

# BUY 3 DRILLS GET 1 FREE!!

## DSXU

- Coated solid carbide drills with spiral oil holes
- For high speed and efficient deephole drilling of steels, stainless steels and high temp alloys

Effective August 1st, 2014  
Ends October 31st, 2014



Ds - Drilling dia. shank  
ℓ - Flute length  
ℓs - Shank length  
L - Overall

### ■ DSXU 3XD

| Drill dia.<br>øDc | Cat. No.    | Dimensions (in) |      |      |      |
|-------------------|-------------|-----------------|------|------|------|
|                   |             | øDs             | ℓ    | ℓs   | L    |
| 1/8               | DSXU1250F03 | .156            | .709 | 1.89 | 2.80 |
| 9/64              | DSXU1406F03 | .156            | .787 | 1.89 | 2.87 |
| 5/32              | DSXU1562F03 | .156            | .787 | 1.89 | 2.87 |
| 11/64             | DSXU1719F03 | .188            | .906 | 1.97 | 3.07 |
| 3/16              | DSXU1875F03 | .188            | .984 | 1.97 | 3.15 |
| 13/64             | DSXU2031F03 | .203            | 1.10 | 2.05 | 3.23 |
| 7/32              | DSXU2188F03 | .219            | 1.18 | 2.05 | 3.23 |
| #A15/64           | DSXU2344F03 | .234            | 1.18 | 2.05 | 3.23 |
| #E1/4             | DSXU2500F03 | .250            | 1.30 | 2.09 | 3.39 |
| 17/64             | DSXU2656F03 | .266            | 1.38 | 2.09 | 3.46 |
| 9/32              | DSXU2813F03 | .281            | 1.50 | 2.13 | 3.62 |
| 19/64             | DSXU2969F03 | .297            | 1.57 | 2.13 | 3.70 |
| 5/16              | DSXU3125F03 | .313            | 1.57 | 2.13 | 3.70 |
| 21/64             | DSXU3281F03 | .328            | 1.69 | 2.17 | 3.94 |
| 11/32             | DSXU3438F03 | .344            | 1.77 | 2.17 | 3.94 |
| 23/64             | DSXU3594F03 | .359            | 1.89 | 2.20 | 4.17 |
| 3/8               | DSXU3750F03 | .375            | 1.97 | 2.20 | 4.17 |
| 25/64             | DSXU3906F03 | .391            | 1.97 | 2.20 | 4.17 |
| 13/32             | DSXU4063F03 | .406            | 2.09 | 2.40 | 4.57 |
| 27/64             | DSXU4219F03 | .422            | 2.17 | 2.40 | 4.57 |
| 7/16              | DSXU4375F03 | .438            | 2.28 | 2.44 | 4.80 |
| 29/64             | DSXU4531F03 | .453            | 2.36 | 2.44 | 4.80 |
| 15/32             | DSXU4688F03 | .469            | 2.36 | 2.44 | 4.80 |
| 31/64             | DSXU4844F03 | .484            | 2.56 | 2.48 | 5.04 |
| 1/2               | DSXU5000F03 | .500            | 2.56 | 2.48 | 5.04 |

