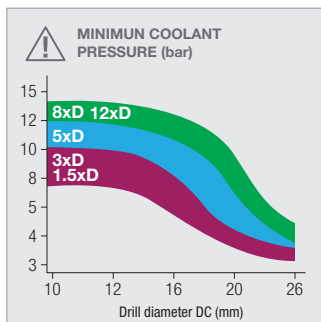
F - ACCESSORIES

G - SPARE PARTS

Designation	Stock	DC	DCON	OAL	LF	LB				MIID
NT-DEX-5D D10-S16F	●	10	16	116	68	59				DEX10 ⁰⁰
NT-DEX-5D D11-S16F	●	11	16	121	73	62				DEX11 ⁰⁰
NT-DEX-5D D12-S16F	●	12	16	130	82	70				DEX12 ⁰⁰
NT-DEX-5D D13-S16F	●	13	16	136	88	75				DEX13 ⁰⁰
NT-DEX-5D D14-S16F	●	14	16	142	94	80				DEX14 ⁰⁰
NT-DEX-5D D15-S20F	●	15	20	150	100	85				DEX15 ⁰⁰
NT-DEX-5D D16-S20F	●	16	20	156	106	90				DEX16 ⁰⁰
NT-DEX-5D D17-S20F	●	17	20	162	112	95				DEX17 ⁰⁰
NT-DEX-5D D18-S25F	●	18	25	174	118	100				DEX18 ⁰⁰
NT-DEX-5D D19-S25F	●	19	25	180	124	105				DEX19 ⁰⁰
NT-DEX-5D D20-S25F	●	20	25	186	130	110				DEX20 ⁰⁰
NT-DEX-5D D21-S25F	●	21	25	194	138	117				DEX21 ⁰⁰
NT-DEX-5D D22-S25F	●	22	25	201	145	125				DEX22 ⁰⁰
NT-DEX-5D D23-S32F	●	23	32	211	151	128				DEX23 ⁰⁰
NT-DEX-5D D24-S32F	●	24	32	218	158	134				DEX24 ⁰⁰
NT-DEX-5D D25/26-S32F	●	25	32	225	165	139				DEX25/26 ⁰⁰

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Head wrench
NT-DEX-5D (DC 10÷11)	NT-WR1011
NT-DEX-5D (DC 12÷17)	NT-WR1217
NT-DEX-5D (DC 18÷20)	NT-WR1820
NT-DEX-5D (DC 21÷25)	NT-WR2126



<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD			
	<h2>DEX drill</h2>		JP5625	JP5725			
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut ● 1 st choice ○ suitable	General machining, medium cut ● 1 st choice ○ suitable	Unstable machining, heavy cut ⚡ 1 st choice ⚡ suitable				
	Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
			P	55 160	55 160		
			M				
K			60 140	60 140			
N							
		S					
		H					

Designation		DC	DC toll.	SIG	PL	LF	Stock	
GENERAL 	GP 10∞ P K	DEX1000-GP	10	k6	140°	1.78	4.42	●
		DEX1010-GP	10.1	k6	140°	1.8	4.4	○
		DEX1020-GP	10.2	k6	140°	1.82	4.38	●
		DEX1030-GP	10.3	k6	140°	1.84	4.36	● ▲
		DEX1040-GP	10.4	k6	140°	1.86	4.34	● ▲
		DEX1050-GP	10.5	k6	140°	1.88	4.32	●
		DEX1060-GP	10.6	k6	140°	1.9	4.3	○
		DEX1070-GP	10.7	k6	140°	1.92	4.28	○
		DEX1080-GP	10.8	k6	140°	1.94	4.26	○
		DEX1090-GP	10.9	k6	140°	1.96	4.24	○
GENERAL 	GP 11∞ P K	DEX1100-GP	11	k6	140°	1.98	4.62	● ▲
		DEX1110-GP	11.1	k6	140°	2	4.6	○
		DEX1120-GP	11.2	k6	140°	2.02	4.58	○
		DEX1130-GP	11.3	k6	140°	2.04	4.56	● ▲
		DEX1140-GP	11.4	k6	140°	2.06	4.54	○
		DEX1150-GP	11.5	k6	140°	2.08	4.52	● ▲
		DEX1160-GP	11.6	k6	140°	2.1	4.5	○
		DEX1170-GP	11.7	k6	140°	2.12	4.48	○
		DEX1180-GP	11.8	k6	140°	2.14	4.46	○
		DEX1190-GP	11.9	k6	140°	2.16	4.44	○

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

GP - Chisel edge

Big size chisel allows high feedrate machining and best centering features.

GP - Outer corner

Small chamfer for very good edge protection in general machining.

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Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

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B - THREADING

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<h1>Heads</h1> <h2>DEX drill</h2> <ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD	
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚙ 1 st choice ⚙ suitable		JP5625 JP5725		
Dimensions		ISO		Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
		P	55 160	55 160	
		M			
		K	60 140	60 140	
		N			
		S			
		H			

Designation		DC	DC toll.	SIG	PL	LF	Stock		
GENERAL		GP 1200 P K	DEX1200-GP	12	k6	140°	2.18	4.82	●
		DEX1210-GP	12.1	k6	140°	2.2	4.8	●	▲
		DEX1220-GP	12.2	k6	140°	2.22	4.78	●	▲
		DEX1230-GP	12.3	k6	140°	2.24	4.76	●	▲
		DEX1240-GP	12.4	k6	140°	2.26	4.74	●	▲
		DEX1250-GP	12.5	k6	140°	2.27	4.73	●	▲
		DEX1260-GP	12.6	k6	140°	2.29	4.71		●
		DEX1270-GP	12.7	k6	140°	2.31	4.69	●	▲
		DEX1280-GP	12.8	k6	140°	2.33	4.67	●	▲
		DEX1290-GP	12.9	k6	140°	2.35	4.645	●	▲
GENERAL		GP 1300 P K	DEX1300-GP	13	k6	140°	2.37	5.23	●
		DEX1310-GP	13.1	k6	140°	2.38	5.22	●	▲
		DEX1320-GP	13.2	k6	140°	2.4	5.2		●
		DEX1330-GP	13.3	k6	140°	2.42	5.18	●	▲
		DEX1340-GP	13.4	k6	140°	2.44	5.16	●	▲
		DEX1350-GP	13.5	k6	140°	2.46	5.14		●
		DEX1360-GP	13.6	k6	140°	2.47	5.13	●	▲
		DEX1370-GP	13.7	k6	140°	2.49	5.11		●
		DEX1380-GP	13.8	k6	140°	2.51	5.09		●
		DEX1390-GP	13.9	k6	140°	2.53	5.07	●	▲

