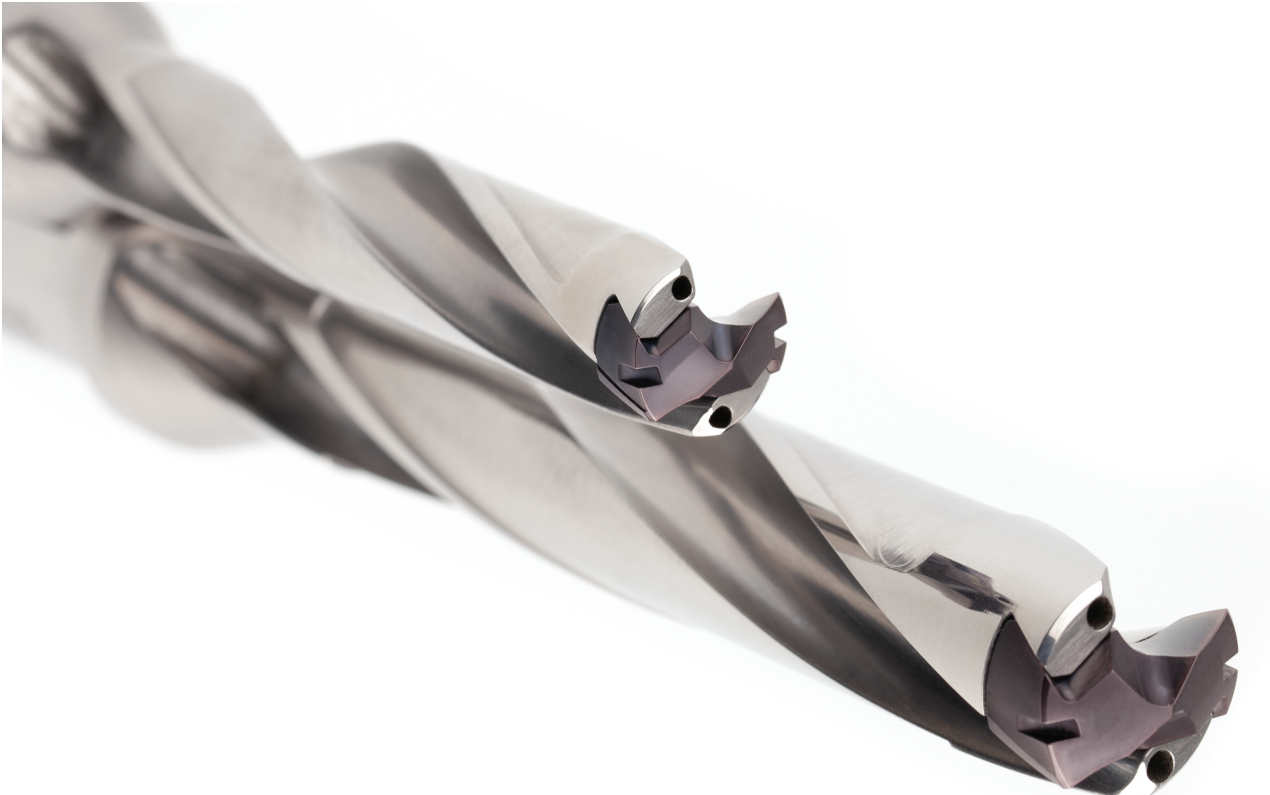




DEX DRILL ACTION

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

scadenza: 31/12/2025

DEX DRILLS

High productivity indexable drilling system with exchangeable heads

APPLICATION

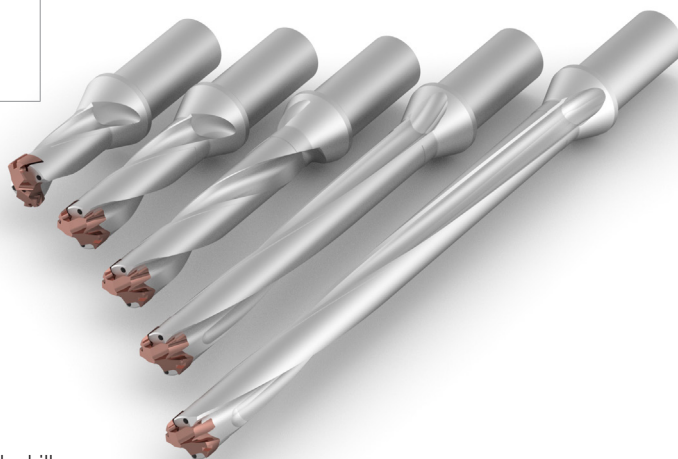


ISO APPLICATION FIELDS

P M K

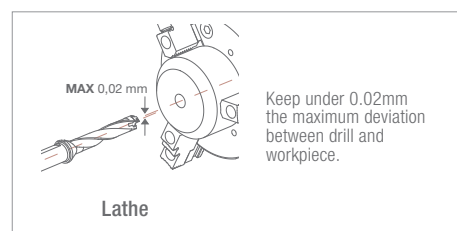
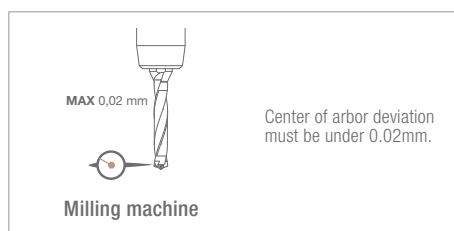
ADVANTAGES AND CHARACTERISTICS

- 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

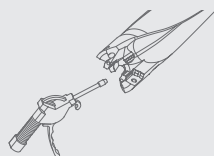


• Inserts

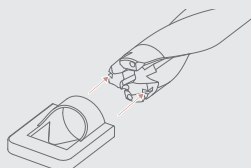
- Available D10-26, can make special diameters or stepped type
- Cemented carbide grades with PVD coatings
- Geometries: GP, SC, TE, FT (flat)



