

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

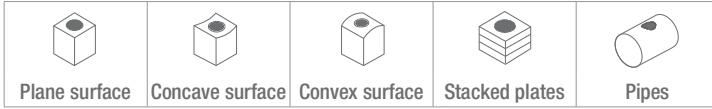
F - ACCESSORIES

G - SPARE PARTS

# DXP

For extra deep holes - Indexable drilling system with exchangeable heads

## APPLICATION



## 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

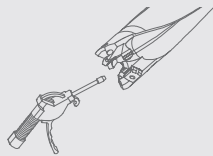
- Weldon shank with internal coolant
- 3/ 6/ 8/ 10xD available from D30 to D60
- Special length and stepped body available upon request



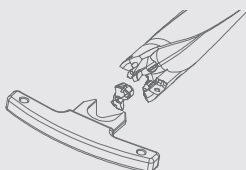
### • Inserts

- 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 INSTALLATION



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



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

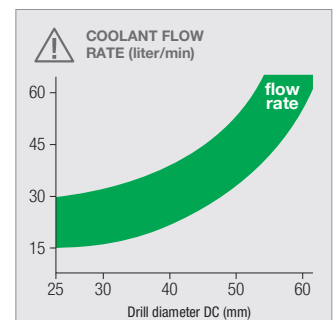
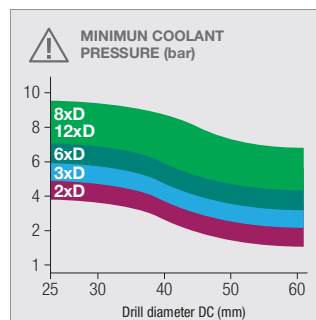


<h1>3xD</h1>		
<h2>DXP drill</h2>		
<ul style="list-style-type: none"> <li>• 3xD pilot type drill body</li> <li>• All with 4 coolant holes</li> <li>• Please select inserts according to columns PILOT and MIID</li> <li>• Peripheral inserts for D30 and D31 have a different shape compared to all the others</li> </ul>		

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



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# 6xD

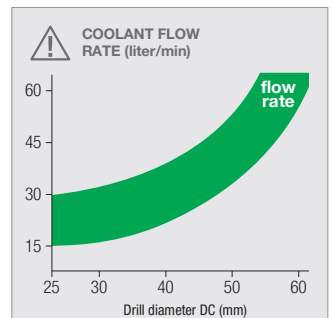
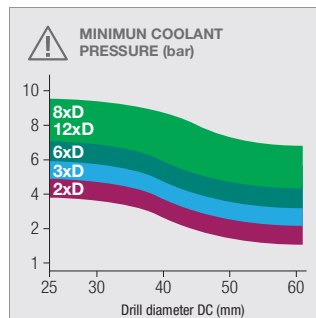
## DXP drill

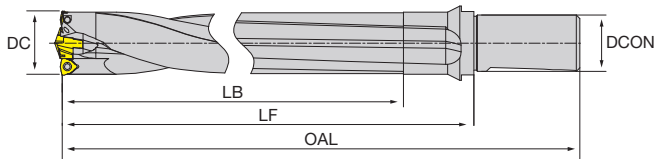

- 6xD pilot type drill body
- All with 4 coolant holes
- Please select inserts according to columns PILOT and MIID
- Peripheral inserts for D30 and D31 have a different shape compared to all the others

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

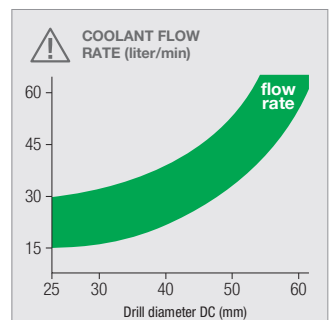
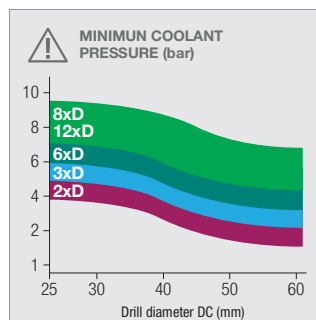


