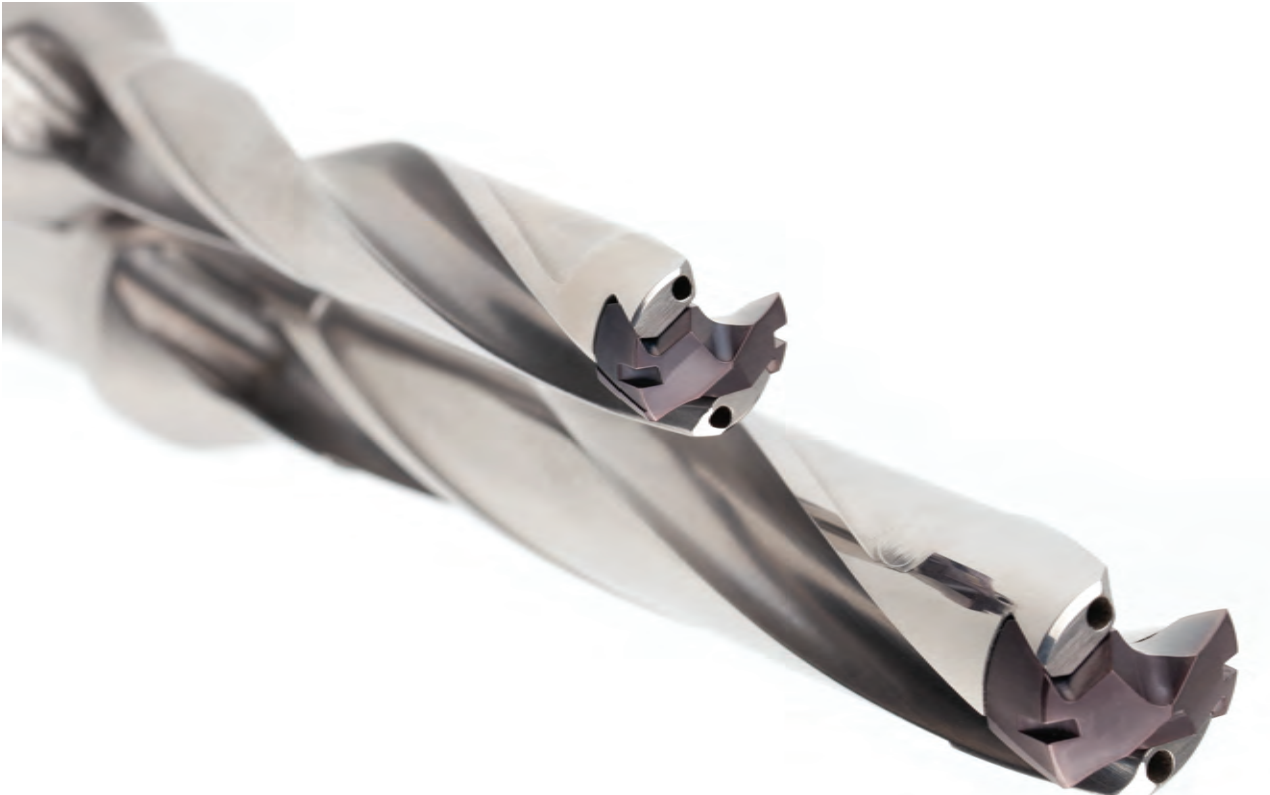




DEX DRILL ACTION

Sistema di foratura ad alte prestazioni con cuspidi intercambiabili

 Plane surface	 Slant surface	 Concave surface	 Convex surface	 Pipes	 Half hole	 Hole expansion	
--	--	--	---	--	--	---	---

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)