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	<h2>DEX drill</h2>		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	General machining, medium cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	Unstable machining, heavy cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable			
	Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)
			P	55 160	55 160	
			M			
K			60 140	60 140		
N						
S						
H						

Designation		DC	DC toll.	SIG	PL	LF	Stock		
GENERAL	GP 14 [∞] P K	DEX1400-GP	14	k6	140°	2.55	5.55	●	
		DEX1410-GP	14.1	k6	140°	2.57	5.53	●	
		DEX1420-GP	14.2	k6	140°	2.58	5.52	●	
		DEX1430-GP	14.3	k6	140°	2.6	5.5	● ▲	
		DEX1440-GP	14.4	k6	140°	2.62	5.48	●	
		DEX1450-GP	14.5	k6	140°	2.64	5.46	●	
		DEX1460-GP	14.6	k6	140°	2.66	5.44	●	
		DEX1470-GP	14.7	k6	140°	2.68	5.42	● ▲	
		DEX1480-GP	14.8	k6	140°	2.69	5.41	● ▲	
		DEX1490-GP	14.9	k6	140°	2.71	5.39	● ▲	
GENERAL	GP 15 [∞] P K	DEX1500-GP	15	k6	140°	2.73	5.97	●	
		DEX1505-GP	15.05	k6	140°			○	
		DEX1510-GP	15.1	k6	140°	2.75	5.95	●	
		DEX1520-GP	15.2	k6	140°	2.77	5.93	●	
		DEX1530-GP	15.3	k6	140°	2.78	5.92	●	
		DEX1540-GP	15.4	k6	140°	2.8	5.9	● ▲	
		DEX1550-GP	15.5	k6	140°	2.82	5.88	●	
		DEX1560-GP	15.6	k6	140°	2.84	5.86	●	
		DEX1570-GP	15.7	k6	140°	2.86	5.84	● ▲	
		DEX1580-GP	15.8	k6	140°	2.88	5.82	●	
DEX1590-GP	15.9	k6	140°	2.89	5.81	● ▲			

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

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C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

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<h1>Heads</h1> <h2>DEX drill</h2> <ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	HF PVD	
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚙ 1 st choice ⚙ suitable	JP5625 JP5725		
Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1 st choice)		
	P	55 160	55 160	
	M			
	K	60 140	60 140	
	N			
	S			
	H			

Designation		DC	DC toll.	SIG	PL	LF	Stock	
GENERAL	GP 16 [∞] P K	DEX1600-GP	16	k6	140°	2.91	5.89	●
		DEX1610-GP	16.1	k6	140°	2.93	5.87	●
		DEX1620-GP	16.2	k6	140°	2.95	5.85	● ▲
		DEX1630-GP	16.3	k6	140°	2.97	5.83	● ▲
		DEX1640-GP	16.4	k6	140°	2.98	5.82	●
		DEX1650-GP	16.5	k6	140°	3	5.8	●
		DEX1660-GP	16.6	k6	140°	3.02	5.78	● ▲
		DEX1670-GP	16.7	k6	140°	3.04	5.76	● ▲
		DEX1680-GP	16.8	k6	140°	3.06	5.74	● ▲
		DEX1690-GP	16.9	k6	140°	3.08	5.72	● ▲
GENERAL	GP 17 [∞] P K	DEX1700-GP	17	k6	140°	3.09	6.81	●
		DEX1710-GP	17.1	k6	140°	3.11	6.79	●
		DEX1720-GP	17.2	k6	140°	3.13	6.77	●
		DEX1730-GP	17.3	k6	140°	3.15	6.77	● ▲
		DEX1740-GP	17.4	k6	140°	3.17	6.75	● ▲
		DEX1750-GP	17.5	k6	140°	3.18	6.72	●
		DEX1760-GP	17.6	k6	140°	3.2	6.7	●
		DEX1770-GP	17.7	k6	140°	3.22	6.68	● ▲
		DEX1780-GP	17.8	k6	140°	3.24	6.66	●
		DEX1790-GP	17.9	k6	140°	3.26	6.64	● ▲

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	<h2>DEX drill</h2>		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut ● 1 st choice ○ suitable	General machining, medium cut ● 1 st choice ○ suitable	Unstable machining, heavy cut ⚙ 1 st choice ⚙ suitable			
	Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)
			P	55 160	55 160	
			M			
K			60 140	60 140		
N						
		S				
		H				

Designation		DC	DC toll.	SIG	PL	LF	Stock	
GENERAL 	GP 1800 P K	DEX1800-GP	18	k6	140°	3.28	7.22	●
		DEX1810-GP	18.1	k6	140°	3.29	7.21	● ▲
		DEX1820-GP	18.2	k6	140°	3.31	7.19	● ▲
		DEX1830-GP	18.3	k6	140°	3.33	7.17	● ▲
		DEX1840-GP	18.4	k6	140°	3.35	7.15	● ▲
		DEX1850-GP	18.5	k6	140°	3.37	7.13	●
		DEX1860-GP	18.6	k6	140°	3.38	7.12	●
		DEX1870-GP	18.7	k6	140°	3.4	7.1	● ▲
		DEX1880-GP	18.8	k6	140°	3.42	7.08	● ▲
		DEX1890-GP	18.9	k6	140°	3.44	7.06	●
GENERAL 	GP 1900 P K	DEX1900-GP	19	k6	140°	3.46	7.54	●
		DEX1910-GP	19.1	k6	140°	3.48	7.52	● ▲
		DEX1920-GP	19.2	k6	140°	3.49	7.51	● ▲
		DEX1930-GP	19.3	k6	140°	3.51	7.49	● ▲
		DEX1940-GP	19.4	k6	140°	3.53	7.47	● ▲
		DEX1950-GP	19.5	k6	140°	3.55	7.45	● ▲
		DEX1960-GP	19.6	k6	140°	3.57	7.43	● ▲
		DEX1970-GP	19.7	k6	140°	3.59	7.41	● ▲
		DEX1980-GP	19.8	k6	140°	3.6	7.4	●
		DEX1990-GP	19.9	k6	140°	3.62	7.38	● ▲

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

GP - Chisel edge

Big size chisel allows high feedrate machining and best centering features.

GP - Outer corner

Small chamfer for very good edge protection in general machining.

