



•
Launching range from $\varnothing 12$ to $\varnothing 20.90$
with 0.1mm increase

•
2 different lengths available: 3xD and 5xD

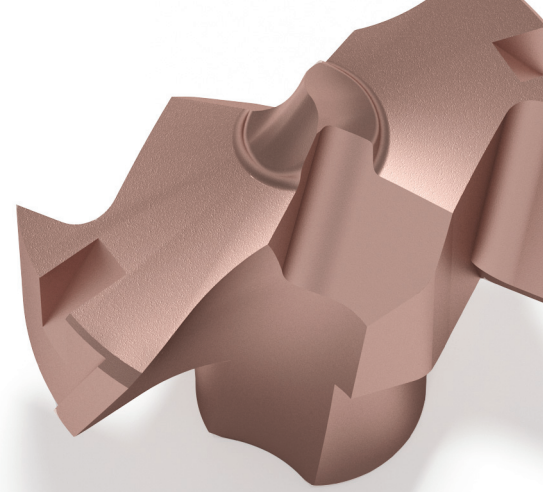
•
Drilling heads combined with a general purpose (GP)
geometry for ISO **P** and ISO **K** application or with a
reinforced chamfered type (TE) for highest performance
on ISO **K** mass production applications.

•
Only 9 drilling bodies to cover the complete range:
25% reduction of inventory cost compared to
market alternatives!

DEXDRILL

High performance drilling system with interchangeable heads

nikkoTOOLS



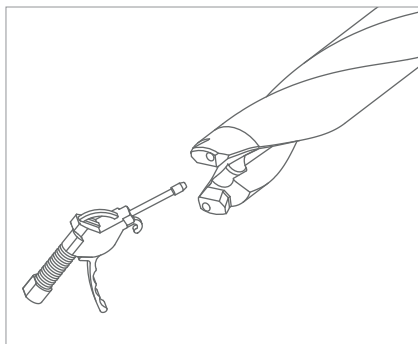
DEXDRILL

High performance drilling system with interchangeable heads

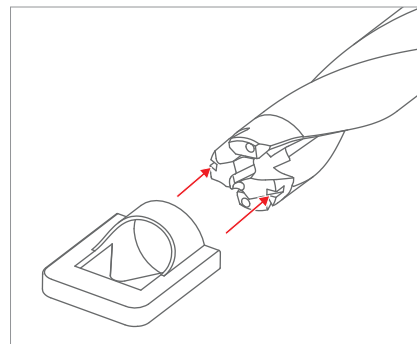
1. Where is DEXdrill applicable?

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

2. Drilling heads installation

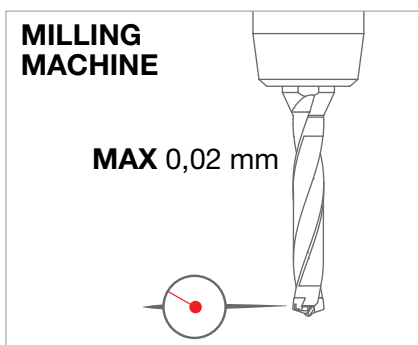


Clean pocket with air blast.
Put insert into drill holder.

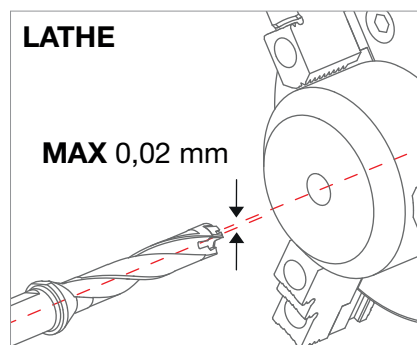


Set wrench into slots on insert flanks.
Slowly turn the wrench clockwise until stop.