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2023

DEX DRILLS

High productivity indexable drilling system with exchangeable heads

APPLICATION



ISO APPLICATION FIELDS

P M K

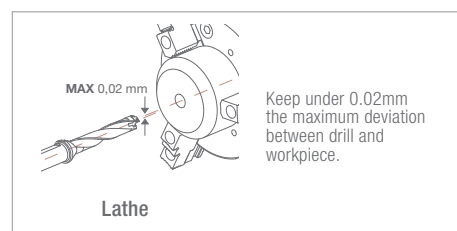
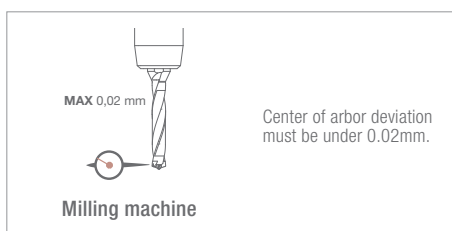
ADVANTAGES AND CHARACTERISTICS

- 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



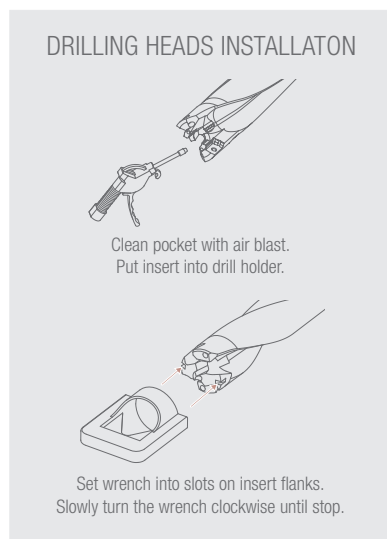
• Drilling bodies

- 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

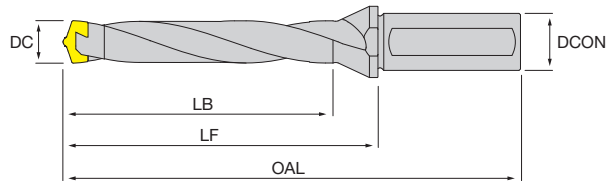
- Available D10-26, can make special diameters or stepped type
- Cemented carbide grades with PVD coatings
- Geometries: GP, SC, TE, FT (flat)



3xD

DEX drill

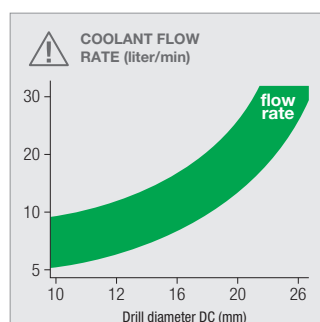
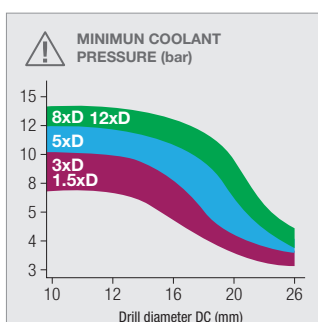
- 3xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fit into the same body, please check MIID column
- Special diameters or stepped type available upon requests



Designation	Stock	DC	DCON	OAL	LF	LB				MIID
NT-DEX-3D D10-S16F	●	10	16	95	47	38				DEX10 ⁰⁰
NT-DEX-3D D11-S16F	●	11	16	98	50	39				DEX11 ⁰⁰
NT-DEX-3D D12-S16F	●	12	16	104	56	44				DEX12 ⁰⁰
NT-DEX-3D D13-S16F	●	13	16	108	60	47				DEX13 ⁰⁰
NT-DEX-3D D14-S16F	●	14	16	112	64	50				DEX14 ⁰⁰
NT-DEX-3D D15-S20F	●	15	20	118	68	53				DEX15 ⁰⁰
NT-DEX-3D D16-S20F	●	16	20	122	72	56				DEX16 ⁰⁰
NT-DEX-3D D17-S20F	●	17	20	126	76	59				DEX17 ⁰⁰
NT-DEX-3D D18-S25F	●	18	25	136	80	62				DEX18 ⁰⁰
NT-DEX-3D D19-S25F	●	19	25	140	84	65				DEX19 ⁰⁰
NT-DEX-3D D20-S25F	●	20	25	144	88	68				DEX20 ⁰⁰
NT-DEX-3D D21-S25F	●	21	25	152	96	75				DEX21 ⁰⁰
NT-DEX-3D D22-S25F	●	22	25	157	101	81				DEX22 ⁰⁰
NT-DEX-3D D23-S32F	●	23	32	165	105	82				DEX23 ⁰⁰
NT-DEX-3D D24-S32F	●	24	32	170	110	86				DEX24 ⁰⁰
NT-DEX-3D D25/26-S32F	●	25	32	175	115	89				DEX25/26 ⁰⁰

