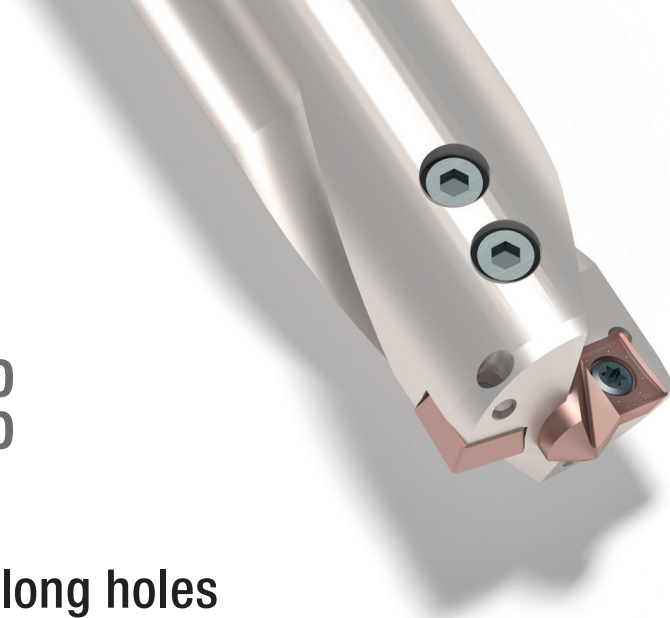
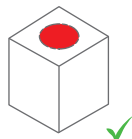
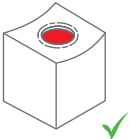
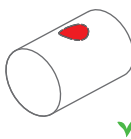
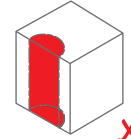
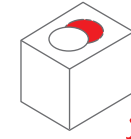
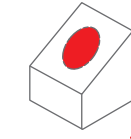
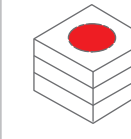


DRSPILOT^{6XD}_{9XD}

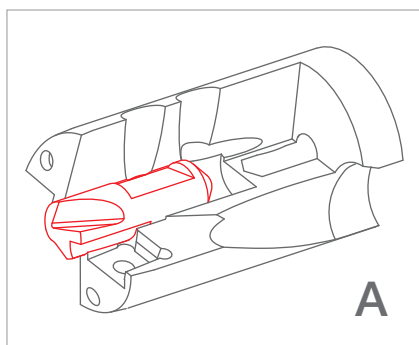
Perfect centering even on extra long holes



1. Where is DRSpilot applicable?

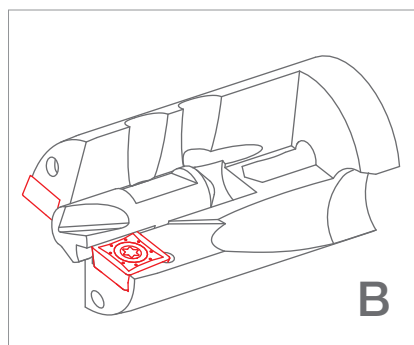
PLAIN SURFACE	CONCAVE SURFACE	PIPES	HALF HOLE	HOLE EXPANSION	SLANT SURFACE	STACKED PLATES
						

2. Installation of inserts and pilot drill



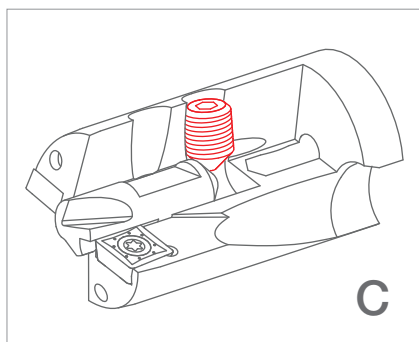
A

Insert DRSP pilot in the drilling body.



