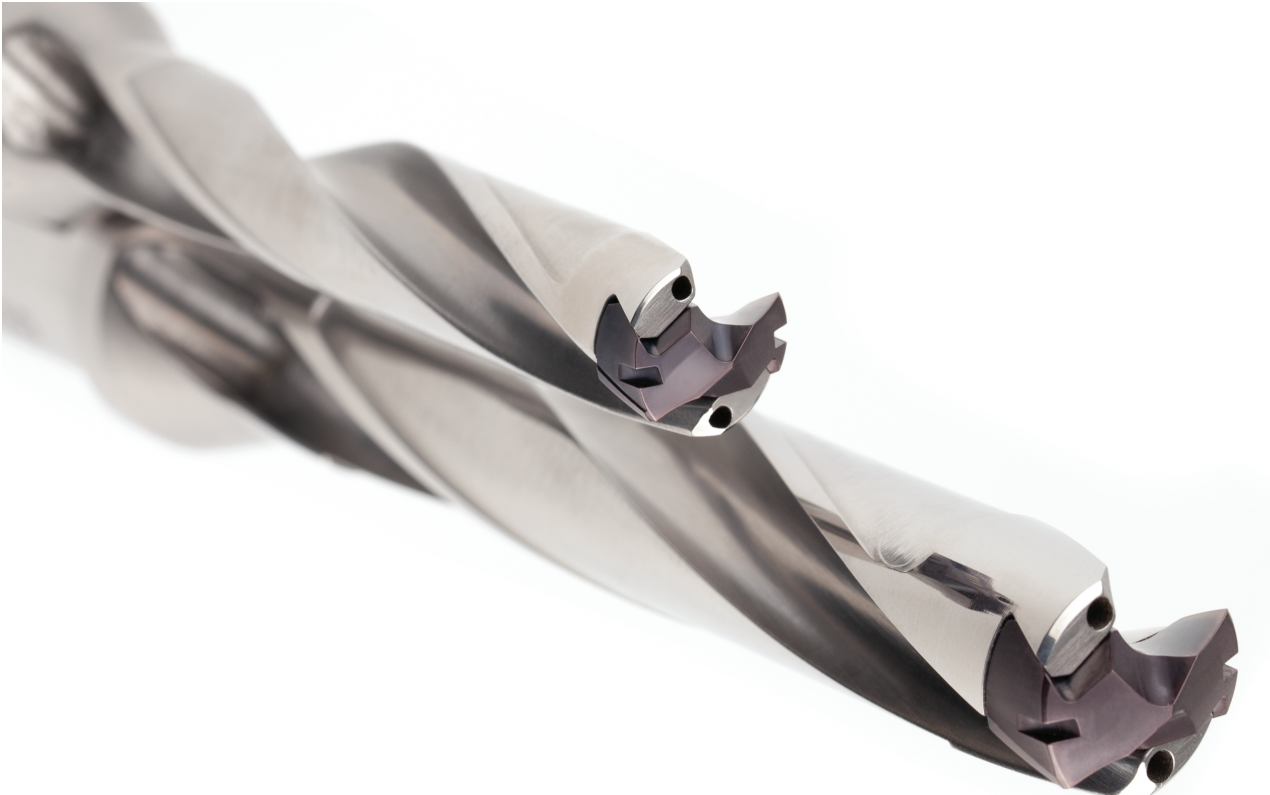




# DEX DRILL ACTION

Sistema di foratura ad alte prestazioni con cuspidi intercambiabili



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

Cuspidi: DEX

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

**nixko**TOOLS

**uemme**  
TOOLS and EQUIPMENT

scadenza 28/02/2026

# DEX DRILLS

High productivity indexable drilling system with exchangeable heads

## APPLICATION

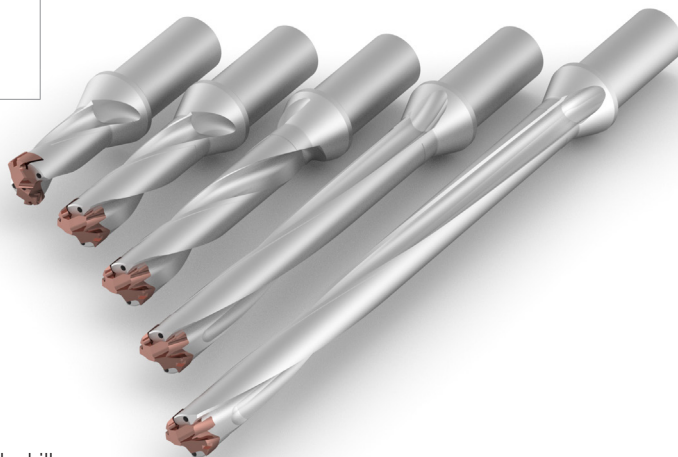


## ISO APPLICATION FIELDS

**P M K**

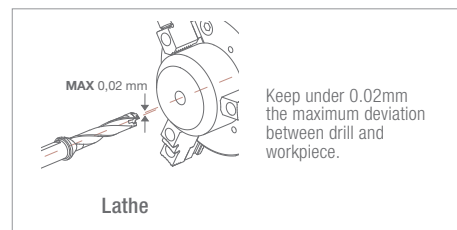
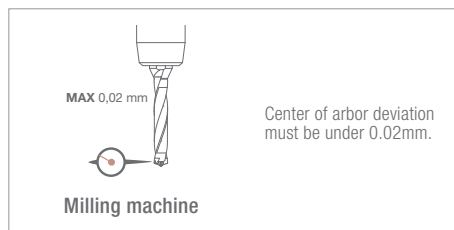
## ADVANTAGES AND CHARACTERISTICS

- 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

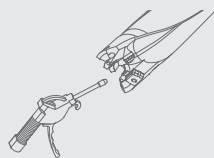


## • Inserts

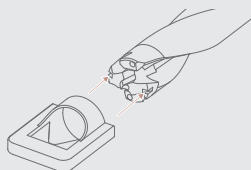
- Available D10-26, can make special diameters or stepped type
- Cemented carbide grades with PVD coatings
- Geometries: GP, SC, TE, FT (flat)



### 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

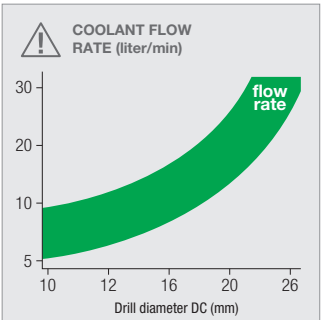
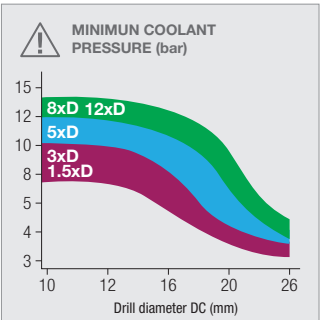
DEX drill

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

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

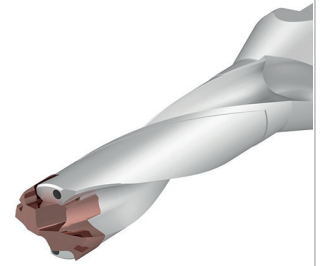
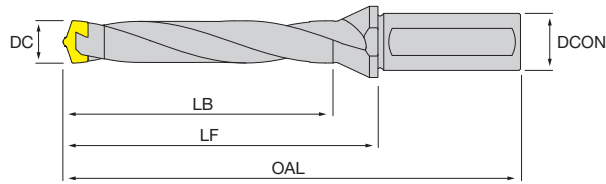
| Spare parts          | Head wrench |
|----------------------|-------------|
|                      |             |
| NT-DEX-3D (DC 10÷11) | NT-WR1011   |
| NT-DEX-3D (DC 12÷17) | NT-WR1217   |
| NT-DEX-3D (DC 18÷20) | NT-WR1820   |
| NT-DEX-3D (DC 21÷25) | NT-WR2126   |