● 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

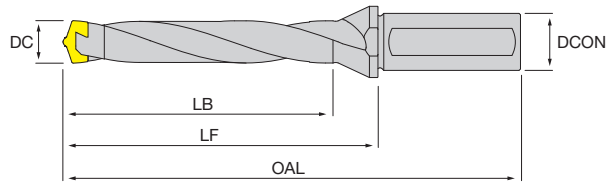
F - ACCESSORIES

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



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

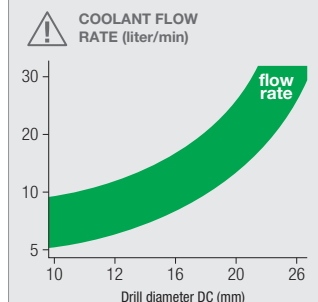
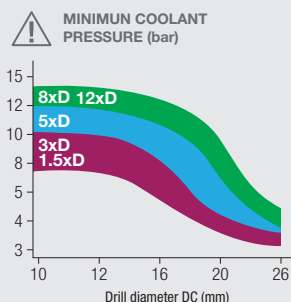
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

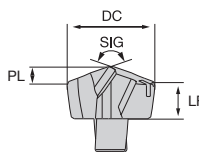
Spare parts

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



Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
DEX drill				JP5625	JP5725		
- 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: 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 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.

GP - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING

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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

HF
PVD

JP5625

JP5725

Stable machining, light cut ● 1st choice ○ suitable

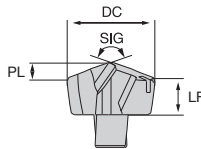
General machining, medium cut ● 1st choice ○ suitable

Unstable machining, heavy cut ⚙ 1st choice ⚙ suitable

Dimensions

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)



P 55 55
160 160
M
K 60 60
140 140
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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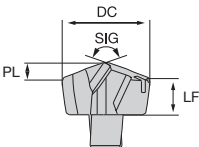


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Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
DEX drill				JP5625	JP5725		
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		General machining, medium cut	● 1 st choice ○ suitable	●	●		
		Unstable machining, heavy cut	⚠ 1 st choice ⚙ suitable				
		Dimensions		ISO		Vc(m/min) - suggested cutting speed range (bold: 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 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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D - MILLING

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F - ACCESSORIES

G - SPARE PARTS

Heads

DEX drill

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HF: Micrograin carbide
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HF
PVD

HF
PVD

JP5625

JP5725

Stable machining, light cut ● 1st choice ○ suitable

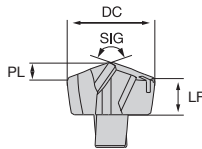
General machining, medium cut ● 1st choice ○ suitable

Unstable machining, heavy cut ⚙ 1st choice ⚙ suitable

Dimensions

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)



P 55 55
160 160
M
K 60 60
140 140
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	● ▲

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

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GP - Outer corner

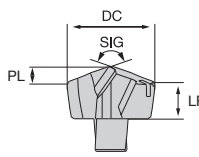


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Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
DEX drill				JP5625	JP5725		
- GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is 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: 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 18∞  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 19∞  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

Heads

DEX drill

- 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

JP5625
JP5725

Stable machining,
light cut ● 1st choice ○ suitable

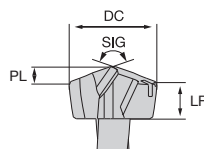
General machining,
medium cut ● 1st choice ○ suitable

