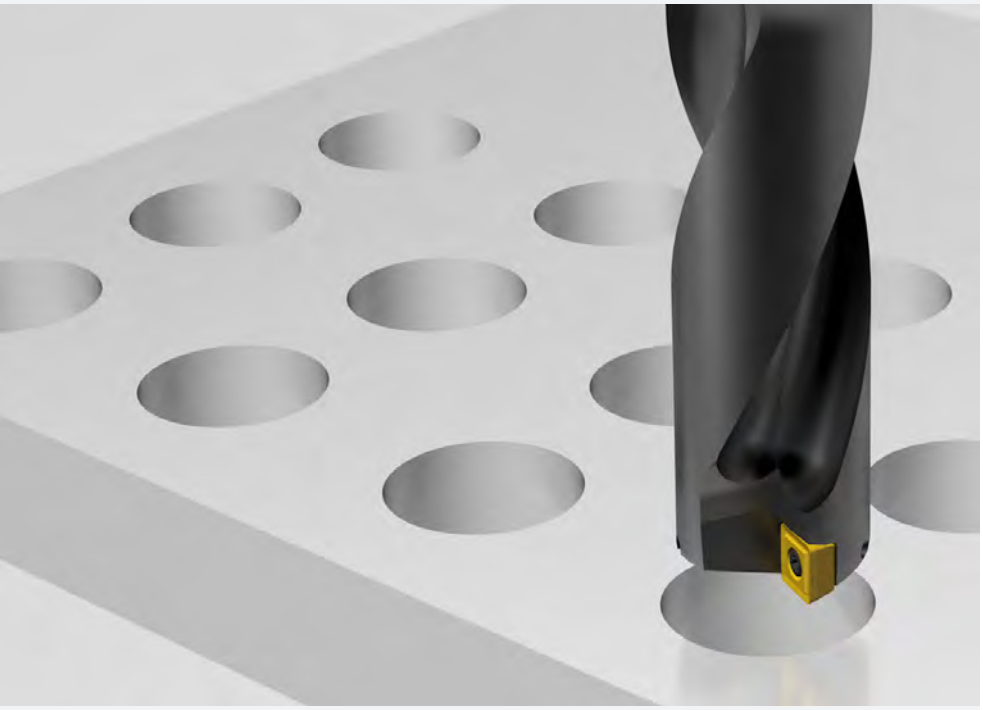

DRILLING

Grade table .E2
Grade details .E3
Quick guide .E4
Indexable drills - DRS .E6
Modular heads - DEX .E24
Combined series - DXP .E52
Multi-functional - SPOT DRILL .E62
Iso Trigon - ISO WCMX .E84
Carbide drills - NCD .E66

DRILLING Grade table

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ISO 513		CARBIDE			
		PVD COATED			UNCOATED
		DEX	DXP	DRS	DRS
P Steel	P01				
	P10				
	P20	JP5630, JP5725	JP5725	JP5530, JP8725	
	P30				
	P40				
M Stainless steel	M01				
	M10				
	M20	JP5630		JP5530, JP9535	
	M30				
	M40				
K Cast iron	K01				
	K10	JP7625, JP5725	JP5725		
	K20			JP5530	
	K30				
N Non-ferrous material	N01				
	N10				JU6520
	N20				
	N30				
S Heat resistance	S01				
	S10			JP9535	
	S20				
	S30				

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GRADE	SYSTEM	HARDNESS HV	COATING		APPLICATION		FEATURES
			TECHNOLOGY	COMPOSITION			
JP5725	DEX - DXP	1.840	PVD	AlTiN	P	P15 P30	High performance grade for steel drilling with a perfect combination between toughness and wear resistance. A very good choice even for nodular cast iron machining.
					K	K10 K30	
JP5630	DEX	1.700	PVD	TiSiN	P	P30	First choice for stainless steel and free-cutting steels. Tough substrate and special coating with low friction coefficient specifically developed for sticky materials.
					M	M30	
JP7625	DEX	1.840	PVD	TiAlCrN	K	K10 K30	Very hard coating film specifically studied for abrasive materials machining. First choice for gray cast iron in combination with TE chamfered geometry.
JP5530	DRS	1.840	PVD	TiAlN	P	P20 P40	Universal grade mainly for steel application but also available for ISO M and ISO K machining.
					M	M25 M30	
					K	K25 K30	
JP8725	DRS	1.840	PVD	AlCrN	P	P15 P30	First choiche for steel application. The new substrate contribute to a great performance increase compared to conventional product.
JP9535	DRS	1.640	PVD	TiAlN	M	M20 M35	First choice for stainless steel machining under general cutting conditions. Also applicable on titanium thanks to a great stability at high temperature.
					S	S15 S25	
JU6520	DRS	1.560	-	-	N	N10 N30	Uncoated grade for non-ferrous materials. The micrograin substrate toughness allows the production of very sharp ground cutting edges.

DRILLING Quick guide

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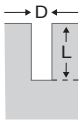
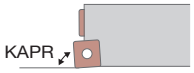
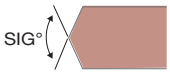


DRS

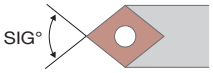


DEX
DXP

NCD



SPOTdrill



	DRS	DRS PILOT	DEX
	E6	E18	E24
Tool diameter	Ø12.50 - Ø50.00	Ø18.00 - Ø30.00	Ø10.00 - Ø26.00
L / D	2 - 3 - 4 - 5	6 - 9	3 - 5 (8 - 12 upon request)
Coolant holes	✓	✓	✓
Effective cutting edges	1	1	2
Point angle	KAPR 85°	SIG pilot 118° - KAPR 87.5°	SIG 140°
Workpiece material	P M K N	P M K N	P M K
No. of corners	4	4	1
No. of geometries	2	2 (periferic) - 1(pilot)	4 (2 upon request)
Special features	-	HSS center pilot	-
Plain Surface	✓	✓	✓
Slant Surface	✓	✗	✗
Concave Surface	✓	✓	✓
Convex Surface	✓	✓	✓
Stacked Plates	✗	✗	✓
Pipes	✓	✓	✓
Half Hole	✓	✗	✗
Hole Expansion	✓	✗	✗
Precision	■■□□□	■■□□□	■■■□□
Productivity	■■■□□	■■■□□	■■■■■
Cost per hole	■■□□□	■■■□□	■■■■□
Range	■■■■□	■■■□□	■■■■□

DRILLING Quick guide

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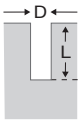
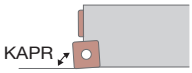
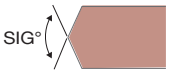


DRS

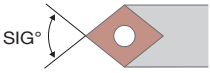


DEX
DXP

NCD



SPOTdrill



	DXP	NCD	SPOTDRILL
	E52	E66	E62
			SCREW-IN CYLINDRICAL
Tool diameter	Ø30.00 - Ø60.00	Ø3.00 - Ø20.00	Ø14.00
L / D	3 - 6 - 8 - 10	3 - 5 (8 upon request)	-
Coolant holes	✓	both	✗
Effective cutting edge	2	2	2
Point angle	SIG pilot 140°	SIG 140°	SIG 90°
Workpiece material	P K	P M K S	P M K N
No. of corners	peripheral 2 / 3	1	4
No. of geometries	1	2	2
Special features	Chip split chipbreaker	-	-
Plain Surface	✓	✓	Spotting
Slant Surface	✗	✗	
Concave Surface	✓	✓	Engraving
Convex Surface	✓	✓	
Stacked Plates	✓	✓	V-Grooving
Pipes	✓	✓	
Half Hole	✗	✗	Chamfering
Hole Expansion	✗	✗	
Precision	■■■□□	■■■■■	
Productivity	■■■■□	■■■■□	
Cost per hole	■■■■□	■■■□□	
Range	■■■■■	■■■■□	

DRS DRILLS

High performance universal indexable drilling system with inserts

APPLICATION

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

ISO APPLICATION FIELDS

P M K N

ADVANTAGES AND CHARACTERISTICS

- Highly universal drilling system suitable for diverse conditions
- Highly cost-efficient system
- Twisted flute style available in 2xD and 3xD, straight flute style in 4xD and 5xD to improve chip evacuation

Drilling bodies

- Weldon shank with internal coolant
- 2/ 3/ 4/ 5xD available from D13 to D50
- Special length and stepped body available upon request

2D - 3D Twisted flute, coolant holes with "Y" design

4D - 5D Straight flute, coolant holes with "II" design

Inserts

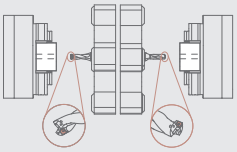
- Available sizes 05/06/07/09/11/14
- Cemented carbide grades with PVD coatings or uncoated for N materials
- Geometries: GP, AL

GP P M K

SIZE
05 06 07 09 11 14

AL N

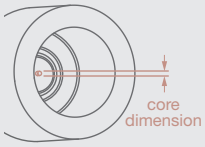
SIZE
05 06 07 09 11 14



Lathe installation

It's recommended to set the outer insert facing the operator as shown in the drawing, both for main and sub-spindle to gain the best results.

Following this suggestion, generally, the inner insert will be set below the center which is the recommended situation for optimal operation.



Quick check of the center height

To check if the machine axis is correctly aligned, a test hole should be drilled checking the remaining core on the hole bottom.

Center-height adjustment is necessary when no core remains or if the core diameter is larger than 1mm.

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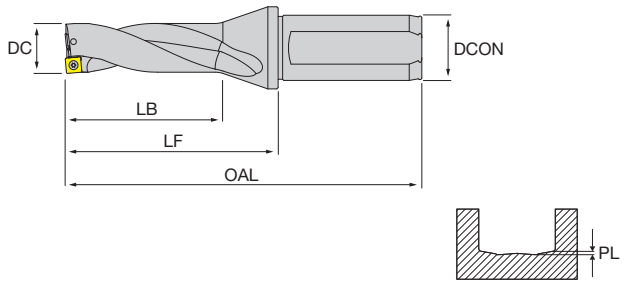
2xD

DRS drill

- 2xD indexable drill body for SP inserts with helical flutes
- All with coolant through
- Please select insert size according to the drill diameter



Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-2D D12.50-S20-05	▽	12.5	20	94	44	26	0.4	0.5			SPoX05
NT-DRS-2D D13.00-S20-05	●	13	20	94	44	26	0.4	0.5			SPoX05
NT-DRS-2D D14.00-S20-05	●	14	20	96	46	28	0.4	0.5			SPoX05
NT-DRS-2D D15.00-S20-05	●	15	20	99	49	30	0.4	0.5			SPoX05
NT-DRS-2D D16.00-S25-06	●	16	25	108	52	32	0.5	0.5			SPoX06
NT-DRS-2D D17.00-S25-06	●	17	25	110	54	34	0.5	0.5			SPoX06
NT-DRS-2D D18.00-S25-06	●	18	25	113	57	36	0.5	0.5			SPoX06
NT-DRS-2D D19.00-S25-06	●	19	25	115	59	38	0.5	0.5			SPoX06
NT-DRS-2D D20.00-S25-06	●	20	25	119	63	40	0.5	0.5			SPoX06
NT-DRS-2D D21.00-S25-06	●	21	25	121	65	42	0.5	0.25			SPoX06
NT-DRS-2D D22.00-S25-07	●	22	25	123	67	44	0.5	0.5			SPoX07
NT-DRS-2D D23.00-S32-07	●	23	32	131	71	46	0.5	0.5			SPoX07
NT-DRS-2D D24.00-S32-07	●	24	32	134	74	48	0.5	0.5			SPoX07
NT-DRS-2D D25.00-S32-07	●	25	32	137	77	50	0.5	0.5			SPoX07
NT-DRS-2D D26.00-S32-07	●	26	32	139	79	52	0.6	0.25			SPoX07
NT-DRS-2D D27.00-S32-07	●	27	32	141	81	54	0.6	0.25			SPoX07
NT-DRS-2D D28.00-S32-09	●	28	32	144	84	56	0.8	0.5			SPoX09
NT-DRS-2D D29.00-S32-09	●	29	32	146	86	58	0.8	0.5			SPoX09
NT-DRS-2D D30.00-S32-09	●	30	32	151	91	60	0.8	0.5			SPoX09
NT-DRS-2D D31.00-S32-09	●	31	32	154	94	62	0.8	0.25			SPoX09
NT-DRS-2D D32.00-S32-09	●	32	32	156	96	64	0.8	0.25			SPoX09
NT-DRS-2D D33.00-S32-09	●	33	32	159	99	66	0.8	0.25			SPoX09
NT-DRS-2D D34.00-S40-11	●	34	40	171	101	68	0.9	0.5			SPoX11
NT-DRS-2D D35.00-S40-11	●	35	40	174	104	70	0.9	0.5			SPoX11
NT-DRS-2D D36.00-S40-11	●	36	40	177	107	72	0.9	0.5			SPoX11
NT-DRS-2D D37.00-S40-11	●	37	40	180	110	74	0.9	0.5			SPoX11
NT-DRS-2D D38.00-S40-11	●	38	40	183	113	76	0.9	0.5			SPoX11
NT-DRS-2D D39.00-S40-11	●	39	40	185	115	78	0.9	0.5			SPoX11
NT-DRS-2D D40.00-S40-11	●	40	40	188	118	80	0.9	0.25			SPoX11
NT-DRS-2D D41.00-S40-11	●	41	40	191	121	82	0.9	0.25			SPoX11
NT-DRS-2D D42.00-S40-14	●	42	40	193	123	84	1	0.5			SPoX14
NT-DRS-2D D43.00-S40-14	●	43	40	196	126	86	1	0.5			SPoX14
NT-DRS-2D D44.00-S40-14	●	44	40	198	128	88	1	0.5			SPoX14
NT-DRS-2D D45.00-S40-14	●	45	40	202	132	90	1	0.5			SPoX14
NT-DRS-2D D46.00-S40-14	●	46	40	205	135	92	1	0.5			SPoX14
NT-DRS-2D D47.00-S40-14	●	47	40	207	137	94	1	0.5			SPoX14
NT-DRS-2D D48.00-S40-14	●	48	40	210	140	96	1	0.25			SPoX14
NT-DRS-2D D49.00-S40-14	●	49	40	212	142	98	1	0.25			SPoX14
NT-DRS-2D D50.00-S40-14	●	50	40	215	145	100	1	0.25			SPoX14

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

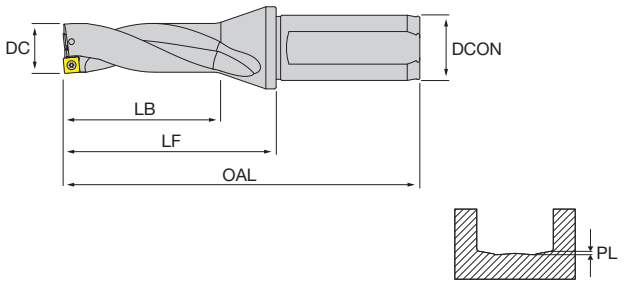
Spare parts	Insert screws	Flag wrenches
NT-DRS-2D Doo.oo-Soo-05	NT-ST20043T06	NT-FTB06
NT-DRS-2D Doo.oo-Soo-06	NT-ST22055T06	NT-FTB06
NT-DRS-2D Doo.oo-Soo-07	NT-ST25065T07	NT-FTB07

Spare parts	Insert screws	Flag wrenches
NT-DRS-2D Doo.oo-Soo-09	NT-ST35080T15	NT-FTB15
NT-DRS-2D Doo.oo-Soo-11	NT-ST40100T15	NT-FTB15
NT-DRS-2D Doo.oo-Soo-14	NT-ST50108T20	NT-FTB20

3xD

DRS drill

- 3xD indexable drill body for SP inserts with helical flutes
- All with coolant through
- Please select insert size according to the drill diameter



Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-3D D12.50-S20-05	●	12.5	20	107	57	39	0.4	0.5			SPoX05
NT-DRS-3D D13.00-S20-05	●	13	20	107	57	39	0.4	0.5			SPoX05
NT-DRS-3D D13.50-S20-05	●	13.5	20	110	60	42	0.4	0.5			SPoX05
NT-DRS-3D D14.00-S20-05	●	14	20	110	60	42	0.4	0.5			SPoX05
NT-DRS-3D D14.50-S20-05	●	14.5	20	114	64	45	0.4	0.5			SPoX05
NT-DRS-3D D15.00-S20-05	●	15	20	114	64	45	0.4	0.5			SPoX05
NT-DRS-3D D15.50-S25-06	●	15.5	25	124	68	48	0.5	0.5			SPoX06
NT-DRS-3D D16.00-S25-06	●	16	25	124	68	48	0.5	0.5			SPoX06
NT-DRS-3D D16.50-S25-06	●	16.5	25	127	71	51	0.5	0.5			SPoX06
NT-DRS-3D D17.00-S25-06	●	17	25	127	71	51	0.5	0.5			SPoX06
NT-DRS-3D D17.50-S25-06	●	17.5	25	131	75	54	0.5	0.5			SPoX06
NT-DRS-3D D18.00-S25-06	●	18	25	131	75	54	0.5	0.5			SPoX06
NT-DRS-3D D18.50-S25-06	●	18.5	25	134	78	57	0.5	0.5			SPoX06
NT-DRS-3D D19.00-S25-06	●	19	25	134	78	57	0.5	0.5			SPoX06
NT-DRS-3D D19.50-S25-06	●	19.5	25	139	83	60	0.5	0.5			SPoX06
NT-DRS-3D D20.00-S25-06	●	20	25	139	83	60	0.5	0.5			SPoX06
NT-DRS-3D D20.50-S25-06	●	20.5	25	142	86	63	0.5	0.25			SPoX06
NT-DRS-3D D21.00-S25-06	●	21	25	142	86	63	0.5	0.25			SPoX06
NT-DRS-3D D21.50-S25-06	●	21.5	25	145	89	66	0.5	0.25			SPoX06
NT-DRS-3D D22.00-S25-07	●	22	25	145	89	66	0.5	0.5			SPoX07
NT-DRS-3D D22.50-S32-07	●	22.5	32	154	94	69	0.5	0.5			SPoX07
NT-DRS-3D D23.00-S32-07	●	23	32	154	94	69	0.5	0.5			SPoX07
NT-DRS-3D D23.50-S32-07	●	23.5	32	158	98	72	0.5	0.5			SPoX07
NT-DRS-3D D24.00-S32-07	●	24	32	158	98	72	0.5	0.5			SPoX07
NT-DRS-3D D24.50-S32-07	●	24.5	32	162	102	75	0.5	0.5			SPoX07
NT-DRS-3D D25.00-S32-07	●	25	32	162	102	75	0.5	0.5			SPoX07
NT-DRS-3D D25.50-S32-07	●	25.5	32	165	105	78	0.6	0.5			SPoX07
NT-DRS-3D D26.00-S32-07	●	26	32	165	105	78	0.6	0.25			SPoX07
NT-DRS-3D D26.50-S32-07	●	26.5	32	168	108	81	0.6	0.25			SPoX07
NT-DRS-3D D27.00-S32-07	●	27	32	168	108	81	0.6	0.25			SPoX07
NT-DRS-3D D27.50-S32-07	●	27.5	32	172	112	84	0.6	0.25			SPoX07
NT-DRS-3D D28.00-S32-09	●	28	32	172	112	84	0.8	0.5			SPoX09
NT-DRS-3D D28.50-S32-09	●	28.5	32	175	115	87	0.8	0.5			SPoX09
NT-DRS-3D D29.00-S32-09	●	29	32	175	115	87	0.8	0.5			SPoX09
NT-DRS-3D D29.50-S32-09	●	29.5	32	181	121	90	0.8	0.5			SPoX09
NT-DRS-3D D30.00-S32-09	●	30	32	181	121	90	0.8	0.5			SPoX09
NT-DRS-3D D31.00-S32-09	●	31	32	185	125	93	0.8	0.25			SPoX09
NT-DRS-3D D32.00-S32-09	●	32	32	188	128	96	0.8	0.25			SPoX09
NT-DRS-3D D33.00-S32-09	●	33	32	192	132	99	0.8	0.25			SPoX09
NT-DRS-3D D34.00-S40-11	●	34	40	205	135	102	0.9	0.5			SPoX11
NT-DRS-3D D35.00-S40-11	●	35	40	209	139	105	0.9	0.5			SPoX11
NT-DRS-3D D36.00-S40-11	●	36	40	213	143	108	0.9	0.5			SPoX11
NT-DRS-3D D37.00-S40-11	●	37	40	217	147	111	0.9	0.5			SPoX11
NT-DRS-3D D38.00-S40-11	●	38	40	221	151	114	0.9	0.5			SPoX11
NT-DRS-3D D39.00-S40-11	●	39	40	224	154	117	0.9	0.25			SPoX11
NT-DRS-3D D40.00-S40-11	●	40	40	228	158	120	0.9	0.25			SPoX11
NT-DRS-3D D41.00-S40-11	●	41	40	232	162	123	0.9	0.5			SPoX11

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

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Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-3D D42.00-S40-14	●	42	40	235	165	126	1	0.5			SPoX14
NT-DRS-3D D43.00-S40-14	●	43	40	239	169	129	1	0.5			SPoX14
NT-DRS-3D D44.00-S40-14	●	44	40	242	172	132	1	0.5			SPoX14
NT-DRS-3D D45.00-S40-14	●	45	40	247	177	135	1	0.5			SPoX14
NT-DRS-3D D46.00-S40-14	●	46	40	251	181	138	1	0.5			SPoX14
NT-DRS-3D D47.00-S40-14	●	47	40	254	184	141	1	0.5			SPoX14
NT-DRS-3D D48.00-S40-14	●	48	40	258	188	144	1	0.25			SPoX14
NT-DRS-3D D49.00-S40-14	●	49	40	261	191	147	1	0.25			SPoX14
NT-DRS-3D D50.00-S40-14	●	50	40	265	195	150	1	0.25			SPoX14

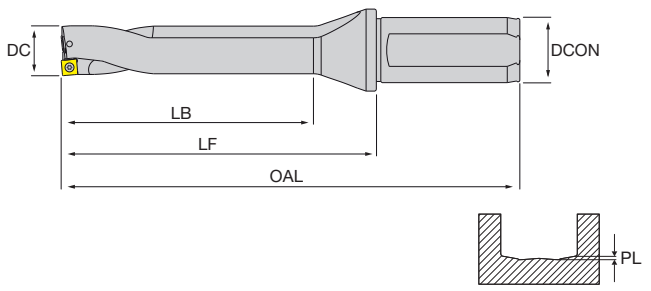
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Insert screws	Flag wrenches
NT-DRS-3D Doo.oo-Soo-05	NT-ST20043T06	NT-FTB06
NT-DRS-3D Doo.oo-Soo-06	NT-ST22055T06	NT-FTB06
NT-DRS-3D Doo.oo-Soo-07	NT-ST25065T07	NT-FTB07
NT-DRS-3D Doo.oo-Soo-09	NT-ST35080T15	NT-FTB15
NT-DRS-3D Doo.oo-Soo-11	NT-ST40100T15	NT-FTB15
NT-DRS-3D Doo.oo-Soo-14	NT-ST50108T20	NT-FTB20

4xD

DRS drill

- 4xD indexable drill body for SP inserts with straight flutes
- All with coolant through
- Please select insert size according to the drill diameter



Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-4D D12.50-S20-05	●	12.5	20	120	70	52	0.4	0.5			SPoX05
NT-DRS-4D D13.00-S20-05	●	13	20	120	70	52	0.4	0.5			SPoX05
NT-DRS-4D D13.50-S20-05	●	13.5	20	124	74	56	0.4	0.5			SPoX05
NT-DRS-4D D14.00-S20-05	●	14	20	124	74	56	0.4	0.5			SPoX05
NT-DRS-4D D14.50-S20-05	●	14.5	20	129	79	60	0.4	0.5			SPoX05
NT-DRS-4D D15.00-S20-05	●	15	20	129	79	60	0.4	0.5			SPoX05
NT-DRS-4D D15.50-S25-06	●	15.5	25	140	84	64	0.5	0.5			SPoX06
NT-DRS-4D D16.00-S25-06	●	16	25	140	84	64	0.5	0.5			SPoX06
NT-DRS-4D D16.50-S25-06	●	16.5	25	144	88	68	0.5	0.5			SPoX06
NT-DRS-4D D17.00-S25-06	●	17	25	144	88	68	0.5	0.5			SPoX06
NT-DRS-4D D17.50-S25-06	●	17.5	25	149	93	72	0.5	0.5			SPoX06
NT-DRS-4D D18.00-S25-06	●	18	25	149	93	72	0.5	0.5			SPoX06
NT-DRS-4D D18.50-S25-06	●	18.5	25	153	97	76	0.5	0.5			SPoX06
NT-DRS-4D D19.00-S25-06	●	19	25	153	97	76	0.5	0.5			SPoX06
NT-DRS-4D D19.50-S25-06	●	19.5	25	159	103	80	0.5	0.5			SPoX06
NT-DRS-4D D20.00-S25-06	●	20	25	159	103	80	0.5	0.5			SPoX06
NT-DRS-4D D20.50-S25-06	●	20.5	25	163	107	84	0.5	0.25			SPoX06
NT-DRS-4D D21.00-S25-06	●	21	25	163	107	84	0.5	0.25			SPoX06
NT-DRS-4D D21.50-S25-06	●	21.5	25	167	111	88	0.5	0.25			SPoX06
NT-DRS-4D D22.00-S25-07	●	22	25	167	111	88	0.5	0.5			SPoX07
NT-DRS-4D D22.50-S32-07	●	22.5	32	177	117	92	0.5	0.5			SPoX07
NT-DRS-4D D23.00-S32-07	●	23	32	177	117	92	0.5	0.5			SPoX07
NT-DRS-4D D23.50-S32-07	●	23.5	32	182	122	96	0.5	0.5			SPoX07
NT-DRS-4D D24.00-S32-07	●	24	32	182	122	96	0.5	0.5			SPoX07
NT-DRS-4D D24.50-S32-07	●	24.5	32	187	127	100	0.5	0.5			SPoX07
NT-DRS-4D D25.00-S32-07	●	25	32	187	127	100	0.5	0.5			SPoX07
NT-DRS-4D D25.50-S32-07	●	25.5	32	191	131	104	0.6	0.5			SPoX07
NT-DRS-4D D26.00-S32-07	●	26	32	191	131	104	0.6	0.25			SPoX07
NT-DRS-4D D26.50-S32-07	●	26.5	32	195	135	108	0.6	0.25			SPoX07
NT-DRS-4D D27.00-S32-07	●	27	32	195	135	108	0.6	0.25			SPoX07
NT-DRS-4D D27.50-S32-07	●	27.5	32	200	140	112	0.6	0.25			SPoX07
NT-DRS-4D D28.00-S32-09	●	28	32	200	140	112	0.8	0.5			SPoX09
NT-DRS-4D D28.50-S32-09	●	28.5	32	204	144	116	0.8	0.5			SPoX09
NT-DRS-4D D29.00-S32-09	●	29	32	204	144	116	0.8	0.5			SPoX09
NT-DRS-4D D29.50-S32-09	●	29.5	32	211	151	120	0.8	0.5			SPoX09
NT-DRS-4D D30.00-S32-09	●	30	32	211	151	120	0.8	0.5			SPoX09
NT-DRS-4D D31.00-S32-09	●	31	32	216	156	124	0.8	0.25			SPoX09
NT-DRS-4D D32.00-S32-09	●	32	32	220	160	128	0.8	0.25			SPoX09
NT-DRS-4D D33.00-S32-09	●	33	32	225	165	132	0.8	0.25			SPoX09
NT-DRS-4D D34.00-S40-11	●	34	40	239	169	136	0.9	0.5			SPoX11
NT-DRS-4D D35.00-S40-11	●	35	40	244	174	140	0.9	0.5			SPoX11
NT-DRS-4D D36.00-S40-11	●	36	40	249	179	144	0.9	0.5			SPoX11
NT-DRS-4D D37.00-S40-11	●	37	40	254	184	148	0.9	0.5			SPoX11
NT-DRS-4D D38.00-S40-11	●	38	40	259	189	152	0.9	0.5			SPoX11
NT-DRS-4D D39.00-S40-11	●	39	40	263	193	156	0.9	0.25			SPoX11
NT-DRS-4D D40.00-S40-11	●	40	40	268	198	160	0.9	0.25			SPoX11
NT-DRS-4D D41.00-S40-11	▲	41	40	273	203	164	0.9	0.5			SPoX11

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

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Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-4D D42.00-S40-14	●	42	40	277	207	168	1	0.5			SPoX14
NT-DRS-4D D43.00-S40-14	●	43	40	282	212	172	1	0.5			SPoX14
NT-DRS-4D D44.00-S40-14	●	44	40	286	216	176	1	0.5			SPoX14
NT-DRS-4D D45.00-S40-14	●	45	40	292	222	180	1	0.5			SPoX14
NT-DRS-4D D46.00-S40-14	●	46	40	297	227	184	1	0.5			SPoX14
NT-DRS-4D D47.00-S40-14	●	47	40	301	231	188	1	0.5			SPoX14
NT-DRS-4D D48.00-S40-14	●	48	40	306	236	192	1	0.25			SPoX14
NT-DRS-4D D49.00-S40-14	▲	49	40	310	240	196	1	0.25			SPoX14
NT-DRS-4D D50.00-S40-14	●	50	40	315	245	200	1	0.25			SPoX14

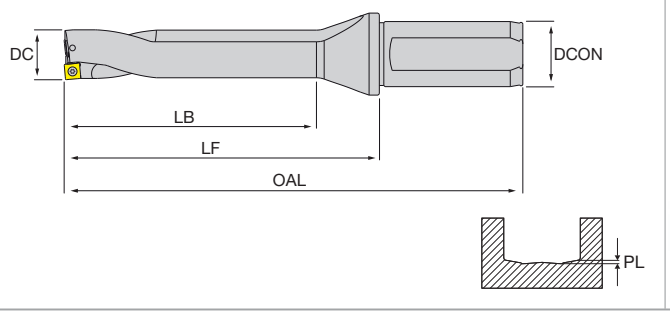
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Insert screws	Flag wrenches
NT-DRS-4D Doo.oo-Soo-05	NT-ST20043T06	NT-FTB06
NT-DRS-4D Doo.oo-Soo-06	NT-ST22055T06	NT-FTB06
NT-DRS-4D Doo.oo-Soo-07	NT-ST25065T07	NT-FTB07
NT-DRS-4D Doo.oo-Soo-09	NT-ST35080T15	NT-FTB15
NT-DRS-4D Doo.oo-Soo-11	NT-ST40100T15	NT-FTB15
NT-DRS-4D Doo.oo-Soo-14	NT-ST50108T20	NT-FTB20

5xD

DRS drill

- 5xD indexable drill body for SP inserts with straight flutes
- All with coolant through
- Please select insert size according to the drill diameter



Designation	Stock	DC	DCON	OAL	LF	LB	PL	ADJLX			MIID
NT-DRS-5D D13.00-S20-05	●	13	20	133	83	65	0.4	0.5			SPoX05
NT-DRS-5D D14.00-S20-05	●	14	20	138	88	70	0.4	0.5			SPoX05
NT-DRS-5D D15.00-S20-05	●	15	20	144	94	75	0.4	0.5			SPoX05
NT-DRS-5D D16.00-S25-06	●	16	25	156	100	80	0.5	0.5			SPoX06
NT-DRS-5D D17.00-S25-06	●	17	25	161	105	85	0.5	0.5			SPoX06
NT-DRS-5D D18.00-S25-06	●	18	25	167	111	90	0.5	0.5			SPoX06
NT-DRS-5D D19.00-S25-06	●	19	25	172	116	95	0.5	0.5			SPoX06
NT-DRS-5D D20.00-S25-06	●	20	25	179	123	100	0.5	0.5			SPoX06
NT-DRS-5D D21.00-S25-06	●	21	25	184	128	105	0.5	0.25			SPoX06
NT-DRS-5D D22.00-S25-07	●	22	25	189	133	110	0.5	0.5			SPoX07
NT-DRS-5D D23.00-S32-07	●	23	32	200	140	115	0.5	0.5			SPoX07
NT-DRS-5D D24.00-S32-07	●	24	32	206	146	120	0.5	0.5			SPoX07
NT-DRS-5D D25.00-S32-07	●	25	32	212	152	125	0.5	0.5			SPoX07
NT-DRS-5D D26.00-S32-07	●	26	32	217	157	130	0.6	0.25			SPoX07
NT-DRS-5D D27.00-S32-07	●	27	32	222	162	135	0.6	0.25			SPoX07
NT-DRS-5D D28.00-S32-09	●	28	32	228	168	140	0.8	0.5			SPoX09
NT-DRS-5D D29.00-S32-09	●	29	32	233	173	145	0.8	0.5			SPoX09
NT-DRS-5D D30.00-S32-09	●	30	32	241	181	150	0.8	0.5			SPoX09
NT-DRS-5D D31.00-S32-09	●	31	32	247	187	155	0.8	0.25			SPoX09
NT-DRS-5D D32.00-S32-09	●	32	32	252	192	160	0.8	0.25			SPoX09
NT-DRS-5D D33.00-S32-09	●	33	32	258	198	165	0.8	0.25			SPoX09
NT-DRS-5D D34.00-S40-11	●	34	40	273	203	170	0.9	0.5			SPoX11
NT-DRS-5D D35.00-S40-11	●	35	40	279	209	175	0.9	0.5			SPoX11
NT-DRS-5D D36.00-S40-11	●	36	40	285	215	180	0.9	0.5			SPoX11
NT-DRS-5D D37.00-S40-11	●	37	40	291	221	185	0.9	0.5			SPoX11
NT-DRS-5D D38.00-S40-11	●	38	40	297	227	190	0.9	0.5			SPoX11
NT-DRS-5D D39.00-S40-11	●	39	40	302	232	195	0.9	0.5			SPoX11
NT-DRS-5D D40.00-S40-11	●	40	40	308	238	200	0.9	0.25			SPoX11
NT-DRS-5D D41.00-S40-11	●	41	40	314	244	205	0.9	0.25			SPoX11
NT-DRS-5D D42.00-S40-14	●	42	40	319	249	210	1	0.5			SPoX14
NT-DRS-5D D43.00-S40-14	●	43	40	325	255	215	1	0.5			SPoX14
NT-DRS-5D D44.00-S40-14	●	44	40	330	260	220	1	0.5			SPoX14
NT-DRS-5D D45.00-S40-14	●	45	40	337	267	225	1	0.5			SPoX14
NT-DRS-5D D46.00-S40-14	●	46	40	343	273	230	1	0.5			SPoX14
NT-DRS-5D D47.00-S40-14	●	47	40	348	278	235	1	0.5			SPoX14
NT-DRS-5D D48.00-S40-14	●	48	40	354	284	240	1	0.25			SPoX14
NT-DRS-5D D49.00-S40-14	●	49	40	359	289	245	1	0.25			SPoX14
NT-DRS-5D D50.00-S40-14	●	50	40	365	295	250	1	0.25			SPoX14

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

Spare parts	Insert screws	Flag wrenches
NT-DRS-5D Doo.oo-Soo-05	NT-ST20043T06	NT-FTB06
NT-DRS-5D Doo.oo-Soo-06	NT-ST22055T06	NT-FTB06
NT-DRS-5D Doo.oo-Soo-07	NT-ST25065T07	NT-FTB07

Spare parts	Insert screws	Flag wrenches
NT-DRS-5D Doo.oo-Soo-09	NT-ST35080T15	NT-FTB15
NT-DRS-5D Doo.oo-Soo-11	NT-ST40100T15	NT-FTB15
NT-DRS-5D Doo.oo-Soo-14	NT-ST50108T20	NT-FTB20

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SPoX

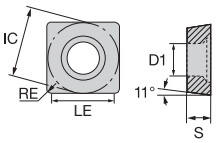
DRS drill

- General purpose type or fine polished sharp geometries for aluminum or non-ferrous materials available
- Diverse PVD coated carbide grades available
- Inserts could also be mounted on DRS Pilot type and ChamferSquare milling bodies

HF: Micrograin carbide
PVD: Physical vapour deposition

	JP5530	JP8725	JP9535	JP9635	JU6520
	HF PVD	HF PVD	HF PVD	HF PVD	HF
Stable machining, light cut (● 1st choice, ○ suitable)		○			●
General machining, medium cut (● 1st choice, ○ suitable)	●	●	●	●	●
Unstable machining, heavy cut (● 1st choice, ○ suitable)	○		●	●	

Dimensions



4 edges

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

ISO	JP5530	JP8725	JP9535	JP9635	JU6520
P	**120** **240**	**120** **240**			
M	40 100		**80** **160**	**80** **160**	
K	**120** **180**				
N					**240** **400**
S					
H					

	Designation		RE	IC	S	D1	LE	JP5530	JP8725	JP9535	JP9635	JU6520	Stock
GENERAL	GP P M K	SPMX050204-GP	0.4	5	2.38	2.5	4.2	●	●	●			
		SPMX060204-GP	0.4	6	2.38	2.8	5.2	●	●	●			
		SPMX07T308-GP	0.8	7.94	3.97	2.8	6.34	●	●	●			
		SPMX090408-GP	0.8	9.8	4.3	4.2	8.2	●	●	▲	●		
		SPMX110408-GP	0.8	11.5	4.76	4.4	9.9	●	●	●			
		SPMX140512-GP	1.2	14.3	5.2	5.5	11.9	●	●	▲	●		
ALUMINIUM	AL N periphery ground polished surface	SPGX050204-AL	0.4	5	2.38	2.5	4.2					●	
		SPGX060204-AL	0.4	6	2.38	2.8	5.2					●	
		SPGX07T308-AL	0.8	7.94	3.97	2.8	6.34					●	
		SPGX090408-AL	0.8	9.8	4.3	4.2	8.2					●	
		SPGX110408-AL	0.8	11.5	4.76	4.4	9.9					●	
		SPGX140512-AL	1.2	14.3	5.2	5.5	11.9					●	

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

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ISO 513	MATERIAL	HARDNESS HB	L/D	DC 12.50 ÷ 15.00			DC 15.50 ÷ 21.50			DC 22.00 ÷ 27.50		
				min	start	max	min	start	max	min	start	max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	2xD - 3xD	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.05	**0.09**	0.13
			4xD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.04	**0.08**	0.12
			5xD	0.04	**0.05**	0.06	0.04	**0.06**	0.08	0.04	**0.07**	0.10
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	2xD - 3xD	0.07	**0.10**	0.13	0.07	**0.11**	0.15	0.09	**0.13**	0.17
			4xD	0.06	**0.09**	0.12	0.06	**0.10**	0.14	0.08	**0.12**	0.16
			5xD	0.06	**0.08**	0.10	0.06	**0.09**	0.12	0.08	**0.11**	0.14
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	2xD - 3xD	0.07	**0.09**	0.11	0.07	**0.10**	0.13	0.09	**0.12**	0.15
			4xD	0.06	**0.08**	0.10	0.06	**0.09**	0.12	0.08	**0.11**	0.14
			5xD	0.06	**0.07**	0.08	0.06	**0.08**	0.10	0.08	**0.10**	0.12
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	2xD - 3xD	0.06	**0.09**	0.12	0.06	**0.10**	0.14	0.06	**0.11**	0.16
			4xD	0.05	**0.08**	0.11	0.05	**0.09**	0.13	0.05	**0.10**	0.15
			5xD	0.05	**0.06**	0.07	0.05	**0.08**	0.11	0.05	**0.09**	0.13
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	2xD - 3xD	0.05	**0.08**	0.11	0.05	**0.09**	0.13	0.05	**0.10**	0.15
			4xD	0.04	**0.07**	0.10	0.04	**0.08**	0.12	0.04	**0.09**	0.14
			5xD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.04	**0.08**	0.12
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	2xD - 3xD	0.06	**0.08**	0.10	0.06	**0.09**	0.12	0.06	**0.10**	0.14
			4xD	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.05	**0.09**	0.13
			5xD	0.05	**0.06**	0.07	0.05	**0.06**	0.07	0.05	**0.08**	0.11
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		2xD - 3xD	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.05	**0.09**	0.13
			4xD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.04	**0.08**	0.12
			5XD	0.04	**0.05**	0.06	0.04	**0.06**	0.08	0.04	**0.07**	0.10
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	2xD - 3xD	0.07	**0.10**	0.13	0.09	**0.13**	0.17	0.11	**0.15**	0.19
			4xD	0.06	**0.09**	0.12	0.08	**0.12**	0.16	0.10	**0.14**	0.18
			5xD	0.06	**0.08**	0.10	0.08	**0.11**	0.14	0.10	**0.13**	0.16
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	2xD - 3xD	0.07	**0.09**	0.11	0.08	**0.12**	0.16	0.09	**0.14**	0.19
			4xD	0.06	**0.08**	0.10	0.07	**0.11**	0.15	0.08	**0.13**	0.18
			5xD	0.06	**0.07**	0.08	0.07	**0.10**	0.13	0.08	**0.12**	0.16
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		2xD - 3xD	0.07	**0.11**	0.15	0.07	**0.12**	0.17	0.09	**0.14**	0.19
			4xD	0.06	**0.10**	0.14	0.06	**0.11**	0.16	0.08	**0.13**	0.18
			5xD	0.06	**0.09**	0.12	0.06	**0.10**	0.14	0.08	**0.12**	0.16
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		2xD - 3xD	0.07	**0.10**	0.13	0.07	**0.11**	0.15	0.09	**0.13**	0.17
			4xD	0.06	**0.09**	0.12	0.06	**0.10**	0.14	0.08	**0.12**	0.16
			5xD	0.06	**0.08**	0.10	0.06	**0.09**	0.12	0.08	**0.11**	0.14

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DC 28.00 ÷ 33.00			DC 34.00 ÷ 41.00			DC 42.00 ÷ 50.00					
min	start	max	min	start	max	min	start	max			
0.06	**0.10**	0.14	0.07	**0.11**	0.15	0.07	**0.12**	0.17			
0.05	**0.09**	0.13	0.06	**0.10**	0.14	0.06	**0.11**	0.16			
0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.06	**0.10**	0.14			
0.09	**0.14**	0.19	0.11	**0.16**	0.21	0.11	**0.17**	0.23			
0.08	**0.13**	0.18	0.10	**0.15**	0.20	0.10	**0.16**	0.22			
0.08	**0.12**	0.16	0.10	**0.14**	0.18	0.10	**0.15**	0.20			
0.09	**0.13**	0.17	0.09	**0.14**	0.19	0.11	**0.16**	0.21			
0.08	**0.12**	0.16	0.08	**0.13**	0.18	0.10	**0.15**	0.20			
0.08	**0.11**	0.14	0.08	**0.12**	0.16	0.10	**0.14**	0.18			
0.07	**0.12**	0.17	0.08	**0.12**	0.18	0.09	**0.14**	0.19			
0.06	**0.11**	0.16	0.07	**0.11**	0.17	0.08	**0.13**	0.18			
0.06	**0.10**	0.14	0.07	**0.10**	0.13	0.08	**0.12**	0.16			
0.06	**0.11**	0.16	0.07	**0.12**	0.17	0.09	**0.13**	0.17			
0.05	**0.10**	0.15	0.06	**0.11**	0.16	0.08	**0.12**	0.16			
0.05	**0.09**	0.13	0.06	**0.10**	0.14	0.08	**0.11**	0.14			
0.07	**0.11**	0.15	0.08	**0.12**	0.16	0.09	**0.13**	0.17			
0.06	**0.10**	0.14	0.07	**0.11**	0.15	0.08	**0.12**	0.16			
0.06	**0.09**	0.12	0.07	**0.10**	0.13	0.08	**0.11**	0.14			
0.06	**0.10**	0.14	0.07	**0.11**	0.15	0.09	**0.12**	0.15			
0.05	**0.09**	0.13	0.06	**0.10**	0.14	0.08	**0.11**	0.14			
0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.08	**0.10**	0.12			
0.11	**0.17**	0.23	0.13	**0.19**	0.25	0.15	**0.21**	0.27			
0.10	**0.16**	0.22	0.12	**0.18**	0.24	0.14	**0.20**	0.26			
0.10	**0.15**	0.20	0.12	**0.17**	0.22	0.14	**0.19**	0.24			
0.11	**0.16**	0.21	0.13	**0.17**	0.21	0.15	**0.19**	0.23			
0.10	**0.15**	0.20	0.12	**0.16**	0.20	0.14	**0.18**	0.22			
0.10	**0.14**	0.18	0.12	**0.15**	0.18	0.14	**0.17**	0.20			
0.09	**0.15**	0.21	0.11	**0.17**	0.23	0.13	**0.18**	0.23			
0.08	**0.14**	0.20	0.10	**0.16**	0.22	0.12	**0.17**	0.22			
0.08	**0.13**	0.18	0.10	**0.15**	0.20	0.12	**0.16**	0.20			
0.09	**0.14**	0.19	0.11	**0.16**	0.21	0.13	**0.17**	0.21			
0.08	**0.13**	0.18	0.10	**0.15**	0.20	0.12	**0.16**	0.20			
0.08	**0.12**	0.16	0.10	**0.14**	0.18	0.12	**0.15**	0.18			

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DRILLING Parameters - cutting speed · DRS

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ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max	JP8725 min	JP8725 start	JP8725 max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	2XD ÷ 5XD	120	**180**	240	120	**180**	240
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	2XD ÷ 5XD	100	**150**	200	100	**150**	200
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	2XD ÷ 5XD	80	**120**	160	80	**120**	160
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max	JP9535 min	JP9535 start	JP9535 max
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	2XD ÷ 5XD	50	**90**	130	80	**120**	160
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	2XD ÷ 5XD		-		60	**90**	120
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	2XD ÷ 5XD	40	**70**	100	80	**120**	160
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		2XD ÷ 5XD		-		60	**100**	140
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max			
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	2XD ÷ 5XD	120	**150**	180			
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	2XD ÷ 5XD	100	**120**	140			
ISO 513	MATERIAL	HARDNESS HB	L/D	JU6520 min	JU6520 start	JU6520 max			
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		2XD ÷ 5XD	240	**320**	400			
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		2XD ÷ 5XD	160	**230**	300			

Complete workpiece materials p. **H**1.

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DRS PILOT

For extra deep holes - High performance indexable drilling system

APPLICATION

Plane surface	Concave surface	Convex surface	Pipes

ISO APPLICATION FIELDS

P M K N

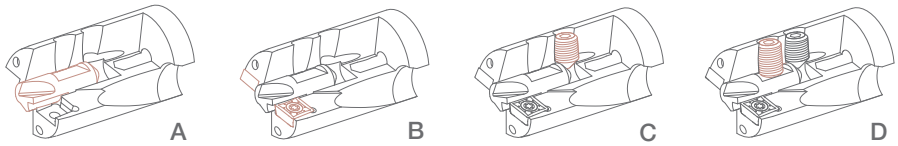
ADVANTAGES AND CHARACTERISTICS

- Highly universal drilling system suitable for diverse conditions
- Highly cost-efficient system for deep hole drilling
- The use of pilot provides better centering effect
- Straight flute design improves chip evacuation and strengthens the body

Drilling bodies

- Weldon shank with internal coolant
- 6xD and 9xD available from D18 to D30
- Special length and stepped body available upon request

Installation of inserts and pilot drill



A Insert DRSP pilot in the drilling body.

B Install the SPMX/SPGX inserts.

C Adjust the DRSP pilot height using the setting grain.

D Screw tight the locking grain.

For pilot adjustement see page E22.