3. Operation recommendations



Center of arbor deviation must be under 0.02mm



Keep under 0.02mm the maximum deviation between drill and workpiece

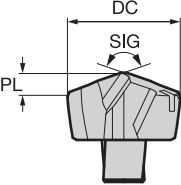


DEX	self-locking drilling head				ISO513	HC-PVD																	
	DC tol.	SIG			JP5625	JP7625																	
	k6	140°			P	40 160																	
					M																		
					K	80 180	100 200																
					N																		
					S																		
GRADE APPLICATION AREA	Stable machining			+	○																		
main application	General machining			-	○																		
applicable	Unstable machining			+	○																		



GENERAL	GP P K	DC	DEX	PL	f _n				●															
		DC 14.80	DEX1480-GP	PL 2.69	f _n	▶	0.16	0.22	0.30	●														
		DC 14.90	DEX1490-GP	PL 2.71	f _n	▶	0.16	0.22	0.30	●														
		DC 15.00	DEX1500-GP	PL 2.73	f _n	▶	0.18	0.25	0.32	●														
		DC 15.10	DEX1510-GP	PL 2.75	f _n	▶	0.18	0.25	0.32	●														
		DC 15.20	DEX1520-GP	PL 2.77	f _n	▶	0.18	0.25	0.32	●														
		DC 15.30	DEX1530-GP	PL 2.78	f _n	▶	0.18	0.25	0.32	●														
		DC 15.40	DEX1540-GP	PL 2.80	f _n	▶	0.18	0.25	0.32	●														
		DC 15.50	DEX1550-GP	PL 2.82	f _n	▶	0.18	0.25	0.32	●														
		DC 15.60	DEX1560-GP	PL 2.84	f _n	▶	0.18	0.25	0.32	●														
		DC 15.70	DEX1570-GP	PL 2.86	f _n	▶	0.18	0.25	0.32	●														
		DC 15.80	DEX1580-GP	PL 2.88	f _n	▶	0.18	0.25	0.32	●														
		DC 15.90	DEX1590-GP	PL 2.89	f _n	▶	0.18	0.25	0.32	●														
		DC 16.00	DEX1600-GP	PL 2.91	f _n	▶	0.20	0.26	0.34	●														
		DC 16.10	DEX1610-GP	PL 2.93	f _n	▶	0.20	0.26	0.34	●														
		DC 16.20	DEX1620-GP	PL 2.95	f _n	▶	0.20	0.26	0.34	●														
		DC 16.30	DEX1630-GP	PL 2.97	f _n	▶	0.20	0.26	0.34	●														
		DC 16.40	DEX1640-GP	PL 2.98	f _n	▶	0.20	0.26	0.34	●														
		DC 16.50	DEX1650-GP	PL 3.00	f _n	▶	0.20	0.26	0.34	●														
		DC 16.60	DEX1660-GP	PL 3.02	f _n	▶	0.20	0.26	0.34	●														
		DC 16.70	DEX1670-GP	PL 3.04	f _n	▶	0.20	0.26	0.34	●														
		DC 16.80	DEX1680-GP	PL 3.06	f _n	▶	0.20	0.26	0.34	●														
		DC 16.90	DEX1690-GP	PL 3.08	f _n	▶	0.20	0.26	0.34	●														
		DC 17.00	DEX1700-GP	PL 3.09	f _n	▶	0.20	0.28	0.36	●														
		DC 17.10	DEX1710-GP	PL 3.11	f _n	▶	0.20	0.28	0.36	●														
		DC 17.20	DEX1720-GP	PL 3.13	f _n	▶	0.20	0.28	0.36	●														
		DC 17.30	DEX1730-GP	PL 3.15	f _n	▶	0.20	0.28	0.36	●														
		DC 17.40	DEX1740-GP	PL 3.17	f _n	▶	0.20	0.28	0.36	●														
		DC 17.50	DEX1750-GP	PL 3.18	f _n	▶	0.20	0.28	0.36	●														