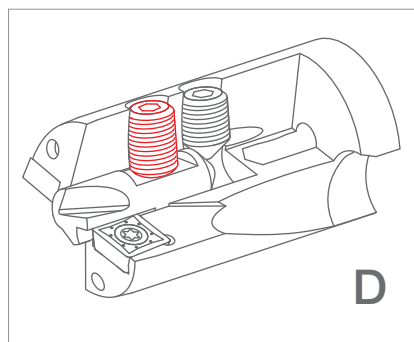
B

Install the SPMX/SPGX inserts.



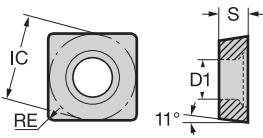
C

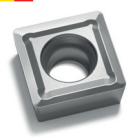
Adjust the DRSP pilot height using the setting grain as shown in the drawing, following the table at pag. 11.



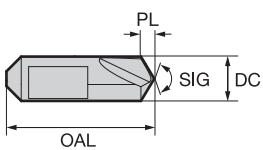
D

Screw tight the locking grain.

SP□X		DRS PILOT 4 edges drilling inserts					ISO513	HC-PVD				HW													
								JP5625	JP5530	JP9635	JU6520														
 4 edges		Size	IC	S	D1	RE	P	60 220	60 220																
		05	5.00	2.38	2.50	0.40	M			40 160															
		06	6.00	2.38	2.80	0.40	K	100 190	100 190																
		07	7.94	3.97	2.80	0.80	N				150 300														
							S																		
GRADE APPLICATION AREA		Stable machining				+ Hardness - Toughness																			
main application		General machining																							
applicable		Unstable machining																							

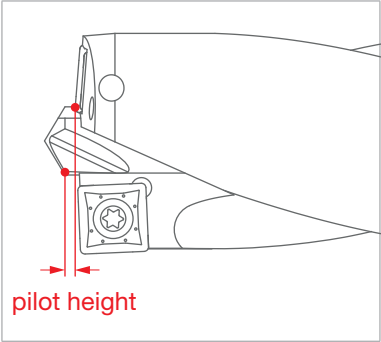
GENERAL	GP P M K		SPMX 050204-GP	6xD 9xD	f _n ▶ f _n ▶	0.08 0.06	0.10 0.08	0.12 0.10	●	●	●													
			SPMX 060204-GP	6xD 9xD	f _n ▶ f _n ▶	0.08 0.06	0.10 0.08	0.12 0.10	●	●	●													
			SPMX 07T308-GP	6xD 9xD	f _n ▶ f _n ▶	0.09 0.07	0.11 0.09	0.13 0.11	●	●	●													
ALUMINIUM	AL N	 polished surface	SPGX 050204-AL	6xD 9xD	f _n ▶ f _n ▶	0.05 0.04	0.07 0.06	0.09 0.08				●												
			SPGX 060204-AL	6xD 9xD	f _n ▶ f _n ▶	0.05 0.04	0.07 0.06	0.09 0.08				●												
			SPGX 07T308-AL	6xD 9xD	f _n ▶ f _n ▶	0.06 0.05	0.08 0.07	0.10 0.09				●												

● stock standard

DRSP		DRS PILOT interchangeable centering drill				
		Size	DC	OAL	PL	SIG
		06	6	20	1.5	118°
		08	8	25	2.1	118°
GENERAL		DRSP 06-GP HSS TIN				●
		DRSP 08-GP HSS TIN				●

● stock standard

HEIGHT ADJUSTEMENT



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

MATERIALS

P

M

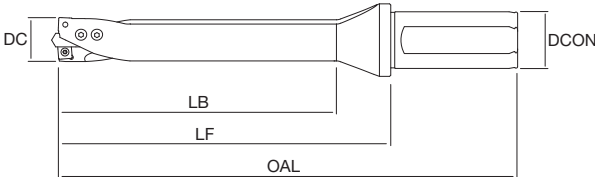
K

N

S

H

▶ p. 14-15

								
DRS PILOT 6XD	DC	DCON	OAL	LF	LB		MIID (insert)	MIID (pilot)

