

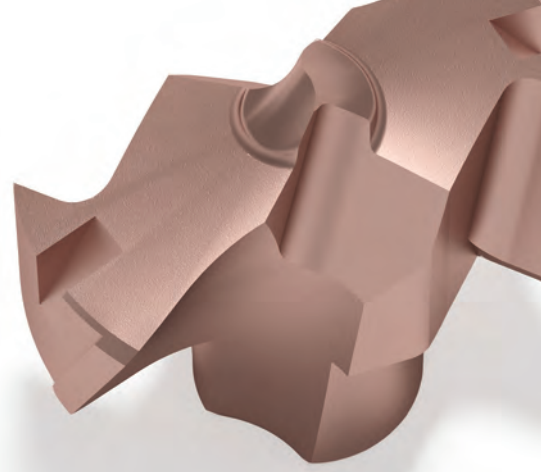
DEXDRILL 



DEXDRILL

High performance drilling system with interchangeable heads

nikkoTOOLS



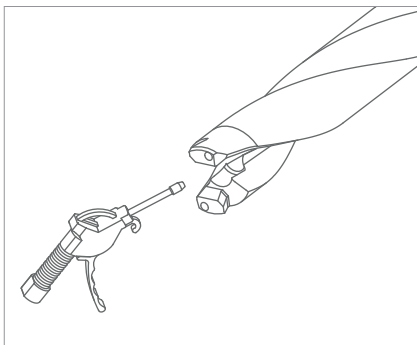
DEXDRILL

High performance drilling system with interchangeable heads

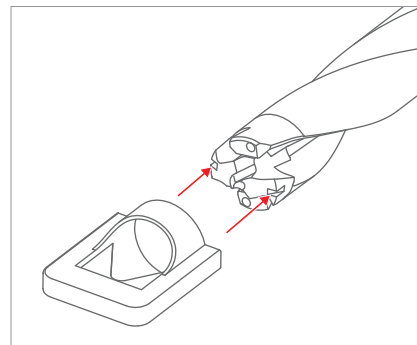
1. Where is DEXdrill applicable?

PLAIN SURFACE	CONCAVE SURFACE	STACKED PLATES	PIPES	SLANT SURFACE	HALF HOLE	HOLE EXPANSION

2. Drilling heads installation

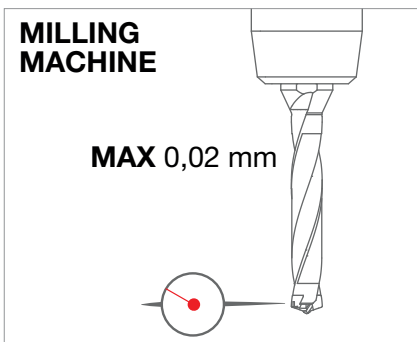


Clean pocket
with air blast.
Put insert into
drill holder.

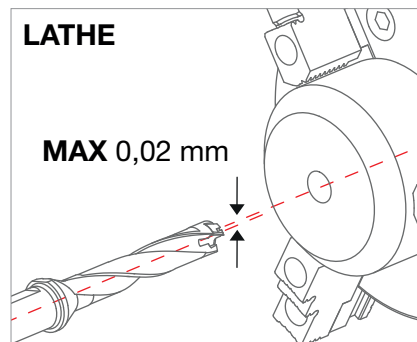


Set wrench into
slots on insert
flanks.
Slowly turn
the wrench
clockwise until
stop.

3. Operation recommendations

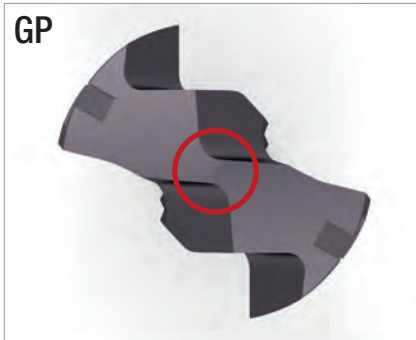


Center of
arbor deviation
must be under
0.02mm

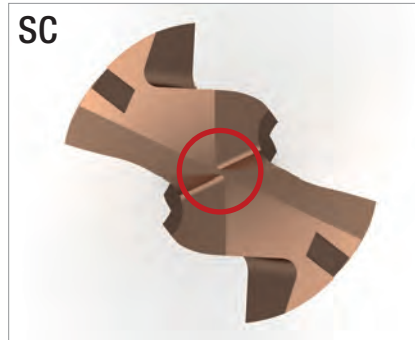


Keep under
0.02mm
the maximum
deviation
between drill
and workpiece

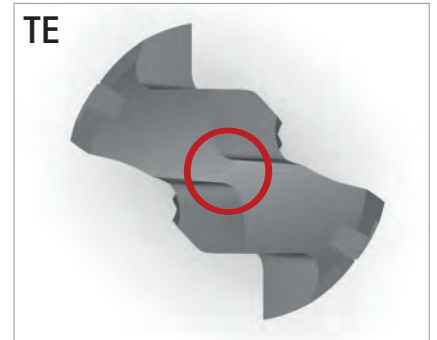
1. Chisel edge



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



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

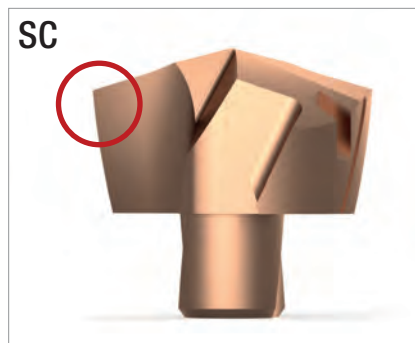


Big size chisel allows high feedrate machining and best centering features.