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

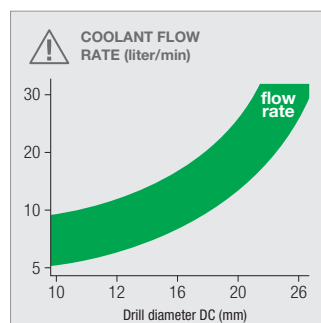
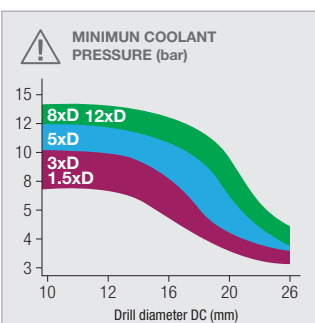
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

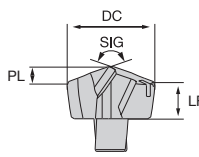
### Spare parts

#### 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<br>PVD: Physical vapour deposition |                                     | HF<br>PVD                                                                | HF<br>PVD |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------|-------------------------------------|--------------------------------------------------------------------------|-----------|--|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                           |                                     | JP5625                                                                   | JP5725    |  |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut                               | ● 1 <sup>st</sup> choice ○ suitable | ○                                                                        | ○         |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut                             | ● 1 <sup>st</sup> choice ○ suitable | ●                                                                        | ●         |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut                             | ⚠ 1 <sup>st</sup> choice ⚠ suitable |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Dimensions                                                | ISO                                 | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                 |  | P                                                         | 55<br>160                           | 55<br>160                                                                |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | M                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | K                                                         | 60<br>140                           | 60<br>140                                                                |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | N                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | S                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                         |                                     |                                                                          |           |  |  |

| Designation |                                                                                                          | DC         | DC toll. | SIG | PL   | LF   | Stock |   |   |
|-------------|----------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|---|
| GENERAL     | GP 10∞ <b>P K</b><br>   | 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∞ <b>P K</b><br> | 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



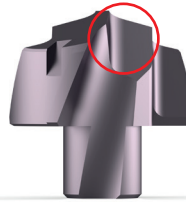
Big size chisel allows high feedrate machining and best centering features.

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

- 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<sup>st</sup> choice ○ suitable

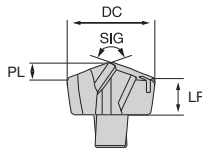
General machining, medium cut ● 1<sup>st</sup> choice ○ suitable

Unstable machining, heavy cut ⚙ 1<sup>st</sup> choice ⚙ suitable

### Dimensions

### ISO

### Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> 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 <b>P</b> <b>K</b> |    | DEX1200-GP | 12   | k6 | 140° | 2.18 | 4.82  |   | ● |  |
|---------|---------------------------|-------------------------------------------------------------------------------------|------------|------|----|------|------|-------|---|---|--|
|         |                           |                                                                                     |            | 12.1 | k6 | 140° | 2.2  | 4.8   | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1220-GP | 12.2 | k6 | 140° | 2.22 | 4.78  | ● | ▲ |  |
|         |                           |                                                                                     |            | 12.3 | k6 | 140° | 2.24 | 4.76  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1240-GP | 12.4 | k6 | 140° | 2.26 | 4.74  | ● | ▲ |  |
|         |                           |                                                                                     |            | 12.5 | k6 | 140° | 2.27 | 4.73  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1260-GP | 12.6 | k6 | 140° | 2.29 | 4.71  | ● | ▲ |  |
|         |                           |                                                                                     |            | 12.7 | k6 | 140° | 2.31 | 4.69  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1280-GP | 12.8 | k6 | 140° | 2.33 | 4.67  | ● | ▲ |  |
|         |                           |                                                                                     |            | 12.9 | k6 | 140° | 2.35 | 4.645 | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1300-GP | 13   | k6 | 140° | 2.37 | 5.23  | ● | ▲ |  |
|         |                           |                                                                                     |            | 13.1 | k6 | 140° | 2.38 | 5.22  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1310-GP | 13.2 | k6 | 140° | 2.4  | 5.2   | ● | ▲ |  |
|         |                           |                                                                                     |            | 13.3 | k6 | 140° | 2.42 | 5.18  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1320-GP | 13.4 | k6 | 140° | 2.44 | 5.16  | ● | ▲ |  |
|         |                           |                                                                                     |            | 13.5 | k6 | 140° | 2.46 | 5.14  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1330-GP | 13.6 | k6 | 140° | 2.47 | 5.13  | ● | ▲ |  |
|         |                           |                                                                                     |            | 13.7 | k6 | 140° | 2.49 | 5.11  | ● | ▲ |  |
| GENERAL | GP 1300 <b>P</b> <b>K</b> |  | DEX1350-GP | 13.8 | k6 | 140° | 2.51 | 5.09  | ● | ▲ |  |
|         |                           |                                                                                     |            | 13.9 | k6 | 140° | 2.53 | 5.07  | ● | ▲ |  |

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

### GP - Chisel edge



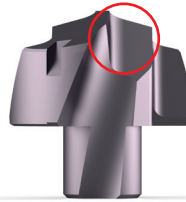
Big size chisel allows high feedrate machining and best centering features.

### GP - Outer corner

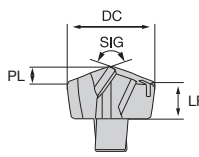


Small chamfer for very good edge protection in general machining.

### GP - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition |                                     | HF<br>PVD                                                                | HF<br>PVD |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------|-------------------------------------|--------------------------------------------------------------------------|-----------|--|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                           |                                     | JP5625                                                                   | JP5725    |  |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut                               | ● 1 <sup>st</sup> choice ○ suitable | ○                                                                        | ○         |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut                             | ● 1 <sup>st</sup> choice ○ suitable | ●                                                                        | ●         |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut                             | ⚠ 1 <sup>st</sup> choice ⚠ suitable |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                           |                                     |                                                                          |           |  |  |
| Dimensions                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | ISO                                                       |                                     | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                 |  | P                                                         | 55<br>160                           | 55<br>160                                                                |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | M                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | K                                                         | 60<br>140                           | 60<br>140                                                                |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | N                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | S                                                         |                                     |                                                                          |           |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                         |                                     |                                                                          |           |  |  |

| Designation |                                                                                                                  | DC         | DC toll. | SIG  | PL   | LF   | Stock |     |
|-------------|------------------------------------------------------------------------------------------------------------------|------------|----------|------|------|------|-------|-----|
| GENERAL     | GP 1400 <b>P</b> <b>K</b><br>   | 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 <b>P</b> <b>K</b><br> | 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



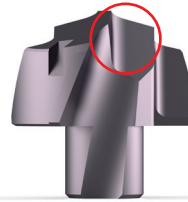
Big size chisel allows high feedrate machining and best centering features.

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<sup>st</sup> choice ○ suitable

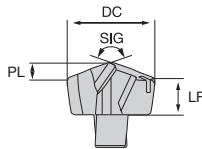
General machining, medium cut ● 1<sup>st</sup> choice ○ suitable

Unstable machining, heavy cut ⚙ 1<sup>st</sup> choice ⚙ suitable

### Dimensions

### ISO

### Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> 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 <sup>oo</sup> <b>P</b> <b>K</b> | 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 <sup>oo</sup> <b>P</b> <b>K</b> | 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



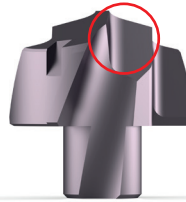
Big size chisel allows high feedrate machining and best centering features.

### GP - Outer corner

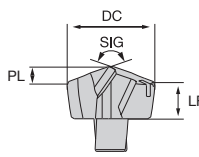


Small chamfer for very good edge protection in general machining.