● stock standard

DEX			self-locking drilling head						ISO513		HC-PVD												
									JP5625	JP7625	JP5625	JP7625											
	DC tol.	SIG					P	40 160															
	k6	140°					M																
							K	80 180	100 200														
							N																
							S																
							H																
GRADE APPLICATION AREA		Stable machining																					
		General machining																					
		Unstable machining																					
GENERAL 	GP P K	DC 17.60	DEX1760-GP	PL 3.20	$f_n \blacktriangleright$ 0.20	0.28	0.36	●															
		DC 17.70	DEX1770-GP	PL 3.22	$f_n \blacktriangleright$ 0.20	0.28	0.36	●															
		DC 17.80	DEX1780-GP	PL 3.24	$f_n \blacktriangleright$ 0.20	0.28	0.36	●															
		DC 17.90	DEX1790-GP	PL 3.26	$f_n \blacktriangleright$ 0.20	0.28	0.36	●															
		DC 18.00	DEX1800-GP	PL 3.28	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.10	DEX1810-GP	PL 3.29	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.20	DEX1820-GP	PL 3.31	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.30	DEX1830-GP	PL 3.33	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.40	DEX1840-GP	PL 3.35	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.50	DEX1850-GP	PL 3.37	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.60	DEX1860-GP	PL 3.38	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.70	DEX1870-GP	PL 3.40	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.80	DEX1880-GP	PL 3.42	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 18.90	DEX1890-GP	PL 3.44	$f_n \blacktriangleright$ 0.22	0.30	0.40	●															
		DC 19.00	DEX1900-GP	PL 3.46	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.10	DEX1910-GP	PL 3.48	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.20	DEX1920-GP	PL 3.49	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.30	DEX1930-GP	PL 3.51	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.40	DEX1940-GP	PL 3.53	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.50	DEX1950-GP	PL 3.55	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.60	DEX1960-GP	PL 3.57	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.70	DEX1970-GP	PL 3.59	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.80	DEX1980-GP	PL 3.60	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 19.90	DEX1990-GP	PL 3.62	$f_n \blacktriangleright$ 0.24	0.32	0.42	●															
		DC 20.00	DEX2000-GP	PL 3.64	$f_n \blacktriangleright$ 0.26	0.35	0.44	●															
		DC 20.10	DEX2010-GP	PL 3.66	$f_n \blacktriangleright$ 0.26	0.35	0.44	●															
		DC 20.20	DEX2020-GP	PL 3.68	$f_n \blacktriangleright$ 0.26	0.35	0.44	●															
		DC 20.30	DEX2030-GP	PL 3.69	$f_n \blacktriangleright$ 0.26	0.35	0.44	●															