Inserts

- Available sizes 05/06/07
- Cemented carbide grades with PVD coatings or uncoated for N materials
- Geometries: GP, AL
- Pilot drill made of coated premium HSS

GP P M K

SIZE
05 06 07

AL N

SIZE
05 06 07

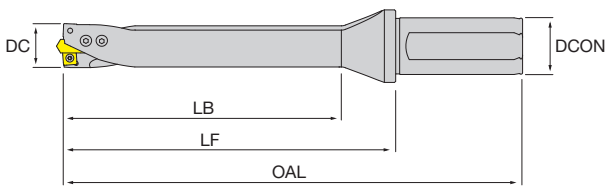
Pilot P M K N

SIZE
06 08

6xD

DRS pilot

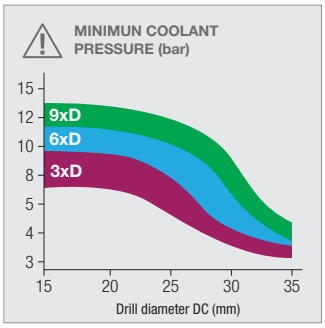
- 6xD indexable drill body with pilot and seats for SP inserts with straight flutes
- All with coolant through
- Please select insert and pilot size according to the drill diameter

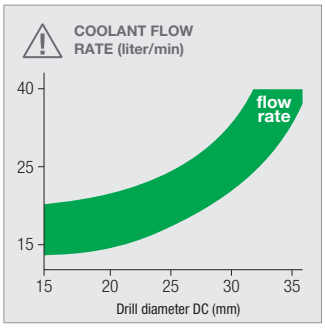


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DRS-6D D18.00-S25-05P6	●	18	25	191	135	112				DRSP06	SPoX05
NT-DRS-6D D19.00-S25-05P6	●	19	25	197	141	118				DRSP06	SPoX05
NT-DRS-6D D20.00-S25-06P6	●	20	25	203	147	124				DRSP06	SPoX06
NT-DRS-6D D21.00-S25-06P6	●	21	25	209	153	130				DRSP06	SPoX06
NT-DRS-6D D22.00-S25-06P6	●	22	25	215	159	136				DRSP06	SPoX06
NT-DRS-6D D23.00-S32-06P6	●	23	32	228	168	142				DRSP06	SPoX06
NT-DRS-6D D24.00-S32-06P6	●	24	32	234	174	148				DRSP06	SPoX06
NT-DRS-6D D25.00-S32-06P6	●	25	32	240	180	154				DRSP06	SPoX06
NT-DRS-6D D26.00-S32-07P8	●	26	32	246	186	160				DRSP08	SPoX07
NT-DRS-6D D27.00-S32-07P8	●	27	32	252	192	166				DRSP08	SPoX07
NT-DRS-6D D28.00-S32-07P8	●	28	32	258	198	172				DRSP08	SPoX07
NT-DRS-6D D29.00-S32-07P8	●	29	32	264	204	178				DRSP08	SPoX07
NT-DRS-6D D30.00-S32-07P8	●	30	32	270	210	184				DRSP08	SPoX07

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

Spare parts	Insert screws	Flag wrenches	Locking grains	Setting grains	L wrench
NT-DRS-6D (DC 18÷19)	NT-ST20043T06	NT-FTB06	NT-ST042	NT-ST043	NT-WR025
NT-DRS-6D (DC 20÷22)	NT-ST22055T06	NT-FTB06	NT-ST042	NT-ST043	NT-WR025
NT-DRS-6D (DC 23÷25)	NT-ST22055T06	NT-FTB06	NT-ST044	NT-ST045	NT-WR025
NT-DRS-6D (DC 26÷30)	NT-ST25065T07	NT-FTB07	NT-ST046	NT-ST047	NT-WR030

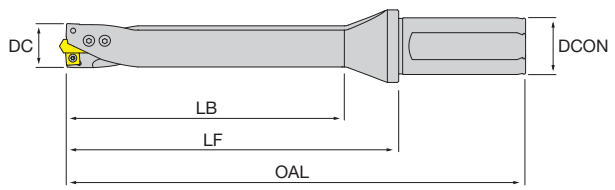




9xD

DRS pilot

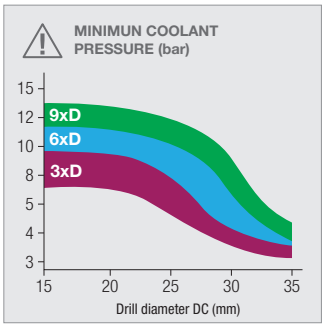
- 9xD indexable drill body with pilot and seats for SP inserts with straight flutes
- All with coolant through
- Please select insert and pilot size according to the drill diameter

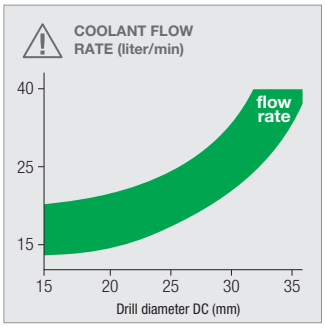


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DRS-9D D18.00-S25-05P6	●	18	25	245	189	166				DRSP06	SPoX05
NT-DRS-9D D19.00-S25-05P6	●	19	25	254	198	175				DRSP06	SPoX05
NT-DRS-9D D20.00-S25-06P6	●	20	25	263	207	184				DRSP06	SPoX06
NT-DRS-9D D21.00-S25-06P6	●	21	25	272	216	193				DRSP06	SPoX06
NT-DRS-9D D22.00-S25-06P6	●	22	25	281	225	202				DRSP06	SPoX06
NT-DRS-9D D23.00-S32-06P6	●	23	32	297	237	211				DRSP06	SPoX06
NT-DRS-9D D24.00-S32-06P6	●	24	32	306	246	220				DRSP06	SPoX06
NT-DRS-9D D25.00-S32-06P6	●	25	32	315	255	229				DRSP06	SPoX06
NT-DRS-9D D26.00-S32-07P8	●	26	32	324	264	238				DRSP08	SPoX07
NT-DRS-9D D27.00-S32-07P8	●	27	32	333	273	247				DRSP08	SPoX07
NT-DRS-9D D28.00-S32-07P8	●	28	32	342	282	256				DRSP08	SPoX07
NT-DRS-9D D29.00-S32-07P8	●	29	32	351	291	265				DRSP08	SPoX07
NT-DRS-9D D30.00-S32-07P8	●	30	32	360	300	274				DRSP08	SPoX07

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

Spare parts	Insert screws	Flag wrenches	Locking grains	Setting grains	L wrench
NT-DRS-6D (DC 18÷19)	NT-ST20043T06	NT-FTB06	NT-ST042	NT-ST043	NT-WR025
NT-DRS-6D (DC 20÷22)	NT-ST22055T06	NT-FTB06	NT-ST042	NT-ST043	NT-WR025
NT-DRS-6D (DC 23÷25)	NT-ST22055T06	NT-FTB06	NT-ST044	NT-ST045	NT-WR025
NT-DRS-6D (DC 26÷30)	NT-ST25065T07	NT-FTB07	NT-ST046	NT-ST047	NT-WR030





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SPoX

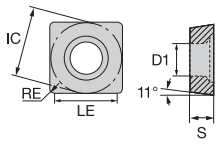
DRS pilot

- General purpose type or fine polished sharp geometries for aluminum or non-ferrous materials available
- Diverse PVD coated carbide grades available
- Inserts could also be mounted on Chamfer-Square milling bodies

HF: Micrograin carbide
PVD: Physical vapour deposition

	JP5530	JP8725	JP9535	JU6520
	HF PVD	HF PVD	HF PVD	HF
Stable machining, light cut (● 1st choice, ○ suitable)		○		●
General machining, medium cut (● 1st choice, ○ suitable)	●	●	●	●
Unstable machining, heavy cut (● 1st choice, ○ suitable)	○		●	

Dimensions



4 edges

ISO	JP5530	JP8725	JP9535	JU6520
	HF PVD	HF PVD	HF PVD	HF
	Vc(m/min) - suggested cutting speed range (bold: 1st choice)			
P	**90** **200**	**90** **200**		
M	30 85		**50** **130**	
K	**90** **150**			
N				**160** **320**
S				
H				

	Designation		RE	IC	S	D1	LE	JP5530	JP8725	JP9535	JU6520	Stock
GENERAL	GP P M K	SPMX050204-GP	0.4	5	2.38	2.5	4.2	●	●	●		
		SPMX060204-GP	0.4	6	2.38	2.8	5.2	●	●	●		
		SPMX07T308-GP	0.8	7.94	3.97	2.8	6.34	●	●	●		
ALUMINIUM	AL N periphery ground polished surface	SPGX050204-AL	0.4	5	2.38	2.5	4.2				●	
		SPGX060204-AL	0.4	6	2.38	2.8	5.2				●	
		SPGX07T308-AL	0.8	7.94	3.97	2.8	6.34				●	

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

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Pilot

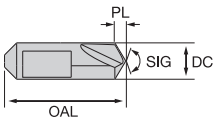
DRS pilot

- TIN coated HSS pilot for DRS PILOT drills
- 1 Pilot is already pre-mounted on DRS Pilot drill body
- Universal use for PMKN materials
- Cannot be mounted on DEX Pilot

Hss: High speed steel
PVD: Physical vapour deposition

		Hss PVD	HSS TIN
Stable machining, light cut	● 1st choice ○ suitable		
General machining, medium cut	● 1st choice ○ suitable	●	
Unstable machining, heavy cut	● 1st choice ○ suitable	●	

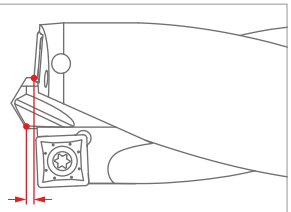
Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	**90** 200	
M	**50** 130	
K	**90** 150	
N	**160** 320	
S		
H		

	Designation	DC	OAL	PL	SIG		Stock	
GENERAL	GP P M K N DRSP06-GP	6	20	1.5	118°		●	
	DRSP08-GP	8	25	2.1	118°		●	

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



pilot height

MATERIAL	6xD	9xD
P M K	1.0 mm	1.4 mm
N	1.5 mm	1.7 mm

ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max	JP8725 min	JP8725 start	JP8725 max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	6XD	100	**150**	200	100	**150**	200
			9XD	90	**130**	170	90	**130**	170
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	6XD	80	**120**	160	80	**120**	160
			9XD	70	**105**	140	70	**105**	140
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	6XD	65	**95**	125	65	**95**	125
			9XD	55	**85**	115	55	**85**	115
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max	JP9535 min	JP9535 start	JP9535 max
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	6XD	40	**80**	120	70	**100**	130
			9XD	30	**60**	90	50	**80**	110
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	6XD		-		60	**80**	100
			9XD		-		50	**70**	90
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	6XD	35	**60**	85	70	**100**	130
			9XD	30	**50**	70	50	**80**	110
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		6XD		-		60	**90**	120
			9XD		-		50	**80**	110
ISO 513	MATERIAL	HARDNESS HB	L/D	JP5530 min	JP5530 start	JP5530 max			
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	6XD	110	**130**	150			
			9XD	90	**110**	130			
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	6XD	80	**100**	120			
			9XD	70	**90**	110			
ISO 513	MATERIAL	HARDNESS HB	L/D	JU6520 min	JU6520 start	JU6520 max			
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		6XD	200	**260**	320			
			9XD	160	**220**	280			
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		6XD	120	**180**	240			
			9XD	100	**150**	200			

Complete workpiece materials p. **H**1.

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ISO 513	MATERIAL	HARDNESS HB	L/D	DC 18.00 ÷ 19.00			DC 20.00 ÷ 25.00			DC 26.00 ÷ 30.00		
				min	start	max	min	start	max	min	start	max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	6XD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.05	**0.08**	0.11
			9XD	0.04	**0.05**	0.06	0.04	**0.06**	0.08	0.05	**0.07**	0.09
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	6XD	0.06	**0.09**	0.12	0.08	**0.11**	0.14	0.08	**0.12**	0.16
			9XD	0.06	**0.08**	0.10	0.08	**0.10**	0.12	0.08	**0.11**	0.14
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	6XD	0.06	**0.08**	0.10	0.08	**0.10**	0.12	0.08	**0.11**	0.14
			9XD	0.06	**0.07**	0.08	0.08	**0.09**	0.10	0.08	**0.10**	0.12
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	6XD	0.05	**0.08**	0.11	0.05	**0.09**	0.13	0.06	**0.10**	0.14
			9XD	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.06	**0.09**	0.12
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	6XD	0.04	**0.07**	0.10	0.04	**0.08**	0.12	0.05	**0.09**	0.13
			9XD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.05	**0.08**	0.11
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	6XD	0.05	**0.06**	0.07	0.05	**0.08**	0.11	0.06	**0.09**	0.12
			9XD	0.04	**0.05**	0.06	0.05	**0.07**	0.09	0.06	**0.08**	0.10
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		6XD	0.04	**0.06**	0.08	0.04	**0.07**	0.10	0.05	**0.08**	0.11
			9XD	0.03	**0.05**	0.07	0.04	**0.06**	0.08	0.05	**0.07**	0.09
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	6XD	0.08	**0.11**	0.14	0.10	**0.13**	0.16	0.10	**0.15**	0.20
			9XD	0.08	**0.10**	0.12	0.10	**0.12**	0.14	0.10	**0.14**	0.18
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	6XD	0.07	**0.10**	0.13	0.08	**0.12**	0.16	0.10	**0.14**	0.18
			9XD	0.07	**0.08**	0.11	0.08	**0.11**	0.14	0.10	**0.13**	0.16
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		6XD	0.06	**0.10**	0.14	0.08	**0.12**	0.16	0.08	**0.13**	0.18
			9XD	0.06	**0.09**	0.12	0.08	**0.11**	0.14	0.08	**0.12**	0.16
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		6XD	0.06	**0.09**	0.12	0.08	**0.11**	0.14	0.08	**0.12**	0.16
			9XD	0.06	**0.08**	0.10	0.08	**0.10**	0.12	0.08	**0.11**	0.14

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DEX DRILLS

High productivity indexable drilling system with exchangeable heads

APPLICATION

Plane surface	Concave surface	Convex surface	Stacked plates	Pipes

ISO APPLICATION FIELDS

P M K

ADVANTAGES AND CHARACTERISTICS

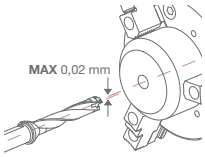
- High reliable quick change indexable drilling system
- Solid drill head with 3D geometry, adapted for high feed rate and provides high efficiency in machining
- Attracting cost efficiency per hole, good replacement for regrind solid carbide drills

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

Center of arbor deviation must be under 0.02mm.

Milling machine



Keep under 0.02mm the maximum deviation between drill and workpiece.

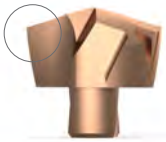
Lathe

Inserts

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

GP P K

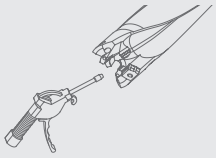
SC P M



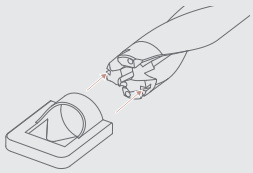
TE K

FT P K

DRILLING HEADS INSTALLATON



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



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

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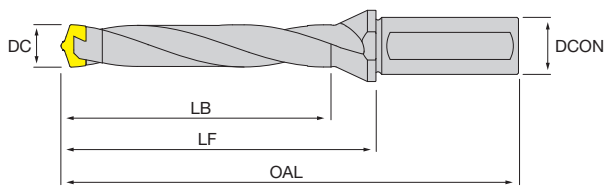
3xD

DEX drill

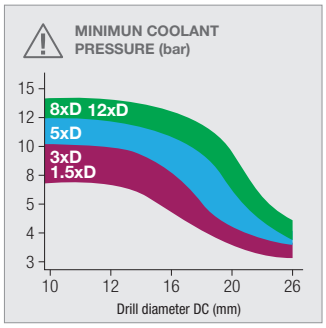
- 3xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fits into the same body, please check MIID column
- Special diameters or stepped type available upon requests

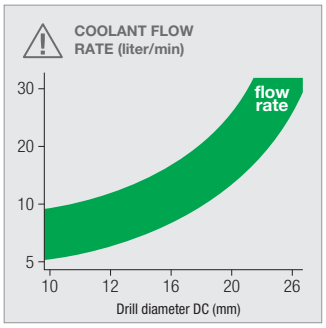


Designation	Stock	DC	DCON	OAL	LF	LB					MIID
NT-DEX-3D D10-S16F	●	10	16	95	47	38					DEX10oo
NT-DEX-3D D11-S16F	●	11	16	98	50	39					DEX11oo
NT-DEX-3D D12-S16F	●	12	16	104	56	44					DEX12oo
NT-DEX-3D D13-S16F	●	13	16	108	60	47					DEX13oo
NT-DEX-3D D14-S16F	●	14	16	112	64	50					DEX14oo
NT-DEX-3D D15-S20F	●	15	20	118	68	53					DEX15oo
NT-DEX-3D D16-S20F	●	16	20	122	72	56					DEX16oo
NT-DEX-3D D17-S20F	●	17	20	126	76	59					DEX17oo
NT-DEX-3D D18-S25F	●	18	25	136	80	62					DEX18oo
NT-DEX-3D D19-S25F	●	19	25	140	84	65					DEX19oo
NT-DEX-3D D20-S25F	●	20	25	144	88	68					DEX20oo
NT-DEX-3D D21-S25F	●	21	25	152	96	75					DEX21oo
NT-DEX-3D D22-S25F	●	22	25	157	101	81					DEX22oo
NT-DEX-3D D23-S32F	●	23	32	165	105	82					DEX23oo
NT-DEX-3D D24-S32F	●	24	32	170	110	86					DEX24oo
NT-DEX-3D D25/26-S32F	●	25	32	175	115	89					DEX25/26oo

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

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



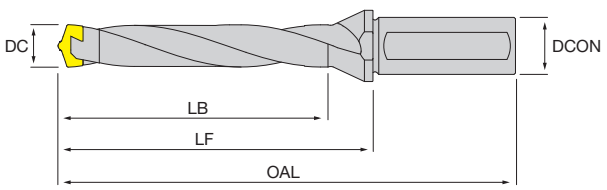


A - TURNING
B - THREADING
C - GROOVING
D - MILLING
E - DRILLING
F - ACCESSORIES
G - SPARE PARTS

5xD

DEX drill

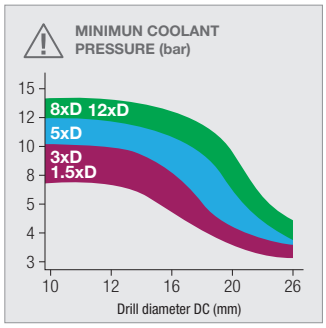
- 5xD indexable drill body for DEX drill head
- All with coolant through
- Different drill heads can fits into the same body, please check MIID column
- Special diameters or stepped type available upon requests

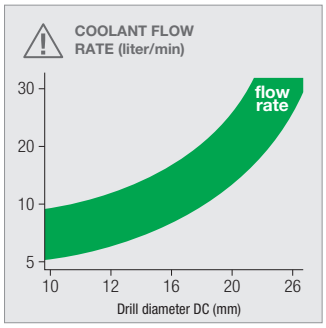


Designation	Stock	DC	DCON	OAL	LF	LB					MIID
NT-DEX-5D D10-S16F	●	10	16	116	68	59					DEX10oo
NT-DEX-5D D11-S16F	●	11	16	121	73	62					DEX11oo
NT-DEX-5D D12-S16F	●	12	16	130	82	70					DEX12oo
NT-DEX-5D D13-S16F	●	13	16	136	88	75					DEX13oo
NT-DEX-5D D14-S16F	●	14	16	142	94	80					DEX14oo
NT-DEX-5D D15-S20F	●	15	20	150	100	85					DEX15oo
NT-DEX-5D D16-S20F	●	16	20	156	106	90					DEX16oo
NT-DEX-5D D17-S20F	●	17	20	162	112	95					DEX17oo
NT-DEX-5D D18-S25F	●	18	25	174	118	100					DEX18oo
NT-DEX-5D D19-S25F	●	19	25	180	124	105					DEX19oo
NT-DEX-5D D20-S25F	●	20	25	186	130	110					DEX20oo
NT-DEX-5D D21-S25F	●	21	25	194	138	117					DEX21oo
NT-DEX-5D D22-S25F	●	22	25	201	145	125					DEX22oo
NT-DEX-5D D23-S32F	●	23	32	211	151	128					DEX23oo
NT-DEX-5D D24-S32F	●	24	32	218	158	134					DEX24oo
NT-DEX-5D D25/26-S32F	●	25	32	225	165	139					DEX25/26oo

● 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





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Heads

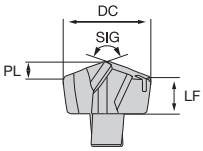
DEX drill

- 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
- Can fit with 3xD or 5xD DEX drill bodies
- Diameters out of catalogue can be made upon request
- Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests

HF: Micrograin carbide
PVD: Physical vapour deposition

		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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

GP - Chisel edge

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

GP - Outer corner

Small chamfer for very good edge protection in general machining.