### ■ DSXU 5XD

| Drill dia.<br>øDc | Cat. No.    | Dimensions (in) |      |      |      |
|-------------------|-------------|-----------------|------|------|------|
|                   |             | øDs             | ℓ    | ℓs   | L    |
| 1/8               | DSXU1250F05 | .156            | 1.10 | 1.89 | 3.19 |
| 9/64              | DSXU1406F05 | .156            | 1.26 | 1.89 | 3.35 |
| 5/32              | DSXU1562F05 | .156            | 1.26 | 1.89 | 3.35 |
| 11/64             | DSXU1719F05 | .188            | 1.42 | 1.97 | 3.58 |
| 3/16              | DSXU1875F05 | .188            | 1.57 | 1.97 | 3.70 |
| 13/64             | DSXU2031F05 | .203            | 1.73 | 2.05 | 3.78 |
| 7/32              | DSXU2188F05 | .219            | 1.89 | 2.05 | 3.94 |
| #A15/64           | DSXU2344F05 | .234            | 1.89 | 2.05 | 3.94 |
| #E1/4             | DSXU2500F05 | .250            | 2.05 | 2.09 | 4.13 |
| 17/64             | DSXU2656F05 | .266            | 2.20 | 2.09 | 4.29 |
| 9/32              | DSXU2813F05 | .281            | 2.36 | 2.13 | 4.49 |
| 19/64             | DSXU2969F05 | .297            | 2.52 | 2.13 | 4.65 |
| 5/16              | DSXU3125F05 | .313            | 2.52 | 2.13 | 4.65 |
| 21/64             | DSXU3281F05 | .328            | 2.68 | 2.17 | 5.00 |
| 11/32             | DSXU3438F05 | .344            | 2.83 | 2.17 | 5.00 |
| 23/64             | DSXU3594F05 | .359            | 2.99 | 2.20 | 5.35 |
| 3/8               | DSXU3750F05 | .375            | 3.15 | 2.20 | 5.35 |
| 25/64             | DSXU3906F05 | .391            | 3.15 | 2.20 | 5.35 |
| 13/32             | DSXU4063F05 | .406            | 3.31 | 2.40 | 5.87 |
| 27/64             | DSXU4219F05 | .422            | 3.46 | 2.40 | 5.87 |
| 7/16              | DSXU4375F05 | .438            | 3.62 | 2.44 | 6.22 |
| 29/64             | DSXU4531F05 | .453            | 3.78 | 2.44 | 6.22 |
| 15/32             | DSXU4688F05 | .469            | 3.78 | 2.44 | 6.22 |
| 31/64             | DSXU4844F05 | .484            | 4.09 | 2.48 | 6.57 |
| 1/2               | DSXU5000F05 | .500            | 4.09 | 2.48 | 6.57 |

Promo Code: GUS17



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3726 N. Ventura Dr., Arlington Heights, IL 60004  
888-554-8394

# DMXU - VS

- Coated solid carbide drill
- For high efficiency drilling of steels, stainless steels and high temp alloys.