### GP - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition |                                     | HF<br>PVD | HF<br>PVD |                                                                          |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------|-------------------------------------|-----------|-----------|--------------------------------------------------------------------------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                           |                                     | JP5625    | JP5725    |                                                                          |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut                               | ● 1 <sup>st</sup> choice ○ suitable | ○         | ○         |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut                             | ● 1 <sup>st</sup> choice ○ suitable | ●         | ●         |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut                             | ⚙ 1 <sup>st</sup> choice ⚙ suitable |           |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Dimensions                                                |                                     | ISO       |           | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |
|                                                                                                                                                                                                                                                                                                                                                                                 |  | P                                                         | 55<br>160                           | 55<br>160 |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | M                                                         |                                     |           |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | K                                                         | 60<br>140                           | 60<br>140 |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | N                                                         |                                     |           |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | S                                                         |                                     |           |           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                         |                                     |           |           |                                                                          |  |

| Designation |                                                                                               | DC         | DC toll. | SIG | PL   | LF   | Stock |     |
|-------------|-----------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|-----|
| GENERAL     | GP 18∞<br>   | 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∞<br> | 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



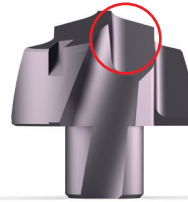
Big size chisel allows high feedrate machining and best centering features.

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

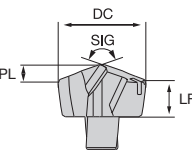
F - ACCESSORIES

G - SPARE PARTS

# Heads

## DEX drill

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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<br>PVD: Physical vapour deposition                         |                                     | HF<br>PVD                                                                      | HF<br>PVD     |           |
|                                                                                   |                                     | <b>JP5625</b>                                                                  | <b>JP5725</b> |           |
| Stable machining,<br>light cut                                                    | ● 1 <sup>st</sup> choice ○ suitable | ○                                                                              | ○             |           |
| General machining,<br>medium cut                                                  | ● 1 <sup>st</sup> choice ○ suitable | ●                                                                              | ●             |           |
| Unstable machining,<br>heavy cut                                                  | ● 1 <sup>st</sup> choice ○ suitable |                                                                                |               |           |
| <b>Dimensions</b>                                                                 |                                     | <b>ISO</b>                                                                     |               |           |
|  |                                     | <b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b> |               |           |
|                                                                                   |                                     | <b>P</b>                                                                       | 55<br>160     | 55<br>160 |
|                                                                                   |                                     | <b>M</b>                                                                       |               |           |
|                                                                                   |                                     | <b>K</b>                                                                       | 60<br>140     | 60<br>140 |
|                                                                                   |                                     | <b>N</b>                                                                       |               |           |
|                                                                                   |                                     | <b>S</b>                                                                       |               |           |
|                                                                                   |                                     | <b>H</b>                                                                       |               |           |

| Designation |                                                                                     | DC         | DC toll. | SIG | PL   | LF   | Stock |     |
|-------------|-------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|-----|
| GENERAL     | GP 20 <sup>oo</sup> <b>P K</b>                                                      | 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 <sup>oo</sup> <b>P K</b>                                                      | DEX2100-GP | 21       | k6  | 140° | 3.82 | 8.28  | ●   |
|             |  | DEX2150-GP | 21.5     | k6  | 140° | 3.91 | 8.19  | ●   |
| GENERAL     | GP 22 <sup>oo</sup> <b>P K</b>                                                      | DEX2200-GP | 22       | k6  | 140° | 4    | 8.7   | ●   |
|             |  | DEX2250-GP | 22.5     | k6  | 140° | 4.09 | 8.61  | ●   |
| GENERAL     | GP 23 <sup>oo</sup> <b>P K</b>                                                      | 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



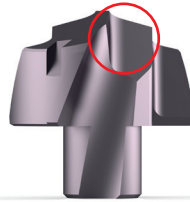
Big size chisel allows high feedrate machining and best centering features.

GP - Outer corner

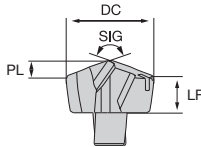


Small chamfer for very good edge protection in general machining.

GP - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |           | HF: Micrograin carbide<br>PVD: Physical vapour deposition                         |  | HF<br>PVD                           | HF<br>PVD |                                                                          |  |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|-----------------------------------------------------------------------------------|--|-------------------------------------|-----------|--------------------------------------------------------------------------|--|--|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |           |                                                                                   |  | JP5625                              | JP5725    |                                                                          |  |  |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |           | Stable machining, light cut                                                       |  | ● 1 <sup>st</sup> choice ○ suitable | ○         | ○                                                                        |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | General machining, medium cut                                                     |  | ● 1 <sup>st</sup> choice ○ suitable | ●         | ●                                                                        |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Unstable machining, heavy cut                                                     |  | ⚡ 1 <sup>st</sup> choice ⚡ suitable |           |                                                                          |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Dimensions                                                                        |  | ISO                                 |           | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |  |  | <b>P</b>                            | 55<br>160 | 55<br>160                                                                |  |  |  |
| <b>M</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |  |                                     |           |                                                                          |  |  |  |
| <b>K</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 60<br>140 |                                                                                   |  | 60<br>140                           |           |                                                                          |  |  |  |
| <b>N</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |  |                                     |           |                                                                          |  |  |  |
| <b>S</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |  |                                     |           |                                                                          |  |  |  |
| <b>H</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |  |                                     |           |                                                                          |  |  |  |

| Designation |                                                                                                                       | DC         | DC toll. | SIG | PL   | LF   | Stock |   |   |  |  |
|-------------|-----------------------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|---|--|--|
| GENERAL     | GP 24 <sup>oo</sup> <b>P K</b><br>   | DEX2400-GP | 24       | k6  | 140° | 4.36 | 9.54  | ● | ▲ |  |  |
|             |                                                                                                                       | DEX2450-GP | 24.5     | k6  | 140° | 4.46 | 9.44  |   | ● |  |  |
| GENERAL     | GP 25 <sup>oo</sup> <b>P K</b><br> | 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



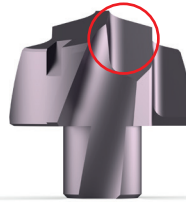
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# Heads

## 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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- 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 ● 1<sup>st</sup> choice ○ suitable

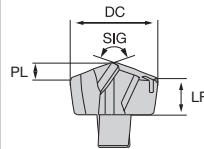
General machining, medium cut ● 1<sup>st</sup> choice ○ suitable

Unstable machining, heavy cut ▲ 1<sup>st</sup> choice ○ suitable

### Dimensions

ISO

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



P

55

160

M

30

80

K

N

S

H

### Designation

DC

DC toll.

SIG

PL

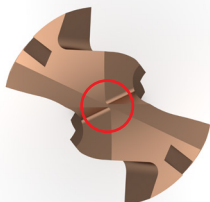
LF

Stock

| LOW FORCE                                                                         | SC 10∞ P M | DESIGNATION | DC   | DC toll. | SIG  | PL   | LF   | Stock |
|-----------------------------------------------------------------------------------|------------|-------------|------|----------|------|------|------|-------|
|                                                                                   |            |             | 10   | k6       | 140° | 1.78 | 4.42 | ●     |
|  |            | DEX1000-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 | ○     |

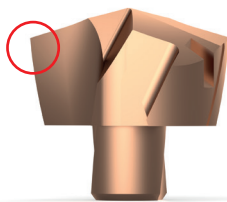
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

### SC - Chisel edge



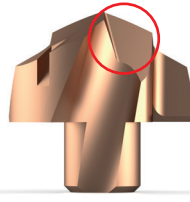
Small size chisel allows perfect balancing between centering performance and torque level.

### SC - Outer corner

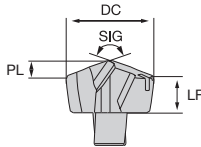


Sharp edge for better cutting action and no burr formation on sticky materials.