Unstable machining,
heavy cut ⚙ 1st choice ⚙ suitable

Dimensions

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)



P

55
160

55
160

M

60
140

60
140

K

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	●	▲	
			20.1	k6	140°	3.66	7.94	●	●	
		DEX2010-GP	20.2	k6	140°	3.68	7.92	●	▲	
			20.3	k6	140°	3.69	7.91	●	▲	
		DEX2020-GP	20.4	k6	140°	3.71	7.89	●	▲	
			20.5	k6	140°	3.73	7.87	●	●	
		DEX2030-GP	20.6	k6	140°	3.75	7.85	●	●	
			20.7	k6	140°	3.77	7.83	●	▲	
		DEX2040-GP	20.8	k6	140°	3.79	7.81	●	▲	
			20.9	k6	140°	3.8	7.8	●	●	
GENERAL	GP 21 ₀₀ P K	DEX2100-GP	21	k6	140°	3.82	8.28	●	●	
			21.5	k6	140°	3.91	8.19	●	●	
GENERAL	GP 22 ₀₀ P K	DEX2200-GP	22	k6	140°	4	8.7	●	●	
			22.5	k6	140°	4.09	8.61	●	●	
GENERAL	GP 23 ₀₀ P K	DEX2300-GP	23	k6	140°	4.18	9.12	●	▲	
			23.5	k6	140°	4.28	9.02	●	●	

● 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

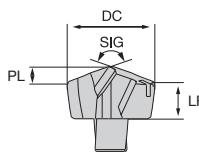


Small chamfer for very good edge protection in general machining.

GP - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
DEX drill				JP5625	JP5725		
- 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: 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 24 ^{oo} P K 	DEX2400-GP	24	k6	140°	4.36	9.54	● ▲	
		DEX2450-GP	24.5	k6	140°	4.46	9.44	●	
GENERAL	GP 25 ^{oo} 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	●	

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

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Small chamfer for very good edge protection in general machining.

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A - TURNING

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G - SPARE PARTS

Heads

DEX drill

- 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
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 HF: Micrograin carbide
 PVD: Physical vapour deposition

 HF
 PVD

JP5630

Stable machining, light cut

 1st choice ○ suitable

General machining, medium cut

 1st choice ○ suitable

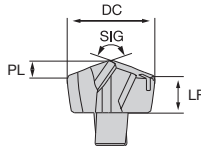
Unstable machining, heavy cut

 1st 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 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	○

● 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

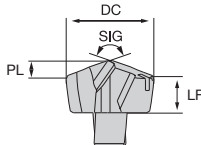


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



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

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	
DEX drill				JP5630	
- 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: 1 st choice)	
P 55 160					
M 30 80					
K					
N					
S					
		H			

Designation		DC	DC toll.	SIG	PL	LF	Stock		
LOW FORCE	SC 12∞ 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 13∞ 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	●	

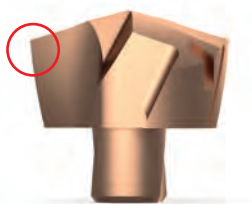
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

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 difficult to cut materials.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

Heads

DEX drill

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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

JP5630

Stable machining, light cut ● 1st choice ○ suitable

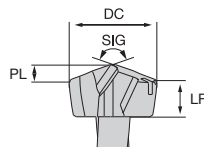
General machining, medium cut ● 1st choice ○ suitable

Unstable machining, heavy cut ⚠ 1st 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	DEX1400-SC	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	DEX1500-SC	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	○

● 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

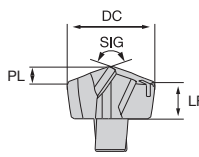


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



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

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	
DEX drill				JP5630	
- 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: 1 st choice)	
P	55 160				
M	30 80				
K					
N					
S					
		H			

Designation		DC	DC toll.	SIG	PL	LF	Stock		
LOW FORCE		SC 16∞ 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 17∞ 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	○

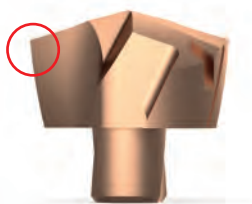
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

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 difficult to cut materials.