GP - Gash geometry

Gashing design allows good chip evacuation and reduce thrust load.

nikkoTOOLS

Heads

DEX drill

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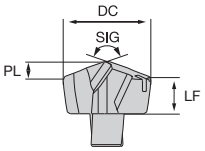
		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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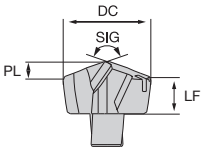
		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		



Dimensions	ISO	JP5625	JP5725	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
	P	55 160	55 160	
	M			
	K	60 140	60 140	
	N			
	S			
	H			

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

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

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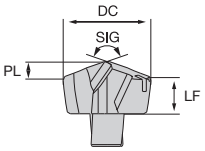
PVD: Physical vapour deposition

	HF PVD	HF PVD
	JP5625	JP5725
Stable machining, light cut (● 1st choice, ○ suitable)	○	○
General machining, medium cut (● 1st choice, ○ suitable)	●	●
Unstable machining, heavy cut (● 1st choice, ○ suitable)		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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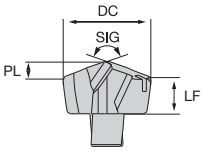
		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		



Dimensions	ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)
	P	55 160	55 160	
	M			
	K	60 140	60 140	
	N			
	S			
	H			

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

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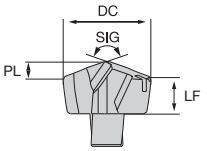
	HF PVD	HF PVD
	JP5625	JP5725
Stable machining, light cut (● 1st choice, ○ suitable)	○	○
General machining, medium cut (● 1st choice, ○ suitable)	●	●
Unstable machining, heavy cut (● 1st choice, ○ suitable)		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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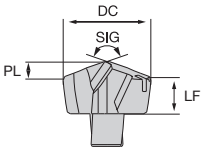
		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

	Designation		DC	DC toll.	SIG	PL	LF	JP5625	JP5725	Stock
GENERAL	GP 24oo P K	DEX2400-GP	24	k6	140°	4.36	9.54	●	▲	
		DEX2450-GP	24.5	k6	140°	4.46	9.44		●	
GENERAL	GP 25oo P K	DEX2500-GP	25	k6	140°	4.55	9.95		●	
		DEX2550-GP	25.5	k6	140°	4.64	9.86	●	▲	
		DEX2600-GP	26	k6	140°	4.73	9.86		●	

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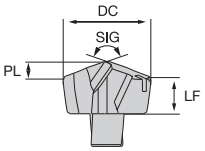
	HF PVD
	JP5630
Stable machining, light cut: ● 1st choice ○ suitable	
General machining, medium cut: ● 1st choice ○ suitable	●
Unstable machining, heavy cut: ● 1st choice ○ suitable	○

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	55 160	
M	30 80	
K		
N		
S		
H		

	Designation		DC	DC toll.	SIG	PL	LF	Stock	
LOW FORCE	SC 10oo P M	DEX1000-SC	10	k6	140°	1.78	4.42	●	
		DEX1010-SC	10.1	k6	140°	1.8	4.4	○	
		DEX1020-SC	10.2	k6	140°	1.82	4.38	●	
		DEX1030-SC	10.3	k6	140°	1.84	4.36	●	
		DEX1040-SC	10.4	k6	140°	1.86	4.34	●	
		DEX1050-SC	10.5	k6	140°	1.88	4.32	●	
		DEX1060-SC	10.6	k6	140°	1.9	4.3	○	
		DEX1070-SC	10.7	k6	140°	1.92	4.28	○	
		DEX1080-SC	10.8	k6	140°	1.94	4.26	○	
		DEX1090-SC	10.9	k6	140°	1.96	4.24	○	
LOW FORCE	SC 11oo 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

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

SC - Outer corner

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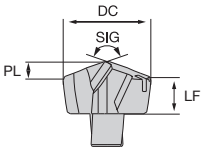
	HF PVD
	JP5630
Stable machining, light cut	● 1st choice ○ suitable
General machining, medium cut	● 1st choice ○ suitable
Unstable machining, heavy cut	● 1st choice ○ suitable

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	55 160
M	30 80
K	
N	
S	
H	

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

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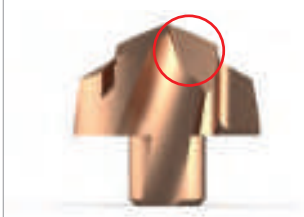

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	HF PVD
	JP5630
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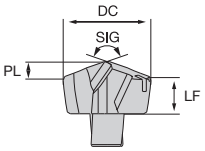
General machining, medium cut	● 1st choice ○ suitable
Unstable machining, heavy cut	● 1st choice ○ suitable

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	55 160
M	30 80
K	
N	
S	
H	

	Designation		DC	DC toll.	SIG	PL	LF	Stock
LOW FORCE	SC 14oo 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 15oo 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

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nikkoTOOLS

Heads

DEX drill

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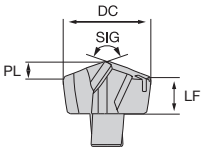
	HF PVD
	JP5630
Stable machining, light cut	● 1st choice ○ suitable
General machining, medium cut	● 1st choice ○ suitable
Unstable machining, heavy cut	● 1st choice ○ suitable

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	55 160
M	30 80
K	
N	
S	
H	

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

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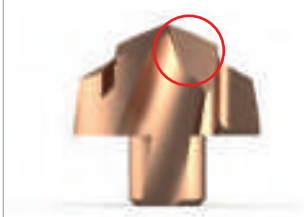

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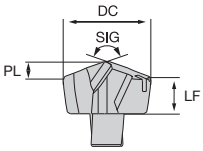
	HF PVD
	JP5630
Stable machining, light cut: ● 1st choice ○ suitable	
General machining, medium cut: ● 1st choice ○ suitable	●
Unstable machining, heavy cut: ● 1st choice ○ suitable	○

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	55 160
M	30 80
K	
N	
S	
H	

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

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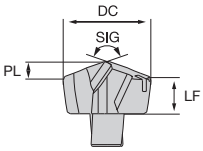
	HF PVD	JP5630
Stable machining, light cut (● 1st choice, ○ suitable)		
General machining, medium cut (● 1st choice, ○ suitable)	●	
Unstable machining, heavy cut (● 1st choice, ○ suitable)	○	

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	55 160	
M	30 80	
K		
N		
S		
H		

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

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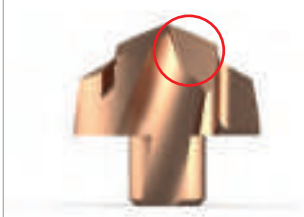

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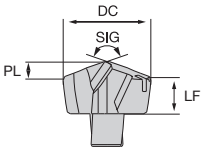
	HF PVD	JP5630
Stable machining, light cut	1st choice / suitable	
General machining, medium cut	1st choice / suitable	1st choice
Unstable machining, heavy cut	1st choice / suitable	suitable



Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
	P	55 160
	M	30 80
	K	
	N	
	S	
	H	

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

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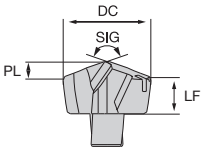
	HF PVD
	JP7625
Stable machining, light cut	● 1st choice ○ suitable
General machining, medium cut	● 1st choice ○ suitable
Unstable machining, heavy cut	● 1st choice ○ suitable

Dimensions



ISO	JP7625	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P		
M		
K	70 160	
N		
S		
H		

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

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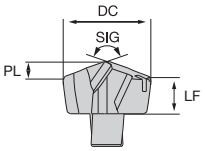
Stable machining, light cut	● 1st choice ○ suitable
General machining, medium cut	● 1st choice ○ suitable
Unstable machining, heavy cut	● 1st choice ○ suitable

Dimensions



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P	
M	
K	70 160
N	
S	
H	

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

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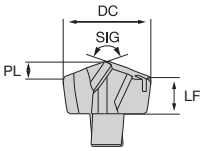

ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	
M	
K	70 160
N	
S	
H	

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

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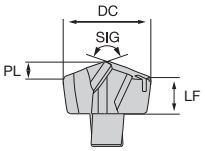
	HF PVD
	JP7625
Stable machining, light cut (1st choice / suitable)	
General machining, medium cut (1st choice / suitable)	●
Unstable machining, heavy cut (1st choice / suitable)	



Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
	P	
	M	
	K	70 160
	N	
	S	
	H	

	Designation	DC	DC toll.	SIG	PL	LF	Stock
REINFORCED TE 25oo K	DEX2500-TE	25	k6	140°	4.55	9.95	●
	DEX2550-TE	25.5	k6	140°	4.64	9.86	●
	DEX2600-TE	26	k6	140°	4.73	9.86	●

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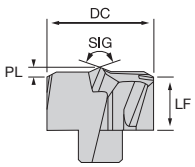
		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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

CUTTING CONDITIONS

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

nikkoTOOLS

Heads

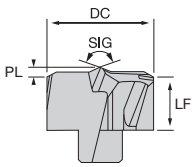
DEX drill

- GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes
- Can fit with 3xD or 5xD DEX drill bodies
- Diameters out of catalogue can be made upon request
- Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests

HF: Micrograin carbide
PVD: Physical vapour deposition

		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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

CUTTING CONDITIONS

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

nikkoTOOLS

Heads

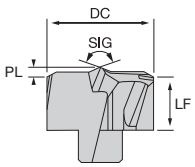
DEX drill

- GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes
- Can fit with 3xD or 5xD DEX drill bodies
- Diameters out of catalogue can be made upon request
- Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests

HF: Micrograin carbide
PVD: Physical vapour deposition

		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

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

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

CUTTING CONDITIONS

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

Heads

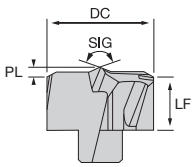
DEX drill

- GP geometry is for general purpose use, SC geometry is more featured for stainless, and TE geometry is more featured for cast iron, FT is for making flat-bottom holes
- Can fit with 3xD or 5xD DEX drill bodies
- Diameters out of catalogue can be made upon request
- Step drill (step on the drill head or with chamfer insert on the drill body) or 1.5/ 8/ 12xD available upon requests

HF: Micrograin carbide
PVD: Physical vapour deposition

		HF PVD	HF PVD
		JP5625	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	○
General machining, medium cut	● 1st choice ○ suitable	●	●
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	JP5625	JP5725
P	55 160	55 160
M		
K	60 140	60 140
N		
S		
H		

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

	Designation	DC	DC toll.	SIG	PL	LF			Stock
FLAT TYPE	FT 25oo 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.

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

Complete workpiece materials p. **H**1.

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

Complete workpiece materials p. **H**1.

(fn: mm/rev)

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

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DXP

For extra deep holes - Indexable drilling system with exchangeable heads

APPLICATION

Plane surface	Concave surface	Convex surface	Stacked plates	Pipes

ISO APPLICATION FIELDS

P K

ADVANTAGES AND CHARACTERISTICS

· High performance deep hole modular drilling system
· Pilot enables better centering in deep hole drilling (available also in 3xD for who seeks better centering)
· Adapted for higher feed rate among indexable solutions

Drilling bodies

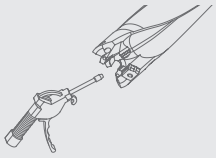
· Weldon shank with internal coolant
· 3/ 6/ 8/ 10xD available from D30 to D60
· Special length and stepped body available upon request

4 holes design

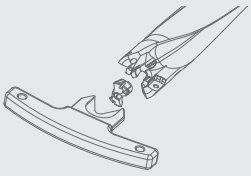
Inserts

· Pilot head available from D15 to D28 with HC geometry for perfect self-centering and reduces drilling force.
· Peripheral insert featuring CS geometry (Chip Splitter) designed to efficiently break and eject chips

DRILLING HEADS INSTALLATON



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



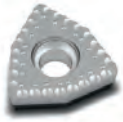
Set wrench into slots on insert flanks.
Slowly turn the wrench clockwise until stop.

HC P K

CS P K

SIZE
04

CS P K



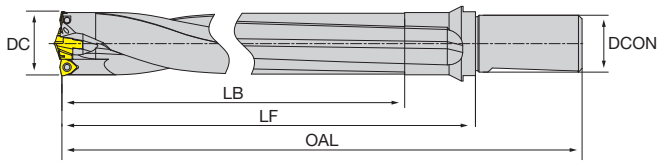
SIZE
05 06 08 10

nikkoTOOLS

3xD

DXP drill

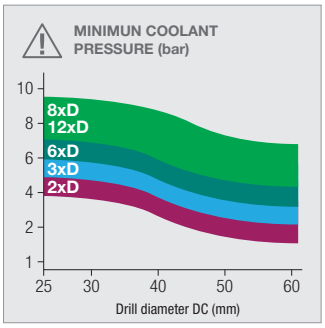
- 3xD pilot type drill body
- All with 4 coolant holes
- Please select inserts according to columns PILOT and MIID
- Peripheral inserts for D30 and D31 have a different shape compared to all the others

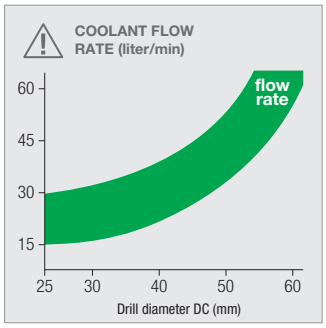


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DXP-03 D30-S32-P16E04	▲	30	32	185	125	99.9				DXP-P16	DXP-E04
NT-DXP-03 D31-S32-P17E04	▲	31	32	189	129	103.9				DXP-P17	DXP-E04
NT-DXP-03 D32-S32-P15E05	▲	32	32	194	134	105.7				DXP-P15	DXP-E05
NT-DXP-03 D33-S32-P16E05	▲	33	32	196	136	107.8				DXP-P16	DXP-E05
NT-DXP-03 D34-S32-P16E05	▲	34	32	199	139	110.8				DXP-P16	DXP-E05
NT-DXP-03 D35-S32-P18E05	▲	35	32	204	144	116.5				DXP-P18	DXP-E05
NT-DXP-03 D36-S32-P18E05	▲	36	32	206	146	118.5				DXP-P18	DXP-E05
NT-DXP-03 D37-S32-P16E06	▲	37	32	209	149	119.8				DXP-P16	DXP-E06
NT-DXP-03 D38-S32-P16E06	▲	38	32	214	154	122.8				DXP-P16	DXP-E06
NT-DXP-03 D39-S32-P18E06	▲	39	32	217	157	127.5				DXP-P18	DXP-E06
NT-DXP-03 D40-S32-P18E06	▲	40	32	234	164	131.5				DXP-P18	DXP-E06
NT-DXP-03 D41-S32-P19E06	▲	41	32	236	166	134				DXP-P19	DXP-E06
NT-DXP-03 D42-S50-P19E06	▲	42	50	240	170	137				DXP-P19	DXP-E06
NT-DXP-03 D43-S50-P16E08	▲	43	50	243	173	137.8				DXP-P16	DXP-E08
NT-DXP-03 D44-S50-P18E08	▲	44	50	246	176	142.5				DXP-P18	DXP-E08
NT-DXP-03 D45-S50-P18E08	▲	45	50	249	179	145.5				DXP-P18	DXP-E08
NT-DXP-03 D46-S50-P19E08	▲	46	50	252	182	149				DXP-P19	DXP-E08
NT-DXP-03 D47-S50-P20E08	▲	47	50	255	185	152.6				DXP-P20	DXP-E08
NT-DXP-03 D48-S50-P21E08	▲	48	50	259	189	156.1				DXP-P21	DXP-E08
NT-DXP-03 D49-S50-P22E08	▲	49	50	262	192	159.7				DXP-P22	DXP-E08
NT-DXP-03 D50-S50-P23E08	▲	50	50	265	195	163.3				DXP-P23	DXP-E08
NT-DXP-03 D51-S50-P24E08	▲	51	50	269	199	167.9				DXP-P24	DXP-E08
NT-DXP-03 D52-S50-P25E08	▲	52	50	280	210	170.5				DXP-P25	DXP-E08
NT-DXP-03 D53-S50-P26E08	▲	53	50	274	204	173.5				DXP-P26	DXP-E08
NT-DXP-03 D54-S50-P27E08	▲	54	50	278	208	178.5				DXP-P27	DXP-E08
NT-DXP-03 D55-S50-P28E08	▲	55	50	280	210	180.5				DXP-P28	DXP-E08
NT-DXP-03 D56-S50-P20E10	▲	56	50	283	213	179.6				DXP-P20	DXP-E10
NT-DXP-03 D57-S50-P21E10	▲	57	50	286	216	183.1				DXP-P21	DXP-E10
NT-DXP-03 D58-S50-P22E10	▲	58	50	289	219	186.7				DXP-P22	DXP-E10
NT-DXP-03 D59-S50-P23E10	▲	59	50	292	222	190.3				DXP-P23	DXP-E10
NT-DXP-03 D60-S50-P24E10	▲	60	50	295	225	193.9				DXP-P24	DXP-E10

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

Spare parts	Head wrench	Insert screws	Flag wrenches
NT-DXP-03 (DC 30)	NT-WR1416	NT-ST25080T09	NT-FTB09
NT-DXP-03 (DC 31)	NT-WR1720	NT-ST25080T09	NT-FTB09
NT-DXP-03 (DC 32÷34)	NT-WR1416	NT-ST30080T10	NT-FTB10
NT-DXP-03 (DC 35÷36)	NT-WR1720	NT-ST30080T10	NT-FTB10
NT-DXP-03 (DC 37÷38)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-03 (DC 39÷42)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-03 (DC 43)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-03 (DC 44÷47)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-03 (DC 48÷55)	NT-WR2128	NT-ST40100T15	NT-FTB15
NT-DXP-03 (DC 56)	NT-WR1720	NT-ST50100T20	NT-FTB20
NT-DXP-03 (DC 57÷60)	NT-WR2128	NT-ST50100T20	NT-FTB20

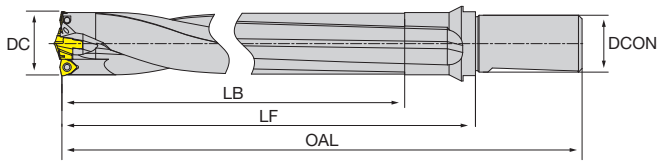




6xD

DXP drill

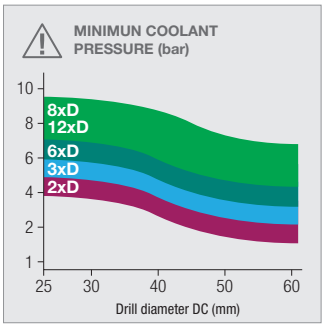
- 6xD pilot type drill body
- All with 4 coolant holes
- Please select inserts according to columns PILOT and MIID
- Peripheral inserts for D30 and D31 have a different shape compared to all the others

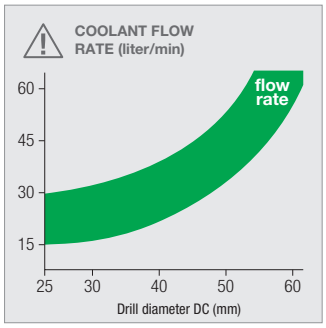


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DXP-06 D30-S32-P16E04	▲	30	32	275	215	189.9				DXP-P16	DXP-E04
NT-DXP-06 D31-S32-P17E04	▲	31	32	282	222	196.9				DXP-P17	DXP-E04
NT-DXP-06 D32-S32-P15E05	▲	32	32	289	229	200.7				DXP-P15	DXP-E05
NT-DXP-06 D33-S32-P16E05	▲	33	32	295	235	206.8				DXP-P16	DXP-E05
NT-DXP-06 D34-S32-P16E05	▲	34	32	301	241	212.8				DXP-P16	DXP-E05
NT-DXP-06 D35-S32-P18E05	▲	35	32	309	249	221.5				DXP-P18	DXP-E05
NT-DXP-06 D36-S32-P18E05	▲	36	32	314	254	226.5				DXP-P18	DXP-E05
NT-DXP-06 D37-S32-P16E06	▲	37	32	320	260	230.8				DXP-P16	DXP-E06
NT-DXP-06 D38-S32-P16E06	▲	38	32	328	268	236.8				DXP-P16	DXP-E06
NT-DXP-06 D39-S32-P18E06	▲	39	32	334	274	244.5				DXP-P18	DXP-E06
NT-DXP-06 D40-S32-P18E06	▲	40	32	353	283	250.5				DXP-P18	DXP-E06
NT-DXP-06 D41-S32-P19E06	▲	41	32	359	289	257				DXP-P19	DXP-E06
NT-DXP-06 D42-S50-P19E06	▲	42	50	366	296	263				DXP-P19	DXP-E06
NT-DXP-06 D43-S50-P16E08	▲	43	50	372	302	266.8				DXP-P16	DXP-E08
NT-DXP-06 D44-S50-P18E08	▲	44	50	378	308	274.5				DXP-P18	DXP-E08
NT-DXP-06 D45-S50-P18E08	▲	45	50	384	314	280.5				DXP-P18	DXP-E08
NT-DXP-06 D46-S50-P19E08	▲	46	50	390	320	287				DXP-P19	DXP-E08
NT-DXP-06 D47-S50-P20E08	▲	47	50	396	326	293.6				DXP-P20	DXP-E08
NT-DXP-06 D48-S50-P21E08	▲	48	50	403	333	300.1				DXP-P21	DXP-E08
NT-DXP-06 D49-S50-P22E08	▲	49	50	409	339	306.7				DXP-P22	DXP-E08
NT-DXP-06 D50-S50-P23E08	▲	50	50	415	345	313.3				DXP-P23	DXP-E08
NT-DXP-06 D51-S50-P24E08	▲	51	50	421	351	319.9				DXP-P24	DXP-E08
NT-DXP-06 D52-S50-P25E08	▲	52	50	427	357	326.5				DXP-P25	DXP-E08
NT-DXP-06 D53-S50-P26E08	▲	53	50	433	363	332.5				DXP-P26	DXP-E08
NT-DXP-06 D54-S50-P27E08	▲	54	50	440	370	340.5				DXP-P27	DXP-E08
NT-DXP-06 D55-S50-P28E08	▲	55	50	445	375	345.5				DXP-P28	DXP-E08
NT-DXP-06 D56-S50-P20E10	▲	56	50	451	381	347.6				DXP-P20	DXP-E10
NT-DXP-06 D57-S50-P21E10	▲	57	50	457	387	354.1				DXP-P21	DXP-E10
NT-DXP-06 D58-S50-P22E10	▲	58	50	463	393	360.7				DXP-P22	DXP-E10
NT-DXP-06 D59-S50-P23E10	▲	59	50	469	399	367.3				DXP-P23	DXP-E10
NT-DXP-06 D60-S50-P24E10	▲	60	50	475	405	373.9				DXP-P24	DXP-E10

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

Spare parts	Head wrench	Insert screws	Flag wrenches
NT-DXP-06 (DC 30)	NT-WR1416	NT-ST25080T09	NT-FTB09
NT-DXP-06 (DC 31)	NT-WR1720	NT-ST25080T09	NT-FTB09
NT-DXP-06 (DC 32÷34)	NT-WR1416	NT-ST30080T10	NT-FTB10
NT-DXP-06 (DC 35÷36)	NT-WR1720	NT-ST30080T10	NT-FTB10
NT-DXP-06 (DC 37÷38)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-06 (DC 39÷42)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-06 (DC 43)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-06 (DC 44÷47)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-06 (DC 48÷55)	NT-WR2128	NT-ST40100T15	NT-FTB15
NT-DXP-06 (DC 56)	NT-WR1720	NT-ST50100T20	NT-FTB20
NT-DXP-06 (DC 57÷60)	NT-WR2128	NT-ST50100T20	NT-FTB20



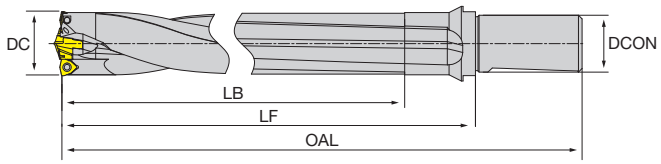


nikkoTOOLS

8xD

DXP drill

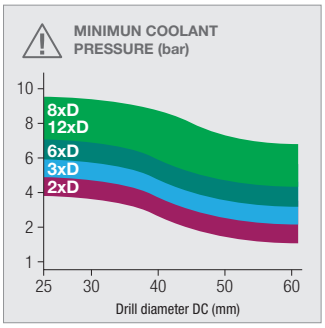
- 8xD pilot type drill body
- All with 4 coolant holes
- Please select inserts according to columns PILOT and MIID
- Peripheral inserts for D30 and D31 have a different shape compared to all the others

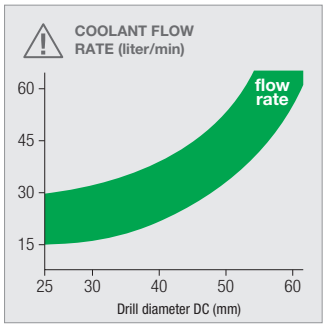


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DXP-08 D30-S32-P16E04	▲	30	32	335	275	249.9				DXP-P16	DXP-E04
NT-DXP-08 D31-S32-P17E04	▲	31	32	344	284	258.9				DXP-P17	DXP-E04
NT-DXP-08 D32-S32-P15E05	▲	32	32	353	293	264.7				DXP-P15	DXP-E05
NT-DXP-08 D33-S32-P16E05	▲	33	32	361	301	272.8				DXP-P16	DXP-E05
NT-DXP-08 D34-S32-P16E05	▲	34	32	369	309	280.8				DXP-P16	DXP-E05
NT-DXP-08 D35-S32-P18E05	▲	35	32	379	319	291.5				DXP-P18	DXP-E05
NT-DXP-08 D36-S32-P18E05	▲	36	32	386	326	298.5				DXP-P18	DXP-E05
NT-DXP-08 D37-S32-P16E06	▲	37	32	394	334	304.8				DXP-P16	DXP-E06
NT-DXP-08 D38-S32-P16E06	▲	38	32	404	344	312.8				DXP-P16	DXP-E06
NT-DXP-08 D39-S32-P18E06	▲	39	32	412	352	322.5				DXP-P18	DXP-E06
NT-DXP-08 D40-S32-P18E06	▲	40	32	433	363	330.5				DXP-P18	DXP-E06
NT-DXP-08 D41-S32-P19E06	▲	41	32	441	371	339				DXP-P19	DXP-E06
NT-DXP-08 D42-S50-P19E06	▲	42	50	450	380	347				DXP-P19	DXP-E06
NT-DXP-08 D43-S50-P16E08	▲	43	50	458	388	352.8				DXP-P16	DXP-E08
NT-DXP-08 D44-S50-P18E08	▲	44	50	466	396	362.5				DXP-P18	DXP-E08
NT-DXP-08 D45-S50-P18E08	▲	45	50	474	404	370.5				DXP-P18	DXP-E08
NT-DXP-08 D46-S50-P19E08	▲	46	50	482	412	379				DXP-P19	DXP-E08
NT-DXP-08 D47-S50-P20E08	▲	47	50	490	420	387.6				DXP-P20	DXP-E08
NT-DXP-08 D48-S50-P21E08	▲	48	50	499	429	396.1				DXP-P21	DXP-E08
NT-DXP-08 D49-S50-P22E08	▲	49	50	507	437	404.7				DXP-P22	DXP-E08
NT-DXP-08 D50-S50-P23E08	▲	50	50	515	445	413.3				DXP-P23	DXP-E08
NT-DXP-08 D51-S50-P24E08	▲	51	50	523	453	421.9				DXP-P24	DXP-E08
NT-DXP-08 D52-S50-P25E08	▲	52	50	531	461	430.5				DXP-P25	DXP-E08
NT-DXP-08 D53-S50-P26E08	▲	53	50	539	469	438.5				DXP-P26	DXP-E08
NT-DXP-08 D54-S50-P27E08	▲	54	50	548	478	448.5				DXP-P27	DXP-E08
NT-DXP-08 D55-S50-P28E08	▲	55	50	555	485	455.5				DXP-P28	DXP-E08
NT-DXP-08 D56-S50-P20E10	▲	56	50	563	493	459.6				DXP-P20	DXP-E10
NT-DXP-08 D57-S50-P21E10	▲	57	50	571	501	468.1				DXP-P21	DXP-E10
NT-DXP-08 D58-S50-P22E10	▲	58	50	579	509	476.7				DXP-P22	DXP-E10
NT-DXP-08 D59-S50-P23E10	▲	59	50	587	517	485.3				DXP-P23	DXP-E10
NT-DXP-08 D60-S50-P24E10	▲	60	50	595	525	493.9				DXP-P24	DXP-E10