### SC - Gash geometry



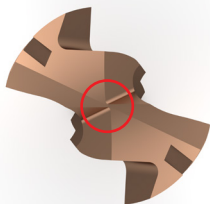
Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |           | HF: Micrograin carbide<br>PVD: Physical vapour deposition                         |                                                                          | HF<br>PVD |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------|-----------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |           |                                                                                   |                                                                          | JP5630    |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |           | Stable machining, light cut                                                       | ● 1 <sup>st</sup> choice ○ suitable                                      |           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | General machining, medium cut                                                     | ● 1 <sup>st</sup> choice ○ suitable                                      | ●         |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Unstable machining, heavy cut                                                     | ● 1 <sup>st</sup> choice ○ suitable                                      | ○         |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Dimensions                                                                        |                                                                          | ISO       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |  | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |           |  |
| P                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 55<br>160 |                                                                                   |                                                                          |           |  |
| M                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 30<br>80  |                                                                                   |                                                                          |           |  |
| K                                                                                                                                                                                                                                                                                                                                                                                                                                                                |           |                                                                                   |                                                                          |           |  |
| N                                                                                                                                                                                                                                                                                                                                                                                                                                                                |           |                                                                                   |                                                                          |           |  |
| S                                                                                                                                                                                                                                                                                                                                                                                                                                                                |           |                                                                                   |                                                                          |           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | H                                                                                 |                                                                          |           |  |

| Designation |                                                                                                          | DC         | DC toll. | SIG | PL   | LF   | Stock |   |  |
|-------------|----------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|--|
| LOW FORCE   | SC 12∞ <b>P M</b><br>   | 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∞ <b>P M</b><br> | 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  | ● |  |

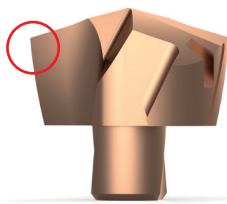
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



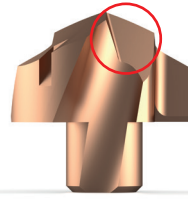
Small size chisel allows perfect balancing between centering performance and torque level.

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.

# 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

● 1<sup>st</sup> choice ○ suitable

General machining,  
medium cut

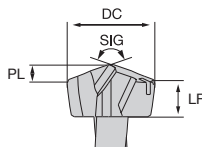
● 1<sup>st</sup> choice ○ suitable

Unstable machining,  
heavy cut

● 1<sup>st</sup> choice ○ suitable

### Dimensions

### ISO

Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> 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°

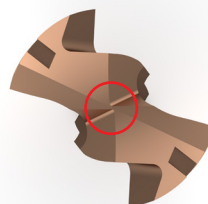
2.89

5.81

○

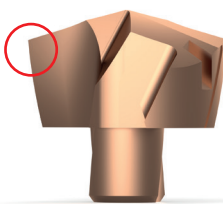
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

### SC - Chisel edge



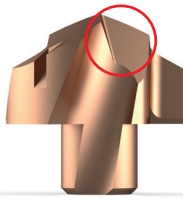
Small size chisel allows perfect balancing between centering performance and torque level.

### SC - Outer corner



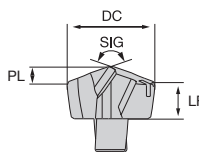
Sharp edge for better cutting action and no burr formation on sticky materials.

### SC - Gash geometry



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

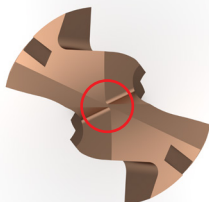


| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition |                                     | HF<br>PVD                                                                |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------|-------------------------------------|--------------------------------------------------------------------------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                           |                                     | JP5630                                                                   |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut                               | ● 1 <sup>st</sup> choice ○ suitable |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut                             | ● 1 <sup>st</sup> choice ○ suitable | ●                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut                             | ⚙ 1 <sup>st</sup> choice ⚙ suitable | ⚙                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                           |                                     |                                                                          |  |
| Dimensions                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | ISO                                                       |                                     | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |
|                                                                                                                                                                                                                                                                                                                                                                                 |  | P                                                         | 55<br>160                           |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | M                                                         | 30<br>80                            |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | K                                                         |                                     |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | N                                                         |                                     |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | S                                                         |                                     |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                         |                                     |                                                                          |  |

| Designation |                                                                                                          | DC         | DC toll. | SIG | PL   | LF   | Stock |   |  |
|-------------|----------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|--|
| LOW FORCE   | SC 16∞ <b>P M</b><br>   | 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∞ <b>P M</b><br> | 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  | ○ |  |

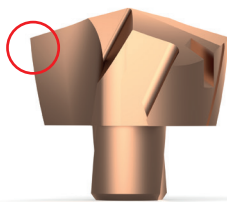
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

SC - Chisel edge



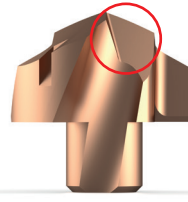
Small size chisel allows perfect balancing between centering performance and torque level.

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
- 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 ● 1<sup>st</sup> choice ○ suitable

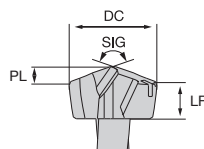
General machining, medium cut ● 1<sup>st</sup> choice ○ suitable

Unstable machining, heavy cut ⚙ 1<sup>st</sup> choice ⚙ suitable

### Dimensions

### ISO

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



**P**

55  
160

**M**

30  
80

**K**

**N**

**S**

**H**

### Designation

### DC

### DC toll.

### SIG

### PL

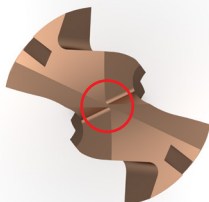
### LF

### Stock

|           |                    |            |      |    |      |      |      |   |
|-----------|--------------------|------------|------|----|------|------|------|---|
| LOW FORCE | SC 1800 <b>P M</b> | 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 <b>P M</b> | 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 | ● |

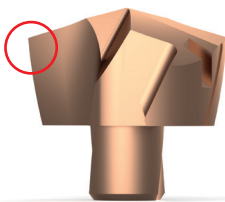
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

### SC - Chisel edge



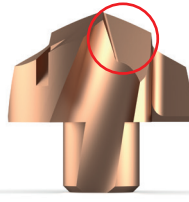
Small size chisel allows perfect balancing between centering performance and torque level.

### SC - Outer corner

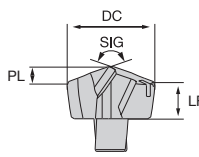


Sharp edge for better cutting action and no burr formation on sticky materials.

### SC - Gash geometry



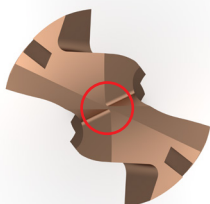
Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition                         |  | HF<br>PVD                           |   |                                                                          |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------|--|-------------------------------------|---|--------------------------------------------------------------------------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                   |  | JP5630                              |   |                                                                          |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut                                                       |  | ● 1 <sup>st</sup> choice ○ suitable |   |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut                                                     |  | ● 1 <sup>st</sup> choice ○ suitable | ● |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut                                                     |  | ● 1 <sup>st</sup> choice ○ suitable | ○ |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Dimensions                                                                        |  | ISO                                 |   | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |  | <b>P</b>                            |   | 55<br>160                                                                |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                                   |  | <b>M</b>                            |   | 30<br>80                                                                 |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                                   |  | <b>K</b>                            |   |                                                                          |  |
| <b>N</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                   |  |                                     |   |                                                                          |  |
| <b>S</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                   |  |                                     |   |                                                                          |  |
| <b>H</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                   |  |                                     |   |                                                                          |  |

| Designation |                                                                                                          | DC         | DC toll. | SIG | PL   | LF   | Stock |   |  |
|-------------|----------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|--|
| LOW FORCE   | SC 20∞ <b>P M</b><br>   | 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∞ <b>P M</b><br> | DEX2100-SC | 21       | k6  | 140° | 3.82 | 8.28  | ● |  |
|             |                                                                                                          | DEX2150-SC | 21.5     | k6  | 140° | 3.91 | 8.19  | ● |  |
| LOW FORCE   | SC 22∞ <b>P M</b><br> | 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∞ <b>P M</b><br> | DEX2300-SC | 23       | k6  | 140° | 4.18 | 9.12  | ● |  |
|             |                                                                                                          | DEX2350-SC | 23.5     | k6  | 140° | 4.28 | 9.02  | ● |  |

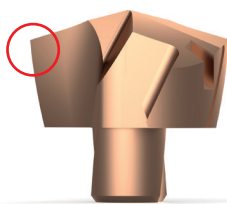
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▼ stock exhaustion

SC - Chisel edge



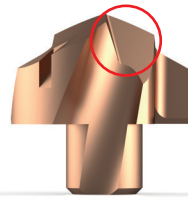
Small size chisel allows perfect balancing between centering performance and torque level.