GP - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING
 B - THREADING
 C - GROOVING
 D - MILLING
 E - DRILLING
 F - ACCESSORIES
 G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

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G - SPARE PARTS

<h1>Heads</h1> <h2>DEX drill</h2> <ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚙ 1 st choice ⚙ suitable	JP5625 JP5725				
Dimensions			ISO			Vc(m/min) - suggested cutting speed range (bold: 1 st choice)
	P	55 160	55 160			
	M					
	K	60 140	60 140			
	N					
	S					
	H					

Designation		DC	DC toll.	SIG	PL	LF	Stock	
GENERAL	GP 20 ₀₀ P K	DEX2000-GP	20	k6	140°	3.64	7.96	● ▲
		DEX2010-GP	20.1	k6	140°	3.66	7.94	●
		DEX2020-GP	20.2	k6	140°	3.68	7.92	● ▲
		DEX2030-GP	20.3	k6	140°	3.69	7.91	● ▲
		DEX2040-GP	20.4	k6	140°	3.71	7.89	● ▲
		DEX2050-GP	20.5	k6	140°	3.73	7.87	●
		DEX2060-GP	20.6	k6	140°	3.75	7.85	●
		DEX2070-GP	20.7	k6	140°	3.77	7.83	● ▲
		DEX2080-GP	20.8	k6	140°	3.79	7.81	● ▲
		DEX2090-GP	20.9	k6	140°	3.8	7.8	●
GENERAL	GP 21 ₀₀ P K	DEX2100-GP	21	k6	140°	3.82	8.28	●
		DEX2150-GP	21.5	k6	140°	3.91	8.19	●
GENERAL	GP 22 ₀₀ P K	DEX2200-GP	22	k6	140°	4	8.7	●
		DEX2250-GP	22.5	k6	140°	4.09	8.61	●
GENERAL	GP 23 ₀₀ P K	DEX2300-GP	23	k6	140°	4.18	9.12	● ▲
		DEX2350-GP	23.5	k6	140°	4.28	9.02	●

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	<h2>DEX drill</h2>		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut	<input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	<input type="radio"/>	<input type="radio"/>		
	General machining, medium cut	<input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	<input checked="" type="radio"/>	<input checked="" type="radio"/>		
	Unstable machining, heavy cut	<input type="radio"/> 1 st choice <input checked="" type="radio"/> suitable	<input type="radio"/>	<input checked="" type="radio"/>		
	Dimensions	ISO		Vc(m/min) - suggested cutting speed range (bold: 1st choice)		
		P	55 160	55 160		
	M					
	K	60 140	60 140			
	N					
	S					
	H					

Designation		DC	DC toll.	SIG	PL	LF	Stock		
GENERAL	GP 24_∞ P K 	DEX2400-GP	24	k6	140°	4.36	9.54	●	▲
	DEX2450-GP	24.5	k6	140°	4.46	9.44		●	
GENERAL	GP 25_∞ P K 	DEX2500-GP	25	k6	140°	4.55	9.95		●
	DEX2550-GP	25.5	k6	140°	4.64	9.86	●	▲	
	DEX2600-GP	26	k6	140°	4.73	9.86		●	

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C - GROOVING

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD												
	<h2>DEX drill</h2>	JP5630												
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚠ 1 st choice ⚠ suitable													
	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)											
		<table border="1"> <tr><td>P</td><td>55 160</td></tr> <tr><td>M</td><td>30 80</td></tr> <tr><td>K</td><td></td></tr> <tr><td>N</td><td></td></tr> <tr><td>S</td><td></td></tr> <tr><td>H</td><td></td></tr> </table>	P	55 160	M	30 80	K		N		S		H	
P	55 160													
M	30 80													
K														
N														
S														
H														

Designation		DC	DC toll.	SIG	PL	LF	Stock
LOW FORCE 	SC 10∞ P M						
	DEX1000-SC	10	k6	140°	1.78	4.42	●
	DEX1010-SC	10.1	k6	140°	1.8	4.4	○
	DEX1020-SC	10.2	k6	140°	1.82	4.38	●
	DEX1030-SC	10.3	k6	140°	1.84	4.36	●
	DEX1040-SC	10.4	k6	140°	1.86	4.34	●
	DEX1050-SC	10.5	k6	140°	1.88	4.32	●
	DEX1060-SC	10.6	k6	140°	1.9	4.3	○
	DEX1070-SC	10.7	k6	140°	1.92	4.28	○
	DEX1080-SC	10.8	k6	140°	1.94	4.26	○
DEX1090-SC	10.9	k6	140°	1.96	4.24	○	
LOW FORCE 	SC 11∞ P M						
	DEX1100-SC	11	k6	140°	1.98	4.62	●
	DEX1110-SC	11.1	k6	140°	2	4.6	○
	DEX1120-SC	11.2	k6	140°	2.02	4.58	○
	DEX1130-SC	11.3	k6	140°	2.04	4.56	●
	DEX1140-SC	11.4	k6	140°	2.06	4.54	○
	DEX1150-SC	11.5	k6	140°	2.08	4.52	●
	DEX1160-SC	11.6	k6	140°	2.1	4.5	○
	DEX1170-SC	11.7	k6	140°	2.12	4.48	○
	DEX1180-SC	11.8	k6	140°	2.14	4.46	○
DEX1190-SC	11.9	k6	140°	2.16	4.44	○	

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SC - Gash geometry

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚡ 1 st choice ⚡ suitable	JP5630	
<h2>DEX drill</h2>			
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	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
		P 55 160 M 30 80 K N S H	

		Designation	DC	DC toll.	SIG	PL	LF	Stock	
LOW FORCE		SC 1200 P M	DEX1200-SC	12	k6	140°	2.18	4.82	●
		DEX1210-SC	12.1	k6	140°	2.2	4.8	●	
		DEX1220-SC	12.2	k6	140°	2.22	4.78	●	
		DEX1230-SC	12.3	k6	140°	2.24	4.76	●	
		DEX1240-SC	12.4	k6	140°	2.26	4.74	○	
		DEX1250-SC	12.5	k6	140°	2.27	4.73	●	
		DEX1260-SC	12.6	k6	140°	2.29	4.71	●	
		DEX1270-SC	12.7	k6	140°	2.31	4.69	○	
		DEX1280-SC	12.8	k6	140°	2.33	4.67	○	
		DEX1290-SC	12.9	k6	140°	2.35	4.645	○	
LOW FORCE		SC 1300 P M	DEX1300-SC	13	k6	140°	2.37	5.23	●
		DEX1310-SC	13.1	k6	140°	2.38	5.22	●	
		DEX1320-SC	13.2	k6	140°	2.4	5.2	○	
		DEX1330-SC	13.3	k6	140°	2.42	5.18	○	
		DEX1340-SC	13.4	k6	140°	2.44	5.16	○	
		DEX1350-SC	13.5	k6	140°	2.46	5.14	●	
		DEX1360-SC	13.6	k6	140°	2.47	5.13	○	
		DEX1370-SC	13.7	k6	140°	2.49	5.11	○	
		DEX1380-SC	13.8	k6	140°	2.51	5.09	○	
		DEX1390-SC	13.9	k6	140°	2.53	5.07	●	