**Ds** - Drilling dia. shank  
**ℓ** - Flute length  
**ℓs** - Shank length  
**L** - Overall

## DMXU 2XD

| Drill dia.<br>øD <sub>c</sub> | Cat. No.   | Dimensions (in) |      |      |      |
|-------------------------------|------------|-----------------|------|------|------|
|                               |            | øDs             | ℓ    | ℓs   | L    |
| #34                           | DMXU1110VS | .111            | .630 | 1.18 | 1.81 |
| #33                           | DMXU1130VS | .113            | .630 | 1.18 | 1.81 |
| #32                           | DMXU1160VS | .116            | .630 | 1.18 | 1.81 |
| #31                           | DMXU1200VS | .120            | .708 | 1.22 | 1.93 |
| 1/8                           | DMXU1250VS | .125            | .708 | 1.22 | 1.93 |
| #30                           | DMXU1285VS | .129            | .708 | 1.22 | 1.93 |
| #29                           | DMXU1360VS | .136            | .787 | 1.26 | 2.05 |
| #28                           | DMXU1405VS | .141            | .787 | 1.26 | 2.05 |
| 9/64                          | DMXU1406VS | .141            | .787 | 1.26 | 2.05 |
| #27                           | DMXU1440VS | .144            | .787 | 1.26 | 2.05 |
| #26                           | DMXU1470VS | .147            | .886 | 1.30 | 2.17 |
| #25                           | DMXU1495VS | .150            | .886 | 1.30 | 2.17 |
| #24                           | DMXU1520VS | .152            | .886 | 1.30 | 2.17 |
| #23                           | DMXU1540VS | .154            | .886 | 1.30 | 2.17 |
| 5/32                          | DMXU1562VS | .156            | .886 | 1.30 | 2.17 |
| #22                           | DMXU1570VS | .157            | .886 | 1.30 | 2.17 |
| #21                           | DMXU1590VS | .159            | .886 | 1.30 | 2.17 |
| #20                           | DMXU1610VS | .161            | .886 | 1.30 | 2.17 |
| #19                           | DMXU1660VS | .166            | .945 | 1.34 | 2.28 |
| #18                           | DMXU1695VS | .170            | .945 | 1.34 | 2.28 |
| 11/64                         | DMXU1719VS | .172            | .945 | 1.34 | 2.28 |
| #17                           | DMXU1730VS | .173            | .945 | 1.34 | 2.28 |
| #16                           | DMXU1770VS | .177            | .945 | 1.34 | 2.28 |
| #15                           | DMXU1800VS | .180            | .945 | 1.34 | 2.28 |
| #14                           | DMXU1820VS | .182            | .945 | 1.34 | 2.28 |
| #13                           | DMXU1850VS | .185            | .945 | 1.34 | 2.28 |
| 3/16                          | DMXU1875VS | .188            | 1.02 | 1.42 | 2.44 |
| #12                           | DMXU1890VS | .189            | 1.02 | 1.42 | 2.44 |
| #11                           | DMXU1910VS | .191            | 1.02 | 1.42 | 2.44 |
| #10                           | DMXU1935VS | .194            | 1.02 | 1.42 | 2.44 |
| #9                            | DMXU1960VS | .196            | 1.02 | 1.42 | 2.44 |
| #8                            | DMXU1990VS | .199            | 1.02 | 1.42 | 2.44 |
| #7                            | DMXU2010VS | .201            | 1.02 | 1.42 | 2.44 |
| 13/64                         | DMXU2031VS | .203            | 1.02 | 1.42 | 2.44 |
| #6                            | DMXU2040VS | .204            | 1.02 | 1.42 | 2.44 |
| #5                            | DMXU2055VS | .206            | 1.02 | 1.42 | 2.44 |
| #4                            | DMXU2090VS | .209            | 1.10 | 1.50 | 2.60 |
| #3                            | DMXU2130VS | .213            | 1.10 | 1.50 | 2.60 |
| 7/32                          | DMXU2188VS | .219            | 1.10 | 1.50 | 2.60 |
| #2                            | DMXU2210VS | .221            | 1.10 | 1.50 | 2.60 |
| #1                            | DMXU2280VS | .228            | 1.10 | 1.50 | 2.60 |
| #A 15/64                      | DMXU2344VS | .234            | 1.10 | 1.50 | 2.60 |

