

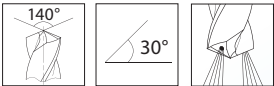
Now Improved with

EDGE CUT™ for Superior Cutter Performance



High-Performance
Double-Margin
Coolant Through Drill
Ideal for Steels & Cast Materials
3xD-12xD

CARBIDE 3xD to 12xD



Varianta® Supral Provides a low coefficient of friction, reducing tool wear and resulting in a longer tool life. ideal for materials below 45Rc.

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Design – Spiral-fluted, right-hand cut, with external coolant and a cylindrical shank.

Ideal for – Steels and cast materials

Available Upon Request – Firm Hold Shank, Additional PVD Coatings

P M K S Material Code

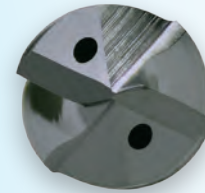


Coolant Holes - Cool the cutting edge and improve chip evacuation.

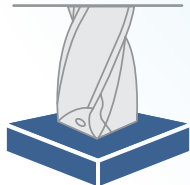
140° Point Geometry - Split-point geometry for superior drill penetration and accuracy.

Double-Margin Design - For improved drilling stability and smooth surface finish.

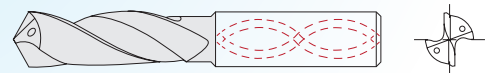
Polish - Chip evacuation is improved during deep-hole drilling, when the flutes are polished.



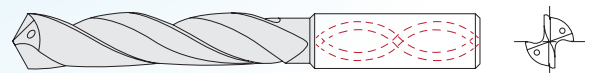
No Pecking Required



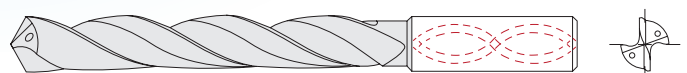
3xD

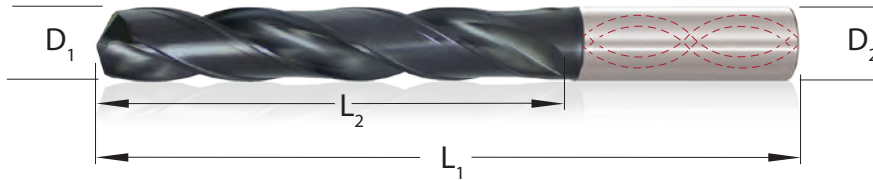


5xD



8xD





Part Number (insert 03, 05 or 08 in place of __)	D ₁	Decimal	D ₁ (mm)	D ₂ (mm)	3xD Dimensions (mm)		5xD Dimensions (mm)		8xD Dimensions (mm)	
					L ₂	L ₁	L ₂	L ₁	L ₂	L ₁
DXC__03000T9		.1181	3.000	6	20	62	28	66	34	72
DXC__03100T9		.1220	3.100	6	20	62	28	66	34	72
DXC__03175T9	1/8	.1250	3.175	6	20	62	28	66	34	72
DXC__03200T9		.1260	3.200	6	20	62	28	66	34	72
DXC__03300T9		.1299	3.300	6	20	62	28	66	34	72
DXC__03400T9		.1339	3.400	6	20	62	28	66	34	72
DXC__03500T9		.1378	3.500	6	20	62	28	66	34	72
DXC__03572T9	9/64	.1406	3.572	6	20	62	28	66	34	72
DXC__03600T9		.1417	3.600	6	20	62	28	66	34	72
DXC__03700T9		.1457	3.700	6	20	62	28	66	34	72
DXC__03800T9	#25	.1496	3.800	6	24	66	36	74	43	81
DXC__03900T9		.1535	3.900	6	24	66	36	74	43	81
DXC__03970T9	5/32	.1563	3.970	6	24	66	36	74	43	81
DXC__04000T9		.1575	4.000	6	24	66	36	74	43	81
DXC__04100T9		.1614	4.100	6	24	66	36	74	43	81
DXC__04200T9		.1654	4.200	6	24	66	36	74	43	81
DXC__04300T9		.1693	4.300	6	24	66	36	74	43	81
DXC__04370T9	11/64	.1719	4.370	6	24	66	36	74	43	81
DXC__04400T9		.1732	4.400	6	24	66	36	74	43	81
DXC__04500T9		.1772	4.500	6	24	66	36	74	43	81
DXC__04600T9		.1811	4.600	6	24	66	36	74	43	81
DXC__04650T9		.1831	4.650	6	24	66	36	74	43	81
DXC__00130T9	#13	.1850	4.700	6	24	66	36	74	43	81
DXC__04760T9	3/16	.1875	4.760	6	28	66	44	82	57	95
DXC__00120T9	#12	.1890	4.800	6	28	66	44	82	57	95
DXC__04900T9		.1929	4.900	6	28	66	44	82	57	95
DXC__05000T9		.1969	5.000	6	28	66	44	82	57	95
DXC__05100T9		.2008	5.100	6	28	66	44	82	57	95
DXC__05160T9	13/64	.2031	5.160	6	28	66	44	82	57	95
DXC__00060T9	#6	.2040	5.182	6	28	66	44	82	57	95
DXC__05200T9		.2047	5.200	6	28	66	44	82	57	95
DXC__05300T9		.2087	5.300	6	28	66	44	82	57	95
DXC__05400T9		.2126	5.400	6	28	66	44	82	57	95
DXC__05500T9		.2165	5.500	6	28	66	44	82	57	95
DXC__05550T9		.2185	5.550	6	28	66	44	82	57	95
DXC__05560T9	7/32	.2187	5.560	6	28	66	44	82	57	95