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD
	<h2>DEX drill</h2>		JP5630
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	General machining, medium cut	● 1 st choice ○ suitable	●
	Unstable machining, heavy cut	⊕ 1 st choice ⊖ suitable	⊕
	Dimensions		ISO
		Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
		P	55 160
		M	30 80
		K	
		N	
		S	
	H		

Designation		DC	DC toll.	SIG	PL	LF	Stock		
LOW FORCE		SC 1400 P M	14	k6	140°	2.55	5.55	●	
		DEX1410-SC	14.1	k6	140°	2.57	5.53	●	
		DEX1420-SC	14.2	k6	140°	2.58	5.52	●	
		DEX1430-SC	14.3	k6	140°	2.6	5.5	○	
		DEX1440-SC	14.4	k6	140°	2.62	5.48	○	
		DEX1450-SC	14.5	k6	140°	2.64	5.46	●	
		DEX1460-SC	14.6	k6	140°	2.66	5.44	●	
		DEX1470-SC	14.7	k6	140°	2.68	5.42	○	
		DEX1480-SC	14.8	k6	140°	2.69	5.41	●	
		DEX1490-SC	14.9	k6	140°	2.71	5.39	○	
LOW FORCE		SC 1500 P M	15	k6	140°	2.73	5.97	●	
		DEX1510-SC	15.1	k6	140°	2.75	5.95	●	
		DEX1520-SC	15.2	k6	140°	2.77	5.93	●	
		DEX1530-SC	15.3	k6	140°	2.78	5.92	●	
		DEX1540-SC	15.4	k6	140°	2.8	5.9	○	
		DEX1550-SC	15.5	k6	140°	2.82	5.88	●	
		DEX1560-SC	15.6	k6	140°	2.84	5.86	○	
		DEX1570-SC	15.7	k6	140°	2.86	5.84	○	
		DEX1580-SC	15.8	k6	140°	2.88	5.82	○	
		DEX1590-SC	15.9	k6	140°	2.89	5.81	○	

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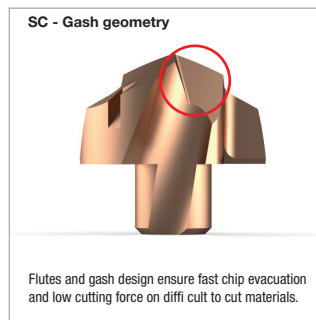
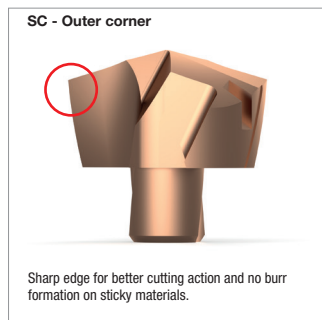
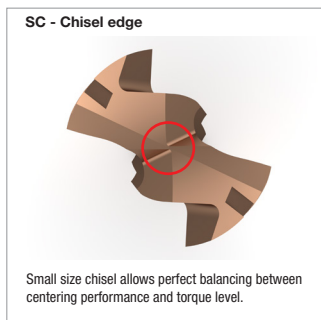
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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚡ 1 st choice ⚡ suitable	JP5630	
<h2>DEX drill</h2>			
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	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
		P 55 160 M 30 80 K N S H	

Designation		DC	DC toll.	SIG	PL	LF	Stock		
LOW FORCE		SC 1600 P M	DEX1600-SC	16	k6	140°	2.91	5.89	●
		DEX1610-SC	16.1	k6	140°	2.93	5.87	○	
		DEX1620-SC	16.2	k6	140°	2.95	5.85	●	
		DEX1630-SC	16.3	k6	140°	2.97	5.83	●	
		DEX1640-SC	16.4	k6	140°	2.98	5.82	○	
		DEX1650-SC	16.5	k6	140°	3	5.8	●	
		DEX1660-SC	16.6	k6	140°	3.02	5.78	●	
		DEX1670-SC	16.7	k6	140°	3.04	5.76	○	
		DEX1680-SC	16.8	k6	140°	3.06	5.74	○	
		DEX1690-SC	16.9	k6	140°	3.08	5.72	○	
LOW FORCE		SC 1700 P M	DEX1700-SC	17	k6	140°	3.09	6.81	●
		DEX1710-SC	17.1	k6	140°	3.11	6.79	●	
		DEX1720-SC	17.2	k6	140°	3.13	6.77	○	
		DEX1730-SC	17.3	k6	140°	3.15	6.75	○	
		DEX1740-SC	17.4	k6	140°	3.17	6.73	○	
		DEX1750-SC	17.5	k6	140°	3.18	6.72	●	
		DEX1760-SC	17.6	k6	140°	3.2	6.7	○	
		DEX1770-SC	17.7	k6	140°	3.22	6.68	●	
		DEX1780-SC	17.8	k6	140°	3.24	6.66	●	
		DEX1790-SC	17.9	k6	140°	3.26	6.64	○	

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion



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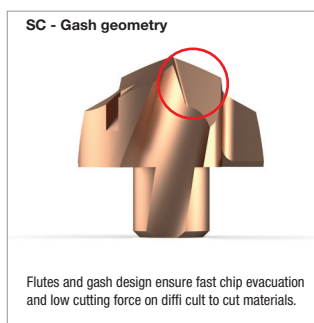
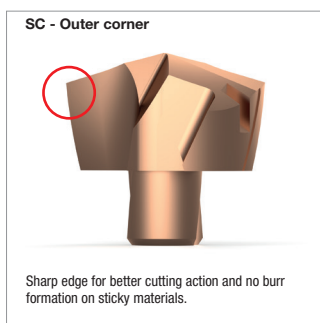
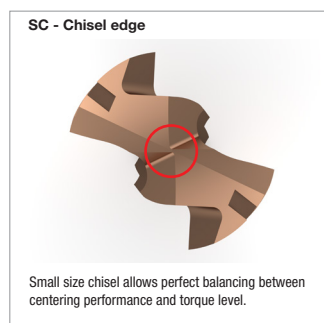
F - ACCESSORIES