2. Outer corner



Small chamfer for very good edge protection in general machining.



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

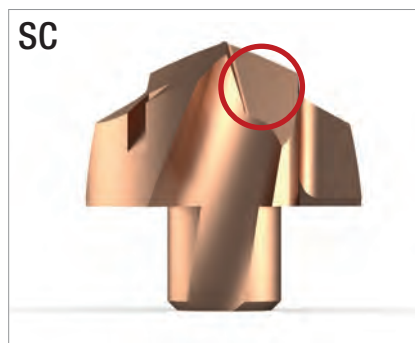


Big negative chamfer for higher performance on cast iron machining.

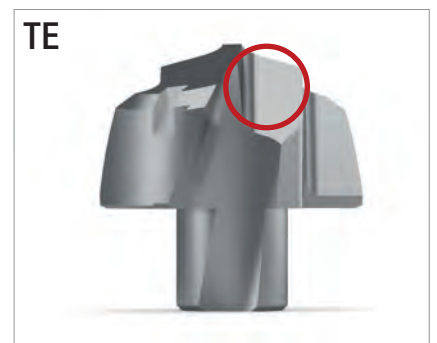
3. Gash geometry



Gashing design allows good chip evacuation and reduce thrust load.



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

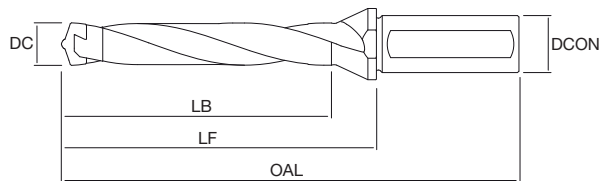


Gashing design allows good chip evacuation and reduce thrust load.

DEXDRILL

P	M	K	N	S	H
H	H	H			

- Self-locking drilling system without spare parts
- Quick change of the drilling head, directly in the machine
- Perfect insert's tightening thanks to the well balanced elastic deformation of the seat
- Polished surface and special design of the flutes guarantee a better chip ejection
- 1 mm drilling bodies' step, from 10 to 26 mm, with 3xD and 5xD lengths



	Stock	DC	DCON	OAL	LF	LB	MIID					
3xD	NT-DEX-3D D10-S16F	●	10.00÷10.90	16	95	47	38	DEX10...				
	NT-DEX-3D D11-S16F	●	11.00÷11.90	16	98	50	39	DEX11...				
	NT-DEX-3D D12-S16F	●	12.00÷12.90	16	104	56	44	DEX12...				
	NT-DEX-3D D13-S16F	●	13.00÷13.90	16	108	60	47	DEX13...				
	NT-DEX-3D D14-S16F	●	14.00÷14.90	16	112	64	50	DEX14...				
	NT-DEX-3D D15-S20F	●	15.00÷15.90	20	118	68	53	DEX15...				
	NT-DEX-3D D16-S20F	●	16.00÷16.90	20	122	72	56	DEX16...				
	NT-DEX-3D D17-S20F	●	17.00÷17.90	20	126	76	59	DEX17...				
	NT-DEX-3D D18-S25F	●	18.00÷18.90	25	136	80	62	DEX18...				
	NT-DEX-3D D19-S25F	●	19.00÷19.90	25	140	84	65	DEX19...				
	NT-DEX-3D D20-S25F	●	20.00÷20.90	25	144	88	68	DEX20...				
	NT-DEX-3D D21-S25F	●	21.00÷21.90	25	152	96	75	DEX21...				
	NT-DEX-3D D22-S25F	●	22.00÷22.90	25	157	101	81	DEX22...				
NT-DEX-3D D23-S32F	●	23.00÷23.90	32	165	105	82	DEX23...					
NT-DEX-3D D24-S32F	●	24.00÷24.90	32	170	110	86	DEX24...					
NT-DEX-3D D25/26-S32F	●	25.00÷26.00	32	175	115	89	DEX25/26...					
5xD	NT-DEX-5D D10-S16F	●	10.00÷10.90	16	116	68	59	DEX10...				
	NT-DEX-5D D11-S16F	●	11.00÷11.90	16	121	73	62	DEX11...				
	NT-DEX-5D D12-S16F	●	12.00÷12.90	16	130	82	70	DEX12...				
	NT-DEX-5D D13-S16F	●	13.00÷13.90	16	136	88	75	DEX13...				
	NT-DEX-5D D14-S16F	●	14.00÷14.90	16	142	94	80	DEX14...				
	NT-DEX-5D D15-S20F	●	15.00÷15.90	20	150	100	85	DEX15...				
	NT-DEX-5D D16-S20F	●	16.00÷16.90	20	156	106	90	DEX16...				
	NT-DEX-5D D17-S20F	●	17.00÷17.90	20	162	112	95	DEX17...				
	NT-DEX-5D D18-S25F	●	18.00÷18.90	25	174	118	100	DEX18...				
	NT-DEX-5D D19-S25F	●	19.00÷19.90	25	180	124	105	DEX19...				
	NT-DEX-5D D20-S25F	●	20.00÷20.90	25	186	130	110	DEX20...				
	NT-DEX-5D D21-S25F	●	21.00÷21.90	25	194	138	117	DEX21...				
	NT-DEX-5D D22-S25F	●	22.00÷22.90	25	201	145	125	DEX22...				
NT-DEX-5D D23-S32F	●	23.00÷23.90	32	211	151	128	DEX23...					
NT-DEX-5D D24-S32F	●	24.00÷24.90	32	218	158	134	DEX24...					
NT-DEX-5D D25/26-S32F	●	25.00÷26.00	32	225	165	139	DEX25/26...					