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

## 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

● 1<sup>st</sup> choice ○ suitable

General machining,  
medium cut

● 1<sup>st</sup> choice ○ suitable

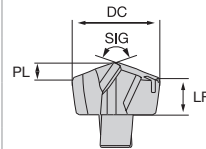
Unstable machining,  
heavy cut

● 1<sup>st</sup> choice ○ suitable

### Dimensions

### ISO

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


**P** 55  
160  
**M** 30  
80  
**K**  
**N**  
**S**  
**H**

### Designation

### DC

### DC toll.

### SIG

### PL

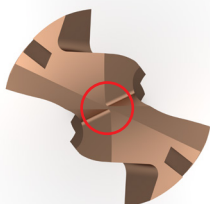
### LF

### Stock

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

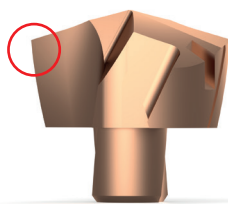
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

### SC - Chisel edge



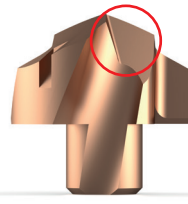
Small size chisel allows perfect balancing between centering performance and torque level.

### SC - Outer corner

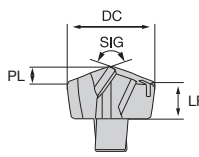


Sharp edge for better cutting action and no burr formation on sticky materials.

### SC - Gash geometry



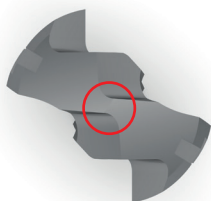
Flutes and gash design ensure fast chip evacuation and low cutting force on difficult to cut materials.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition                         |  | HF<br>PVD |  |                                                                          |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------|--|-----------|--|--------------------------------------------------------------------------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                   |  | JP7625    |  |                                                                          |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut ● 1 <sup>st</sup> choice ○ suitable                   |  |           |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut ● 1 <sup>st</sup> choice ○ suitable                 |  | ●         |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut ⚙ 1 <sup>st</sup> choice ⚙ suitable                 |  | ⚙         |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Dimensions                                                                        |  | ISO       |  | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |  | P         |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                                   |  | M         |  |                                                                          |  |
| K                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                   |  | 70<br>160 |  |                                                                          |  |
| N                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                   |  |           |  |                                                                          |  |
| S                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                   |  |           |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                                                 |  |           |  |                                                                          |  |

| Designation |                                                                                                                    | DC         | DC toll. | SIG | PL   | LF   | Stock |   |  |
|-------------|--------------------------------------------------------------------------------------------------------------------|------------|----------|-----|------|------|-------|---|--|
| REINFORCED  | TE 10 <sup>∞</sup> <b>K</b><br>   | 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 <sup>∞</sup> <b>K</b><br>  | DEX1100-TE | 11       | k6  | 140° | 1.98 | 4.62  | ● |  |
|             |                                                                                                                    | DEX1150-TE | 11.5     | k6  | 140° | 2.08 | 4.52  | ● |  |
| REINFORCED  | TE 12 <sup>∞</sup> <b>K</b><br> | DEX1200-TE | 12       | k6  | 140° | 2.18 | 4.82  | ● |  |
|             |                                                                                                                    | DEX1250-TE | 12.5     | k6  | 140° | 2.27 | 4.73  | ● |  |
| REINFORCED  | TE 13 <sup>∞</sup> <b>K</b><br> | DEX1300-TE | 13       | k6  | 140° | 2.37 | 5.23  | ● |  |
|             |                                                                                                                    | DEX1350-TE | 13.5     | k6  | 140° | 2.46 | 5.14  | ● |  |
| REINFORCED  | TE 14 <sup>∞</sup> <b>K</b><br> | 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



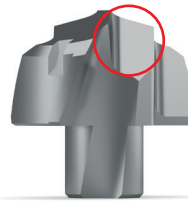
Big size chisel allows high feedrate machining and best centering features.

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

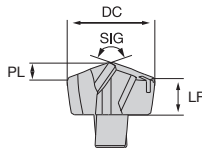
HF  
PVD

**JP7625**

- Stable machining, light cut ● 1<sup>st</sup> choice ○ suitable
- General machining, medium cut ● 1<sup>st</sup> choice ○ suitable
- Unstable machining, heavy cut ⚙ 1<sup>st</sup> choice ⚙ suitable

### Dimensions

ISO

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

**P**  
**M**  
**K**  
**N**  
**S**  
**H**

70  
160

### Designation

DC

DC toll.

SIG

PL

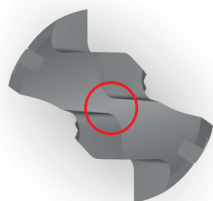
LF

Stock

| REINFORCED | TE 1500 <b>K</b>                                                                    | 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 <b>K</b>                                                                    | DEX1600-TE | 16   | k6 | 140° | 2.91 | 5.89 | ● |
|            |   | DEX1650-TE | 16.5 | k6 | 140° | 3    | 5.8  | ● |
| REINFORCED | TE 1700 <b>K</b>                                                                    | DEX1700-TE | 17   | k6 | 140° | 3.09 | 6.81 | ● |
|            |  | DEX1750-TE | 17.5 | k6 | 140° | 3.18 | 6.72 | ● |
| REINFORCED | TE 1800 <b>K</b>                                                                    | DEX1800-TE | 18   | k6 | 140° | 3.28 | 7.22 | ● |
|            |  | DEX1850-TE | 18.5 | k6 | 140° | 3.37 | 7.13 | ● |
| REINFORCED | TE 1900 <b>K</b>                                                                    | 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



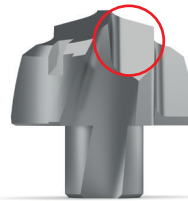
Big size chisel allows high feedrate machining and best centering features.

### TE - Outer corner



Big negative chamfer for higher performance on cast iron machining.

### TE - Gash geometry

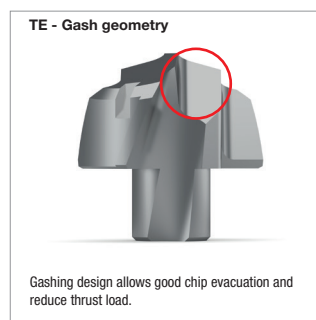
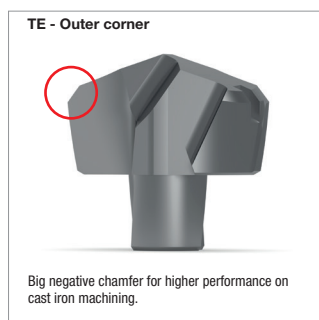
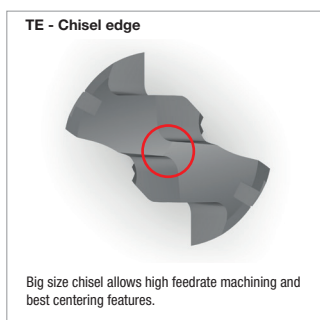


Gashing design allows good chip evacuation and reduce thrust load.

| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | HF: Micrograin carbide<br>PVD: Physical vapour deposition         |  | HF<br>PVD |  |                                                                          |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------|--|-----------|--|--------------------------------------------------------------------------|--|
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                   |  | JP7625    |  |                                                                          |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |  | Stable machining, light cut ● 1 <sup>st</sup> choice ○ suitable   |  |           |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | General machining, medium cut ● 1 <sup>st</sup> choice ○ suitable |  | ●         |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Unstable machining, heavy cut ⚙ 1 <sup>st</sup> choice ⚙ suitable |  | ⚙         |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Dimensions                                                        |  | ISO       |  | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                   |  | P         |  |                                                                          |  |
| M                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                   |  |           |  |                                                                          |  |
| K                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                   |  | 70<br>160 |  |                                                                          |  |
| N                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                   |  |           |  |                                                                          |  |
| S                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                   |  |           |  |                                                                          |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | H                                                                 |  |           |  |                                                                          |  |