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

Spare parts	Head wrench	Insert screws	Flag wrenches
NT-DXP-08 (DC 30)	NT-WR1416	NT-ST25080T09	NT-FTB09
NT-DXP-08 (DC 31)	NT-WR1720	NT-ST25080T09	NT-FTB09
NT-DXP-08 (DC 32÷34)	NT-WR1416	NT-ST30080T10	NT-FTB10
NT-DXP-08 (DC 35÷36)	NT-WR1720	NT-ST30080T10	NT-FTB10
NT-DXP-08 (DC 37÷38)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-08 (DC 39÷42)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-08 (DC 43)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-08 (DC 44÷47)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-08 (DC 48÷55)	NT-WR2128	NT-ST40100T15	NT-FTB15
NT-DXP-08 (DC 56)	NT-WR1720	NT-ST50100T20	NT-FTB20
NT-DXP-08 (DC 57÷60)	NT-WR2128	NT-ST50100T20	NT-FTB20

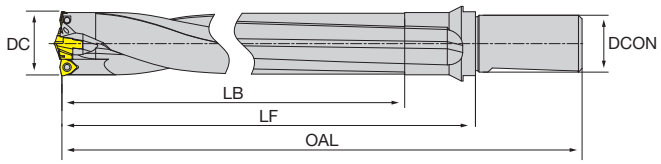




10xD

DXP drill

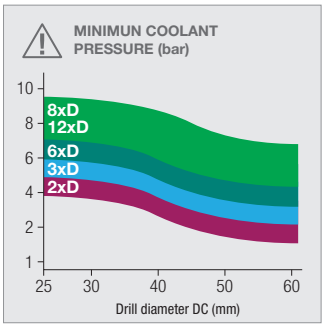
- 10xD pilot type drill body
- All with 4 coolant holes
- Please select inserts according to columns PILOT and MIID
- Peripheral inserts for D30 and D31 have a different shape compared to all the others

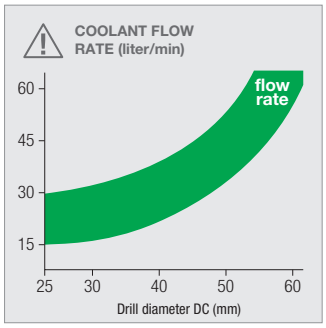


Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DXP-10 D30-S32-P16E04	▲	30	32	395	335	319.9				DXP-P16	DXP-E04
NT-DXP-10 D31-S32-P17E04	▲	31	32	406	346	320.9				DXP-P17	DXP-E04
NT-DXP-10 D32-S32-P15E05	▲	32	32	417	357	328.7				DXP-P15	DXP-E05
NT-DXP-10 D33-S32-P16E05	▲	33	32	427	367	338.8				DXP-P16	DXP-E05
NT-DXP-10 D34-S32-P16E05	▲	34	32	437	377	328.8				DXP-P16	DXP-E05
NT-DXP-10 D35-S32-P18E05	▲	35	32	448	388	360.5				DXP-P18	DXP-E05
NT-DXP-10 D36-S32-P18E05	▲	36	32	458	398	370.5				DXP-P18	DXP-E05
NT-DXP-10 D37-S32-P16E06	▲	37	32	468	408	378.8				DXP-P16	DXP-E06
NT-DXP-10 D38-S32-P16E06	▲	38	32	480	420	388.8				DXP-P16	DXP-E06
NT-DXP-10 D39-S32-P18E06	▲	39	32	490	430	400.5				DXP-P18	DXP-E06
NT-DXP-10 D40-S32-P18E06	▲	40	32	513	443	410.5				DXP-P18	DXP-E06
NT-DXP-10 D41-S32-P19E06	▲	41	32	523	453	421				DXP-P19	DXP-E06
NT-DXP-10 D42-S50-P19E06	▲	42	50	534	464	431				DXP-P19	DXP-E06
NT-DXP-10 D43-S50-P16E08	▲	43	50	544	474	438.8				DXP-P16	DXP-E08
NT-DXP-10 D44-S50-P18E08	▲	44	50	554	484	450.5				DXP-P18	DXP-E08
NT-DXP-10 D45-S50-P18E08	▲	45	50	564	494	460.5				DXP-P18	DXP-E08
NT-DXP-10 D46-S50-P19E08	▲	46	50	574	504	471				DXP-P19	DXP-E08
NT-DXP-10 D47-S50-P20E08	▲	47	50	584	514	481.6				DXP-P20	DXP-E08
NT-DXP-10 D48-S50-P21E08	▲	48	50	595	525	492.1				DXP-P21	DXP-E08
NT-DXP-10 D49-S50-P22E08	▲	49	50	605	535	502.7				DXP-P22	DXP-E08
NT-DXP-10 D50-S50-P23E08	▲	50	50	615	545	513.3				DXP-P23	DXP-E08
NT-DXP-10 D51-S50-P24E08	▲	51	50	625	555	523.9				DXP-P24	DXP-E08
NT-DXP-10 D52-S50-P25E08	▲	52	50	635	565	534.5				DXP-P25	DXP-E08
NT-DXP-10 D53-S50-P26E08	▲	53	50	645	575	544.5				DXP-P26	DXP-E08
NT-DXP-10 D54-S50-P27E08	▲	54	50	656	586	556.5				DXP-P27	DXP-E08
NT-DXP-10 D55-S50-P28E08	▲	55	50	665	595	565.5				DXP-P28	DXP-E08
NT-DXP-10 D56-S50-P20E10	▲	56	50	675	605	571.6				DXP-P20	DXP-E10
NT-DXP-10 D57-S50-P21E10	▲	57	50	685	615	582.1				DXP-P21	DXP-E10
NT-DXP-10 D58-S50-P22E10	▲	58	50	695	625	592.7				DXP-P22	DXP-E10
NT-DXP-10 D59-S50-P23E10	▲	59	50	705	635	603.3				DXP-P23	DXP-E10
NT-DXP-10 D60-S50-P24E10	▲	60	50	715	645	613.9				DXP-P24	DXP-E10

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

Spare parts	Head wrench	Insert screws	Flag wrenches
NT-DXP-10 (DC 30)	NT-WR1416	NT-ST25080T09	NT-FTB09
NT-DXP-10 (DC 31)	NT-WR1720	NT-ST25080T09	NT-FTB09
NT-DXP-10 (DC 32÷34)	NT-WR1416	NT-ST30080T10	NT-FTB10
NT-DXP-10 (DC 35÷36)	NT-WR1720	NT-ST30080T10	NT-FTB10
NT-DXP-10 (DC 37÷38)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-10 (DC 39÷42)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-10 (DC 43)	NT-WR1416	NT-ST40100T15	NT-FTB15
NT-DXP-10 (DC 44÷47)	NT-WR1720	NT-ST40100T15	NT-FTB15
NT-DXP-10 (DC 48÷55)	NT-WR2128	NT-ST40100T15	NT-FTB15
NT-DXP-10 (DC 56)	NT-WR1720	NT-ST50100T20	NT-FTB20
NT-DXP-10 (DC 57÷60)	NT-WR2128	NT-ST50100T20	NT-FTB20





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Pilot

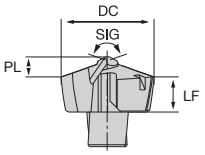
DXP drill

- PVD coated carbide pilot HC (high concentricity) pilot is for general purpose use
- DXP pilot may look like a DEX drill head but they're not interchangeable
- Step drills can be made upon request

HF: Micrograin carbide
PVD: Physical vapour deposition

	HF PVD
	JP5725
Stable machining, light cut (1st choice / suitable)	○
General machining, medium cut (1st choice / suitable)	●
Unstable machining, heavy cut (1st choice / suitable)	

Dimensions



ISO	JP5725
P	55 160
M	
K	60 140
N	
S	
H	

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

	Designation	DC	DC toll.	SIG	PL	LF	Stock
GENERAL HC P K high centering	DXP-P15-HC	15	k6	150°	3.05	5.65	▲
	DXP-P16-HC	16	k6	150°	3.25	5.55	▲
	DXP-P17-HC	17	k6	150°	3.35	6.55	▲
	DXP-P18-HC	18	k6	150°	3.5	7	▲
	DXP-P19-HC	19	k6	150°	3.83	7.17	▲
	DXP-P20-HC	20	k6	150°	4.03	7.57	▲
	DXP-P21-HC	21	k6	150°	4.23	7.87	▲
	DXP-P22-HC	22	k6	150°	4.51	8.19	●
	DXP-P23-HC	23	k6	150°	4.8	8.5	▲
	DXP-P24-HC	24	k6	150°	4.9	9	▲
	DXP-P25-HC	25	k6	150°	4.92	9.58	▲
	DXP-P26-HC	26	k6	150°	5.16	9.34	▲
	DXP-P27-HC	27	k6	150°	5.41	10.09	▲
	DXP-P28-HC	28	k6	150°	5.62	9.88	▲

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

HC - Perfect centering

Improved centering for big diameters extra long drilling bodies (until 10xD).

External

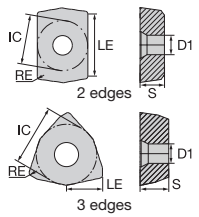
DXP drill

- New generation "Chip Splitter"
- Specially waved edge splits the chips, improves heat dissipation, prolongs the tool life, improves hole quality
- Peripheral inserts for DXP drill
- Step drills can be made upon request

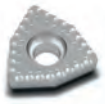
HF: Micrograin carbide
PVD: Physical vapour deposition

		HF PVD	JP5725
Stable machining, light cut	● 1st choice ○ suitable	○	
General machining, medium cut	● 1st choice ○ suitable	●	
Unstable machining, heavy cut	● 1st choice ○ suitable		

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
P	55 160	
M		
K	60 140	
N		
S		
H		

	Designation		RE	IC	S	D1	LE	Stock	
GENERAL	CS P K chip splitter	DXP-E04-CS	0.4	7.26	3.79	2.85	10.76	▲	
	CS P K  chip splitter	DXP-E05-CS	0.8	8	3.75	3.4	5.29	▲	
		DXP-E06-CS	0.8	10	3.75	4.4	6.62	▲	
		DXP-E08-CS	0.8	12	4.75	4.4	7.94	●	
		DXP-E10-CS	0.8	15	5.25	5.5	9.92	▲	

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

CS - Chips formation

The short chips created by CS geometry can be easely ejected even on very deep holes.

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ISO 513	MATERIAL	HARDNESS HB	L/D	JP5725 min	JP5725 start	JP5725 max		
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	3xD - 6xD	80	**120**	160		
			8xD	65	**100**	135		
			10xD	55	**85**	115		
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	3xD - 6xD	60	**90**	120		
			8xD	50	**75**	100		
			10xD	40	**60**	80		
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	3xD - 6xD	40	**60**	80		
			8xD	35	**50**	65		
			10xD	30	**40**	50		
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	3xD - 6xD	80	**110**	140		
			8xD	70	**90**	110		
			10xD	60	**80**	100		
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	3xD - 6xD	80	**100**	120		
			8xD	70	**90**	110		
			10xD	60	**80**	100		

Complete workpiece materials p. **H**1.

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ISO 513	MATERIAL	HARDNESS HB	L/D	DC 30.00 ÷ 35.00			DC 36.00 ÷ 40.00			DC 41.00 ÷ 45.00		
				min	start	max	min	start	max	min	start	max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	3xD - 6xD	0.16	**0.22**	0.28	0.18	**0.25**	0.32	0.18	**0.27**	0.36
			8xD	0.12	**0.17**	0.22	0.14	**0.20**	0.26	0.14	**0.21**	0.28
			10xD	0.10	**0.15**	0.20	0.12	**0.17**	0.22	0.12	**0.18**	0.24
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	3xD - 6xD	0.18	**0.25**	0.32	0.20	**0.28**	0.36	0.20	**0.31**	0.42
			8xD	0.14	**0.20**	0.26	0.16	**0.22**	0.28	0.16	**0.25**	0.34
			10xD	0.12	**0.17**	0.22	0.14	**0.19**	0.24	0.14	**0.22**	0.30
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	3xD - 6xD	0.18	**0.24**	0.30	0.20	**0.27**	0.34	0.20	**0.30**	0.40
			8xD	0.14	**0.19**	0.24	0.16	**0.21**	0.26	0.16	**0.24**	0.32
			10xD	0.12	**0.16**	0.20	0.14	**0.18**	0.22	0.14	**0.21**	0.28
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	3xD - 6xD	0.20	**0.27**	0.34	0.22	**0.30**	0.38	0.22	**0.33**	0.44
			8xD	0.16	**0.21**	0.26	0.18	**0.24**	0.30	0.18	**0.27**	0.36
			10xD	0.14	**0.18**	0.22	0.16	**0.21**	0.26	0.16	**0.23**	0.30
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	3xD - 6xD	0.16	**0.22**	0.28	0.18	**0.24**	0.30	0.18	**0.28**	0.36
			8xD	0.12	**0.17**	0.22	0.14	**0.19**	0.24	0.14	**0.21**	0.28
			10xD	0.10	**0.15**	0.20	0.12	**0.16**	0.20	0.12	**0.18**	0.24

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DC 46.00 ÷ 50.00			DC 51.00 ÷ 55.00			DC 56.00 ÷ 60.00					
min	start	max	min	start	max	min	start	max			
0.20	**0.30**	0.40	0.20	**0.32**	0.44	0.22	**0.34**	0.46			
0.16	**0.24**	0.32	0.16	**0.26**	0.36	0.18	**0.27**	0.36			
0.14	**0.21**	0.28	0.14	**0.22**	0.30	0.16	**0.24**	0.32			
0.22	**0.29**	0.46	0.22	**0.36**	0.50	0.24	**0.38**	0.52			
0.18	**0.27**	0.36	0.18	**0.27**	0.40	0.20	**0.31**	0.42			
0.16	**0.24**	0.32	0.16	**0.26**	0.36	0.16	**0.26**	0.36			
0.22	**0.33**	0.44	0.22	**0.35**	0.48	0.24	**0.37**	0.50			
0.18	**0.27**	0.36	0.18	**0.28**	0.38	0.20	**0.30**	0.40			
0.16	**0.23**	0.30	0.16	**0.25**	0.34	0.16	**0.26**	0.36			
0.24	**0.36**	0.48	0.24	**0.38**	0.52	0.26	**0.40**	0.54			
0.20	**0.29**	0.38	0.20	**0.31**	0.42	0.20	**0.32**	0.44			
0.16	**0.25**	0.34	0.16	**0.26**	0.36	0.18	**0.28**	0.38			
0.20	**0.29**	0.38	0.20	**0.31**	0.42	0.20	**0.32**	0.44			
0.16	**0.23**	0.30	0.16	**0.25**	0.34	0.16	**0.26**	0.36			
0.14	**0.20**	0.26	0.14	**0.22**	0.30	0.14	**0.22**	0.30			

Complete workpiece materials p. **H**1.

SPOT DRILL

High quality multipurpose system

APPLICATION

Spotting	Engraving	V-Grooving	Chamfering

ISO APPLICATION FIELDS

P M K N

ADVANTAGES AND CHARACTERISTICS

- Highly universal system for chamfering, engraving, spot drilling or milling grooves
- Convenient to use with great flexibility
- Inserts available with different radii and for diverse workpiece materials

Drilling bodies

- Cylindrical type and screw-in type
- Max. drilling dia. 14mm, min. drilling dia. 2.4mm
- Smart kit of 1 holder plus 4 inserts available
- Extension sleeves (steel/carbon 10xD)

Extension arbors

Inserts

- Available R03/08 for PMK, R04/08 for aluminium
- Cemented carbide grades with PVD coatings or uncoated for N materials
- Geometries: GP, AL

GP P M K

SIZE 11

AL N

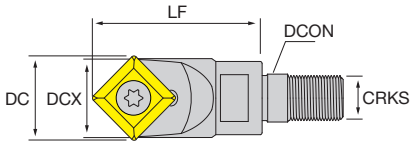
SIZE 11

NT-SPOT

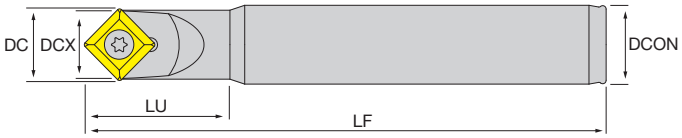
SPOT drill

- Spot drill system with SPOT inserts
- External coolant
- Multifunctional system for maximum versatility
- Inserts cannot be mounted on DRS drills or ChamferSquare milling holders

Screw-in



Cylindrical



Designation	Stock	DC	DCX	CICT	DCON	LF	LU	CRKS			MIID
SCREW-IN											
NT-SPOT D14-M08-L052	●	15.4	14	1	8.5	35	-	M8			SPOT11
CYLINDRICAL											
NT-SPOT D14-S16-L100	●	15.4	14	1	16	100	30	-			SPOT11

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

Spare parts	Insert screws	Flag wrenches
NT-SPOT D14-○○○-L○○○	NT-ST35080T15	NT-FTB15

SPOT11

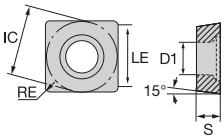
SPOT drill

- General purpose type or fine polished sharp geometries for aluminum or non-ferrous materials available
- Diverse PVD coated or uncoated carbide grades available
- Multiple radii available for each geometry
- Inserts cannot be mounted on DRS drills or ChamferSquare milling holders

HF: Micrograin carbide
PVD: Physical vapour deposition

	JP7525	JP8725	JP9535	JU6520
	HF PVD	HF PVD	HF PVD	HF
Stable machining, light cut (● 1st choice, ○ suitable)		○		●
General machining, medium cut (● 1st choice, ○ suitable)	●	●	●	●
Unstable machining, heavy cut (● 1st choice, ○ suitable)	●		●	

Dimensions



4 edges

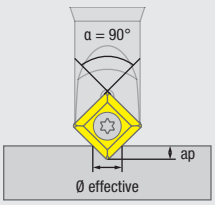
ISO	JP7525	JP8725	JP9535	JU6520
	HF PVD	HF PVD	HF PVD	HF
P		120 240		
M			80 160	
K	100 160			
N				240 400
S				
H				

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

	Designation	RE	IC	S	D1	LE	JP7525	JP8725	JP9535	JU6520	Stock
GENERAL	GP P M K SPOT11 R03-GP	0.3	11	3.97	4.3	10.4	●	●	●		
	SPOT11 R08-GP	0.8	11	3.97	4.3	9.4	●	●	●		
ALUMINIUM	AL N polished surface SPOT11 R04-AL	0.4	11	3.97	4.3	10.2				●	
	SPOT11 R08-AL	0.8	11	3.97	4.3	9.4				●	

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

EFFECTIVE DIAMETER



Ø = 2xap x tan (α/2)

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ISO 513	MATERIAL	HARDNESS HB	JP8725 min	start	max		
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	120	**180**	240		
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	100	**150**	200		
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	80	**120**	160		
ISO 513	MATERIAL	HARDNESS HB	JP9535 min	start	max		
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	80	**120**	160		
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	60	**90**	120		
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	80	**120**	160		
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		60	**100**	140		
ISO 513	MATERIAL	HARDNESS HB	JP7525 min	start	max		
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100	**130**	160		
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100	**110**	120		
ISO 513	MATERIAL	HARDNESS HB	JU6520 min	start	max		
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		240	**320**	400		
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		160	**230**	300		

Complete workpiece materials p. **H**1.