Heads

DEX drill

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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

JP5630

Stable machining,
light cut

● 1st choice ○ suitable

General machining,
medium cut

● 1st choice ○ suitable

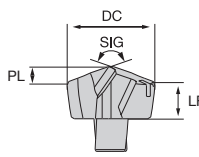
Unstable machining,
heavy cut

● 1st 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 1800 P M	DEX1800-SC	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	DEX1900-SC	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	●

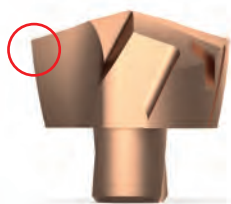
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



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

SC - Outer corner

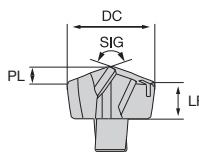


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



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

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD			
DEX drill				JP5630			
- 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: 1 st choice)	
				P		55 160	
		M		30 80			
		K					
		N					
		S					
		H					

Designation		DC	DC toll.	SIG	PL	LF	Stock		
LOW FORCE		SC 20 ^{oo} 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 ^{oo} 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 ^{oo} 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 ^{oo} 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 difficult to cut materials.

A - TURNING

B - THREADING

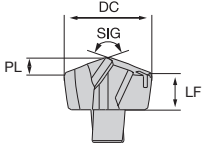
C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD			
DEX drill				JP5630			
- 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: 1 st choice)	
				P 55 160			
				M 30 80			
				K			
				N			
				S			
				H			
Designation		DC	DC toll.	SIG	PL	LF	Stock
LOW FORCE 	SC 24 ₀₀ P M						
	DEX2400-SC	24	k6	140°	4.36	9.54	●
LOW FORCE 	DEX2450-SC	24.5	k6	140°	4.46	9.44	●
	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



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

SC - Outer corner

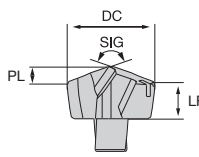


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



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

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD			
DEX drill				JP7625			
- 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: 1 st choice)	
				P			
				M			
				K		70 160	
N							
		S					
		H					

Designation		DC	DC toll.	SIG	PL	LF	Stock	
REINFORCED	TE 10 [∞] K							
	 DEX1000-TE	10	k6	140°	1.78	4.42	●	
	DEX1020-TE	10.2	k6	140°	1.82	4.38	●	
	DEX1030-TE	10.3	k6	140°	1.84	4.36	●	
	DEX1050-TE	10.5	k6	140°	1.88	4.32	●	
REINFORCED	TE 11 [∞] K							
	 DEX1100-TE	11	k6	140°	1.98	4.62	●	
	DEX1150-TE	11.5	k6	140°	2.08	4.52	●	
REINFORCED	TE 12 [∞] K							
	 DEX1200-TE	12	k6	140°	2.18	4.82	●	
	DEX1250-TE	12.5	k6	140°	2.27	4.73	●	
REINFORCED	TE 13 [∞] K							
	 DEX1300-TE	13	k6	140°	2.37	5.23	●	
	DEX1350-TE	13.5	k6	140°	2.46	5.14	●	
REINFORCED	TE 14 [∞] K							
	 DEX1400-TE	14	k6	140°	2.55	5.55	●	
	DEX1450-TE	14.5	k6	140°	2.64	5.46	●	

● 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

Heads

DEX drill

- 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

JP7625

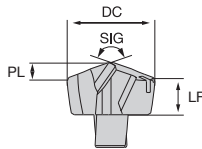
Stable machining,
light cut ● 1st choice ○ suitable

General machining,
medium cut ● 1st choice ○ suitable

Unstable machining,
heavy cut ⚙ 1st 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