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



# 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

● 1<sup>st</sup> choice ○ suitable

General machining,  
medium cut

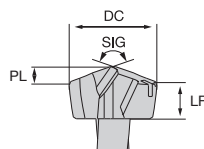
● 1<sup>st</sup> choice ○ suitable

Unstable machining,  
heavy cut

● 1<sup>st</sup> choice ○ suitable

### Dimensions

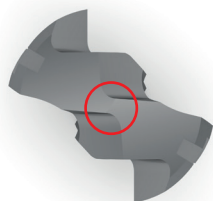
ISO

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

**P**  
**M**  
**K** 70  
160  
**N**  
**S**  
**H**

| Designation       |                   | DC   | DC toll. | SIG  | PL   | LF   | Stock |  |
|-------------------|-------------------|------|----------|------|------|------|-------|--|
| <b>REINFORCED</b> | <b>TE 2500 K</b>  |      |          |      |      |      |       |  |
|                   | <b>DEX2500-TE</b> | 25   | k6       | 140° | 4.55 | 9.95 | ●     |  |
|                   | <b>DEX2550-TE</b> | 25.5 | k6       | 140° | 4.64 | 9.86 | ●     |  |
|                   | <b>DEX2600-TE</b> | 26   | k6       | 140° | 4.73 | 9.86 | ●     |  |

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

### TE - Chisel edge



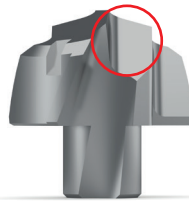
Big size chisel allows high feedrate machining and best centering features.

### TE - Outer corner



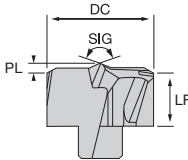
Big negative chamfer for higher performance on cast iron machining.

### TE - Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.



| Heads                                                                                                                                                                                                                                                                                                                                                                                                                                                            |           | HF: Micrograin carbide<br>PVD: Physical vapour deposition                         |                                     | HF        | HF        |                                                                          |  |  |  |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|-----------------------------------------------------------------------------------|-------------------------------------|-----------|-----------|--------------------------------------------------------------------------|--|--|--|--|--|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |                                                                                   |                                     | PVD       | PVD       |                                                                          |  |  |  |  |  |
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |           |                                                                                   |                                     | JP5625    | JP5725    |                                                                          |  |  |  |  |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |           | Stable machining, light cut                                                       | ● 1 <sup>st</sup> choice ○ suitable | ○         | ○         |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | General machining, medium cut                                                     | ● 1 <sup>st</sup> choice ○ suitable | ●         | ●         |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Unstable machining, heavy cut                                                     | ⚙ 1 <sup>st</sup> choice ⚙ suitable |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Dimensions                                                                        |                                     | ISO       |           | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |  |                                     | <b>P</b>  | 55<br>160 | 55<br>160                                                                |  |  |  |  |  |
| <b>M</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |                                     |           |           |                                                                          |  |  |  |  |  |
| <b>K</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 60<br>140 |                                                                                   |                                     | 60<br>140 |           |                                                                          |  |  |  |  |  |
| <b>N</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |                                     |           |           |                                                                          |  |  |  |  |  |
| <b>S</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                                                   |                                     |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | <b>H</b>                                                                          |                                     |           |           |                                                                          |  |  |  |  |  |

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

- 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 ● 1<sup>st</sup> choice ○ suitable

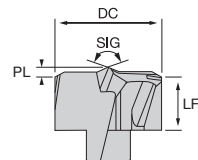
General machining, medium cut ● 1<sup>st</sup> choice ○ suitable

Unstable machining, heavy cut ⚙ 1<sup>st</sup> choice ⚙ suitable

### Dimensions

ISO

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



**P** 55  
160  
**M**  
**K** 60  
140  
**N**  
**S**  
**H**

55  
160  
60  
140  
60  
140

### Designation

DC

DC toll.

SIG

PL

LF

### Stock

| Designation |                                                                                                           | DC         | DC toll. | SIG  | PL   | LF   | Stock |     |   |
|-------------|-----------------------------------------------------------------------------------------------------------|------------|----------|------|------|------|-------|-----|---|
| FLAT TYPE   | FT 1500 <b>P K</b><br>   | DEX1500-FT | 15       | k6   | 140° | 2.73 | 5.97  |     | ○ |
|             | DEX1550-FT                                                                                                | 15.5       | k6       | 140° | 2.82 | 5.88 |       | ○   |   |
| FLAT TYPE   | FT 1600 <b>P K</b><br> | DEX1600-FT | 16       | k6   | 140° | 2.91 | 5.89  |     | ○ |
|             | DEX1650-FT                                                                                                | 16.5       | k6       | 140° | 3    | 5.8  |       | ○   |   |
| FLAT TYPE   | FT 1700 <b>P K</b><br> | DEX1700-FT | 17       | k6   | 140° | 3.09 | 6.81  |     | ○ |
|             | DEX1750-FT                                                                                                | 17.5       | k6       | 140° | 3.18 | 6.72 |       | ○   |   |
| FLAT TYPE   | FT 1800 <b>P K</b><br> | DEX1800-FT | 18       | k6   | 140° | 3.28 | 7.22  | ● ▲ |   |
|             | DEX1850-FT                                                                                                | 18.5       | k6       | 140° | 3.37 | 7.13 |       | ○   |   |
| FLAT TYPE   | FT 1900 <b>P K</b><br> | 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<br>PVD: Physical vapour deposition |                                  | HF        | HF        |                                                                          |  |  |  |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|-----------------------------------------------------------|----------------------------------|-----------|-----------|--------------------------------------------------------------------------|--|--|--|--|--|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |                                                           |                                  | PVD       | PVD       |                                                                          |  |  |  |  |  |
| DEX drill                                                                                                                                                                                                                                                                                                                                                                                                                                                        |           |                                                           |                                  | JP5625    | JP5725    |                                                                          |  |  |  |  |  |
| <ul style="list-style-type: none"><li>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</li><li>Can fit with 3xD or 5xD DEX drill bodies</li><li>Diameters out of catalogue can be made upon request</li><li>Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests</li></ul> |           | Stable machining, light cut                               | 1 <sup>st</sup> choice  suitable |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | General machining, medium cut                             | 1 <sup>st</sup> choice  suitable |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Unstable machining, heavy cut                             | 1 <sup>st</sup> choice  suitable |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | Dimensions                                                |                                  | ISO       |           | Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice) |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           |                                                           |                                  | <b>P</b>  | 55<br>160 | 55<br>160                                                                |  |  |  |  |  |
| <b>M</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                           |                                  |           |           |                                                                          |  |  |  |  |  |
| <b>K</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 60<br>140 |                                                           |                                  | 60<br>140 |           |                                                                          |  |  |  |  |  |
| <b>N</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                           |                                  |           |           |                                                                          |  |  |  |  |  |
| <b>S</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                         |           |                                                           |                                  |           |           |                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |           | <b>H</b>                                                  |                                  |           |           |                                                                          |  |  |  |  |  |

| Designation |                                    | DC         | DC toll. | SIG | PL   | LF   | Stock |  |  |  |
|-------------|------------------------------------|------------|----------|-----|------|------|-------|--|--|--|
| FLAT TYPE   | FT 20 <sup>oo</sup> <b>P K</b><br> | DEX2000-FT | 20       | k6  | 140° | 3.64 | 7.96  |  |  |  |
|             |                                    | DEX2050-FT | 20.5     | k6  | 140° | 3.73 | 7.87  |  |  |  |
| FLAT TYPE   | FT 21 <sup>oo</sup> <b>P K</b><br> | DEX2100-FT | 21       | k6  | 140° | 3.82 | 8.28  |  |  |  |
|             |                                    | DEX2150-FT | 21.5     | k6  | 140° | 3.91 | 8.19  |  |  |  |
| FLAT TYPE   | FT 22 <sup>oo</sup> <b>P K</b><br> | DEX2200-FT | 22       | k6  | 140° | 4    | 8.7   |  |  |  |
|             |                                    | DEX2250-FT | 22.5     | k6  | 140° | 4.09 | 8.61  |  |  |  |
| FLAT TYPE   | FT 23 <sup>oo</sup> <b>P K</b><br> | DEX2300-FT | 23       | k6  | 140° | 4.18 | 9.12  |  |  |  |
|             |                                    | DEX2350-FT | 23.5     | k6  | 140° | 4.28 | 9.02  |  |  |  |
| FLAT TYPE   | FT 24 <sup>oo</sup> <b>P K</b><br> | 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
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HF: Micrograin carbide  
PVD: Physical vapour deposition