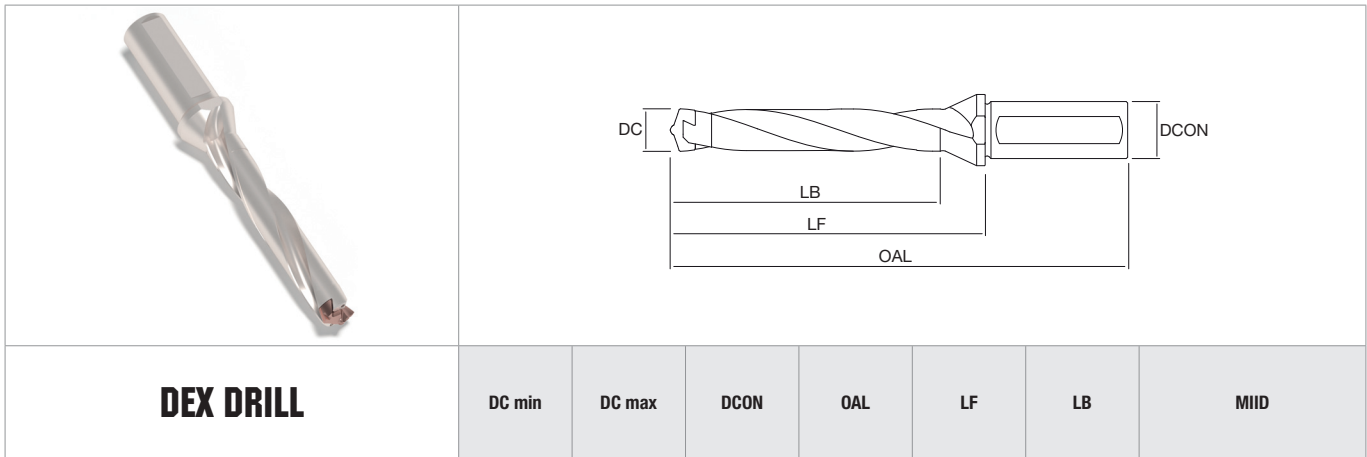
● stock standard

<h1>DEX</h1>	self-locking drilling head			ISO513	HC-PVD																	
					JP5625	JP7625																
	DC tol.	SIG				P	40 160															
	k6	140°				M																
						K	80 180	100 200														
						N																
						S																
						H																
GRADE APPLICATION AREA		Stable machining			+																	
■ main application		General machining			-																	
■ applicable		Unstable machining			+																	

GENERAL	GP P K 	DC 20.40	DEX2040-GP	PL 3.71 f _n	▶ 0.26	0.35	0.44	●																
		DC 20.50	DEX2050-GP	PL 3.73 f _n	▶ 0.26	0.35	0.44	●																
		DC 20.60	DEX2060-GP	PL 3.75 f _n	▶ 0.26	0.35	0.44	●																
		DC 20.70	DEX2070-GP	PL 3.77 f _n	▶ 0.26	0.35	0.44	●																
		DC 20.80	DEX2080-GP	PL 3.79 f _n	▶ 0.26	0.35	0.44	●																
		DC 20.90	DEX2090-GP	PL 3.80 f _n	▶ 0.26	0.35	0.44	●																
REINFORCED	TE K 	DC 12.00	DEX1200-TE	PL 2.18 f _n	▶ 0.24	0.28	0.34	●																
		DC 12.50	DEX1250-TE	PL 2.27 f _n	▶ 0.24	0.28	0.34	●																
		DC 13.00	DEX1300-TE	PL 2.37 f _n	▶ 0.26	0.30	0.36	●																
		DC 13.50	DEX1350-TE	PL 2.46 f _n	▶ 0.26	0.30	0.36	●																
		DC 14.00	DEX1400-TE	PL 2.55 f _n	▶ 0.28	0.32	0.38	●																
		DC 14.50	DEX1450-TE	PL 2.64 f _n	▶ 0.28	0.32	0.38	●																
		DC 15.00	DEX1500-TE	PL 2.73 f _n	▶ 0.30	0.34	0.40	●																
		DC 15.50	DEX1550-TE	PL 2.82 f _n	▶ 0.30	0.34	0.40	●																
		DC 16.00	DEX1600-TE	PL 2.91 f _n	▶ 0.32	0.36	0.42	●																
		DC 16.50	DEX1650-TE	PL 3.00 f _n	▶ 0.32	0.36	0.42	●																
		DC 17.00	DEX1700-TE	PL 3.09 f _n	▶ 0.34	0.38	0.44	●																
		DC 17.50	DEX1750-TE	PL 3.18 f _n	▶ 0.34	0.38	0.44	●																
		DC 18.00	DEX1800-TE	PL 3.28 f _n	▶ 0.36	0.40	0.46	●																
		DC 18.50	DEX1850-TE	PL 3.37 f _n	▶ 0.36	0.40	0.46	●																
		DC 19.00	DEX1900-TE	PL 3.46 f _n	▶ 0.38	0.42	0.48	●																
		DC 19.50	DEX1950-TE	PL 3.55 f _n	▶ 0.38	0.42	0.48	●																
		DC 20.00	DEX2000-TE	PL 3.64 f _n	▶ 0.40	0.44	0.50	●																
DC 20.50	DEX2050-TE	PL 3.73 f _n	▶ 0.40	0.44	0.50	●																		