<h1>8xD</h1>		
<h2>DXP drill</h2>		
<ul style="list-style-type: none"> <li>• 8xD pilot type drill body</li> <li>• All with 4 coolant holes</li> <li>• Please select inserts according to columns PILOT and MIID</li> <li>• Peripheral inserts for D30 and D31 have a different shape compared to all the others</li> </ul>		

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



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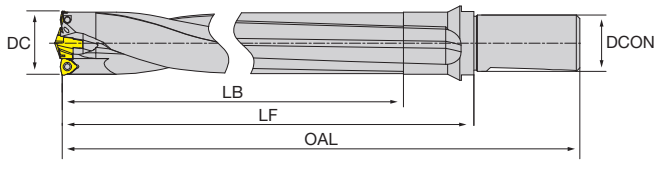
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# 10xD

## 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

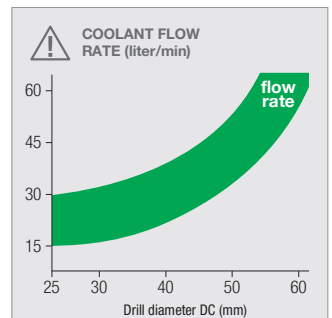
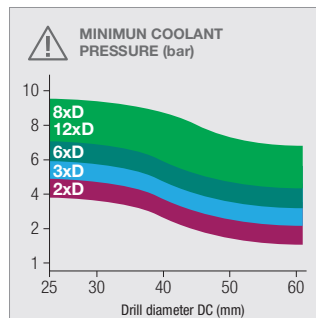


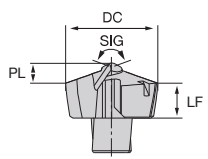



Designation	Stock	DC	DCON	OAL	LF	LB				PILOT	MIID
NT-DXP-10 D30-S32-P16E04	▲	30	32	395	335	319.9				DXP-P16	DXP-E04
NT-DXP-10 D31-S32-P17E04	▲	31	32	406	346	320.9				DXP-P17	DXP-E04
NT-DXP-10 D32-S32-P15E05	▲	32	32	417	357	328.7				DXP-P15	DXP-E05
NT-DXP-10 D33-S32-P16E05	▲	33	32	427	367	338.8				DXP-P16	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

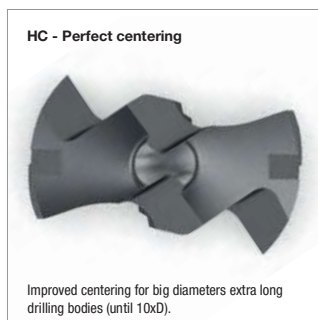
Spare parts	Head wrench	Insert screws	Flag wrenches
NT-DXP-10 (DC 30)	NT-WR1416	NT-ST25080T09	NT-FTB09
NT-DXP-10 (DC 31)	NT-WR1720	NT-ST25080T09	NT-FTB09
NT-DXP-10 (DC 32÷34)	NT-WR1416	NT-ST30080T10	NT-FTB10
NT-DXP-10 (DC 35÷36)	NT-WR1720	NT-ST30080T10	NT-FTB10
NT-DXP-10 (DC 37÷38)	NT-WR1416	NT-ST40100T15	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



<h1>Pilot</h1>	HF: Micrograin carbide PVD: Physical vapour deposition	HF PVD	
		<b>JP5725</b>	
<h2>DXP drill</h2>	<ul style="list-style-type: none"> <li>● PVD coated carbide pilot HC (high concentricity) pilot is for general purpose use</li> <li>● DXP pilot may look like a DEX drill head but they're not interchangeable</li> <li>● Step drills can be made upon request</li> </ul>	Stable machining, light cut <input checked="" type="radio"/> 1 <sup>st</sup> choice <input type="radio"/> suitable General machining, medium cut <input checked="" type="radio"/> 1 <sup>st</sup> choice <input type="radio"/> suitable Unstable machining, heavy cut <input checked="" type="radio"/> 1 <sup>st</sup> choice <input type="radio"/> suitable	
	<b>Dimensions</b> 	<b>ISO</b> <b>P</b> 55 160 <b>M</b> <b>K</b> 60 140 <b>N</b> <b>S</b> <b>H</b>	<b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b> P: 55-160 M: 60-140 K: 60-140 N: 60-140 S: 60-140 H: 60-140