			DC	DC toll.	SIG	PL	LF		
REINFORCED	TE 1500 K 	DEX1500-TE	15	k6	140°	2.73	5.97	●	
		DEX1550-TE	15.5	k6	140°	2.82	5.88	●	
		DEX1580-TE	15.8	k6	140°	2.88	5.82	○	
REINFORCED	TE 1600 K 	DEX1600-TE	16	k6	140°	2.91	5.89	●	
		DEX1650-TE	16.5	k6	140°	3	5.8	●	
REINFORCED	TE 1700 K 	DEX1700-TE	17	k6	140°	3.09	6.81	●	
		DEX1750-TE	17.5	k6	140°	3.18	6.72	●	
REINFORCED	TE 1800 K 	DEX1800-TE	18	k6	140°	3.28	7.22	●	
		DEX1850-TE	18.5	k6	140°	3.37	7.13	●	
REINFORCED	TE 1900 K 	DEX1900-TE	19	k6	140°	3.46	7.54	●	
		DEX1950-TE	19.5	k6	140°	3.55	7.45	●	

● 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.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD			
DEX drill				JP7625			
- 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: 1 st 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



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

Heads

DEX drill

- 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

JP7625

Stable machining,
light cut

● 1st choice ○ suitable

General machining,
medium cut

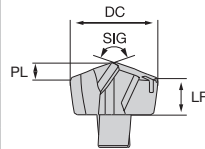
● 1st choice ○ suitable

Unstable machining,
heavy cut

● 1st choice ○ suitable

Dimensions

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)

P
M
K
N
S
H

70
160

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.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD				
DEX drill				JP5625	JP5725				
- 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: 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		
FLAT TYPE 	FT 10∞ P K							○	
	DEX1000-FT	10	k6	140°	1.78	4.42		○	
FLAT TYPE 	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		○	
FLAT TYPE 	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		○	
FLAT TYPE 	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		○	
FLAT TYPE 	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		○	
FLAT TYPE 	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

Heads

DEX drill

- 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

JP5625
JP5725

Stable machining,
light cut

● 1st choice ○ suitable

General machining,
medium cut

● 1st choice ○ suitable

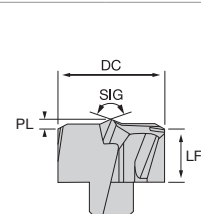
Unstable machining,
heavy cut

● 1st 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

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.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD				
		JP5625	JP5725						
DEX drill									
- 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: 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			
FLAT TYPE	FT 20 ^{oo} 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 ^{oo} 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 ^{oo} P K 	DEX2200-FT	22	k6	140°	4	8.7	●	▲	
		DEX2250-FT	22.5	k6	140°	4.09	8.61		○	
FLAT TYPE	FT 23 ^{oo} 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 ^{oo} 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

Heads

DEX drill

- 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

JP5625
JP5725

Stable machining,
light cut

● 1st choice ○ suitable

General machining,
medium cut

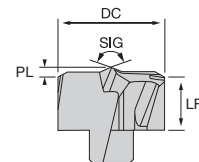
● 1st choice ○ suitable

Unstable machining,
heavy cut

● 1st choice ○ suitable

Dimensions

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)

P 55 55
160 160
M
K 60 60
140 140
N
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	-	-	-	-	-	-	0.08	0.13	0.18
	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	-	-	-	-	-	-	0.10	0.15	0.20
B - THREADING	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	-	-	-	-	-	-	0.10	0.14	0.18
	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	-	-	-	-	-	-	0.09	0.12	0.15
C - GROOVING	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	-	-	-	-	-	-	0.08	0.11	0.14
	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	-	-	-	-	-	-	0.08	0.11	0.14
	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	-	-	-	-	-	-	0.08	0.10	0.12
D - MILLING	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	-	-	-	-	-	-	0.11	0.18	0.25
	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	-	-	-	-	-	-	0.09	0.14	0.19

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(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