HF  
PVD

HF  
PVD

**JP5625**
**JP5725**

Stable machining,  
light cut

● 1<sup>st</sup> choice ○ suitable

General machining,  
medium cut

● 1<sup>st</sup> choice ○ suitable

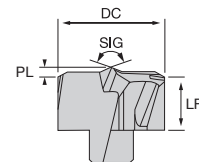
Unstable machining,  
heavy cut

● 1<sup>st</sup> choice ○ suitable

### Dimensions

### ISO

### Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> 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

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<br>HB | L/D       | JP5630 |       |     | JP5725 |       |     |  |
|---------|---------------------------------------------------------------------------------------|----------------|-----------|--------|-------|-----|--------|-------|-----|--|
|         |                                                                                       |                |           | min    | start | max | min    | start | max |  |
| P1 - P2 | Free cutting steel and low carbon<br>(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<br>(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<br>(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<br>HB | L/D       | JP5630 |       |     |        |       |     |  |
|         |                                                                                       |                |           | min    | start | max |        |       |     |  |
| P7      | Ferritic and martensitic stainless steel<br>(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<br>(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<br>(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<br>(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<br>HB | L/D       | JP5725 |       |     | JP7625 |       |     |  |
|         |                                                                                       |                |           | min    | start | max | min    | start | max |  |
| K1      | Grey cast iron<br>(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<br>(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<br>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   | <b>P1 - P2</b> | Free cutting steel and low carbon<br>(ex. 1.0715/9 smn 28/avp, 1.0503/c45)            | ≤ 200          | 3xD - 5xD | 0.10             | <b>0.16</b> | 0.22 | 0.10             | <b>0.17</b> | 0.24 | 0.12             | <b>0.19</b> | 0.26 |
|               |                |                                                                                       |                | 8xD       | 0.08             | <b>0.13</b> | 0.18 | 0.08             | <b>0.14</b> | 0.20 | 0.10             | <b>0.15</b> | 0.20 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.08             | <b>0.13</b> | 0.18 |
|               | <b>P3 - P4</b> | Medium and high alloy steel<br>(ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)                | 200 ÷ 300      | 3xD - 5xD | 0.12             | <b>0.19</b> | 0.26 | 0.12             | <b>0.20</b> | 0.28 | 0.14             | <b>0.22</b> | 0.30 |
|               |                |                                                                                       |                | 8xD       | 0.10             | <b>0.15</b> | 0.20 | 0.10             | <b>0.16</b> | 0.22 | 0.11             | <b>0.17</b> | 0.23 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.10             | <b>0.15</b> | 0.20 |
| B - THREADING | <b>P5 - P6</b> | High tensile strength and tool steel<br>(ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®) | 300 ÷ 400      | 3xD - 5xD | 0.12             | <b>0.18</b> | 0.24 | 0.12             | <b>0.19</b> | 0.26 | 0.14             | <b>0.21</b> | 0.28 |
|               |                |                                                                                       |                | 8xD       | 0.10             | <b>0.14</b> | 0.18 | 0.10             | <b>0.15</b> | 0.20 | 0.11             | <b>0.16</b> | 0.21 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.10             | <b>0.14</b> | 0.18 |
|               | <b>P7</b>      | Ferritic and martensitic stainless steel<br>(ex. 1.4021/X 20 Cr 13/AISI420)           | ≤ 200          | 3xD - 5xD | 0.11             | <b>0.15</b> | 0.19 | 0.11             | <b>0.16</b> | 0.21 | 0.13             | <b>0.18</b> | 0.23 |
|               |                |                                                                                       |                | 8xD       | 0.09             | <b>0.14</b> | 0.15 | 0.09             | <b>0.13</b> | 0.17 | 0.11             | <b>0.15</b> | 0.19 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.09             | <b>0.12</b> | 0.15 |
| C - GROOVING  | <b>P8</b>      | Precipitation hardening stainless steel<br>(ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)     | ≤ 450          | 3xD - 5xD | 0.09             | <b>0.14</b> | 0.19 | 0.09             | <b>0.15</b> | 0.21 | 0.11             | <b>0.16</b> | 0.21 |
|               |                |                                                                                       |                | 8xD       | 0.07             | <b>0.11</b> | 0.15 | 0.07             | <b>0.12</b> | 0.17 | 0.09             | <b>0.13</b> | 0.17 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.08             | <b>0.11</b> | 0.14 |
|               | <b>M1</b>      | Austenitic stainless steel<br>(ex. 1.4305/X 10 CrNiS 18 9/AISI303)                    | > 200          | 3xD - 5xD | 0.10             | <b>0.14</b> | 0.18 | 0.10             | <b>0.15</b> | 0.20 | 0.12             | <b>0.16</b> | 0.20 |
|               |                |                                                                                       |                | 8xD       | 0.08             | <b>0.11</b> | 0.14 | 0.08             | <b>0.12</b> | 0.16 | 0.10             | <b>0.13</b> | 0.16 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.08             | <b>0.11</b> | 0.14 |
|               | <b>M2 - M3</b> | Austenitic and Duplex stainless steel<br>(ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)      |                | 3xD - 5xD | 0.10             | <b>0.13</b> | 0.16 | 0.10             | <b>0.14</b> | 0.18 | 0.12             | <b>0.15</b> | 0.18 |
|               |                |                                                                                       |                | 8xD       | 0.08             | <b>0.10</b> | 0.12 | 0.08             | <b>0.11</b> | 0.14 | 0.10             | <b>0.12</b> | 0.14 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.08             | <b>0.10</b> | 0.12 |
| D - MILLING   | <b>K1</b>      | Grey cast iron<br>(ex. 0.6025/GG 25/EN-GJL-250)                                       | 150 ÷ 250      | 3xD - 5xD | 0.14             | <b>0.22</b> | 0.30 | 0.14             | <b>0.24</b> | 0.34 | 0.16             | <b>0.26</b> | 0.36 |
|               |                |                                                                                       |                | 8xD       | 0.11             | <b>0.18</b> | 0.25 | 0.11             | <b>0.19</b> | 0.27 | 0.12             | <b>0.20</b> | 0.28 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.11             | <b>0.18</b> | 0.25 |