GENERAL	HC <b>P K</b>	Designation	DC	DC toll.	SIG	PL	LF	Stock	
 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



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B - THREADING

C - GROOVING



D - MILLING

E - DRILLING

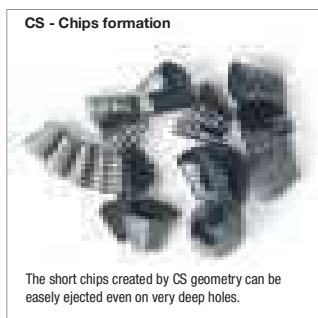
F - ACCESSORIES

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<h1>External</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD
	<h2>DXP drill</h2>		<b>JP5725</b>
<ul style="list-style-type: none"> <li>• New generation "Chip Splitter"</li> <li>• Specially waved edge splits the chips, improves heat dissipation, prolongs the tool life, improves hole quality</li> <li>• Peripheral inserts for DXP drill</li> <li>• Step drills can be made upon request</li> </ul>	Stable machining, light cut	● 1 <sup>st</sup> choice ○ suitable	○
	General machining, medium cut	● 1 <sup>st</sup> choice ○ suitable	●
	Unstable machining, heavy cut	● 1 <sup>st</sup> choice ○ suitable	○
	<b>Dimensions</b>		<b>ISO</b>
		<b>P</b>	55 160
		<b>M</b>	
		<b>K</b>	60 140
		<b>N</b>	
		<b>S</b>	
		<b>H</b>	

Designation		RE	IC	S	D1	LE	Stock	
GENERAL	 CS <b>P K</b> chip splitter DXP-E04-CS	0.4	7.26	3.79	2.85	10.76	▲	
	 CS <b>P K</b> 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



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

Complete workpiece materials p. H1.

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

Complete workpiece materials p. H1.

(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	<b>0.30</b>	0.40	0.20	<b>0.32</b>	0.44	0.22	<b>0.34</b>	0.46			
0.16	<b>0.24</b>	0.32	0.16	<b>0.26</b>	0.36	0.18	<b>0.27</b>	0.36			
0.14	<b>0.21</b>	0.28	0.14	<b>0.22</b>	0.30	0.16	<b>0.24</b>	0.32			
0.22	<b>0.29</b>	0.46	0.22	<b>0.36</b>	0.50	0.24	<b>0.38</b>	0.52			
0.18	<b>0.27</b>	0.36	0.18	<b>0.27</b>	0.40	0.20	<b>0.31</b>	0.42			
0.16	<b>0.24</b>	0.32	0.16	<b>0.26</b>	0.36	0.16	<b>0.26</b>	0.36			
0.22	<b>0.33</b>	0.44	0.22	<b>0.35</b>	0.48	0.24	<b>0.37</b>	0.50			
0.18	<b>0.27</b>	0.36	0.18	<b>0.28</b>	0.38	0.20	<b>0.30</b>	0.40			
0.16	<b>0.23</b>	0.30	0.16	<b>0.25</b>	0.34	0.16	<b>0.26</b>	0.36			
0.24	<b>0.36</b>	0.48	0.24	<b>0.38</b>	0.52	0.26	<b>0.40</b>	0.54			
0.20	<b>0.29</b>	0.38	0.20	<b>0.31</b>	0.42	0.20	<b>0.32</b>	0.44			
0.16	<b>0.25</b>	0.34	0.16	<b>0.26</b>	0.36	0.18	<b>0.28</b>	0.38			
0.20	<b>0.29</b>	0.38	0.20	<b>0.31</b>	0.42	0.20	<b>0.32</b>	0.44			
0.16	<b>0.23</b>	0.30	0.16	<b>0.25</b>	0.34	0.16	<b>0.26</b>	0.36			
0.14	<b>0.20</b>	0.26	0.14	<b>0.22</b>	0.30	0.14	<b>0.22</b>	0.30			

Complete workpiece materials p. H1.

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