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

NCD DRILLS

High performace solid carbide drill series

APPLICATION

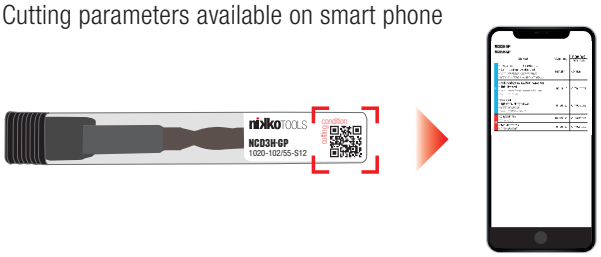
Plane surface	Concave surface	Convex surface	Stacked plates	Pipes

ISO APPLICATION FIELDS

P M K S

ADVANTAGES AND CHARACTERISTICS

· Premium quality delivering top class performance
· Suitable for different types of holes and surfaces on diverse materials
· Twisted flute style with or without coolant available in 3xD and 5xD as standards, for other sizes and step drills we can provide as special
· Cutting parameters available on smart phone



Range

· D3-20mm, 3xD and 5xD, with and without coolant
· Special length and step drill available upon request

Geometries

· GP for general purpose, wide application range
· SC for reduced cutting force and smooth cutting

GP P K

SC P M S

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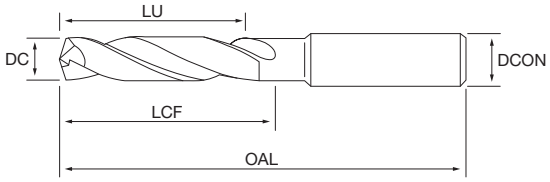
NCD3-GP

NCD

- First choice for steel and cast iron machining (<45 HRC)
- **Without** coolant holes
- Self centering geometry for accurate holes
- AlTin-nano based coating for long lasting tool life

3xD

P K



Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3-GP 0300-062/020-S06	●	3	3	14	20	62	6	140°			
NCD3-GP 0310-062/020-S06	●	3.1	3	14	20	62	6	140°			
NCD3-GP 0320-062/020-S06	●	3.2	3	14	20	62	6	140°			
NCD3-GP 0330-062/020-S06	●	3.3	3	14	20	62	6	140°			
NCD3-GP 0340-062/020-S06	●	3.4	3	14	20	62	6	140°			
NCD3-GP 0350-062/020-S06	●	3.5	3	14	20	62	6	140°			
NCD3-GP 0360-062/020-S06	●	3.6	3	14	20	62	6	140°			
NCD3-GP 0370-062/020-S06	●	3.7	3	14	20	62	6	140°			
NCD3-GP 0380-066/024-S06	●	3.8	3	17	24	66	6	140°			
NCD3-GP 0390-066/024-S06	●	3.9	3	17	24	66	6	140°			
NCD3-GP 0400-066/024-S06	●	4	3	17	24	66	6	140°			
NCD3-GP 0410-066/024-S06	●	4.1	3	17	24	66	6	140°			
NCD3-GP 0420-066/024-S06	●	4.2	3	17	24	66	6	140°			
NCD3-GP 0430-066/024-S06	●	4.3	3	17	24	66	6	140°			
NCD3-GP 0440-066/024-S06	●	4.4	3	17	24	66	6	140°			
NCD3-GP 0450-066/024-S06	●	4.5	3	17	24	66	6	140°			
NCD3-GP 0460-066/024-S06	●	4.6	3	17	24	66	6	140°			
NCD3-GP 0470-066/024-S06	●	4.7	3	17	24	66	6	140°			
NCD3-GP 0480-066/028-S06	●	4.8	3	20	28	66	6	140°			
NCD3-GP 0490-066/028-S06	●	4.9	3	20	28	66	6	140°			
NCD3-GP 0500-066/028-S06	●	5	3	20	28	66	6	140°			
NCD3-GP 0510-066/028-S06	●	5.1	3	20	28	66	6	140°			
NCD3-GP 0520-066/028-S06	●	5.2	3	20	28	66	6	140°			
NCD3-GP 0530-066/028-S06	●	5.3	3	20	28	66	6	140°			
NCD3-GP 0540-066/028-S06	●	5.4	3	20	28	66	6	140°			
NCD3-GP 0550-066/028-S06	●	5.5	3	20	28	66	6	140°			
NCD3-GP 0560-066/028-S06	●	5.6	3	20	28	66	6	140°			
NCD3-GP 0570-066/028-S06	●	5.7	3	20	28	66	6	140°			
NCD3-GP 0580-066/028-S06	●	5.8	3	20	28	66	6	140°			
NCD3-GP 0590-066/028-S06	●	5.9	3	20	28	66	6	140°			
NCD3-GP 0600-066/028-S06	●	6	3	20	28	66	6	140°			
NCD3-GP 0610-079/034-S08	●	6.1	3	24	34	79	8	140°			
NCD3-GP 0620-079/034-S08	●	6.2	3	24	34	79	8	140°			
NCD3-GP 0630-079/034-S08	●	6.3	3	24	34	79	8	140°			
NCD3-GP 0640-079/034-S08	●	6.4	3	24	34	79	8	140°			
NCD3-GP 0650-079/034-S08	●	6.5	3	24	34	79	8	140°			
NCD3-GP 0660-079/034-S08	●	6.6	3	24	34	79	8	140°			
NCD3-GP 0670-079/034-S08	●	6.7	3	24	34	79	8	140°			
NCD3-GP 0680-079/034-S08	●	6.8	3	24	34	79	8	140°			
NCD3-GP 0690-079/034-S08	●	6.9	3	24	34	79	8	140°			
NCD3-GP 0700-079/034-S08	●	7	3	24	34	79	8	140°			
NCD3-GP 0710-079/041-S08	●	7.1	3	29	41	79	8	140°			
NCD3-GP 0720-079/041-S08	●	7.2	3	29	41	79	8	140°			
NCD3-GP 0730-079/041-S08	●	7.3	3	29	41	79	8	140°			
NCD3-GP 0740-079/041-S08	●	7.4	3	29	41	79	8	140°			
NCD3-GP 0750-079/041-S08	●	7.5	3	29	41	79	8	140°			
NCD3-GP 0760-079/041-S08	●	7.6	3	29	41	79	8	140°			
NCD3-GP 0770-079/041-S08	●	7.7	3	29	41	79	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3-GP 0780-079/041-S08	●	7.8	3	29	41	79	8	140°			
NCD3-GP 0790-079/041-S08	●	7.9	3	29	41	79	8	140°			
NCD3-GP 0800-079/041-S08	●	8	3	29	41	79	8	140°			
NCD3-GP 0810-089/047-S10	●	8.1	3	35	47	89	10	140°			
NCD3-GP 0820-089/047-S10	●	8.2	3	35	47	89	10	140°			
NCD3-GP 0830-089/047-S10	●	8.3	3	35	47	89	10	140°			
NCD3-GP 0840-089/047-S10	●	8.4	3	35	47	89	10	140°			
NCD3-GP 0850-089/047-S10	●	8.5	3	35	47	89	10	140°			
NCD3-GP 0860-089/047-S10	●	8.6	3	35	47	89	10	140°			
NCD3-GP 0870-089/047-S10	●	8.7	3	35	47	89	10	140°			
NCD3-GP 0880-089/047-S10	●	8.8	3	35	47	89	10	140°			
NCD3-GP 0890-089/047-S10	●	8.9	3	35	47	89	10	140°			
NCD3-GP 0900-089/047-S10	●	9	3	35	47	89	10	140°			
NCD3-GP 0910-089/047-S10	●	9.1	3	35	47	89	10	140°			
NCD3-GP 0920-089/047-S10	●	9.2	3	35	47	89	10	140°			
NCD3-GP 0930-089/047-S10	●	9.3	3	35	47	89	10	140°			
NCD3-GP 0940-089/047-S10	●	9.4	3	35	47	89	10	140°			
NCD3-GP 0950-089/047-S10	●	9.5	3	35	47	89	10	140°			
NCD3-GP 0960-089/047-S10	●	9.6	3	35	47	89	10	140°			
NCD3-GP 0970-089/047-S10	●	9.7	3	35	47	89	10	140°			
NCD3-GP 0980-089/047-S10	●	9.8	3	35	47	89	10	140°			
NCD3-GP 0990-089/047-S10	●	9.9	3	35	47	89	10	140°			
NCD3-GP 1000-089/047-S10	●	10	3	35	47	89	10	140°			
NCD3-GP 1010-102/055-S12	●	10.1	3	40	55	102	12	140°			
NCD3-GP 1020-102/055-S12	●	10.2	3	40	55	102	12	140°			
NCD3-GP 1030-102/055-S12	●	10.3	3	40	55	102	12	140°			
NCD3-GP 1040-102/055-S12	●	10.4	3	40	55	102	12	140°			
NCD3-GP 1050-102/055-S12	●	10.5	3	40	55	102	12	140°			
NCD3-GP 1060-102/055-S12	●	10.6	3	40	55	102	12	140°			
NCD3-GP 1070-102/055-S12	●	10.7	3	40	55	102	12	140°			
NCD3-GP 1080-102/055-S12	●	10.8	3	40	55	102	12	140°			
NCD3-GP 1090-102/055-S12	●	10.9	3	40	55	102	12	140°			
NCD3-GP 1100-102/055-S12	●	11	3	40	55	102	12	140°			
NCD3-GP 1110-102/055-S12	●	11.1	3	40	55	102	12	140°			
NCD3-GP 1120-102/055-S12	●	11.2	3	40	55	102	12	140°			
NCD3-GP 1130-102/055-S12	●	11.3	3	40	55	102	12	140°			
NCD3-GP 1140-102/055-S12	●	11.4	3	40	55	102	12	140°			
NCD3-GP 1150-102/055-S12	●	11.5	3	40	55	102	12	140°			
NCD3-GP 1160-102/055-S12	●	11.6	3	40	55	102	12	140°			
NCD3-GP 1170-102/055-S12	●	11.7	3	40	55	102	12	140°			
NCD3-GP 1180-102/055-S12	●	11.8	3	40	55	102	12	140°			
NCD3-GP 1190-102/055-S12	●	11.9	3	40	55	102	12	140°			
NCD3-GP 1200-102/055-S12	●	12	3	40	55	102	12	140°			
NCD3-GP 1250-107/060-S14	●	12.5	3	43	60	107	14	140°			
NCD3-GP 1300-107/060-S14	●	13	3	43	60	107	14	140°			
NCD3-GP 1350-107/060-S14	●	13.5	3	43	60	107	14	140°			
NCD3-GP 1400-107/060-S14	●	14	3	43	60	107	14	140°			
NCD3-GP 1450-115/065-S16	●	14.5	3	45	65	115	16	140°			
NCD3-GP 1500-115/065-S16	●	15	3	49	65	115	16	140°			
NCD3-GP 1550-115/065-S16	●	15.5	3	49	65	115	16	140°			
NCD3-GP 1600-115/065-S16	●	16	3	49	65	115	16	140°			
NCD3-GP 1650-123/073-S18	●	16.5	3	52	73	123	18	140°			
NCD3-GP 1700-123/073-S18	●	17	3	52	73	123	18	140°			
NCD3-GP 1750-123/073-S18	●	17.5	3	52	73	123	18	140°			
NCD3-GP 1800-123/073-S18	●	18	3	52	73	123	18	140°			
NCD3-GP 1850-131/079-S20	●	18.5	3	55	79	131	20	140°			
NCD3-GP 1900-131/079-S20	●	19	3	55	79	131	20	140°			
NCD3-GP 1950-131/079-S20	●	19.5	3	55	79	131	20	140°			
NCD3-GP 2000-131/079-S20	●	20	3	55	79	131	20	140°			

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

nikkoTOOLS

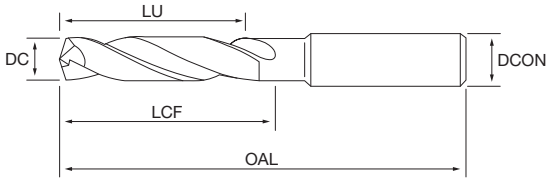
NCD5-GP

NCD

- First choice for steel and cast iron machining (<45 HRC)
- **Without** coolant holes
- Self centering geometry for accurate holes
- AlTin-nano based coating for long lasting tool life

5xD

P K



Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5-GP 0300-066/028-S06	●	3	5	23	28	66	6	140°			
NCD5-GP 0310-066/028-S06	●	3.1	5	23	28	66	6	140°			
NCD5-GP 0320-066/028-S06	●	3.2	5	23	28	66	6	140°			
NCD5-GP 0330-066/028-S06	●	3.3	5	23	28	66	6	140°			
NCD5-GP 0340-066/028-S06	●	3.4	5	23	28	66	6	140°			
NCD5-GP 0350-066/028-S06	●	3.5	5	23	28	66	6	140°			
NCD5-GP 0360-066/028-S06	●	3.6	5	23	28	66	6	140°			
NCD5-GP 0370-066/028-S06	●	3.7	5	23	28	66	6	140°			
NCD5-GP 0380-074/036-S06	●	3.8	5	29	36	74	6	140°			
NCD5-GP 0390-074/036-S06	●	3.9	5	29	36	74	6	140°			
NCD5-GP 0400-074/036-S06	●	4	5	29	36	74	6	140°			
NCD5-GP 0410-074/036-S06	●	4.1	5	29	36	74	6	140°			
NCD5-GP 0420-074/036-S06	●	4.2	5	29	36	74	6	140°			
NCD5-GP 0430-074/036-S06	●	4.3	5	29	36	74	6	140°			
NCD5-GP 0440-074/036-S06	●	4.4	5	29	36	74	6	140°			
NCD5-GP 0450-074/036-S06	●	4.5	5	29	36	74	6	140°			
NCD5-GP 0460-074/036-S06	●	4.6	5	29	36	74	6	140°			
NCD5-GP 0470-074/036-S06	●	4.7	5	29	36	74	6	140°			
NCD5-GP 0480-082/044-S06	●	4.8	5	35	44	82	6	140°			
NCD5-GP 0490-082/044-S06	●	4.9	5	35	44	82	6	140°			
NCD5-GP 0500-082/044-S06	●	5	5	35	44	82	6	140°			
NCD5-GP 0510-082/044-S06	●	5.1	5	35	44	82	6	140°			
NCD5-GP 0520-082/044-S06	●	5.2	5	35	44	82	6	140°			
NCD5-GP 0530-082/044-S06	●	5.3	5	35	44	82	6	140°			
NCD5-GP 0540-082/044-S06	●	5.4	5	35	44	82	6	140°			
NCD5-GP 0550-082/044-S06	●	5.5	5	35	44	82	6	140°			
NCD5-GP 0560-082/044-S06	●	5.6	5	35	44	82	6	140°			
NCD5-GP 0570-082/044-S06	●	5.7	5	35	44	82	6	140°			
NCD5-GP 0580-082/044-S06	●	5.8	5	35	44	82	6	140°			
NCD5-GP 0590-082/044-S06	●	5.9	5	35	44	82	6	140°			
NCD5-GP 0600-082/044-S06	●	6	5	35	44	82	6	140°			
NCD5-GP 0610-091/053-S08	●	6.1	5	43	53	91	8	140°			
NCD5-GP 0620-091/053-S08	●	6.2	5	43	53	91	8	140°			
NCD5-GP 0630-091/053-S08	●	6.3	5	43	53	91	8	140°			
NCD5-GP 0640-091/053-S08	●	6.4	5	43	53	91	8	140°			
NCD5-GP 0650-091/053-S08	●	6.5	5	43	53	91	8	140°			
NCD5-GP 0660-091/053-S08	●	6.6	5	43	53	91	8	140°			
NCD5-GP 0670-091/053-S08	●	6.7	5	43	53	91	8	140°			
NCD5-GP 0680-091/053-S08	●	6.8	5	43	53	91	8	140°			
NCD5-GP 0690-091/053-S08	●	6.9	5	43	53	91	8	140°			
NCD5-GP 0700-091/053-S08	●	7	5	43	53	91	8	140°			
NCD5-GP 0710-091/053-S08	●	7.1	5	43	53	91	8	140°			
NCD5-GP 0720-091/053-S08	●	7.2	5	43	53	91	8	140°			
NCD5-GP 0730-091/053-S08	●	7.3	5	43	53	91	8	140°			
NCD5-GP 0740-091/053-S08	●	7.4	5	43	53	91	8	140°			
NCD5-GP 0750-091/053-S08	●	7.5	5	43	53	91	8	140°			
NCD5-GP 0760-091/053-S08	●	7.6	5	43	53	91	8	140°			
NCD5-GP 0770-091/053-S08	●	7.7	5	43	53	91	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5-GP 0780-091/053-S08	●	7.8	5	43	53	91	8	140°			
NCD5-GP 0790-091/053-S08	●	7.9	5	43	53	91	8	140°			
NCD5-GP 0800-091/053-S08	●	8	5	43	53	91	8	140°			
NCD5-GP 0810-103/061-S10	●	8.1	5	48.85	61	103	10	140°			
NCD5-GP 0820-103/061-S10	●	8.2	5	48.7	61	103	10	140°			
NCD5-GP 0830-103/061-S10	●	8.3	5	48.55	61	103	10	140°			
NCD5-GP 0840-103/061-S10	●	8.4	5	49	61	103	10	140°			
NCD5-GP 0850-103/061-S10	●	8.5	5	49	61	103	10	140°			
NCD5-GP 0860-103/061-S10	●	8.6	5	49	61	103	10	140°			
NCD5-GP 0870-103/061-S10	●	8.7	5	49	61	103	10	140°			
NCD5-GP 0880-103/061-S10	●	8.8	5	49	61	103	10	140°			
NCD5-GP 0890-103/061-S10	●	8.9	5	49	61	103	10	140°			
NCD5-GP 0900-103/061-S10	●	9	5	49	61	103	10	140°			
NCD5-GP 0910-103/061-S10	●	9.1	5	49	61	103	10	140°			
NCD5-GP 0920-103/061-S10	●	9.2	5	49	61	103	10	140°			
NCD5-GP 0930-103/061-S10	●	9.3	5	49	61	103	10	140°			
NCD5-GP 0940-103/061-S10	●	9.4	5	49	61	103	10	140°			
NCD5-GP 0950-103/061-S10	●	9.5	5	49	61	103	10	140°			
NCD5-GP 0960-103/061-S10	●	9.6	5	49	61	103	10	140°			
NCD5-GP 0970-103/061-S10	●	9.7	5	49	61	103	10	140°			
NCD5-GP 0980-103/061-S10	●	9.8	5	49	61	103	10	140°			
NCD5-GP 0990-103/061-S10	●	9.9	5	49	61	103	10	140°			
NCD5-GP 1000-103/061-S10	●	10	5	49	61	103	10	140°			
NCD5-GP 1010-118/071-S12	●	10.1	5	52	71	118	12	140°			
NCD5-GP 1020-118/071-S12	●	10.2	5	52	71	118	12	140°			
NCD5-GP 1030-118/071-S12	●	10.3	5	52	71	118	12	140°			
NCD5-GP 1040-118/071-S12	●	10.4	5	52	71	118	12	140°			
NCD5-GP 1050-118/071-S12	●	10.5	5	52	71	118	12	140°			
NCD5-GP 1060-118/071-S12	●	10.6	5	52	71	118	12	140°			
NCD5-GP 1070-118/071-S12	●	10.7	5	52	71	118	12	140°			
NCD5-GP 1080-118/071-S12	●	10.8	5	52	71	118	12	140°			
NCD5-GP 1090-118/071-S12	●	10.9	5	52	71	118	12	140°			
NCD5-GP 1100-118/071-S12	●	11	5	52	71	118	12	140°			
NCD5-GP 1110-118/071-S12	●	11.1	5	52	71	118	12	140°			
NCD5-GP 1120-118/071-S12	●	11.2	5	52	71	118	12	140°			
NCD5-GP 1130-118/071-S12	●	11.3	5	52	71	118	12	140°			
NCD5-GP 1140-118/071-S12	●	11.4	5	52	71	118	12	140°			
NCD5-GP 1150-118/071-S12	●	11.5	5	52	71	118	12	140°			
NCD5-GP 1160-118/071-S12	●	11.6	5	52	71	118	12	140°			
NCD5-GP 1170-118/071-S12	●	11.7	5	52	71	118	12	140°			
NCD5-GP 1180-118/071-S12	●	11.8	5	52	71	118	12	140°			
NCD5-GP 1190-118/071-S12	●	11.9	5	52	71	118	12	140°			
NCD5-GP 1200-118/071-S12	●	12	5	52	71	118	12	140°			
NCD5-GP 1250-124/077-S14	●	12.5	5	63	77	124	14	140°			
NCD5-GP 1300-124/077-S14	●	13	5	63	77	124	14	140°			
NCD5-GP 1350-124/077-S14	●	13.5	5	63	77	124	14	140°			
NCD5-GP 1400-124/077-S14	●	14	5	63	77	124	14	140°			
NCD5-GP 1450-133/083-S16	●	14.5	5	67	83	133	16	140°			
NCD5-GP 1500-133/083-S16	●	15	5	67	83	133	16	140°			
NCD5-GP 1550-133/083-S16	●	15.5	5	67	83	133	16	140°			
NCD5-GP 1600-133/083-S16	●	16	5	67	83	133	16	140°			
NCD5-GP 1650-143/093-S18	●	16.5	5	75	93	143	18	140°			
NCD5-GP 1700-143/093-S18	●	17	5	75	93	143	18	140°			
NCD5-GP 1750-143/093-S18	●	17.5	5	75	93	143	18	140°			
NCD5-GP 1800-143/093-S18	●	18	5	75	93	143	18	140°			
NCD5-GP 1850-153/101-S20	●	18.5	5	81	101	153	20	140°			
NCD5-GP 1900-153/101-S20	●	19	5	81	101	153	20	140°			
NCD5-GP 1950-153/101-S20	●	19.5	5	81	101	153	20	140°			
NCD5-GP 2000-153/101-S20	●	20	5	81	101	153	20	140°			

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

nikkoTOOLS

NCD3H-GP

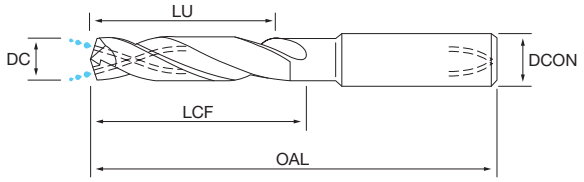
NCD

- First choice for steel and cast iron machining (<45 HRC)
- With coolant holes
- Self centering geometry for accurate holes
- AlTin-nano based coating for long lasting tool life