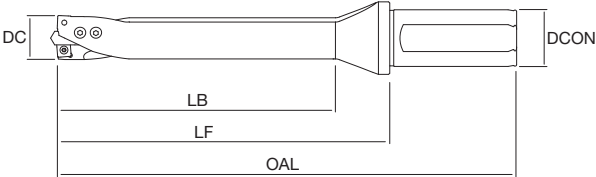
05	NT-DRS-6D	D18.00-S25-05P6	●	18	25	191	135	112	SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	197	141	118		
06	NT-DRS-6D	D20.00-S25-06P6	●	20	25	203	147	124	SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	209	153	130		
		D22.00-S25-06P6	●	22	25	215	159	136		
		D23.00-S32-06P6	●	23	32	228	168	142		
		D24.00-S32-06P6	●	24	32	234	174	148		
		D25.00-S32-06P6	●	25	32	240	180	154		
07	NT-DRS-6D	D26.00-S32-07P8	●	26	32	246	186	160	SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	252	192	166		
		D28.00-S32-07P8	●	28	32	258	198	172		
		D29.00-S32-07P8	●	29	32	264	204	178		
		D30.00-S32-07P8	●	30	32	270	210	184		

● stock standard

Spare Parts	INSERT SCREW	INSERT WRENCH
		
NT-DRS-6D D####-S##-05P6	NT-ST059	NT-FTB06
NT-DRS-6D D####-S##-06P6	NT-ST061	NT-FTB06
NT-DRS-6D D####-S##-07P8	NT-ST062	NT-FTB07

Spare Parts	LOCKING GRAIN	SETTING GRAIN	GRAIN WRENCH
			
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030





DRS PILOT 9XD				DC	DCON	OAL	LF	LB		MIID (insert)	MIID (pilot)
---------------	--	--	--	----	------	-----	----	----	--	---------------	--------------

05	NT-DRS-9D	D18.00-S25-05P6	●	18	25	245	189	166		SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	254	198	175			
06	NT-DRS-9D	D20.00-S25-06P6	●	20	25	263	207	184		SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	272	216	193			
		D22.00-S25-06P6	●	22	25	281	225	202			
		D23.00-S32-06P6	●	23	32	297	237	211			
		D24.00-S32-06P6	●	24	32	306	246	220			
		D25.00-S32-06P6	●	25	32	315	255	229			
07	NT-DRS-9D	D26.00-S32-07P8	●	26	32	324	264	238		SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	333	273	247			
		D28.00-S32-07P8	●	28	32	342	282	256			
		D29.00-S32-07P8	●	29	32	351	291	265			
		D30.00-S32-07P8	●	30	32	360	300	274			

● stock standard

Spare Parts

INSERT SCREW



INSERT WRENCH



NT-DRS-9D D0000-S00-05P6	NT-ST059	NT-FTB06
NT-DRS-9D D0000-S00-06P6	NT-ST061	NT-FTB06
NT-DRS-9D D0000-S00-07P8	NT-ST062	NT-FTB07

Spare Parts

LOCKING GRAIN



SETTING GRAIN



GRAIN WRENCH



DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030

CUTTING SPEED [m/min]