DRILLING HEADS INSTALLATION



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

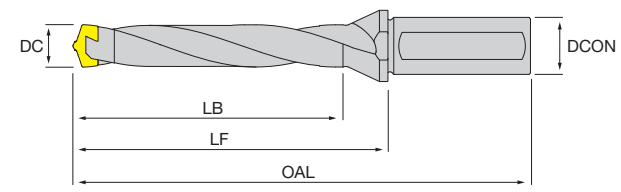


Set wrench into slots on insert flanks.
Slowly turn the wrench clockwise until stop.

3xD

DEX drill

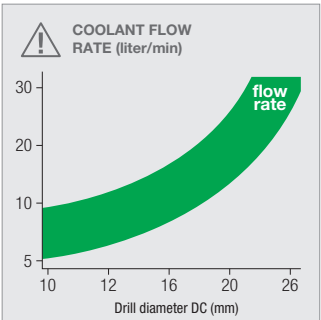
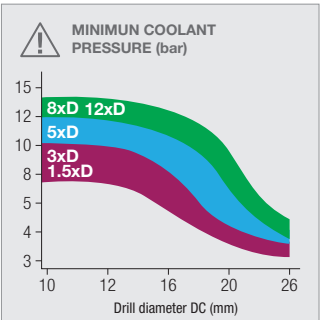
- 3xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fits into the same body, please check MIID column
- Special diameters or stepped type available upon requests



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

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

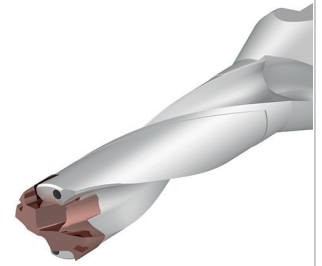
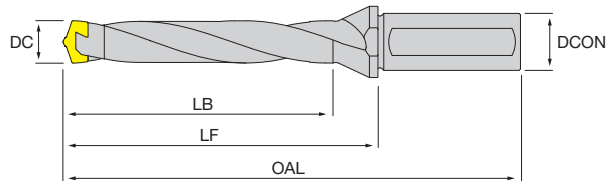
Spare parts	Head wrench
	