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD												
	<h2>DEX drill</h2>		JP5630												
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	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)												
		<table border="1"> <tr><td>P</td><td>55 160</td></tr> <tr><td>M</td><td>30 80</td></tr> <tr><td>K</td><td></td></tr> <tr><td>N</td><td></td></tr> <tr><td>S</td><td></td></tr> <tr><td>H</td><td></td></tr> </table>	P	55 160	M	30 80	K		N		S		H		
P	55 160														
M	30 80														
K															
N															
S															
H															

Designation		DC	DC toll.	SIG	PL	LF	Stock	
LOW FORCE		SC 1800 P M	18	k6	140°	3.28	7.22	●
		DEX1810-SC	18.1	k6	140°	3.29	7.21	●
		DEX1820-SC	18.2	k6	140°	3.31	7.19	○
		DEX1830-SC	18.3	k6	140°	3.33	7.17	●
		DEX1840-SC	18.4	k6	140°	3.35	7.15	○
		DEX1850-SC	18.5	k6	140°	3.37	7.13	●
		DEX1860-SC	18.6	k6	140°	3.38	7.12	○
		DEX1870-SC	18.7	k6	140°	3.4	7.1	○
		DEX1880-SC	18.8	k6	140°	3.42	7.08	○
		DEX1890-SC	18.9	k6	140°	3.44	7.06	○
LOW FORCE		SC 1900 P M	19	k6	140°	3.46	7.54	●
		DEX1910-SC	19.1	k6	140°	3.48	7.52	○
		DEX1920-SC	19.2	k6	140°	3.49	7.51	●
		DEX1930-SC	19.3	k6	140°	3.51	7.49	●
		DEX1940-SC	19.4	k6	140°	3.53	7.47	○
		DEX1950-SC	19.5	k6	140°	3.55	7.45	●
		DEX1960-SC	19.6	k6	140°	3.57	7.43	○
		DEX1970-SC	19.7	k6	140°	3.59	7.41	●
		DEX1980-SC	19.8	k6	140°	3.6	7.4	○
		DEX1990-SC	19.9	k6	140°	3.62	7.38	●

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion



<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚠ 1 st choice ⚠ suitable	JP5630	
<h2>DEX drill</h2>			
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 			
	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
		P 55 160 M 30 80 K N S H	

Designation		DC	DC toll.	SIG	PL	LF	Stock	
LOW FORCE 	SC 20 ₀₀ P M	DEX2000-SC	20	k6	140°	3.64	7.96	●
		DEX2010-SC	20.1	k6	140°	3.66	7.94	○
		DEX2020-SC	20.2	k6	140°	3.68	7.92	○
		DEX2030-SC	20.3	k6	140°	3.69	7.91	○
		DEX2040-SC	20.4	k6	140°	3.71	7.89	○
		DEX2050-SC	20.5	k6	140°	3.73	7.87	●
		DEX2060-SC	20.6	k6	140°	3.75	7.85	○
		DEX2070-SC	20.7	k6	140°	3.77	7.83	○
		DEX2080-SC	20.8	k6	140°	3.79	7.81	○
		DEX2090-SC	20.9	k6	140°	3.8	7.8	○
LOW FORCE 	SC 21 ₀₀ P M	DEX2100-SC	21	k6	140°	3.82	8.28	●
		DEX2150-SC	21.5	k6	140°	3.91	8.19	●
LOW FORCE 	SC 22 ₀₀ P M	DEX2200-SC	22	k6	140°	4	8.7	●
		DEX2230-SC	22.3	k6	140°			○
		DEX2250-SC	22.5	k6	140°	4.09	8.61	●
LOW FORCE 	SC 23 ₀₀ P M	DEX2300-SC	23	k6	140°	4.18	9.12	●
		DEX2350-SC	23.5	k6	140°	4.28	9.02	●

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge

Small size chisel allows perfect balancing between centering performance and torque level.

SC - Outer corner

Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry

Flutes and gash design ensure fast chip evacuation and low cutting force on diffi cult to cut materials.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD
	<h2>DEX drill</h2>		JP5630
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut	● 1 st choice ○ suitable	
	General machining, medium cut	● 1 st choice ○ suitable	●
	Unstable machining, heavy cut	⊕ 1 st choice ⊖ suitable	⊕
	Dimensions		ISO
		Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
		P	55 160
		M	30 80
		K	
		N	
		S	
		H	

Designation		DC	DC toll.	SIG	PL	LF	Stock	
LOW FORCE 	SC 24_∞ P M DEX2400-SC	24	k6	140°	4.36	9.54	●	
	DEX2450-SC	24.5	k6	140°	4.46	9.44	●	
LOW FORCE 	SC 25_∞ P M DEX2500-SC	25	k6	140°	4.55	9.95	●	
	DEX2550-SC	25.5	k6	140°	4.64	9.86	●	
	DEX2600-SC	26	k6	140°	4.73	9.86	●	

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge

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SC - Gash geometry

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<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	
	<h2>DEX drill</h2>		JP7625	
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut	● 1 st choice ○ suitable		
	General machining, medium cut	● 1 st choice ○ suitable	●	
	Unstable machining, heavy cut	▲ 1 st choice ▲ suitable	▲	
	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
		P M K 70 160 N S H		

Designation		DC	DC toll.	SIG	PL	LF	Stock
REINFORCED	TE 1000 K	10	k6	140°	1.78	4.42	●
	DEX1000-TE						
	DEX1020-TE						
	DEX1030-TE						
REINFORCED	TE 1100 K	11	k6	140°	1.98	4.62	●
	DEX1100-TE						
REINFORCED	TE 1200 K	12	k6	140°	2.18	4.82	●
	DEX1200-TE						
REINFORCED	TE 1300 K	13	k6	140°	2.37	5.23	●
	DEX1300-TE						
REINFORCED	TE 1400 K	14	k6	140°	2.55	5.55	●
	DEX1400-TE						
REINFORCED	TE 1450 K	14.5	k6	140°	2.64	5.46	●
	DEX1450-TE						

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

TE - Chisel edge

Big size chisel allows high feedrate machining and best centering features.

TE - Outer corner

Big negative chamfer for higher performance on cast iron machining.