|               | <b>K2</b>      | Nodular cast iron<br>(ex. 0.7050/GGG 50/EN-GJS-500-7)                                 | 150 ÷ 350      | 3xD - 5xD | 0.12             | <b>0.18</b> | 0.24 | 0.12             | <b>0.20</b> | 0.28 | 0.13             | <b>0.21</b> | 0.29 |
|               |                |                                                                                       |                | 8xD       | 0.10             | <b>0.15</b> | 0.20 | 0.10             | <b>0.16</b> | 0.22 | 0.11             | <b>0.17</b> | 0.23 |
|               |                |                                                                                       |                | 12xD      | -                | -           | -    | -                | -           | -    | 0.09             | <b>0.14</b> | 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             | <b>0.20</b> | 0.28 | 0.16             | <b>0.23</b> | 0.30 | 0.16             | <b>0.25</b> | 0.34 | 0.16             | <b>0.29</b> | 0.42 | 0.20             | <b>0.32</b> | 0.44 | 0.20             | <b>0.34</b> | 0.48 |
| 0.10             | <b>0.16</b> | 0.22 | 0.12             | <b>0.18</b> | 0.24 | 0.12             | <b>0.20</b> | 0.28 | 0.12             | <b>0.23</b> | 0.34 | 0.16             | <b>0.26</b> | 0.36 | 0.16             | <b>0.27</b> | 0.38 |
| 0.08             | <b>0.14</b> | 0.20 | 0.11             | <b>0.16</b> | 0.21 | 0.11             | <b>0.17</b> | 0.23 | 0.11             | <b>0.20</b> | 0.29 | 0.14             | <b>0.22</b> | 0.30 | 0.14             | <b>0.24</b> | 0.34 |
| 0.14             | <b>0.23</b> | 0.32 | 0.18             | <b>0.26</b> | 0.34 | 0.18             | <b>0.29</b> | 0.40 | 0.18             | <b>0.33</b> | 0.48 | 0.24             | <b>0.37</b> | 0.50 | 0.24             | <b>0.40</b> | 0.56 |
| 0.11             | <b>0.18</b> | 0.25 | 0.14             | <b>0.20</b> | 0.26 | 0.14             | <b>0.23</b> | 0.32 | 0.14             | <b>0.26</b> | 0.38 | 0.20             | <b>0.30</b> | 0.40 | 0.20             | <b>0.32</b> | 0.44 |
| 0.10             | <b>0.16</b> | 0.22 | 0.13             | <b>0.18</b> | 0.23 | 0.13             | <b>0.20</b> | 0.27 | 0.13             | <b>0.23</b> | 0.33 | 0.17             | <b>0.26</b> | 0.35 | 0.17             | <b>0.28</b> | 0.39 |
| 0.14             | <b>0.22</b> | 0.30 | 0.18             | <b>0.25</b> | 0.32 | 0.18             | <b>0.28</b> | 0.38 | 0.18             | <b>0.32</b> | 0.46 | 0.24             | <b>0.36</b> | 0.48 | 0.24             | <b>0.38</b> | 0.52 |
| 0.11             | <b>0.17</b> | 0.23 | 0.14             | <b>0.20</b> | 0.26 | 0.14             | <b>0.22</b> | 0.30 | 0.14             | <b>0.25</b> | 0.36 | 0.20             | <b>0.29</b> | 0.38 | 0.20             | <b>0.31</b> | 0.42 |
| 0.10             | <b>0.15</b> | 0.20 | 0.13             | <b>0.17</b> | 0.21 | 0.13             | <b>0.20</b> | 0.27 | 0.13             | <b>0.23</b> | 0.33 | 0.17             | <b>0.25</b> | 0.33 | 0.17             | <b>0.27</b> | 0.37 |
| 0.13             | <b>0.19</b> | 0.25 | 0.17             | <b>0.22</b> | 0.27 | 0.17             | <b>0.24</b> | 0.31 | 0.17             | <b>0.27</b> | 0.37 | 0.22             | <b>0.31</b> | 0.40 | 0.22             | <b>0.32</b> | 0.42 |
| 0.11             | <b>0.16</b> | 0.21 | 0.14             | <b>0.18</b> | 0.22 | 0.14             | <b>0.19</b> | 0.24 | 0.14             | <b>0.22</b> | 0.30 | 0.18             | <b>0.25</b> | 0.32 | 0.18             | <b>0.26</b> | 0.34 |
| 0.09             | <b>0.13</b> | 0.17 | 0.12             | <b>0.15</b> | 0.18 | 0.12             | <b>0.17</b> | 0.22 | 0.12             | <b>0.19</b> | 0.26 | 0.15             | <b>0.21</b> | 0.27 | 0.15             | <b>0.22</b> | 0.29 |
| 0.11             | <b>0.17</b> | 0.23 | 0.15             | <b>0.20</b> | 0.25 | 0.15             | <b>0.22</b> | 0.29 | 0.15             | <b>0.25</b> | 0.35 | 0.19             | <b>0.28</b> | 0.37 | 0.19             | <b>0.29</b> | 0.39 |
| 0.09             | <b>0.14</b> | 0.19 | 0.11             | <b>0.16</b> | 0.21 | 0.12             | <b>0.17</b> | 0.22 | 0.12             | <b>0.20</b> | 0.28 | 0.15             | <b>0.22</b> | 0.29 | 0.15             | <b>0.23</b> | 0.31 |
| 0.08             | <b>0.12</b> | 0.16 | 0.09             | <b>0.13</b> | 0.17 | 0.10             | <b>0.15</b> | 0.20 | 0.10             | <b>0.17</b> | 0.24 | 0.13             | <b>0.19</b> | 0.25 | 0.13             | <b>0.20</b> | 0.27 |
| 0.12             | <b>0.17</b> | 0.22 | 0.16             | <b>0.20</b> | 0.24 | 0.16             | <b>0.22</b> | 0.28 | 0.16             | <b>0.25</b> | 0.34 | 0.20             | <b>0.28</b> | 0.36 | 0.20             | <b>0.29</b> | 0.38 |
| 0.10             | <b>0.14</b> | 0.18 | 0.12             | <b>0.16</b> | 0.20 | 0.12             | <b>0.17</b> | 0.22 | 0.12             | <b>0.19</b> | 0.26 | 0.16             | <b>0.22</b> | 0.28 | 0.16             | <b>0.23</b> | 0.30 |
| 0.08             | <b>0.12</b> | 0.16 | 0.11             | <b>0.14</b> | 0.17 | 0.11             | <b>0.15</b> | 0.19 | 0.11             | <b>0.17</b> | 0.23 | 0.14             | <b>0.20</b> | 0.26 | 0.14             | <b>0.21</b> | 0.28 |
| 0.12             | <b>0.16</b> | 0.20 | 0.16             | <b>0.19</b> | 0.22 | 0.16             | <b>0.20</b> | 0.24 | 0.16             | <b>0.23</b> | 0.30 | 0.20             | <b>0.26</b> | 0.32 | 0.20             | <b>0.27</b> | 0.34 |
| 0.10             | <b>0.13</b> | 0.16 | 0.12             | <b>0.15</b> | 0.18 | 0.12             | <b>0.16</b> | 0.20 | 0.12             | <b>0.18</b> | 0.24 | 0.16             | <b>0.21</b> | 0.26 | 0.16             | <b>0.22</b> | 0.28 |
| 0.08             | <b>0.11</b> | 0.14 | 0.11             | <b>0.13</b> | 0.15 | 0.11             | <b>0.14</b> | 0.17 | 0.11             | <b>0.16</b> | 0.21 | 0.14             | <b>0.18</b> | 0.22 | 0.14             | <b>0.19</b> | 0.24 |
| 0.16             | <b>0.28</b> | 0.40 | 0.22             | <b>0.32</b> | 0.42 | 0.22             | <b>0.35</b> | 0.48 | 0.22             | <b>0.40</b> | 0.58 | 0.28             | <b>0.45</b> | 0.62 | 0.28             | <b>0.48</b> | 0.68 |
| 0.12             | <b>0.22</b> | 0.32 | 0.18             | <b>0.26</b> | 0.34 | 0.18             | <b>0.28</b> | 0.38 | 0.18             | <b>0.32</b> | 0.46 | 0.22             | <b>0.36</b> | 0.50 | 0.22             | <b>0.38</b> | 0.54 |
| 0.11             | <b>0.19</b> | 0.27 | 0.15             | <b>0.22</b> | 0.29 | 0.15             | <b>0.25</b> | 0.35 | 0.15             | <b>0.27</b> | 0.39 | 0.20             | <b>0.32</b> | 0.44 | 0.20             | <b>0.34</b> | 0.48 |
| 0.13             | <b>0.22</b> | 0.31 | 0.18             | <b>0.26</b> | 0.34 | 0.18             | <b>0.28</b> | 0.38 | 0.18             | <b>0.32</b> | 0.46 | 0.22             | <b>0.36</b> | 0.50 | 0.22             | <b>0.38</b> | 0.54 |
| 0.11             | <b>0.18</b> | 0.25 | 0.14             | <b>0.20</b> | 0.26 | 0.14             | <b>0.22</b> | 0.30 | 0.14             | <b>0.25</b> | 0.36 | 0.18             | <b>0.27</b> | 0.40 | 0.18             | <b>0.30</b> | 0.42 |
| 0.09             | <b>0.15</b> | 0.21 | 0.13             | <b>0.18</b> | 0.23 | 0.13             | <b>0.20</b> | 0.27 | 0.13             | <b>0.23</b> | 0.33 | 0.15             | <b>0.25</b> | 0.35 | 0.15             | <b>0.26</b> | 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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