NT-DEX-3D (DC 10÷11)	NT-WR1011
NT-DEX-3D (DC 12÷17)	NT-WR1217
NT-DEX-3D (DC 18÷20)	NT-WR1820
NT-DEX-3D (DC 21÷25)	NT-WR2126



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

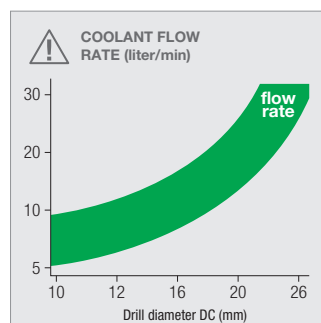
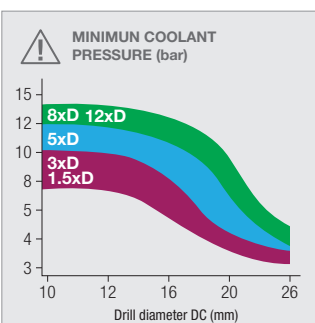
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

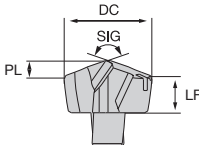
Spare parts

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		
		JPS625	JPS725				
DEX drill		Stable machining, light cut		● 1 st choice ○ suitable	○	○	
- 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		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					

GENERAL	Designation		DC	DC toll.	SIG	PL	LF	Stock		
		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



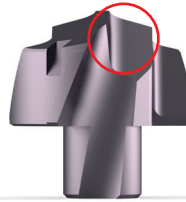
Big size chisel allows high feedrate machining and best centering features.

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

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

Heads

DEX drill

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- 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

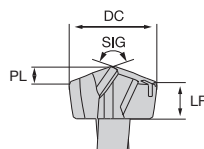
 General machining, medium cut ● 1st choice ○ suitable

 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

 60
140

 60
140

K

 60
140

 60
140

N

 60
140

 60
140

S

 60
140

 60
140

H

 60
140

 60
140

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

● ▲

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

GP - Chisel edge



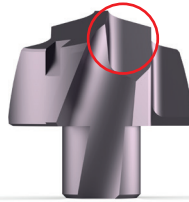
Big size chisel allows high feedrate machining and best centering features.

GP - Outer corner

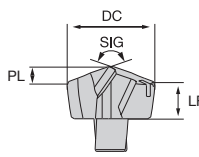


Small chamfer for very good edge protection in general machining.

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 1400 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 1500 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

GP - Chisel edge



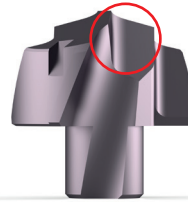
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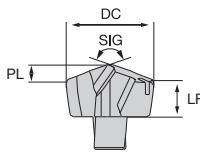
F - ACCESSORIES

G - SPARE PARTS

Heads

DEX drill

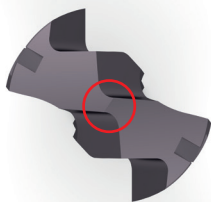
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HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD	
		JP5625	JP5725	
Stable machining, light cut	● 1 st choice ○ suitable	○	○	
General machining, medium cut	● 1 st choice ○ suitable	●	●	
Unstable machining, heavy cut	● 1 st choice ○ 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 16 ^{oo} 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 ^{oo} 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

GP - Chisel edge



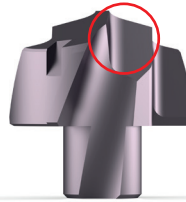
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GP - Outer corner

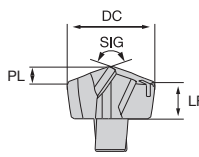


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Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	HF PVD		
DEX drill				JP5625	JP5725		
- GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is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



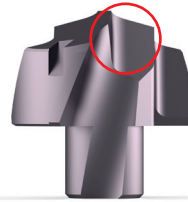
Big size chisel allows high feedrate machining and best centering features.