TE - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD
	<h2>DEX drill</h2>		JP7625
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut	● 1 st choice ○ suitable	
	General machining, medium cut	● 1 st choice ○ suitable	●
	Unstable machining, heavy cut	⊕ 1 st choice ⊖ suitable	⊕
	Dimensions		ISO
		P	
		M	
		K	70 160
		N	
		S	
		H	

Designation		DC	DC toll.	SIG	PL	LF	Stock
REINFORCED	TE 1500 K 	15	k6	140°	2.73	5.97	●
	DEX1500-TE						●
	DEX1550-TE						●
REINFORCED	TE 1600 K 	16	k6	140°	2.91	5.89	●
	DEX1600-TE						●
REINFORCED	TE 1700 K 	17	k6	140°	3.09	6.81	●
	DEX1700-TE						●
REINFORCED	TE 1800 K 	18	k6	140°	3.28	7.22	●
	DEX1800-TE						●
REINFORCED	TE 1850 K 	18.5	k6	140°	3.37	7.13	●
	DEX1850-TE						●
REINFORCED	TE 1900 K 	19	k6	140°	3.46	7.54	●
	DEX1900-TE						●
REINFORCED	TE 1950 K 	19.5	k6	140°	3.55	7.45	●
	DEX1950-TE						●

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

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TE - Outer corner

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TE - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	
	DEX drill	JP7625	
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut ● 1 st choice ○ suitable		
	General machining, medium cut ● 1 st choice ○ suitable	●	
	Unstable machining, heavy cut ▲ 1 st choice ▼ suitable	▲	
	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
	P M K 70 160 N S H		

Designation		DC	DC toll.	SIG	PL	LF	Stock
REINFORCED	TE 20[∞] K 	DEX2000-TE	20	k6	140°	3.64 7.96	●
		DEX2050-TE	20.5	k6	140°	3.73 7.87	●
		DEX2070-TE	20.7	k6	140°	3.77 7.83	○
REINFORCED	TE 21[∞] K 	DEX2100-TE	21	k6	140°	3.82 8.28	●
		DEX2150-TE	21.5	k6	140°	3.91 8.19	●
REINFORCED	TE 22[∞] K 	DEX2200-TE	22	k6	140°	4 8.7	●
		DEX2250-TE	22.5	k6	140°	4.09 8.61	●
REINFORCED	TE 23[∞] K 	DEX2300-TE	23	k6	140°	4.18 9.12	●
		DEX2350-TE	23.5	k6	140°	4.28 9.02	●
REINFORCED	TE 24[∞] K 	DEX2400-TE	24	k6	140°	4.36 9.54	●
		DEX2450-TE	24.5	k6	140°	4.46 9.44	●

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▼ stock exhaustion

TE - Chisel edge

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TE - Outer corner

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TE - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING
B - THREADING
C - GROOVING
D - MILLING
E - DRILLING
F - ACCESSORIES
G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>Heads</h1>		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD		
		DEX drill		JP7625		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 		Stable machining, light cut	● 1 st choice ○ suitable			
		General machining, medium cut	● 1 st choice ○ suitable	●		
		Unstable machining, heavy cut	⊕ 1 st choice ⊖ suitable	⊕		
		Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)		
			P M K 70 160 N S H			
Designation	DC	DC toll.	SIG	PL	LF	Stock
REINFORCED TE 2500 K						
DEX2500-TE	25	k6	140°	4.55	9.95	●
DEX2550-TE	25.5	k6	140°	4.64	9.86	●
DEX2600-TE	26	k6	140°	4.73	9.86	●

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

TE - Chisel edge

Big size chisel allows high feedrate machining and best centering features.

TE - Outer corner

Big negative chamfer for higher performance on cast iron machining.

TE - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	DEX drill		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	General machining, medium cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	Unstable machining, heavy cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable			
	Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)
			P	55 160	55 160	
			M			
K			60 140	60 140		
N						
S						
H						

Designation		DC	DC toll.	SIG	PL	LF	Stock		
FLAT TYPE	FT 10∞ P K 	DEX1000-FT	10	k6	140°	1.78	4.42		○
		DEX1050-FT	10.5	k6	140°	1.88	4.32		○
FLAT TYPE	FT 11∞ P K 	DEX1100-FT	11	k6	140°	1.98	4.62		○
		DEX1150-FT	11.5	k6	140°	2.08	4.52		○
FLAT TYPE	FT 12∞ P K 	DEX1200-FT	12	k6	140°	2.18	4.82		○
		DEX1250-FT	12.5	k6	140°	2.27	4.73		○
FLAT TYPE	FT 13∞ P K 	DEX1300-FT	13	k6	140°	2.37	5.23		○
		DEX1350-FT	13.5	k6	140°	2.46	5.14	● ▲	
FLAT TYPE	FT 14∞ P K 	DEX1400-FT	14	k6	140°	2.55	5.55		○
		DEX1450-FT	14.5	k6	140°	2.64	5.46		○

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

CUTTING CONDITIONS

Please reduce cutting speed and feed rate by 20% when using flat type drilling heads.

A - TURNING
B - THREADING
C - GROOVING
D - MILLING
E - DRILLING
F - ACCESSORIES
G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	<h2>DEX drill</h2>		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut	<input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	<input type="radio"/>	<input type="radio"/>		
	General machining, medium cut	<input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	<input checked="" type="radio"/>	<input checked="" type="radio"/>		
	Unstable machining, heavy cut	<input type="radio"/> 1 st choice <input type="radio"/> suitable	<input type="radio"/>	<input type="radio"/>		
	Dimensions		ISO			
		Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
		P	55 160	55 160		
		M				
		K	60 140	60 140		
		N				
		S				
H						

Designation		DC	DC toll.	SIG	PL	LF	Stock	
FLAT TYPE 	FT 1500 P K DEX1500-FT	15	k6	140°	2.73	5.97		○
	DEX1550-FT	15.5	k6	140°	2.82	5.88		○
FLAT TYPE 	FT 1600 P K DEX1600-FT	16	k6	140°	2.91	5.89		○
	DEX1650-FT	16.5	k6	140°	3	5.8		○
FLAT TYPE 	FT 1700 P K DEX1700-FT	17	k6	140°	3.09	6.81		○
	DEX1750-FT	17.5	k6	140°	3.18	6.72		○
FLAT TYPE 	FT 1800 P K DEX1800-FT	18	k6	140°	3.28	7.22	●	▲
	DEX1850-FT	18.5	k6	140°	3.37	7.13		○
FLAT TYPE 	FT 1900 P K DEX1900-FT	19	k6	140°	3.46	7.54	●	▲
	DEX1950-FT	19.5	k6	140°	3.55	7.45		○

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

CUTTING CONDITIONS

Please reduce cutting speed and feed rate by 20% when using flat type drilling heads.