External coolant supply

**30°**  
Helix  
**2X**  
L/D  
**130°**  
Point angle



| Drill dia.<br>øD <sub>c</sub> | Cat. No.   | Dimensions (in) |      |      |      |
|-------------------------------|------------|-----------------|------|------|------|
|                               |            | øDs             | ℓ    | ℓs   | L    |
| #B                            | DMXU2380VS | .238            | 1.22 | 1.54 | 2.76 |
| #C                            | DMXU2420VS | .242            | 1.22 | 1.54 | 2.76 |
| #D                            | DMXU2460VS | .246            | 1.22 | 1.54 | 2.76 |
| #E 1/4                        | DMXU2500VS | .250            | 1.22 | 1.54 | 2.76 |
| #F                            | DMXU2570VS | .257            | 1.22 | 1.54 | 2.76 |
| #G                            | DMXU2610VS | .261            | 1.22 | 1.54 | 2.76 |
| 17/64                         | DMXU2656VS | .266            | 1.34 | 1.57 | 2.91 |
| #H                            | DMXU2660VS | .266            | 1.34 | 1.57 | 2.91 |
| #I                            | DMXU2720VS | .272            | 1.34 | 1.57 | 2.91 |
| #J                            | DMXU2770VS | .277            | 1.34 | 1.57 | 2.91 |
| #K                            | DMXU2810VS | .281            | 1.34 | 1.57 | 2.91 |
| 9/32                          | DMXU2812VS | .281            | 1.34 | 1.57 | 2.91 |
| #L                            | DMXU2900VS | .290            | 1.34 | 1.57 | 2.91 |
| #M                            | DMXU2950VS | .295            | 1.34 | 1.57 | 2.91 |
| 19/64                         | DMXU2969VS | .297            | 1.46 | 1.65 | 3.11 |
| #N                            | DMXU3020VS | .302            | 1.46 | 1.65 | 3.11 |
| 5/16                          | DMXU3125VS | .313            | 1.46 | 1.65 | 3.11 |
| #O                            | DMXU3160VS | .316            | 1.46 | 1.65 | 3.11 |
| #P                            | DMXU3230VS | .323            | 1.46 | 1.65 | 3.11 |
| 21/64                         | DMXU3281VS | .328            | 1.46 | 1.65 | 3.11 |
| #Q                            | DMXU3320VS | .332            | 1.46 | 1.65 | 3.11 |
| #R                            | DMXU3390VS | .339            | 1.57 | 1.73 | 3.31 |
| 11/32                         | DMXU3438VS | .344            | 1.57 | 1.73 | 3.31 |
| #S                            | DMXU3480VS | .348            | 1.57 | 1.73 | 3.31 |
| #T                            | DMXU3580VS | .358            | 1.57 | 1.73 | 3.31 |
| 23/64                         | DMXU3594VS | .359            | 1.57 | 1.73 | 3.31 |
| #U                            | DMXU3680VS | .368            | 1.57 | 1.73 | 3.31 |
| 3/8                           | DMXU3750VS | .375            | 1.69 | 1.81 | 3.50 |
| #V                            | DMXU3770VS | .377            | 1.69 | 1.81 | 3.50 |
| #W                            | DMXU3860VS | .386            | 1.69 | 1.81 | 3.50 |
| 25/64                         | DMXU3906VS | .391            | 1.69 | 1.81 | 3.50 |
| #X                            | DMXU3970VS | .397            | 1.69 | 1.81 | 3.50 |
| #Y                            | DMXU4040VS | .404            | 1.69 | 1.81 | 3.50 |
| 13/32                         | DMXU4062VS | .406            | 1.69 | 1.81 | 3.50 |
| #Z                            | DMXU4130VS | .413            | 1.69 | 1.81 | 3.50 |
| 27/64                         | DMXU4219VS | .422            | 1.85 | 1.89 | 3.74 |
| 7/16                          | DMXU4375VS | .438            | 1.85 | 1.89 | 3.74 |
| 29/64                         | DMXU4531VS | .453            | 1.85 | 1.89 | 3.74 |
| 15/32                         | DMXU4688VS | .469            | 2.01 | 2.01 | 4.02 |
| 31/64                         | DMXU4844VS | .484            | 2.01 | 2.01 | 4.02 |
| 1/2                           | DMXU5000VS | .500            | 2.01 | 2.01 | 4.02 |

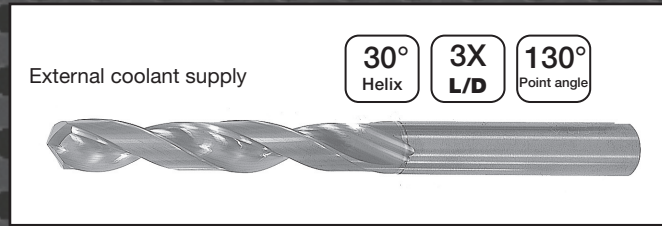
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# DMXU - VM

- Coated solid carbide drill
- For high efficiency drilling of steels, stainless steels and high temp alloys.