Other Dimensions are Available Upon Request

Continued on page 56

Tolerance

Drill Dia (h7) Inches (in)	Drill Dia (h7) Metric (mm)	Shank Dia (h6) Inches (in)	Shank Dia (h6) Metric (mm)
.0000-.1181: + 0/-0.00039	0-3: + 0/-0.010	.0000-.1181: + 0/-0.00024	0-3: + 0/-0.006
.1182-.2362: + 0/-0.00047	3.01-6: + 0/-0.012	.1182-.2362: + 0/-0.00031	3.01-6: + 0/-0.008
.2363-.3937: + 0/-0.00059	6.01-10.0: + 0/-0.015	.2363-.3937: + 0/-0.00035	6.01-10.0: + 0/-0.009
.3938-.7087: + 0/-0.00071	10.01-18.0: + 0/-0.018	.3938-.7087: + 0/-0.00043	10.01-18.0: + 0/-0.011

Part Number (insert 03, 05 or 08 in place of _)	D ₁	Decimal	D ₁ (mm)	D ₂ (mm)	3xD Dimensions (mm)		5xD Dimensions (mm)		8xD Dimensions (mm)	
					L ₂	L ₁	L ₂	L ₁	L ₂	L ₁
DXC__05600T9		.2205	5.600	6	28	66	44	82	57	95
DXC__05700T9		.2244	5.700	6	28	66	44	82	57	95
DXC__05800T9		.2283	5.800	6	28	66	44	82	57	95
DXC__05900T9		.2323	5.900	6	28	66	44	82	57	95
DXC__05950T9	15/64	.2344	5.950	6	28	66	44	82	57	95
DXC__06000T9		.2362	6.000	6	28	66	44	82	57	95
DXC__06100T9		.2402	6.100	8	34	79	53	91	76	114
DXC__06200T9		.2441	6.200	8	34	79	53	91	76	114
DXC__06300T9		.2480	6.300	8	34	79	53	91	76	114
DXC__06350T9	1/4	.2500	6.350	8	34	79	53	91	76	114
DXC__06400T9		.2520	6.400	8	34	79	53	91	76	114
DXC__06500T9		.2559	6.500	8	34	79	53	91	76	114
DXC__06600T9		.2598	6.600	8	34	79	53	91	76	114
DXC__06700T9		.2638	6.700	8	34	79	53	91	76	114
DXC__06750T9	17/64	.2656	6.750	8	34	79	53	91	76	114
DXC__06800T9		.2677	6.800	8	34	79	53	91	76	114
DXC__06900T9		.2717	6.900	8	41	79	53	91	76	114
DXC__07000T9		.2756	7.000	8	41	79	53	91	76	114
DXC__07100T9		.2795	7.100	8	41	79	53	91	76	114
DXC__07140T9	9/32	.2813	7.140	8	41	79	53	91	76	114
DXC__07200T9		.2835	7.200	8	41	79	53	91	76	114
DXC__07300T9		.2874	7.300	8	41	79	53	91	76	114
DXC__07400T9		.2913	7.400	8	41	79	53	91	76	114
DXC__07500T9		.2953	7.500	8	41	79	53	91	76	114
DXC__07540T9	19/64	.2969	7.540	8	41	79	53	91	76	114
DXC__07700T9		.3031	7.700	8	41	79	53	91	76	114
DXC__07800T9		.3071	7.800	8	41	79	53	91	76	114
DXC__07900T9		.3110	7.900	8	41	79	53	91	76	114
DXC__07940T9	5/16	.3125	7.940	8	41	79	53	91	76	114
DXC__08000T9		.3150	8.000	8	41	79	53	91	76	114
DXC__08100T9		.3189	8.100	10	47	89	61	103	95	142
DXC__08200T9		.3228	8.200	10	47	89	61	103	95	142
DXC__08300T9		.3268	8.300	10	47	89	61	103	95	142
DXC__08330T9	21/64	.3281	8.330	10	47	89	61	103	95	142
DXC__08400T9		.3307	8.400	10	47	89	61	103	95	142
DXC__08500T9		.3346	8.500	10	47	89	61	103	95	142
DXC__08600T9		.3386	8.600	10	47	89	61	103	95	142
DXC__08700T9		.3425	8.700	10	47	89	61	103	95	142
DXC__08730T9	11/32	.3437	8.730	10	47	89	61	103	95	142
DXC__08800T9		.3465	8.800	10	47	89	61	103	95	142
DXC__09000T9		.3543	9.000	10	47	89	61	103	95	142
DXC__09130T9	23/64	.3594	9.130	10	47	89	61	103	95	142
DXC__09200T9		.3622	9.200	10	47	89	61	103	95	142
DXC__09300T9		.3661	9.300	10	47	89	61	103	95	142