high performance for cast iron
reinforced chamfer

● stock standard



		DC min	DC max	DCON	OAL	LF	LB	MIID		
3xD	NT-DEX-3D	D12-S16F	●	12.00	12.99	16	108	60	48	DEX1200 ÷ DEX1290
		D13-S16F	●	13.00	13.99	16	112	64	51	DEX1300 ÷ DEX1390
		D14-S16F	●	14.00	14.99	16	117	69	55	DEX1400 ÷ DEX1490
		D15-S20F	●	15.00	15.99	20	123	73	58	DEX1500 ÷ DEX1590
		D16-S20F	●	16.00	16.99	20	127	77	61	DEX1600 ÷ DEX1690
		D17-S20F	●	17.00	17.99	20	132	82	65	DEX1700 ÷ DEX1790
		D18-S25F	●	18.00	18.99	25	142	86	68	DEX1800 ÷ DEX1890
		D19-S25F	●	19.00	19.99	25	146	90	71	DEX1900 ÷ DEX1990
5xD	NT-DEX-5D	D20-S25F	●	20.00	20.99	25	150	94	74	DEX2000 ÷ DEX2090
		D12-S16F	●	12.00	12.99	16	134	86	74	DEX1200 ÷ DEX1290
		D13-S16F	●	13.00	13.99	16	140	92	79	DEX1300 ÷ DEX1390
		D14-S16F	●	14.00	14.99	16	147	99	85	DEX1400 ÷ DEX1490
		D15-S20F	●	15.00	15.99	20	155	105	90	DEX1500 ÷ DEX1590
		D16-S20F	●	16.00	16.99	20	161	111	95	DEX1600 ÷ DEX1690
		D17-S20F	●	17.00	17.99	20	168	118	101	DEX1700 ÷ DEX1790
		D18-S25F	●	18.00	18.99	25	180	124	106	DEX1800 ÷ DEX1890
D19-S25F	●	19.00	19.99	25	186	130	111	DEX1900 ÷ DEX1990		
D20-S25F	●	20.00	20.99	25	192	136	116	DEX2000 ÷ DEX2090		

● stock standard



DC ≤ 17	NT-WR1217
DC ≥ 18	NT-WR1820

CUTTING SPEED [m/min]

	MATERIALS (HARDNESS/Rm)	W.-Nr	DIN	AISI-ASTM	TRADE MARK	JP5625	JP7625
P1	Free cutting steel and structural steel (< 500 N/mm ²)	1.0715	9 SMn 28	1213	AVP	100÷160	
		1.0765	36 SMnPb 14	A29	PR80		
P2	Carbon steel and low alloy steel (500-700 N/mm ²)	1.7147	20 MnCr 5	5120	-	80÷140	
		1.0511	C 40	1040	-		
P3	Medium alloy steel and heat treated steel (600-800 N/mm ²)	1.1201	42 CrMo 4	4142, 4140	-	60÷100	
		1.6511	36 CrNiMo 4	9840	-		
P4	High alloy steel (800-1000 N/mm ²)	1.1663	C 125 W	W1	-	50÷90	
		1.3505	100 Cr 6	52100	-		
P5	Tool steel (900-1200 N/mm ²)	1.2080	X 210 Cr 12	D3	K100	40÷80	
		1.2379	X 155 CrVMo 12 1	-	K110		
K1	Grey cast iron (150-250 HB)	0.6020	GG-20	A48 30 B	-	80÷180	100÷200
		0.6025	GG-25	A48 35 B	-		
K2	Nodular cast iron (150-350 HB)	0.7050	GGG-50	A536 80-55-6	-	80÷140	100÷160
		0.7070	GGG-70	A536 100-70-03	-		

www.nikkotools.com



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