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

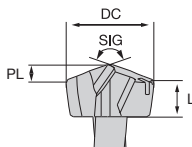
F - ACCESSORIES

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	HF PVD	
		JP5625	JP5725	
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 20 ^{oo} 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 ^{oo} P K	DEX2100-GP	21	k6	140°	3.82	8.28	●
		DEX2150-GP	21.5	k6	140°	3.91	8.19	●
GENERAL	GP 22 ^{oo} P K	DEX2200-GP	22	k6	140°	4	8.7	●
		DEX2250-GP	22.5	k6	140°	4.09	8.61	●
GENERAL	GP 23 ^{oo} P K	DEX2300-GP	23	k6	140°	4.18	9.12	● ▲
		DEX2350-GP	23.5	k6	140°	4.28	9.02	●

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

GP - Chisel edge



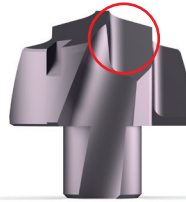
Big size chisel allows high feedrate machining and best centering features.

GP - Outer corner

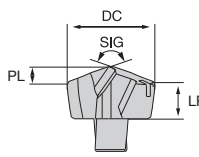


Small chamfer for very good edge protection in general machining.

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 ⁰⁰ P K 	DEX2400-GP	24	k6	140°	4.36	9.54	●	▲		
		DEX2450-GP	24.5	k6	140°	4.46	9.44		●		
GENERAL	GP 25 ⁰⁰ 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

GP - Chisel edge



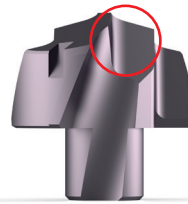
Big size chisel allows high feedrate machining and best centering features.

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

JP5630

Stable machining, light cut ● 1st choice ○ suitable

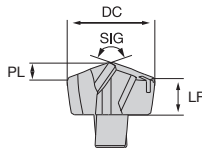
General machining, medium cut ● 1st choice ○ suitable

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°

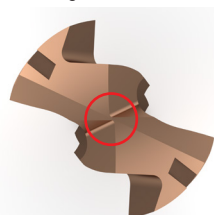
2.16

4.44

○

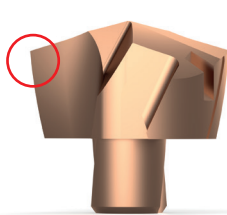
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▼ stock exhaustion

SC - Chisel edge



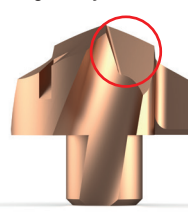
Small size chisel allows perfect balancing between centering performance and torque level.

SC - Outer corner

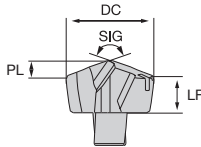


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



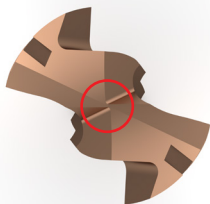
Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

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	●	

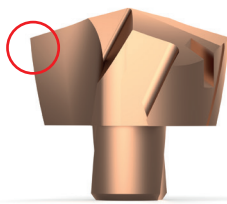
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



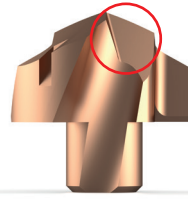
Small size chisel allows perfect balancing between centering performance and torque level.

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

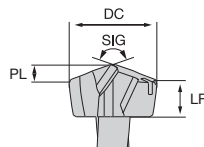
JP5630

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

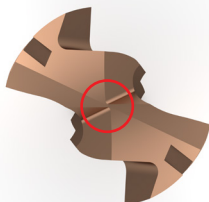
S

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	○

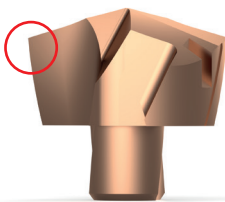
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



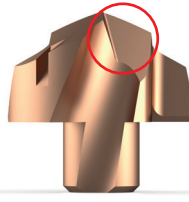
Small size chisel allows perfect balancing between centering performance and torque level.