DXC__09500T9		.3740	9.500	10	47	89	61	103	95	142
DXC__09520T9	3/8	.3750	9.520	10	47	89	61	103	95	142
DXC__09600T9		.3780	9.600	10	47	89	61	103	95	142
DXC__09800T9		.3858	9.800	10	47	89	61	103	95	142
DXC__09900T9		.3898	9.900	10	47	89	61	103	95	142
DXC__09920T9	25/64	.3906	9.920	10	47	89	61	103	95	142
DXC__10000T9		.3937	10.000	10	47	89	61	103	95	142
DXC__10100T9		.3976	10.100	12	55	102	71	118	114	162
DXC__10200T9		.4016	10.200	12	55	102	71	118	114	162
DXC__10300T9		.4055	10.300	12	55	102	71	118	114	162
DXC__10320T9	13/32	.4063	10.320	12	55	102	71	118	114	162
DXC__10400T9		.4094	10.400	12	55	102	71	118	114	162
DXC__10500T9		.4134	10.500	12	55	102	71	118	114	162
DXC__10720T9	27/64	.4219	10.720	12	55	102	71	118	114	162
DXC__10800T9		.4252	10.800	12	55	102	71	118	114	162
DXC__11000T9		.4331	11.000	12	55	102	71	118	114	162
DXC__11100T9		.4370	11.100	12	55	102	71	118	114	162
DXC__11113T9	7/16	.4375	11.113	12	55	102	71	118	114	162
DXC__11200T9		.4409	11.200	12	55	102	71	118	114	162

Part Number (insert 03, 05 or 08 in place of _)	D ₁	Decimal	D ₁ (mm)	D ₂ (mm)	3xD Dimensions (mm)		5xD Dimensions (mm)		8xD Dimensions (mm)	
					L ₂	L ₁	L ₂	L ₁	L ₂	L ₁
DXC__11500T9		.4528	11.500	12	55	102	71	118	114	162
DXC__11510T9	29/64	.4531	11.510	12	55	102	71	118	114	162
DXC__11700T9		.4606	11.700	12	55	102	71	118	114	162
DXC__11800T9		.4646	11.800	12	55	102	71	118	114	162
DXC__11910T9	15/32	.4687	11.910	12	55	102	71	118	114	162
DXC__12000T9		.4724	12.000	12	55	102	71	118	114	162
DXC__12100T9		.4764	12.100	14	60	107	77	124	131	178
DXC__12200T9		.4803	12.200	14	60	107	77	124	131	178
DXC__12300T9		.4843	12.300	14	60	107	77	124	131	178
DXC__12303T9	31/64	.4844	12.303	14	60	107	77	124	131	178
DXC__12500T9		.4921	12.500	14	60	107	77	124	131	178
DXC__12600T9		.4961	12.600	14	60	107	77	124	131	178
DXC__12700T9	1/2	.5000	12.700	14	60	107	77	124	131	178
DXC__13000T9		.5118	13.000	14	60	107	77	124	131	178
DXC__13300T9		.5236	13.300	14	60	107	77	124	131	178
DXC__13490T9	17/32	.5313	13.490	14	60	107	77	124	131	178
DXC__13500T9		.5315	13.500	14	60	107	77	124	131	178
DXC__14000T9		.5512	14.000	14	60	107	77	124	131	178
DXC__14290T9	9/16	.5625	14.290	16	65	115	83	133	152	203
DXC__14500T9		.5709	14.500	16	65	115	83	133	152	203
DXC__15000T9		.5906	15.000	16	65	115	83	133	152	203
DXC__15500T9		.6102	15.500	16	65	115	83	133	152	203
DXC__15870T9	5/8	.6250	15.870	16	65	115	83	133	152	203
DXC__16000T9		.6299	16.000	16	65	115	83	133	152	203
DXC__16500T9		.6496	16.500	18	73	123	93	143	171	222
DXC__17000T9		.6693	17.000	18	73	123	93	143	171	222
DXC__17500T9		.6890	17.500	18	73	123	93	143	171	222
DXC__18000T9		.7087	18.000	18	73	123	93	143	171	222
DXC__18500T9		.7283	18.500	20	79	131	101	153	190	243
DXC__19050T9	3/4	.7500	19.050	20	79	131	101	153	190	243
DXC__19500T9		.7677	19.500	20	79	131	101	153	190	243
DXC__20000T9		.7874	20.000	20	79	131	101	153	190	243