	MATERIALS	HARDNESS/Rm	W.-Nr	DIN	AIISI-ASTM	TRADE MARK
P1	Free cutting steel and structural steel	< 500 N/mm ²	1.0715 1.0765	9 SMn 28 36 SMnPb 14	1213 A29	AVP PR80
P2	Carbon steel and low alloy steel	500-700 N/mm ²	1.7147 1.0511	20 MnCr 5 C 40	5120 1040	- -
P3	Medium alloy steel and heat treated steel	600-800 N/mm ²	1.1201 1.6511	42 CrMo 4 36 CrNiMo 4	4142, 4140 9840	- -
P4	High alloy steel	800-1000 N/mm ²	1.1663 1.3505	C 125 W 100 Cr 6	W1 52100	- -
P5	Tool steel	900-1200 N/mm ²	1.2080 1.2379	X 210 Cr 12 X 155 CrVMo 12 1	D3 -	K100 K110
M1	Ferritic stainless steel	400-700 N/mm ²	1.4016 1.4104	X 6 Cr 17 X 12 CrMoS 17	430 430 F	- -
M2	Austenitic stainless steel (good machinability)	500-750 N/mm ²	1.4305 1.4301	X 10 CrNiS 18 9 X 6 CrNi 18 10	303 304, 304 H	- -
M3	Austenitic stainless steel (medium machinability)	550-850 N/mm ²	1.4401 1.4462	X 5 CrNiMo 17 12 2 X 2 CrNiMoN 22 5	316 F 51-329 A	- DUPLEX
M4	Martensitic stainless steel	650-950 N/mm ²	1.4021 1.4410	X 20 Cr 13 X 2 CrNiMoN 25 7 4	420 F 53-329 S1	- SUPER DUPLEX
M5	PH stainless steel	800-1250 N/mm ²	1.4540 1.4542	X 4 CrNiCuNb 16 4 X 5 CrNiNb 16 4	XM-12 631	15-5-PH 17-4-PH
K1	Grey cast iron	150-250 HB	0.6020 0.6025	GG-20 GG-25	A48 30 B A48 35 B	- -
K2	Nodular cast iron	150-350 HB	0.7050 0.7070	GGG-50 GGG-70	A536 80-55-6 A536 100-70-03	- -
N1	Aluminium alloys ≤ 12% Si		3.3547 3.2315	AlMg4.5Mn AlMgSi 1	5083 6082	Peraluman 440 Anticorodal 100
N2	Aluminium alloys > 12% Si		3.2582	GD-AlSi12 G-AlSi6Cu4	A413.0 319	
N3	Copper		2.0940-01 2.1176	CuAl10Fe CuPb10Sn	CA952 CA937	
N4	Bronze and brass		2.0401	Cu Zn39Pb3		OT58 AMPCO 18

DRSDRILL

DRSPILOT

JP5625	JP5530	JP9635	JU6520	JP5625	JP5530	JP9635	JU6520	MATERIALS	HARDNESS/Rm	
180÷300	180÷300			130÷220	130÷220			Free cutting steel and structural steel	< 500 N/mm ²	P1
140÷240	140÷240			100÷180	100÷180			Carbon steel and low alloy steel	500-700 N/mm ²	P2
100÷220	100÷220			80÷170	80÷170			Medium alloy steel and heat treated steel	600-800 N/mm ²	P3
100÷180	100÷180			80÷140	80÷140			High alloy steel	800-1000 N/mm ²	P4
80÷150	80÷150			60÷120	60÷120			Tool steel	900-1200 N/mm ²	P5
		120÷220				90÷160		Ferritic stainless steel	400-700 N/mm ²	M1
		80÷180				60÷130		Austenitic stainless steel (good machinability)	500-750 N/mm ²	M2
		60÷150				50÷110		Austenitic stainless steel (medium machinability)	550-850 N/mm ²	M3
		60÷150				50÷110		Martensitic stainless steel	650-950 N/mm ²	M4
		50÷120				40÷100		PH stainless steel	800-1250 N/mm ²	M5
180÷250	180÷250			130÷190	130÷190			Grey cast iron	150-250 HB	K1
120÷180	120÷180			100÷140	100÷140			Nodular cast iron	150-350 HB	K2
			250÷400				200÷300	Aluminium alloys ≤ 12% Si		N1
			150÷300				120÷240	Aluminium alloys > 12% Si		N2
			200÷300				150÷240	Copper		N3
			200÷300				150÷240	Bronze and brass		N4

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