Ds - Drilling dia. shank  
 ℓ - Flute length  
 ℓs - Shank length  
 L - Overall



## DMXU 3XD

| Drill dia.<br>øDc | Cat. No.   | Dimensions (in) |      |      |      |
|-------------------|------------|-----------------|------|------|------|
|                   |            | øDs             | ℓ    | ℓs   | L    |
| #8                | DMXU1990VM | .199            | 1.34 | 1.50 | 2.83 |
| #7                | DMXU2010VM | .201            | 1.34 | 1.50 | 2.83 |
| 13/64             | DMXU2031VM | .203            | 1.34 | 1.50 | 2.83 |
| #6                | DMXU2040VM | .204            | 1.34 | 1.50 | 2.83 |
| #5                | DMXU2055VM | .206            | 1.34 | 1.50 | 2.83 |
| #4                | DMXU2090VM | .209            | 1.34 | 1.50 | 2.83 |
| #3                | DMXU2130VM | .213            | 1.34 | 1.50 | 2.83 |
| 7/32              | DMXU2188VM | .219            | 1.42 | 1.50 | 2.91 |
| #2                | DMXU2210VM | .221            | 1.34 | 1.50 | 2.91 |
| #1                | DMXU2280VM | .228            | 1.34 | 1.50 | 2.91 |
| #A 15/64          | DMXU2344VM | .234            | 1.61 | 1.56 | 3.19 |
| #B                | DMXU2380VM | .238            | 1.34 | 1.58 | 3.19 |
| #C                | DMXU2420VM | .242            | 1.34 | 1.58 | 3.19 |
| #D                | DMXU2460VM | .246            | 1.34 | 1.58 | 3.19 |
| #E, 1/4           | DMXU2500VM | .250            | 1.34 | 1.58 | 3.19 |
| #F                | DMXU2570VM | .257            | 1.69 | 1.57 | 3.27 |
| #G                | DMXU2610VM | .261            | 1.69 | 1.57 | 3.27 |
| 17/64             | DMXU2656VM | .266            | 1.69 | 1.57 | 3.27 |
| #H                | DMXU2660VM | .266            | 1.69 | 1.57 | 3.27 |
| #I                | DMXU2720VM | .272            | 1.69 | 1.57 | 3.27 |
| #J                | DMXU2770VM | .277            | 1.77 | 1.65 | 3.43 |
| #K                | DMXU2810VM | .281            | 1.77 | 1.65 | 3.43 |
| 9/32              | DMXU2812VM | .281            | 1.77 | 1.65 | 3.43 |
| #L                | DMXU2900VM | .290            | 1.77 | 1.65 | 3.43 |
| #M                | DMXU2950VM | .295            | 1.77 | 1.65 | 3.43 |
| 19/64             | DMXU2969VM | .297            | 1.89 | 1.65 | 3.54 |