SC - Outer corner

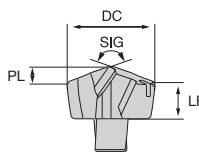


Sharp edge for better cutting action and no burr formation on sticky materials.

SC - Gash geometry



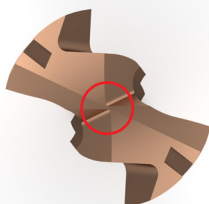
Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD	
DEX drill				JP5630	
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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				
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	○	

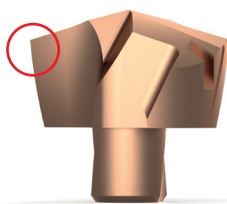
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



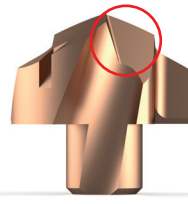
Small size chisel allows perfect balancing between centering performance and torque level.

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.

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
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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

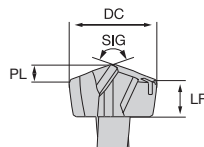
JP5630

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

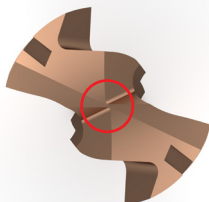
LF

Stock

LOW FORCE	SC 1800 P M	DESIGNATION	DC	DC toll.	SIG	PL	LF	STOCK
			18	k6	140°	3.28	7.22	
		DEX1800-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	○
		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	●

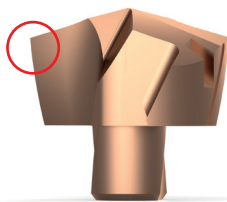
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



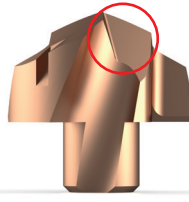
Small size chisel allows perfect balancing between centering performance and torque level.

SC - Outer corner



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

SC - Gash geometry

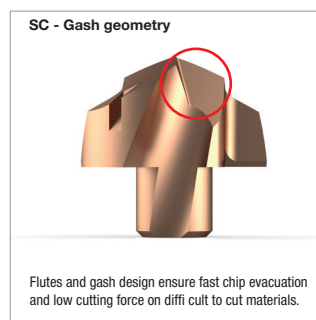
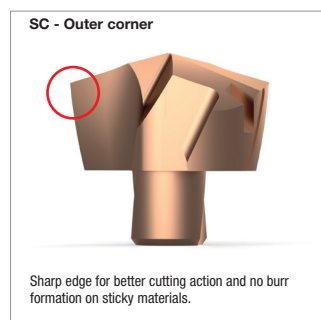
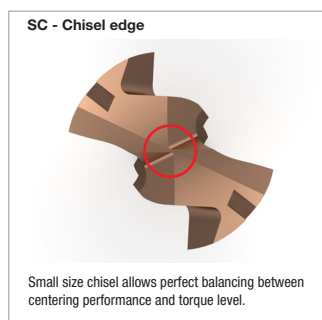


Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

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



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

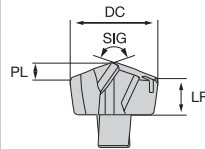
Unstable machining,
heavy cut

● 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

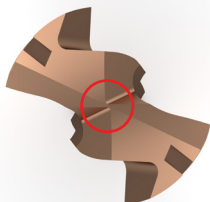
LF

Stock

LOW FORCE	SC 2400 P M	DEX2400-SC	24	k6	140°	4.36	9.54	●
		DEX2450-SC	24.5	k6	140°	4.46	9.44	●
LOW FORCE	SC 2500 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	●

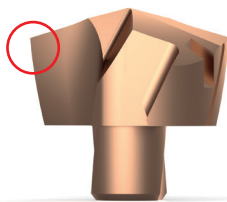
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



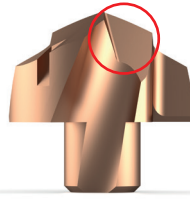
Small size chisel allows perfect balancing between centering performance and torque level.