<h1>Heads</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
	DEX drill		JP5625	JP5725		
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 	Stable machining, light cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	General machining, medium cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable	Unstable machining, heavy cut <input checked="" type="radio"/> 1 st choice <input type="radio"/> suitable			
	Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)
			P	55 160	55 160	
			M			
K			60 140	60 140		
N						
S						
H						

Designation		DC	DC toll.	SIG	PL	LF	Stock		
FLAT TYPE	FT 20[∞] P K 	DEX2000-FT	20	k6	140°	3.64	7.96	●	▲
		DEX2050-FT	20.5	k6	140°	3.73	7.87		○
FLAT TYPE	FT 21[∞] P K 	DEX2100-FT	21	k6	140°	3.82	8.28	●	▲
		DEX2150-FT	21.5	k6	140°	3.91	8.19		○
FLAT TYPE	FT 22[∞] P K 	DEX2200-FT	22	k6	140°	4	8.7	●	▲
		DEX2250-FT	22.5	k6	140°	4.09	8.61		○
FLAT TYPE	FT 23[∞] P K 	DEX2300-FT	23	k6	140°	4.18	9.12	●	
		DEX2350-FT	23.5	k6	140°	4.28	9.02		○
FLAT TYPE	FT 24[∞] P K 	DEX2400-FT	24	k6	140°	4.36	9.54	●	▲
		DEX2450-FT	24.5	k6	140°	4.46	9.44		○

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

CUTTING CONDITIONS

Please reduce cutting speed and feed rate by 20% when using flat type drilling heads.

A - TURNING
B - THREADING
C - GROOVING
D - MILLING
E - DRILLING
F - ACCESSORIES
G - SPARE PARTS

- A - TURNING
- B - THREADING
- C - GROOVING
- D - MILLING
- E - DRILLING
- F - ACCESSORIES
- G - SPARE PARTS

<h1>Heads</h1>		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD			
<h2>DEX drill</h2>				JP5625	JP5725			
<ul style="list-style-type: none"> GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes Can fit with 3xD or 5xD DEX drill bodies Diameters out of catalogue can be made upon request Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests 		Stable machining, light cut	● 1 st choice ○ suitable	○	○			
		General machining, medium cut	● 1 st choice ○ suitable	●	●			
		Unstable machining, heavy cut	⚡ 1 st choice ⚡ suitable					
		Dimensions		ISO				
				Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
				P	55 160			
				M	55 160			
				K	60 140			
				N	60 140			
				S				
				H				
Designation		DC	DC toll.	SIG	PL	LF	Stock	
FLAT TYPE 	FT 2500 P K							
	DEX2500-FT	25	k6	140°	4.55	9.95	●	▲
	DEX2550-FT	25.5	k6	140°	4.64	9.86		○
	DEX2600-FT	26	k6	140°	4.73	9.86	●	▲

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

⚠ CUTTING CONDITIONS

Please reduce cutting speed and feed rate by 20% when using flat type drilling heads.

ISO 513	MATERIAL	HARDNESS HB	L/D	JP5630			JP5725			
				min	start	max	min	start	max	
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	3xD - 5xD	80	120	160	80	120	160	
			8xD	65	100	135	65	100	135	
			12xD	55	85	115	55	85	115	
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	3xD - 5xD		-		60	90	120	
			8xD		-		50	75	100	
			12xD		-		40	60	80	
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	3xD - 5xD		-		40	60	80	
			8xD		-		35	50	65	
			12xD		-		30	40	50	
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5630						
				min	start	max				
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	3xD - 5xD	60	80	100				
			8xD	50	65	80				
			12xD	40	55	70				
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	3xD - 5xD	30	40	50				
			8xD	25	35	45				
			12xD	25	30	35				
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	3xD - 5xD	40	60	80				
			8xD	35	50	65				
			12xD	30	40	50				
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		3xD - 5xD	30	50	70				
			8xD	25	40	55				
			12xD	20	35	50				
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5725			JP7625			
				min	start	max	min	start	max	
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	3xD - 5xD	80	110	140	100	130	160	
			8xD	70	90	110	80	100	120	
			12xD	60	80	100	70	90	110	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	3xD - 5xD	80	100	120	100	120	140	
			8xD	70	90	110	80	100	120	
			12xD	60	80	100	70	90	110	

Complete workpiece materials p. H1.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

	ISO 513	MATERIAL	HARDNESS HB	L/D	DC 10.00 ÷ 10.99			DC 11.00 ÷ 11.99			DC 12.00 ÷ 12.99		
					min	start	max	min	start	max	min	start	max
A - TURNING	P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	3xD - 5xD	0.10	0.16	0.22	0.10	0.17	0.24	0.12	0.19	0.26
				8xD	0.08	0.13	0.18	0.08	0.14	0.20	0.10	0.15	0.20
				12xD	-	-	-	-	0.13	0.18	-	-	-
B - THREADING	P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	3xD - 5xD	0.12	0.19	0.26	0.12	0.20	0.28	0.14	0.22	0.30
				8xD	0.10	0.15	0.20	0.10	0.16	0.22	0.11	0.17	0.23
				12xD	-	-	-	-	0.15	0.20	-	-	-
C - GROOVING	P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	3xD - 5xD	0.12	0.18	0.24	0.12	0.19	0.26	0.14	0.21	0.28
				8xD	0.10	0.14	0.18	0.10	0.15	0.20	0.11	0.16	0.21
				12xD	-	-	-	-	0.14	0.18	-	-	-
D - MILLING	P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	3xD - 5xD	0.11	0.15	0.19	0.11	0.16	0.21	0.13	0.18	0.23
				8xD	0.09	0.14	0.15	0.09	0.13	0.17	0.11	0.15	0.19
				12xD	-	-	-	-	0.12	0.15	-	-	-
E - DRILLING	P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	3xD - 5xD	0.09	0.14	0.19	0.09	0.15	0.21	0.11	0.16	0.21
				8xD	0.07	0.11	0.15	0.07	0.12	0.17	0.09	0.13	0.17
				12xD	-	-	-	-	0.11	0.14	-	-	-
F - ACCESSORIES	M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	3xD - 5xD	0.10	0.14	0.18	0.10	0.15	0.20	0.12	0.16	0.20
				8xD	0.08	0.11	0.14	0.08	0.12	0.16	0.10	0.13	0.16
				12xD	-	-	-	-	0.11	0.14	-	-	-
G - SPARE PARTS	M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		3xD - 5xD	0.10	0.13	0.16	0.10	0.14	0.18	0.12	0.15	0.18
				8xD	0.08	0.10	0.12	0.08	0.11	0.14	0.10	0.12	0.14
				12xD	-	-	-	-	0.10	0.12	-	-	-
H1	K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	3xD - 5xD	0.14	0.22	0.30	0.14	0.24	0.34	0.16	0.26	0.36
				8xD	0.11	0.18	0.25	0.11	0.19	0.27	0.12	0.20	0.28
				12xD	-	-	-	-	0.18	0.25	-	-	-
H2	K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	3xD - 5xD	0.12	0.18	0.24	0.12	0.20	0.28	0.13	0.21	0.29
				8xD	0.10	0.15	0.20	0.10	0.16	0.22	0.11	0.17	0.23
				12xD	-	-	-	-	0.14	0.20	-	-	-