3xD

with coolant holes

P K



Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3H-GP 0300-062/020-S06	●	3	3	14	20	62	6	140°			
NCD3H-GP 0310-062/020-S06	●	3.1	3	14	20	62	6	140°			
NCD3H-GP 0320-062/020-S06	●	3.2	3	14	20	62	6	140°			
NCD3H-GP 0330-062/020-S06	●	3.3	3	14	20	62	6	140°			
NCD3H-GP 0340-062/020-S06	●	3.4	3	14	20	62	6	140°			
NCD3H-GP 0350-062/020-S06	●	3.5	3	14	20	62	6	140°			
NCD3H-GP 0360-062/020-S06	●	3.6	3	14	20	62	6	140°			
NCD3H-GP 0370-062/020-S06	●	3.7	3	14	20	62	6	140°			
NCD3H-GP 0380-066/024-S06	●	3.8	3	17	24	66	6	140°			
NCD3H-GP 0390-066/024-S06	●	3.9	3	17	24	66	6	140°			
NCD3H-GP 0400-066/024-S06	●	4	3	17	24	66	6	140°			
NCD3H-GP 0410-066/024-S06	●	4.1	3	17	24	66	6	140°			
NCD3H-GP 0420-066/024-S06	●	4.2	3	17	24	66	6	140°			
NCD3H-GP 0430-066/024-S06	●	4.3	3	17	24	66	6	140°			
NCD3H-GP 0440-066/024-S06	●	4.4	3	17	24	66	6	140°			
NCD3H-GP 0450-066/024-S06	●	4.5	3	17	24	66	6	140°			
NCD3H-GP 0460-066/024-S06	●	4.6	3	17	24	66	6	140°			
NCD3H-GP 0470-066/024-S06	●	4.7	3	17	24	66	6	140°			
NCD3H-GP 0480-066/028-S06	●	4.8	3	20	28	66	6	140°			
NCD3H-GP 0490-066/028-S06	●	4.9	3	20	28	66	6	140°			
NCD3H-GP 0500-066/028-S06	●	5	3	20	28	66	6	140°			
NCD3H-GP 0510-066/028-S06	●	5.1	3	20	28	66	6	140°			
NCD3H-GP 0520-066/028-S06	●	5.2	3	20	28	66	6	140°			
NCD3H-GP 0530-066/028-S06	●	5.3	3	20	28	66	6	140°			
NCD3H-GP 0540-066/028-S06	●	5.4	3	20	28	66	6	140°			
NCD3H-GP 0550-066/028-S06	●	5.5	3	20	28	66	6	140°			
NCD3H-GP 0560-066/028-S06	●	5.6	3	20	28	66	6	140°			
NCD3H-GP 0570-066/028-S06	●	5.7	3	20	28	66	6	140°			
NCD3H-GP 0580-066/028-S06	●	5.8	3	20	28	66	6	140°			
NCD3H-GP 0590-066/028-S06	●	5.9	3	20	28	66	6	140°			
NCD3H-GP 0600-066/028-S06	●	6	3	20	28	66	6	140°			
NCD3H-GP 0610-079/034-S08	●	6.1	3	24	34	79	8	140°			
NCD3H-GP 0620-079/034-S08	●	6.2	3	24	34	79	8	140°			
NCD3H-GP 0630-079/034-S08	●	6.3	3	24	34	79	8	140°			
NCD3H-GP 0640-079/034-S08	●	6.4	3	24	34	79	8	140°			
NCD3H-GP 0650-079/034-S08	●	6.5	3	24	34	79	8	140°			
NCD3H-GP 0660-079/034-S08	●	6.6	3	24	34	79	8	140°			
NCD3H-GP 0670-079/034-S08	●	6.7	3	24	34	79	8	140°			
NCD3H-GP 0680-079/034-S08	●	6.8	3	24	34	79	8	140°			
NCD3H-GP 0690-079/034-S08	●	6.9	3	24	34	79	8	140°			
NCD3H-GP 0700-079/034-S08	●	7	3	24	34	79	8	140°			
NCD3H-GP 0710-079/041-S08	●	7.1	3	29	41	79	8	140°			
NCD3H-GP 0720-079/041-S08	●	7.2	3	29	41	79	8	140°			
NCD3H-GP 0730-079/041-S08	●	7.3	3	29	41	79	8	140°			
NCD3H-GP 0740-079/041-S08	●	7.4	3	29	41	79	8	140°			
NCD3H-GP 0750-079/041-S08	●	7.5	3	29	41	79	8	140°			
NCD3H-GP 0760-079/041-S08	●	7.6	3	29	41	79	8	140°			
NCD3H-GP 0770-079/041-S08	●	7.7	3	29	41	79	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3H-GP 0780-079/041-S08	●	7.8	3	29	41	79	8	140°			
NCD3H-GP 0790-079/041-S08	●	7.9	3	29	41	79	8	140°			
NCD3H-GP 0800-079/041-S08	●	8	3	29	41	79	8	140°			
NCD3H-GP 0810-089/047-S10	●	8.1	3	35	47	89	10	140°			
NCD3H-GP 0820-089/047-S10	●	8.2	3	35	47	89	10	140°			
NCD3H-GP 0830-089/047-S10	●	8.3	3	35	47	89	10	140°			
NCD3H-GP 0840-089/047-S10	●	8.4	3	35	47	89	10	140°			
NCD3H-GP 0850-089/047-S10	●	8.5	3	35	47	89	10	140°			
NCD3H-GP 0860-089/047-S10	●	8.6	3	35	47	89	10	140°			
NCD3H-GP 0870-089/047-S10	●	8.7	3	35	47	89	10	140°			
NCD3H-GP 0880-089/047-S10	●	8.8	3	35	47	89	10	140°			
NCD3H-GP 0890-089/047-S10	●	8.9	3	35	47	89	10	140°			
NCD3H-GP 0900-089/047-S10	●	9	3	35	47	89	10	140°			
NCD3H-GP 0910-089/047-S10	●	9.1	3	35	47	89	10	140°			
NCD3H-GP 0920-089/047-S10	●	9.2	3	35	47	89	10	140°			
NCD3H-GP 0930-089/047-S10	●	9.3	3	35	47	89	10	140°			
NCD3H-GP 0940-089/047-S10	●	9.4	3	35	47	89	10	140°			
NCD3H-GP 0950-089/047-S10	●	9.5	3	35	47	89	10	140°			
NCD3H-GP 0960-089/047-S10	●	9.6	3	35	47	89	10	140°			
NCD3H-GP 0970-089/047-S10	●	9.7	3	35	47	89	10	140°			
NCD3H-GP 0980-089/047-S10	●	9.8	3	35	47	89	10	140°			
NCD3H-GP 0990-089/047-S10	●	9.9	3	35	47	89	10	140°			
NCD3H-GP 1000-089/047-S10	●	10	3	35	47	89	10	140°			
NCD3H-GP 1010-102/055-S12	●	10.1	3	40	55	102	12	140°			
NCD3H-GP 1020-102/055-S12	●	10.2	3	40	55	102	12	140°			
NCD3H-GP 1030-102/055-S12	●	10.3	3	40	55	102	12	140°			
NCD3H-GP 1040-102/055-S12	●	10.4	3	40	55	102	12	140°			
NCD3H-GP 1050-102/055-S12	●	10.5	3	40	55	102	12	140°			
NCD3H-GP 1060-102/055-S12	●	10.6	3	40	55	102	12	140°			
NCD3H-GP 1070-102/055-S12	●	10.7	3	40	55	102	12	140°			
NCD3H-GP 1080-102/055-S12	●	10.8	3	40	55	102	12	140°			
NCD3H-GP 1090-102/055-S12	●	10.9	3	40	55	102	12	140°			
NCD3H-GP 1100-102/055-S12	●	11	3	40	55	102	12	140°			
NCD3H-GP 1110-102/055-S12	●	11.1	3	40	55	102	12	140°			
NCD3H-GP 1120-102/055-S12	●	11.2	3	40	55	102	12	140°			
NCD3H-GP 1130-102/055-S12	●	11.3	3	40	55	102	12	140°			
NCD3H-GP 1140-102/055-S12	●	11.4	3	40	55	102	12	140°			
NCD3H-GP 1150-102/055-S12	●	11.5	3	40	55	102	12	140°			
NCD3H-GP 1160-102/055-S12	●	11.6	3	40	55	102	12	140°			
NCD3H-GP 1170-102/055-S12	●	11.7	3	40	55	102	12	140°			
NCD3H-GP 1180-102/055-S12	●	11.8	3	40	55	102	12	140°			
NCD3H-GP 1190-102/055-S12	●	11.9	3	40	55	102	12	140°			
NCD3H-GP 1200-102/055-S12	●	12	3	40	55	102	12	140°			
NCD3H-GP 1250-107/060-S14	●	12.5	3	43	60	107	14	140°			
NCD3H-GP 1300-107/060-S14	●	13	3	43	60	107	14	140°			
NCD3H-GP 1350-107/060-S14	●	13.5	3	43	60	107	14	140°			
NCD3H-GP 1400-107/060-S14	●	14	3	43	60	107	14	140°			
NCD3H-GP 1450-115/065-S16	●	14.5	3	45	65	115	16	140°			
NCD3H-GP 1500-115/065-S16	●	15	3	49	65	115	16	140°			
NCD3H-GP 1550-115/065-S16	●	15.5	3	49	65	115	16	140°			
NCD3H-GP 1600-115/065-S16	●	16	3	49	65	115	16	140°			
NCD3H-GP 1650-123/073-S18	●	16.5	3	52	73	123	18	140°			
NCD3H-GP 1700-123/073-S18	●	17	3	52	73	123	18	140°			
NCD3H-GP 1750-123/073-S18	●	17.5	3	52	73	123	18	140°			
NCD3H-GP 1800-123/073-S18	●	18	3	52	73	123	18	140°			
NCD3H-GP 1850-131/079-S20	●	18.5	3	55	79	131	20	140°			
NCD3H-GP 1900-131/079-S20	●	19	3	55	79	131	20	140°			
NCD3H-GP 1950-131/079-S20	●	19.5	3	55	79	131	20	140°			
NCD3H-GP 2000-131/079-S20	●	20	3	55	79	131	20	140°			

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

nikkoTOOLS

NCD5H-GP

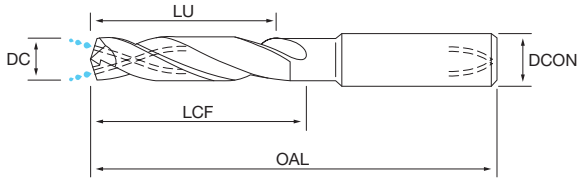
NCD

- First choice for steel and cast iron machining (<45 HRC)
- With coolant holes
- Self centering geometry for accurate holes
- AlTin-nano based coating for long lasting tool life

5xD

with coolant holes

P K



Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5H-GP 0300-066/028-S06	●	3	5	23	28	66	6	140°			
NCD5H-GP 0310-066/028-S06	●	3.1	5	23	28	66	6	140°			
NCD5H-GP 0320-066/028-S06	●	3.2	5	23	28	66	6	140°			
NCD5H-GP 0330-066/028-S06	●	3.3	5	23	28	66	6	140°			
NCD5H-GP 0340-066/028-S06	●	3.4	5	23	28	66	6	140°			
NCD5H-GP 0350-066/028-S06	●	3.5	5	23	28	66	6	140°			
NCD5H-GP 0360-066/028-S06	●	3.6	5	23	28	66	6	140°			
NCD5H-GP 0370-066/028-S06	●	3.7	5	23	28	66	6	140°			
NCD5H-GP 0380-074/036-S06	●	3.8	5	29	36	74	6	140°			
NCD5H-GP 0390-074/036-S06	●	3.9	5	29	36	74	6	140°			
NCD5H-GP 0400-074/036-S06	●	4	5	29	36	74	6	140°			
NCD5H-GP 0410-074/036-S06	●	4.1	5	29	36	74	6	140°			
NCD5H-GP 0420-074/036-S06	●	4.2	5	29	36	74	6	140°			
NCD5H-GP 0430-074/036-S06	●	4.3	5	29	36	74	6	140°			
NCD5H-GP 0440-074/036-S06	●	4.4	5	29	36	74	6	140°			
NCD5H-GP 0450-074/036-S06	●	4.5	5	29	36	74	6	140°			
NCD5H-GP 0460-074/036-S06	●	4.6	5	29	36	74	6	140°			
NCD5H-GP 0470-074/036-S06	●	4.7	5	29	36	74	6	140°			
NCD5H-GP 0480-082/044-S06	●	4.8	5	35	44	82	6	140°			
NCD5H-GP 0490-082/044-S06	●	4.9	5	35	44	82	6	140°			
NCD5H-GP 0500-082/044-S06	●	5	5	35	44	82	6	140°			
NCD5H-GP 0510-082/044-S06	●	5.1	5	35	44	82	6	140°			
NCD5H-GP 0520-082/044-S06	●	5.2	5	35	44	82	6	140°			
NCD5H-GP 0530-082/044-S06	●	5.3	5	35	44	82	6	140°			
NCD5H-GP 0540-082/044-S06	●	5.4	5	35	44	82	6	140°			
NCD5H-GP 0550-082/044-S06	●	5.5	5	35	44	82	6	140°			
NCD5H-GP 0560-082/044-S06	●	5.6	5	35	44	82	6	140°			
NCD5H-GP 0570-082/044-S06	●	5.7	5	35	44	82	6	140°			
NCD5H-GP 0580-082/044-S06	●	5.8	5	35	44	82	6	140°			
NCD5H-GP 0590-082/044-S06	●	5.9	5	35	44	82	6	140°			
NCD5H-GP 0600-082/044-S06	●	6	5	35	44	82	6	140°			
NCD5H-GP 0610-091/053-S08	●	6.1	5	43	53	91	8	140°			
NCD5H-GP 0620-091/053-S08	●	6.2	5	43	53	91	8	140°			
NCD5H-GP 0630-091/053-S08	●	6.3	5	43	53	91	8	140°			
NCD5H-GP 0640-091/053-S08	●	6.4	5	43	53	91	8	140°			
NCD5H-GP 0650-091/053-S08	●	6.5	5	43	53	91	8	140°			
NCD5H-GP 0660-091/053-S08	●	6.6	5	43	53	91	8	140°			
NCD5H-GP 0670-091/053-S08	●	6.7	5	43	53	91	8	140°			
NCD5H-GP 0680-091/053-S08	●	6.8	5	43	53	91	8	140°			
NCD5H-GP 0690-091/053-S08	●	6.9	5	43	53	91	8	140°			
NCD5H-GP 0700-091/053-S08	●	7	5	43	53	91	8	140°			
NCD5H-GP 0710-091/053-S08	●	7.1	5	43	53	91	8	140°			
NCD5H-GP 0720-091/053-S08	●	7.2	5	43	53	91	8	140°			
NCD5H-GP 0730-091/053-S08	●	7.3	5	43	53	91	8	140°			
NCD5H-GP 0740-091/053-S08	●	7.4	5	43	53	91	8	140°			
NCD5H-GP 0750-091/053-S08	●	7.5	5	43	53	91	8	140°			
NCD5H-GP 0760-091/053-S08	●	7.6	5	43	53	91	8	140°			
NCD5H-GP 0770-091/053-S08	●	7.7	5	43	53	91	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5H-GP 0780-091/053-S08	●	7.8	5	43	53	91	8	140°			
NCD5H-GP 0790-091/053-S08	●	7.9	5	43	53	91	8	140°			
NCD5H-GP 0800-091/053-S08	●	8	5	43	53	91	8	140°			
NCD5H-GP 0810-103/061-S10	●	8.1	5	48.85	61	103	10	140°			
NCD5H-GP 0820-103/061-S10	●	8.2	5	48.7	61	103	10	140°			
NCD5H-GP 0830-103/061-S10	●	8.3	5	48.55	61	103	10	140°			
NCD5H-GP 0840-103/061-S10	●	8.4	5	49	61	103	10	140°			
NCD5H-GP 0850-103/061-S10	●	8.5	5	49	61	103	10	140°			
NCD5H-GP 0860-103/061-S10	●	8.6	5	49	61	103	10	140°			
NCD5H-GP 0870-103/061-S10	●	8.7	5	49	61	103	10	140°			
NCD5H-GP 0880-103/061-S10	●	8.8	5	49	61	103	10	140°			
NCD5H-GP 0890-103/061-S10	●	8.9	5	49	61	103	10	140°			
NCD5H-GP 0900-103/061-S10	●	9	5	49	61	103	10	140°			
NCD5H-GP 0910-103/061-S10	●	9.1	5	49	61	103	10	140°			
NCD5H-GP 0920-103/061-S10	●	9.2	5	49	61	103	10	140°			
NCD5H-GP 0930-103/061-S10	●	9.3	5	49	61	103	10	140°			
NCD5H-GP 0940-103/061-S10	●	9.4	5	49	61	103	10	140°			
NCD5H-GP 0950-103/061-S10	●	9.5	5	49	61	103	10	140°			
NCD5H-GP 0960-103/061-S10	●	9.6	5	49	61	103	10	140°			
NCD5H-GP 0970-103/061-S10	●	9.7	5	49	61	103	10	140°			
NCD5H-GP 0980-103/061-S10	●	9.8	5	49	61	103	10	140°			
NCD5H-GP 0990-103/061-S10	●	9.9	5	49	61	103	10	140°			
NCD5H-GP 1000-103/061-S10	●	10	5	49	61	103	10	140°			
NCD5H-GP 1010-118/071-S12	●	10.1	5	52	71	118	12	140°			
NCD5H-GP 1020-118/071-S12	●	10.2	5	52	71	118	12	140°			
NCD5H-GP 1030-118/071-S12	●	10.3	5	52	71	118	12	140°			
NCD5H-GP 1040-118/071-S12	●	10.4	5	52	71	118	12	140°			
NCD5H-GP 1050-118/071-S12	●	10.5	5	52	71	118	12	140°			
NCD5H-GP 1060-118/071-S12	●	10.6	5	52	71	118	12	140°			
NCD5H-GP 1070-118/071-S12	●	10.7	5	52	71	118	12	140°			
NCD5H-GP 1080-118/071-S12	●	10.8	5	52	71	118	12	140°			
NCD5H-GP 1090-118/071-S12	●	10.9	5	52	71	118	12	140°			
NCD5H-GP 1100-118/071-S12	●	11	5	52	71	118	12	140°			
NCD5H-GP 1110-118/071-S12	●	11.1	5	52	71	118	12	140°			
NCD5H-GP 1120-118/071-S12	●	11.2	5	52	71	118	12	140°			
NCD5H-GP 1130-118/071-S12	●	11.3	5	52	71	118	12	140°			
NCD5H-GP 1140-118/071-S12	●	11.4	5	52	71	118	12	140°			
NCD5H-GP 1150-118/071-S12	●	11.5	5	52	71	118	12	140°			
NCD5H-GP 1160-118/071-S12	●	11.6	5	52	71	118	12	140°			
NCD5H-GP 1170-118/071-S12	●	11.7	5	52	71	118	12	140°			
NCD5H-GP 1180-118/071-S12	●	11.8	5	52	71	118	12	140°			
NCD5H-GP 1190-118/071-S12	●	11.9	5	52	71	118	12	140°			
NCD5H-GP 1200-118/071-S12	●	12	5	52	71	118	12	140°			
NCD5H-GP 1250-124/077-S14	●	12.5	5	63	77	124	14	140°			
NCD5H-GP 1300-124/077-S14	●	13	5	63	77	124	14	140°			
NCD5H-GP 1350-124/077-S14	●	13.5	5	63	77	124	14	140°			
NCD5H-GP 1400-124/077-S14	●	14	5	63	77	124	14	140°			
NCD5H-GP 1450-133/083-S16	●	14.5	5	67	83	133	16	140°			
NCD5H-GP 1500-133/083-S16	●	15	5	67	83	133	16	140°			
NCD5H-GP 1550-133/083-S16	●	15.5	5	67	83	133	16	140°			
NCD5H-GP 1600-133/083-S16	●	16	5	67	83	133	16	140°			
NCD5H-GP 1650-143/093-S18	●	16.5	5	75	93	143	18	140°			
NCD5H-GP 1700-143/093-S18	●	17	5	75	93	143	18	140°			
NCD5H-GP 1750-143/093-S18	●	17.5	5	75	93	143	18	140°			
NCD5H-GP 1800-143/093-S18	●	18	5	75	93	143	18	140°			
NCD5H-GP 1850-153/101-S20	●	18.5	5	81	101	153	20	140°			
NCD5H-GP 1900-153/101-S20	●	19	5	81	101	153	20	140°			
NCD5H-GP 1950-153/101-S20	●	19.5	5	81	101	153	20	140°			
NCD5H-GP 2000-153/101-S20	●	20	5	81	101	153	20	140°			

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

nikkoTOOLS

NCD3H-SC

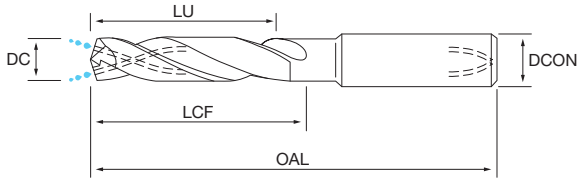
NCD

- First choice for stainless steel and sticky free-cutting steels
- With coolant holes
- Self centering geometry for accurate holes
- AlCrN based multilayer coating with very low friction coefficient to reduce built up edge

3xD

with coolant holes

P M S



Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3H-SC 0300-062/020-S06	●	3	3	14	20	62	6	140°			
NCD3H-SC 0310-062/020-S06	●	3.1	3	14	20	62	6	140°			
NCD3H-SC 0320-062/020-S06	●	3.2	3	14	20	62	6	140°			
NCD3H-SC 0330-062/020-S06	●	3.3	3	14	20	62	6	140°			
NCD3H-SC 0340-062/020-S06	●	3.4	3	14	20	62	6	140°			
NCD3H-SC 0350-062/020-S06	●	3.5	3	14	20	62	6	140°			
NCD3H-SC 0360-062/020-S06	●	3.6	3	14	20	62	6	140°			
NCD3H-SC 0370-062/020-S06	●	3.7	3	14	20	62	6	140°			
NCD3H-SC 0380-066/024-S06	●	3.8	3	17	24	66	6	140°			
NCD3H-SC 0390-066/024-S06	●	3.9	3	17	24	66	6	140°			
NCD3H-SC 0400-066/024-S06	●	4	3	17	24	66	6	140°			
NCD3H-SC 0410-066/024-S06	●	4.1	3	17	24	66	6	140°			
NCD3H-SC 0420-066/024-S06	●	4.2	3	17	24	66	6	140°			
NCD3H-SC 0430-066/024-S06	●	4.3	3	17	24	66	6	140°			
NCD3H-SC 0440-066/024-S06	●	4.4	3	17	24	66	6	140°			
NCD3H-SC 0450-066/024-S06	●	4.5	3	17	24	66	6	140°			
NCD3H-SC 0460-066/024-S06	●	4.6	3	17	24	66	6	140°			
NCD3H-SC 0470-066/024-S06	●	4.7	3	17	24	66	6	140°			
NCD3H-SC 0480-066/028-S06	●	4.8	3	20	28	66	6	140°			
NCD3H-SC 0490-066/028-S06	●	4.9	3	20	28	66	6	140°			
NCD3H-SC 0500-066/028-S06	●	5	3	20	28	66	6	140°			
NCD3H-SC 0510-066/028-S06	●	5.1	3	20	28	66	6	140°			
NCD3H-SC 0520-066/028-S06	●	5.2	3	20	28	66	6	140°			
NCD3H-SC 0530-066/028-S06	●	5.3	3	20	28	66	6	140°			
NCD3H-SC 0540-066/028-S06	●	5.4	3	20	28	66	6	140°			
NCD3H-SC 0550-066/028-S06	●	5.5	3	20	28	66	6	140°			
NCD3H-SC 0560-066/028-S06	●	5.6	3	20	28	66	6	140°			
NCD3H-SC 0570-066/028-S06	●	5.7	3	20	28	66	6	140°			
NCD3H-SC 0580-066/028-S06	●	5.8	3	20	28	66	6	140°			
NCD3H-SC 0590-066/028-S06	●	5.9	3	20	28	66	6	140°			
NCD3H-SC 0600-066/028-S06	●	6	3	20	28	66	6	140°			
NCD3H-SC 0610-079/034-S08	●	6.1	3	24	34	79	8	140°			
NCD3H-SC 0620-079/034-S08	●	6.2	3	24	34	79	8	140°			
NCD3H-SC 0630-079/034-S08	●	6.3	3	24	34	79	8	140°			
NCD3H-SC 0640-079/034-S08	●	6.4	3	24	34	79	8	140°			
NCD3H-SC 0650-079/034-S08	●	6.5	3	24	34	79	8	140°			
NCD3H-SC 0660-079/034-S08	●	6.6	3	24	34	79	8	140°			
NCD3H-SC 0670-079/034-S08	●	6.7	3	24	34	79	8	140°			
NCD3H-SC 0680-079/034-S08	●	6.8	3	24	34	79	8	140°			
NCD3H-SC 0690-079/034-S08	●	6.9	3	24	34	79	8	140°			
NCD3H-SC 0700-079/034-S08	●	7	3	24	34	79	8	140°			
NCD3H-SC 0710-079/041-S08	●	7.1	3	29	41	79	8	140°			
NCD3H-SC 0720-079/041-S08	●	7.2	3	29	41	79	8	140°			
NCD3H-SC 0730-079/041-S08	●	7.3	3	29	41	79	8	140°			
NCD3H-SC 0740-079/041-S08	●	7.4	3	29	41	79	8	140°			
NCD3H-SC 0750-079/041-S08	●	7.5	3	29	41	79	8	140°			
NCD3H-SC 0760-079/041-S08	●	7.6	3	29	41	79	8	140°			
NCD3H-SC 0770-079/041-S08	●	7.7	3	29	41	79	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD3H-SC 0780-079/041-S08	●	7.8	3	29	41	79	8	140°			
NCD3H-SC 0790-079/041-S08	●	7.9	3	29	41	79	8	140°			
NCD3H-SC 0800-079/041-S08	●	8	3	29	41	79	8	140°			
NCD3H-SC 0810-089/047-S10	●	8.1	3	35	47	89	10	140°			
NCD3H-SC 0820-089/047-S10	●	8.2	3	35	47	89	10	140°			
NCD3H-SC 0830-089/047-S10	●	8.3	3	35	47	89	10	140°			
NCD3H-SC 0840-089/047-S10	●	8.4	3	35	47	89	10	140°			
NCD3H-SC 0850-089/047-S10	●	8.5	3	35	47	89	10	140°			
NCD3H-SC 0860-089/047-S10	●	8.6	3	35	47	89	10	140°			
NCD3H-SC 0870-089/047-S10	●	8.7	3	35	47	89	10	140°			
NCD3H-SC 0880-089/047-S10	●	8.8	3	35	47	89	10	140°			
NCD3H-SC 0890-089/047-S10	●	8.9	3	35	47	89	10	140°			
NCD3H-SC 0900-089/047-S10	●	9	3	35	47	89	10	140°			
NCD3H-SC 0910-089/047-S10	●	9.1	3	35	47	89	10	140°			
NCD3H-SC 0920-089/047-S10	●	9.2	3	35	47	89	10	140°			
NCD3H-SC 0930-089/047-S10	●	9.3	3	35	47	89	10	140°			
NCD3H-SC 0940-089/047-S10	●	9.4	3	35	47	89	10	140°			
NCD3H-SC 0950-089/047-S10	●	9.5	3	35	47	89	10	140°			
NCD3H-SC 0960-089/047-S10	●	9.6	3	35	47	89	10	140°			
NCD3H-SC 0970-089/047-S10	●	9.7	3	35	47	89	10	140°			
NCD3H-SC 0980-089/047-S10	●	9.8	3	35	47	89	10	140°			
NCD3H-SC 0990-089/047-S10	●	9.9	3	35	47	89	10	140°			
NCD3H-SC 1000-089/047-S10	●	10	3	35	47	89	10	140°			
NCD3H-SC 1010-102/055-S12	●	10.1	3	40	55	102	12	140°			
NCD3H-SC 1020-102/055-S12	●	10.2	3	40	55	102	12	140°			
NCD3H-SC 1030-102/055-S12	●	10.3	3	40	55	102	12	140°			
NCD3H-SC 1040-102/055-S12	●	10.4	3	40	55	102	12	140°			
NCD3H-SC 1050-102/055-S12	●	10.5	3	40	55	102	12	140°			
NCD3H-SC 1060-102/055-S12	●	10.6	3	40	55	102	12	140°			
NCD3H-SC 1070-102/055-S12	●	10.7	3	40	55	102	12	140°			
NCD3H-SC 1080-102/055-S12	●	10.8	3	40	55	102	12	140°			
NCD3H-SC 1090-102/055-S12	●	10.9	3	40	55	102	12	140°			
NCD3H-SC 1100-102/055-S12	●	11	3	40	55	102	12	140°			
NCD3H-SC 1110-102/055-S12	●	11.1	3	40	55	102	12	140°			
NCD3H-SC 1120-102/055-S12	●	11.2	3	40	55	102	12	140°			
NCD3H-SC 1130-102/055-S12	●	11.3	3	40	55	102	12	140°			
NCD3H-SC 1140-102/055-S12	●	11.4	3	40	55	102	12	140°			
NCD3H-SC 1150-102/055-S12	●	11.5	3	40	55	102	12	140°			
NCD3H-SC 1160-102/055-S12	●	11.6	3	40	55	102	12	140°			
NCD3H-SC 1170-102/055-S12	●	11.7	3	40	55	102	12	140°			
NCD3H-SC 1180-102/055-S12	●	11.8	3	40	55	102	12	140°			
NCD3H-SC 1190-102/055-S12	●	11.9	3	40	55	102	12	140°			
NCD3H-SC 1200-102/055-S12	●	12	3	40	55	102	12	140°			
NCD3H-SC 1250-107/060-S14	●	12.5	3	43	60	107	14	140°			
NCD3H-SC 1300-107/060-S14	●	13	3	43	60	107	14	140°			
NCD3H-SC 1350-107/060-S14	●	13.5	3	43	60	107	14	140°			
NCD3H-SC 1400-107/060-S14	●	14	3	43	60	107	14	140°			
NCD3H-SC 1450-115/065-S16	●	14.5	3	45	65	115	16	140°			
NCD3H-SC 1500-115/065-S16	●	15	3	49	65	115	16	140°			
NCD3H-SC 1550-115/065-S16	●	15.5	3	49	65	115	16	140°			
NCD3H-SC 1600-115/065-S16	●	16	3	49	65	115	16	140°			
NCD3H-SC 1650-123/073-S18	●	16.5	3	52	73	123	18	140°			
NCD3H-SC 1700-123/073-S18	●	17	3	52	73	123	18	140°			
NCD3H-SC 1750-123/073-S18	●	17.5	3	52	73	123	18	140°			
NCD3H-SC 1800-123/073-S18	●	18	3	52	73	123	18	140°			
NCD3H-SC 1850-131/079-S20	●	18.5	3	55	79	131	20	140°			
NCD3H-SC 1900-131/079-S20	●	19	3	55	79	131	20	140°			
NCD3H-SC 1950-131/079-S20	●	19.5	3	55	79	131	20	140°			
NCD3H-SC 2000-131/079-S20	●	20	3	55	79	131	20	140°			