SC - Outer corner



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

SC - Gash geometry

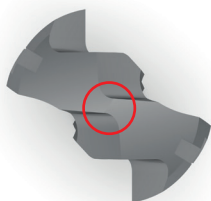


Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

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



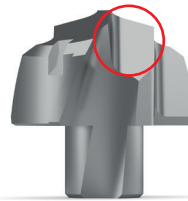
Big size chisel allows high feedrate machining and best centering features.

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

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HF: Micrograin carbide
PVD: Physical vapour deposition

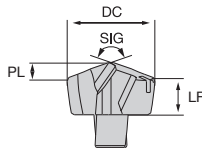
HF
PVD

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

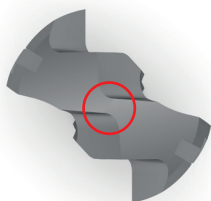
LF

Stock

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



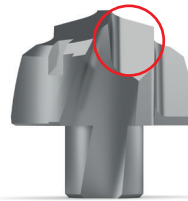
Big size chisel allows high feedrate machining and best centering features.

TE - Outer corner



Big negative chamfer for higher performance on cast iron machining.

TE - Gash geometry



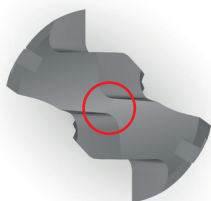
Gashing design allows good chip evacuation and reduce thrust load.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD			
DEX drill				JP7625			
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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			
M							
K				70 160			
N							
S							
		H					

Designation		DC	DC toll.	SIG	PL	LF	Stock		
REINFORCED	TE 20 _{oo} 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 _{oo} K 	DEX2100-TE	21	k6	140°	3.82	8.28	●	
		DEX2150-TE	21.5	k6	140°	3.91	8.19	●	
REINFORCED	TE 22 _{oo} K 	DEX2200-TE	22	k6	140°	4	8.7	●	
		DEX2250-TE	22.5	k6	140°	4.09	8.61	●	
REINFORCED	TE 23 _{oo} K 	DEX2300-TE	23	k6	140°	4.18	9.12	●	
		DEX2350-TE	23.5	k6	140°	4.28	9.02	●	
REINFORCED	TE 24 _{oo} 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



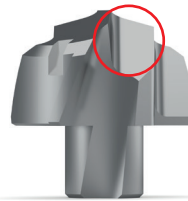
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TE - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

A - TURNING

B - THREADING

C - GROOVING

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F - ACCESSORIES

G - SPARE PARTS

Heads

DEX drill

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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

JP7625

Stable machining,
light cut

● 1st choice ○ suitable

General machining,
medium cut

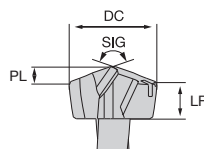
● 1st choice ○ suitable

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

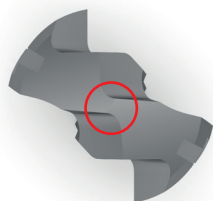
70

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



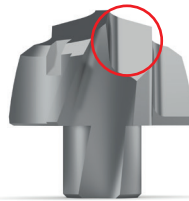
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TE - Outer corner



Big negative chamfer for higher performance on cast iron machining.

TE - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

Heads		HF: Micrograin carbide PVD: Physical vapour deposition		HF	HF						
				PVD	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			
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

Heads

DEX drill

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HF: Micrograin carbide
PVD: Physical vapour deposition

HF
PVD

JP5625
JP5725

Stable machining, light cut ● 1st choice ○ suitable

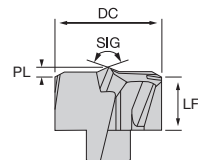
General machining, medium cut ● 1st choice ○ suitable

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 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	HF						
				PVD	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 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

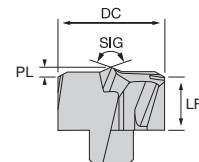
● 1st choice ○ suitable

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

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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