Complete workpiece materials p. H1.

(fn: mm/rev)

DC 13.00 ÷ 13.99			DC 14.00 ÷ 14.99			DC 15.00 ÷ 16.99			DC 17.00 ÷ 19.99			DC 20.00 ÷ 22.99			DC 23.00 ÷ 26.00		
min	start	max	min	start	max	min	start	max	min	start	max	min	start	max	min	start	max
0.12	0.20	0.28	0.16	0.23	0.30	0.16	0.25	0.34	0.16	0.29	0.42	0.20	0.32	0.44	0.20	0.34	0.48
0.10	0.16	0.22	0.12	0.18	0.24	0.12	0.20	0.28	0.12	0.23	0.34	0.16	0.26	0.36	0.16	0.27	0.38
0.08	0.14	0.20	0.11	0.16	0.21	0.11	0.17	0.23	0.11	0.20	0.29	0.14	0.22	0.30	0.14	0.24	0.34
0.14	0.23	0.32	0.18	0.26	0.34	0.18	0.29	0.40	0.18	0.33	0.48	0.24	0.37	0.50	0.24	0.40	0.56
0.11	0.18	0.25	0.14	0.20	0.26	0.14	0.23	0.32	0.14	0.26	0.38	0.20	0.30	0.40	0.20	0.32	0.44
0.10	0.16	0.22	0.13	0.18	0.23	0.13	0.20	0.27	0.13	0.23	0.33	0.17	0.26	0.35	0.17	0.28	0.39
0.14	0.22	0.30	0.18	0.25	0.32	0.18	0.28	0.38	0.18	0.32	0.46	0.24	0.36	0.48	0.24	0.38	0.52
0.11	0.17	0.23	0.14	0.20	0.26	0.14	0.22	0.30	0.14	0.25	0.36	0.20	0.29	0.38	0.20	0.31	0.42
0.10	0.15	0.20	0.13	0.17	0.21	0.13	0.20	0.27	0.13	0.23	0.33	0.17	0.25	0.33	0.17	0.27	0.37
0.13	0.19	0.25	0.17	0.22	0.27	0.17	0.24	0.31	0.17	0.27	0.37	0.22	0.31	0.40	0.22	0.32	0.42
0.11	0.16	0.21	0.14	0.18	0.22	0.14	0.19	0.24	0.14	0.22	0.30	0.18	0.25	0.32	0.18	0.26	0.34
0.09	0.13	0.17	0.12	0.15	0.18	0.12	0.17	0.22	0.12	0.19	0.26	0.15	0.21	0.27	0.15	0.22	0.29
0.11	0.17	0.23	0.15	0.20	0.25	0.15	0.22	0.29	0.15	0.25	0.35	0.19	0.28	0.37	0.19	0.29	0.39
0.09	0.14	0.19	0.11	0.16	0.21	0.12	0.17	0.22	0.12	0.20	0.28	0.15	0.22	0.29	0.15	0.23	0.31
0.08	0.12	0.16	0.09	0.13	0.17	0.10	0.15	0.20	0.10	0.17	0.24	0.13	0.19	0.25	0.13	0.20	0.27
0.12	0.17	0.22	0.16	0.20	0.24	0.16	0.22	0.28	0.16	0.25	0.34	0.20	0.28	0.36	0.20	0.29	0.38
0.10	0.14	0.18	0.12	0.16	0.20	0.12	0.17	0.22	0.12	0.19	0.26	0.16	0.22	0.28	0.16	0.23	0.30
0.08	0.12	0.16	0.11	0.14	0.17	0.11	0.15	0.19	0.11	0.17	0.23	0.14	0.20	0.26	0.14	0.21	0.28
0.12	0.16	0.20	0.16	0.19	0.22	0.16	0.20	0.24	0.16	0.23	0.30	0.20	0.26	0.32	0.20	0.27	0.34
0.10	0.13	0.16	0.12	0.15	0.18	0.12	0.16	0.20	0.12	0.18	0.24	0.16	0.21	0.26	0.16	0.22	0.28
0.08	0.11	0.14	0.11	0.13	0.15	0.11	0.14	0.17	0.11	0.16	0.21	0.14	0.18	0.22	0.14	0.19	0.24
0.16	0.28	0.40	0.22	0.32	0.42	0.22	0.35	0.48	0.22	0.40	0.58	0.28	0.45	0.62	0.28	0.48	0.68
0.12	0.22	0.32	0.18	0.26	0.34	0.18	0.28	0.38	0.18	0.32	0.46	0.22	0.36	0.50	0.22	0.38	0.54
0.11	0.19	0.27	0.15	0.22	0.29	0.15	0.25	0.35	0.15	0.27	0.39	0.20	0.32	0.44	0.20	0.34	0.48
0.13	0.22	0.31	0.18	0.26	0.34	0.18	0.28	0.38	0.18	0.32	0.46	0.22	0.36	0.50	0.22	0.38	0.54
0.11	0.18	0.25	0.14	0.20	0.26	0.14	0.22	0.30	0.14	0.25	0.36	0.18	0.27	0.40	0.18	0.30	0.42
0.09	0.15	0.21	0.13	0.18	0.23	0.13	0.20	0.27	0.13	0.23	0.33	0.15	0.25	0.35	0.15	0.26	0.37

Complete workpiece materials p. H1.

(fn: mm/rev)

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

NOTE



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