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

nikkoTOOLS

NCD5H-SC

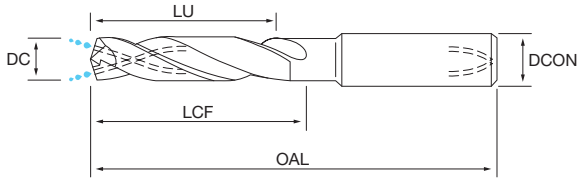
NCD

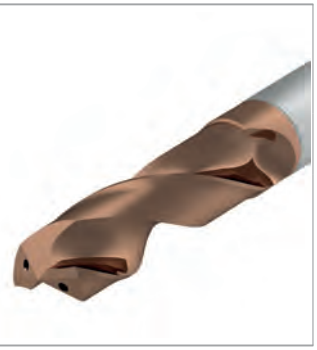
- First choice for stainless steel and sticky free-cutting steels
- With coolant holes
- Self centering geometry for accurate holes
- AlCrN based multilayer coating with very low friction coefficient to reduce built up edge

5xD

with coolant holes

P M S





Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5H-SC 0300-066/028-S06	●	3	5	23	28	66	6	140°			
NCD5H-SC 0310-066/028-S06	●	3.1	5	23	28	66	6	140°			
NCD5H-SC 0320-066/028-S06	●	3.2	5	23	28	66	6	140°			
NCD5H-SC 0330-066/028-S06	●	3.3	5	23	28	66	6	140°			
NCD5H-SC 0340-066/028-S06	●	3.4	5	23	28	66	6	140°			
NCD5H-SC 0350-066/028-S06	●	3.5	5	23	28	66	6	140°			
NCD5H-SC 0360-066/028-S06	●	3.6	5	23	28	66	6	140°			
NCD5H-SC 0370-066/028-S06	●	3.7	5	23	28	66	6	140°			
NCD5H-SC 0380-074/036-S06	●	3.8	5	29	36	74	6	140°			
NCD5H-SC 0390-074/036-S06	●	3.9	5	29	36	74	6	140°			
NCD5H-SC 0400-074/036-S06	●	4	5	29	36	74	6	140°			
NCD5H-SC 0410-074/036-S06	●	4.1	5	29	36	74	6	140°			
NCD5H-SC 0420-074/036-S06	●	4.2	5	29	36	74	6	140°			
NCD5H-SC 0430-074/036-S06	●	4.3	5	29	36	74	6	140°			
NCD5H-SC 0440-074/036-S06	●	4.4	5	29	36	74	6	140°			
NCD5H-SC 0450-074/036-S06	●	4.5	5	29	36	74	6	140°			
NCD5H-SC 0460-074/036-S06	●	4.6	5	29	36	74	6	140°			
NCD5H-SC 0470-074/036-S06	●	4.7	5	29	36	74	6	140°			
NCD5H-SC 0480-082/044-S06	●	4.8	5	35	44	82	6	140°			
NCD5H-SC 0490-082/044-S06	●	4.9	5	35	44	82	6	140°			
NCD5H-SC 0500-082/044-S06	●	5	5	35	44	82	6	140°			
NCD5H-SC 0510-082/044-S06	●	5.1	5	35	44	82	6	140°			
NCD5H-SC 0520-082/044-S06	●	5.2	5	35	44	82	6	140°			
NCD5H-SC 0530-082/044-S06	●	5.3	5	35	44	82	6	140°			
NCD5H-SC 0540-082/044-S06	●	5.4	5	35	44	82	6	140°			
NCD5H-SC 0550-082/044-S06	●	5.5	5	35	44	82	6	140°			
NCD5H-SC 0560-082/044-S06	●	5.6	5	35	44	82	6	140°			
NCD5H-SC 0570-082/044-S06	●	5.7	5	35	44	82	6	140°			
NCD5H-SC 0580-082/044-S06	●	5.8	5	35	44	82	6	140°			
NCD5H-SC 0590-082/044-S06	●	5.9	5	35	44	82	6	140°			
NCD5H-SC 0600-082/044-S06	●	6	5	35	44	82	6	140°			
NCD5H-SC 0610-091/053-S08	●	6.1	5	43	53	91	8	140°			
NCD5H-SC 0620-091/053-S08	●	6.2	5	43	53	91	8	140°			
NCD5H-SC 0630-091/053-S08	●	6.3	5	43	53	91	8	140°			
NCD5H-SC 0640-091/053-S08	●	6.4	5	43	53	91	8	140°			
NCD5H-SC 0650-091/053-S08	●	6.5	5	43	53	91	8	140°			
NCD5H-SC 0660-091/053-S08	●	6.6	5	43	53	91	8	140°			
NCD5H-SC 0670-091/053-S08	●	6.7	5	43	53	91	8	140°			
NCD5H-SC 0680-091/053-S08	●	6.8	5	43	53	91	8	140°			
NCD5H-SC 0690-091/053-S08	●	6.9	5	43	53	91	8	140°			
NCD5H-SC 0700-091/053-S08	●	7	5	43	53	91	8	140°			
NCD5H-SC 0710-091/053-S08	●	7.1	5	43	53	91	8	140°			
NCD5H-SC 0720-091/053-S08	●	7.2	5	43	53	91	8	140°			
NCD5H-SC 0730-091/053-S08	●	7.3	5	43	53	91	8	140°			
NCD5H-SC 0740-091/053-S08	●	7.4	5	43	53	91	8	140°			
NCD5H-SC 0750-091/053-S08	●	7.5	5	43	53	91	8	140°			
NCD5H-SC 0760-091/053-S08	●	7.6	5	43	53	91	8	140°			
NCD5H-SC 0770-091/053-S08	●	7.7	5	43	53	91	8	140°			

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

Designation	Stock	DC	ULDR	LU	LCF	OAL	DCON	SIG			
NCD5H-SC 0780-091/053-S08	●	7.8	5	43	53	91	8	140°			
NCD5H-SC 0790-091/053-S08	●	7.9	5	43	53	91	8	140°			
NCD5H-SC 0800-091/053-S08	●	8	5	43	53	91	8	140°			
NCD5H-SC 0810-103/061-S10	●	8.1	5	48.85	61	103	10	140°			
NCD5H-SC 0820-103/061-S10	●	8.2	5	48.7	61	103	10	140°			
NCD5H-SC 0830-103/061-S10	●	8.3	5	48.55	61	103	10	140°			
NCD5H-SC 0840-103/061-S10	●	8.4	5	49	61	103	10	140°			
NCD5H-SC 0850-103/061-S10	●	8.5	5	49	61	103	10	140°			
NCD5H-SC 0860-103/061-S10	●	8.6	5	49	61	103	10	140°			
NCD5H-SC 0870-103/061-S10	●	8.7	5	49	61	103	10	140°			
NCD5H-SC 0880-103/061-S10	●	8.8	5	49	61	103	10	140°			
NCD5H-SC 0890-103/061-S10	●	8.9	5	49	61	103	10	140°			
NCD5H-SC 0900-103/061-S10	●	9	5	49	61	103	10	140°			
NCD5H-SC 0910-103/061-S10	●	9.1	5	49	61	103	10	140°			
NCD5H-SC 0920-103/061-S10	●	9.2	5	49	61	103	10	140°			
NCD5H-SC 0930-103/061-S10	●	9.3	5	49	61	103	10	140°			
NCD5H-SC 0940-103/061-S10	●	9.4	5	49	61	103	10	140°			
NCD5H-SC 0950-103/061-S10	●	9.5	5	49	61	103	10	140°			
NCD5H-SC 0960-103/061-S10	●	9.6	5	49	61	103	10	140°			
NCD5H-SC 0970-103/061-S10	●	9.7	5	49	61	103	10	140°			
NCD5H-SC 0980-103/061-S10	●	9.8	5	49	61	103	10	140°			
NCD5H-SC 0990-103/061-S10	●	9.9	5	49	61	103	10	140°			
NCD5H-SC 1000-103/061-S10	●	10	5	49	61	103	10	140°			
NCD5H-SC 1010-118/071-S12	●	10.1	5	52	71	118	12	140°			
NCD5H-SC 1020-118/071-S12	●	10.2	5	52	71	118	12	140°			
NCD5H-SC 1030-118/071-S12	●	10.3	5	52	71	118	12	140°			
NCD5H-SC 1040-118/071-S12	●	10.4	5	52	71	118	12	140°			
NCD5H-SC 1050-118/071-S12	●	10.5	5	52	71	118	12	140°			
NCD5H-SC 1060-118/071-S12	●	10.6	5	52	71	118	12	140°			
NCD5H-SC 1070-118/071-S12	●	10.7	5	52	71	118	12	140°			
NCD5H-SC 1080-118/071-S12	●	10.8	5	52	71	118	12	140°			
NCD5H-SC 1090-118/071-S12	●	10.9	5	52	71	118	12	140°			
NCD5H-SC 1100-118/071-S12	●	11	5	52	71	118	12	140°			
NCD5H-SC 1110-118/071-S12	●	11.1	5	52	71	118	12	140°			
NCD5H-SC 1120-118/071-S12	●	11.2	5	52	71	118	12	140°			
NCD5H-SC 1130-118/071-S12	●	11.3	5	52	71	118	12	140°			
NCD5H-SC 1140-118/071-S12	●	11.4	5	52	71	118	12	140°			
NCD5H-SC 1150-118/071-S12	●	11.5	5	52	71	118	12	140°			
NCD5H-SC 1160-118/071-S12	●	11.6	5	52	71	118	12	140°			
NCD5H-SC 1170-118/071-S12	●	11.7	5	52	71	118	12	140°			
NCD5H-SC 1180-118/071-S12	●	11.8	5	52	71	118	12	140°			
NCD5H-SC 1190-118/071-S12	●	11.9	5	52	71	118	12	140°			
NCD5H-SC 1200-118/071-S12	●	12	5	52	71	118	12	140°			
NCD5H-SC 1250-124/077-S14	●	12.5	5	63	77	124	14	140°			
NCD5H-SC 1300-124/077-S14	●	13	5	63	77	124	14	140°			
NCD5H-SC 1350-124/077-S14	●	13.5	5	63	77	124	14	140°			
NCD5H-SC 1400-124/077-S14	●	14	5	63	77	124	14	140°			
NCD5H-SC 1450-133/083-S16	●	14.5	5	67	83	133	16	140°			
NCD5H-SC 1500-133/083-S16	●	15	5	67	83	133	16	140°			
NCD5H-SC 1550-133/083-S16	●	15.5	5	67	83	133	16	140°			
NCD5H-SC 1600-133/083-S16	●	16	5	67	83	133	16	140°			
NCD5H-SC 1650-143/093-S18	●	16.5	5	75	93	143	18	140°			
NCD5H-SC 1700-143/093-S18	●	17	5	75	93	143	18	140°			
NCD5H-SC 1750-143/093-S18	●	17.5	5	75	93	143	18	140°			
NCD5H-SC 1800-143/093-S18	●	18	5	75	93	143	18	140°			
NCD5H-SC 1850-153/101-S20	●	18.5	5	81	101	153	20	140°			
NCD5H-SC 1900-153/101-S20	●	19	5	81	101	153	20	140°			
NCD5H-SC 1950-153/101-S20	●	19.5	5	81	101	153	20	140°			
NCD5H-SC 2000-153/101-S20	●	20	5	81	101	153	20	140°			

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

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ISO 513	MATERIAL	HARDNESS HB	L/D	NCD GP min	NCD GP start	NCD GP max	NCD H GP min	NCD H GP start	NCD H GP max	NCD H SC min	NCD H SC start	NCD H SC max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	3XD ÷ 5XD	80	**100**	120	100	**130**	160	100	**130**	160
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	3XD ÷ 5XD	60	**80**	100	80	**110**	140	80	**110**	140
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	3XD ÷ 5XD	40	**60**	80	60	**90**	120		-	
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	3XD ÷ 5XD		-			-		50	**60**	70
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	3XD ÷ 5XD		-			-		20	**25**	30
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	3XD ÷ 5XD		-			-		40	**60**	80
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		3XD ÷ 5XD		-			-		20	**30**	40
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	3XD ÷ 5XD	80	**90**	100	100	**120**	140		-	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	3XD ÷ 5XD	40	**60**	80	60	**90**	120		-	
S1 - S2 - S3	Fe/Ni/Co based heat resistant alloys (ex. Hastelloy, Inconel 625, Inconel 718)		3XD ÷ 5XD		-			-		30	**40**	50
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		3XD ÷ 5XD		-			-		40	**50**	60

Complete workpiece materials p. **H**1.

DRILLING Parameters - feed rate · NCD

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ISO 513	MATERIAL	HARDNESS HB	TYPE	DC 3.00 ÷ 3.99			DC 4.00 ÷ 4.99			DC 5.00 ÷ 5.99		
				min	start	max	min	start	max	min	start	max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	NCD GP	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20
			NCD H GP	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21
			NCD H SC	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	NCD GP	0.10	**0.12**	0.14	0.11	**0.13**	0.15	0.12	**0.14**	0.16
			NCD H GP	0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.13	**0.15**	0.17
			NCD H SC	0.09	**0.11**	0.13	0.10	**0.12**	0.14	0.11	**0.13**	0.15
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	NCD GP	0.08	**0.10**	0.12	0.09	**0.11**	0.13	0.10	**0.12**	0.14
			NCD H GP	0.08	**0.10**	0.13	0.09	**0.12**	0.14	0.10	**0.13**	0.15
			NCD H SC		-			-			-	
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.07	**0.10**	0.13
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.06	**0.07**	0.08	0.05	**0.07**	0.09	0.06	**0.08**	0.10
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.02	**0.05**	0.08	0.03	**0.06**	0.09	0.06	**0.08**	0.10
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.02	**0.04**	0.06	0.03	**0.05**	0.07	0.04	**0.06**	0.08
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	NCD GP	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22
			NCD H GP	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23
			NCD H SC		-			-			-	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	NCD GP	0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18
			NCD H GP	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19
			NCD H SC		-			-			-	
S1 - S2 - S3	Fe/Ni/Co based heat resistant alloys (ex. Hastelloy, Inconel 625, Inconel 718)		NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.01	**0.02**	0.04	0.01	**0.03**	0.05	0.02	**0.04**	0.06
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.01	**0.03**	0.05	0.02	**0.04**	0.06	0.03	**0.05**	0.07

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DC 6.00 ÷ 6.99			DC 7.00 ÷ 7.99			DC 8.00 ÷ 8.99			DC 9.00 ÷ 9.99			DC 10.00 ÷ 10.99			DC 11.00 ÷ 11.99		
min	start	max	min	start	max	min	start	max	min	start	max	min	start	max	min	start	max
0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26
0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27
0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25
0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22
0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23
0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21
0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20
0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21
	-			-			-			-			-			-	
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.10	**0.12**	0.14	0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19
	-			-		-				-			-			-	
	-			-		-				-			-			-	
0.06	**0.09**	0.12	0.07	**0.10**	0.13	0.08	**0.11**	0.14	0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.12	**0.15**	0.18
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.07	**0.09**	0.11	0.07	**0.10**	0.13	0.10	**0.12**	0.14	0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.13	**0.15**	0.17
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.09	**0.11**	0.13	0.10	**0.12**	0.14	0.11	**0.13**	0.15
0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28
0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29
	-			-			-			-			-			-	
0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24
0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25
	-			-			-			-			-			-	
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.03	**0.05**	0.07	0.04	**0.06**	0.08	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.09	**0.11**	0.13
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.04	**0.06**	0.08	0.05	**0.07**	0.09	0.05	**0.08**	0.11	0.06	**0.09**	0.12	0.09	**0.11**	0.13	0.10	**0.12**	0.14

Complete workpiece materials p. **H**1.

(fn: mm/rev)

ISO 513	MATERIAL	HARDNESS HB	TYPE	DC 12.00 ÷ 12.99			DC 13.00 ÷ 13.99			DC 14.00 ÷ 14.99		
				min	start	max	min	start	max	min	start	max
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	NCD GP	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29
			NCD H GP	0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30
			NCD H SC	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	NCD GP	0.19	**0.21**	0.22	0.20	**0.22**	0.24	0.21	**0.23**	0.25
			NCD H GP	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26
			NCD H SC	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	NCD GP	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23
			NCD H GP	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24
			NCD H SC		-			-			-	
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.13	**0.16**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		NCD GP		-			-		-		
			NCD H GP		-			-		-		
			NCD H SC	0.12	**0.14**	0.16	0.13	**0.15**	0.17	0.14	**0.16**	0.18
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	NCD GP	0.25	**0.27**	0.29	0.26	**0.28**	0.30	0.27	**0.29**	0.31
			NCD H GP	0.26	**0.28**	0.30	0.27	**0.29**	0.32	0.28	**0.30**	0.33
			NCD H SC		-			-			-	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	NCD GP	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27
			NCD H GP	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28
			NCD H SC		-			-			-	
S1 - S2 - S3	Fe/Ni/Co based heat resistant alloys (ex. Hastelloy, Inconel 625, Inconel 718)		NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.10	**0.12**	0.14	0.11	**0.13**	0.15	0.12	**0.14**	0.16
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		NCD GP		-			-			-	
			NCD H GP		-			-			-	
			NCD H SC	0.11	**0.13**	0.15	0.12	**0.14**	0.16	0.13	**0.15**	0.17

Complete workpiece materials p. **H**1.

(fn: mm/rev)

DC 15.00 ÷ 15.99			DC 16.00 ÷ 16.99			DC 17.00 ÷ 17.99			DC 18.00 ÷ 18.99			DC 19.00 ÷ 19.99			DC 20.00 ÷ 20.99		
min	start	max	min	start	max	min	start	max	min	start	max	min	start	max	min	start	max
0.26	**0.28**	0.30	0.29	**0.29**	0.31	0.28	**0.30**	0.32	0.29	**0.31**	0.33	0.30	**0.32**	0.34	0.31	**0.33**	0.35
0.27	**0.29**	0.32	0.30	**0.30**	0.33	0.29	**0.32**	0.34	0.30	**0.33**	0.35	0.32	**0.34**	0.36	0.33	**0.35**	0.37
0.25	**0.27**	0.29	0.30	**0.30**	0.30	0.26	**0.29**	0.32	0.27	**0.30**	0.33	0.30	**0.32**	0.34	0.31	**0.33**	0.35
0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30	0.27	**0.29**	0.31
0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30	0.27	**0.29**	0.32	0.28	**0.30**	0.33
0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30
0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29
0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30
	-			-			-			-			-			-	
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.23	**0.25**	0.27	0.24	**0.26**	0.28
	-		-			-			-			-				-	
	-		-			-			-			-				-	
0.17	**0.20**	0.23	0.18	**0.21**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26	0.22	**0.25**	0.28	0.24	**0.26**	0.28
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24	0.21	**0.23**	0.25	0.22	**0.24**	0.26
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23	0.20	**0.22**	0.24
0.28	**0.30**	0.32	0.29	**0.31**	0.33	0.30	**0.32**	0.34	0.31	**0.33**	0.35	0.32	**0.34**	0.36	0.33	**0.35**	0.37
0.29	**0.32**	0.34	0.30	**0.33**	0.35	0.32	**0.34**	0.36	0.33	**0.35**	0.37	0.34	**0.36**	0.38	0.35	**0.37**	0.39
	-			-			-			-			-			-	
0.24	**0.26**	0.28	0.25	**0.27**	0.29	0.26	**0.28**	0.30	0.27	**0.29**	0.31	0.28	**0.30**	0.32	0.29	**0.31**	0.33
0.25	**0.27**	0.29	0.26	**0.28**	0.30	0.27	**0.29**	0.32	0.28	**0.30**	0.33	0.29	**0.32**	0.34	0.30	**0.33**	0.35
	-			-			-			-			-			-	
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.13	**0.15**	0.17	0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22
	-			-			-			-			-			-	
	-			-			-			-			-			-	
0.14	**0.16**	0.18	0.15	**0.17**	0.19	0.16	**0.18**	0.20	0.17	**0.19**	0.21	0.18	**0.20**	0.22	0.19	**0.21**	0.23

Complete workpiece materials p. **H**1.

(fn: mm/rev)

WCMX

ISO

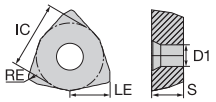
HF: Micrograin carbide
PVD: Physical vapour deposition

	HF PVD
	JP5530

- ISO drilling inserts with geometry for general purposes
- PVD coated carbide grade for universal use
- Inserts could be mounted on ISO drill bodies with seats of the same IC circle

Stable machining, light cut	● 1st choice ○ suitable	
General machining, medium cut	● 1st choice ○ suitable	●
Unstable machining, heavy cut	● 1st choice ○ suitable	○

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	**120** **240**
M	40 100
K	120 180
N	
S	
H	

	Designation	RE	IC	S	D1	LE	Stock
GENERAL GP P M K	WCMX030208-GP	0.8	5.56	2.38	2.8	-	●
	WCMX040208-GP	0.8	6.35	2.38	2.9	-	●
	WCMX050308-GP	0.8	7.94	3.18	3.4	-	●
	WCMX06T308-GP	0.8	9.52	3.97	3.8	-	●
	WCMX080412-GP	1.2	12.7	4.76	4.4	-	●

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