Spare Parts

WRENCH

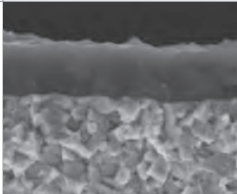
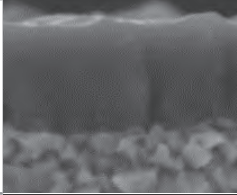
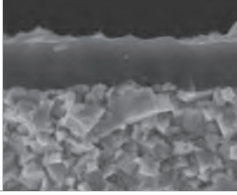


DC 10 ÷ 11	NT-WR1011
DC 12 ÷ 17	NT-WR1217
DC 18 ÷ 20	NT-WR1820
DC 21 ÷ 26	NT-WR2126

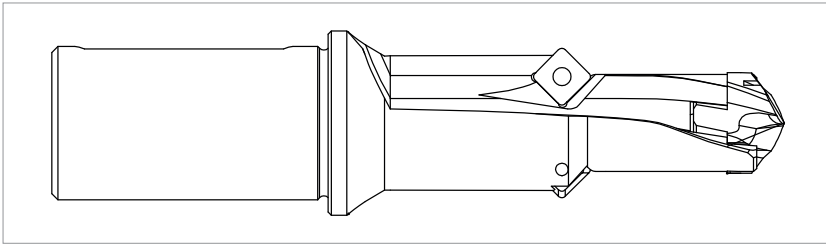
CUTTING SPEED [m/min]

	MATERIALS (HARDNESS/Rm)	W.-Nr	DIN	AISI-ASTM	TRADE MARK	JP5625	JP5630	JP7625
P1	Free cutting steel and structural steel (< 500 N/mm ²)	1.0765	36 SMnPb 14	A29	PR80	100±160	80±140	
P2	Carbon steel and low alloy steel (500-700 N/mm ²)	1.0511	C 40	1040		80±140	80±120	
P3	Medium alloy steel and heat treated steel (600-800 N/mm ²)	1.1201	42 CrMo 4	4142		60±100		
P4	High alloy steel (800-1000 N/mm ²)	1.3505	100 Cr 6	52100		50±90		
P5	Tool steel (900-1200 N/mm ²)	1.2080	X 210 Cr 12	D3	K100	40±80		
P6	High tensile strenght steel (HRC 38-45)				HARDOX 400®	40±60		
P7	Ferritic - Martensitic stainless steel	1.4021	X 20 Cr 13	420			40±70	
P8	PH stainless steel	1.4548	X 5 CrNiCuNb 17 4	630	17-4-PH		40±60	
M1	Austenitic stainless steel (good machinability)	1.4305	X 10 CrNiS 18 9	303			40±70	
M2	Austenitic stainless steel and Duplex	1.4401	X 5 CrNiMo 17 12 2	316			40±60	
M3	Super austenitic stainless steel and super Duplex	1.4410	X 2 CrNiMoN 25 7 4	F 53			30±50	
K1	Grey cast iron (150-250 HB)	0.6025	GG-25	A48 35 B		80±180		100±200
K2	Nodular cast iron (150-350 HB)	0.7050	GGG-50	A536 80-55-6		80±140		100±160

CARBIDE GRADES FEATURES

NAME	MICROSTRUCTURE	COLOR	TECHNOLOGY	COMPOSITION	THICKNESS	HARDNESS	OXIDATION TEMPERATURE	ISO513
JP5625		Dark Blue	PVD	TiAlN	4 - 6 µm	3000 HV	900 °C	P20-P30 K10-K30
JP5630		Copper	PVD	TiSiN	2 - 4 µm	3100 HV	1100 °C	P30 M30
JP7625		Dark Grey	PVD	TiAlCrN	4 - 6 µm	3100 HV	1100 °C	K10-K30

- Tailor made drilling and chamfering bodies



- FT - Flat drilling heads



- CS - Chips splitter drilling heads



- HC - Improved centering for extra long drilling bodies



www.nikkotools.com



Via Don F. Tosatto, 8
30174 Mestre - Venezia
+39 041.959179
info@nikkotools.com



\$NKDEP21DEX