Other Dimensions are Available Upon Request

CARBIDE DRILLS
DRILLS

DXC

**3xD Speeds and Feeds
INCHES**

Material	SFM (Vc) Surface Feet Per Minute	D1mm	IPR = Inches Per Revolution					
			Dec. Inch.	> 3.00 ≤ 5.00	> 5.00 ≤ 8.00	> 8.00 ≤ 12.00	> 12.00 ≤ 16.00	> 16.00 ≤ 20.00
				.1181- .1969	.1970- .3150	.3151- .4724	.4725- .6299	.6300- .7874
P 1 Low-Carbon Steel - 1000 Series (>25 HRc)	328.1		.006	.008	.011	.013	.015	
P 3 Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)	246.1		.003	.004	.005	.008	.009	
M 2 Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)	229.7		.003	.004	.005	.008	.009	
K 1 Gray Cast Iron	600		.004	.006	.008	.011	.014	
S 4 Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)	98.4		.001	.003	.004	.006	.007	

Note: These are only recommended starting figures that depend on conditions such as machine and material rigidity, type of coating if any, etc. **TESTING IS RECOMMENDED**

DXC

**5xD Speeds and Feeds
INCHES**

Material	SFM (Vc) Surface Feet Per Minute	D1mm	IPR = Inches Per Revolution					
			Dec. Inch.	> 3.00 ≤ 5.00	> 5.00 ≤ 8.00	> 8.00 ≤ 12.00	> 12.00 ≤ 16.00	> 16.00 ≤ 20.00
				.1181- .1969	.1970- .3150	.3151- .4724	.4725- .6299	.6300- .7874
P 1 Low-Carbon Steel - 1000 Series (>25 HRc)	328.1		.006	.008	.011	.013	.015	
P 3 Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)	246.1		.003	.004	.005	.008	.009	
M 2 Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)	229.7		.003	.004	.005	.008	.009	
K 1 Gray Cast Iron	600		.004	.006	.008	.011	.014	
S 4 Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)	98.4		.001	.003	.004	.006	.007	

Note: These are only recommended starting figures that depend on conditions such as machine and material rigidity, type of coating if any, etc. **TESTING IS RECOMMENDED**

DXC

**8xD Speeds and Feeds
INCHES**

Material	SFM (Vc) Surface Feet Per Minute	D1mm	IPR = Inches Per Revolution					
			Dec. Inch.	> 3.00 ≤ 5.00	> 5.00 ≤ 8.00	> 8.00 ≤ 12.00	> 12.00 ≤ 16.00	> 16.00 ≤ 20.00
				.1181- .1969	.1970- .3150	.3151- .4724	.4725- .6299	.6300- .7874
P 1 Low-Carbon Steel - 1000 Series (>25 HRc)	311.7		.003	.005	.007	.010	.012	
P 3 Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)	295.3		.003	.005	.007	.010	.012	
M 2 Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)	213.3		.003	.004	.005	.007	.009	
S 4 Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)	82.0		.001	.003	.004	.006	.007	
K 1 Gray Cast Iron	600		.007	.009	.013	.015	.018	

Note: These are only recommended starting figures that depend on conditions such as machine and material rigidity, type of coating if any, etc. **TESTING IS RECOMMENDED**