| Drill dia.<br>øDc | Cat. No.   | Dimensions (in) |      |      |      |
|-------------------|------------|-----------------|------|------|------|
|                   |            | øDs             | ℓ    | ℓs   | L    |
| #N                | DMXU3020VM | .302            | 1.77 | 1.65 | 3.54 |
| 5/16              | DMXU3125VM | .313            | 1.77 | 1.65 | 3.54 |
| #O                | DMXU3160VM | .316            | 2.09 | 1.69 | 3.78 |
| #P                | DMXU3230VM | .323            | 2.09 | 1.69 | 3.78 |
| 21/64             | DMXU3281VM | .328            | 2.09 | 1.69 | 3.78 |
| #Q                | DMXU3320VM | .332            | 2.09 | 1.69 | 3.78 |
| #R                | DMXU3390VM | .339            | 2.17 | 1.69 | 3.86 |
| 11/32             | DMXU3438VM | .344            | 2.17 | 1.69 | 3.86 |
| #S                | DMXU3480VM | .348            | 2.17 | 1.69 | 3.86 |
| #T                | DMXU3580VM | .358            | 2.28 | 1.73 | 4.02 |
| 23/64             | DMXU3594VM | .359            | 2.28 | 1.73 | 4.02 |
| #U                | DMXU3680VM | .368            | 2.28 | 1.73 | 4.02 |
| 3/8               | DMXU3750VM | .375            | 2.36 | 1.77 | 4.13 |
| #V                | DMXU3770VM | .377            | 2.36 | 1.77 | 4.13 |
| #W                | DMXU3860VM | .386            | 2.36 | 1.77 | 4.13 |
| 25/64             | DMXU3906VM | .390            | 2.36 | 1.77 | 4.13 |
| #X                | DMXU3970VM | .397            | 2.60 | 1.81 | 4.41 |
| #Y                | DMXU4040VM | .404            | 2.60 | 1.81 | 4.41 |
| 13/32             | DMXU4062VM | .406            | 2.60 | 1.81 | 4.41 |
| #Z                | DMXU4130VM | .413            | 2.60 | 1.81 | 4.41 |
| 27/64             | DMXU4219VM | .422            | 2.67 | 1.81 | 4.49 |
| 7/16              | DMXU4375VM | .438            | 2.80 | 1.85 | 4.65 |
| 29/64             | DMXU4531VM | .453            | 2.87 | 1.89 | 4.76 |
| 15/32             | DMXU4688VM | .469            | 2.87 | 1.89 | 4.76 |
| 31/64             | DMXU4844VM | .484            | 2.99 | 2.32 | 5.32 |
| 1/2               | DMXU5000VM | .500            | 3.07 | 2.32 | 5.39 |

Promo Code: GUS17

## DSXU Drilling Conditions

| Work Material                | Hardness     | Speed (SFM) |           |           | Feed (IPR) |           |           |
|------------------------------|--------------|-------------|-----------|-----------|------------|-----------|-----------|
|                              |              | .188~.234   | .234~.390 | .390~.781 | .188~.234  | .234~.390 | .390~.781 |
|                              |              | 3~6 mm      | 6~10 mm   | 10~20 mm  | 3~6 mm     | 6~10 mm   | 10~20 mm  |
| Mild Steel, Low carbon steel | ~200 HB      | 230~500     | 260~530   | 300~630   | .006~.010  | .008~.014 | .010~.016 |
| Carbon steel, Alloy steel    | 180 ~ 300 HB | 150~430     | 230~530   | 260~560   | .006~.010  | .008~.014 | .010~.016 |
| High alloy steel             | 250 ~ 300 HB | 130~330     | 200~460   | 200~530   | .004~.008  | .006~.012 | .006~.012 |
| Stainless steel              | <200 HB      | 100~230     | 150~400   | 150~400   | .004~.008  | .004~.010 | .006~.014 |
| Gray cast steel              | <200 HB      | 260~460     | 330~530   | 330~600   | .006~.014  | .008~.016 | .010~.020 |
| Ductile cast iron            | <300 HB      | 230~460     | 260~500   | 260~560   | .006~.014  | .008~.016 | .010~.018 |
| Aluminum alloy               | -            | 260~530     | 330~600   | 330~630   | .006~.014  | .008~.018 | .010~.024 |
| Titanium alloy               | -            | 80~200      | 100~260   | 100~260   | .004~.008  | .004~.010 | .006~.014 |
| Super alloy                  | <250 HB      | 30~100      | 30~130    | 30~130    | .008~.004  | .002~.006 | .004~.010 |
| Hard material                | <40 HB       | 60~165      | 100~200   | 100~200   | .003~.004  | .004~.006 | .005~.008 |

## DMXU Drilling Conditions

| Work Material         | Hardness | 0.1110" ~0.1970" |             | 0.1119"~0.3970" |             | 0.4040"~0.6330" |             | 0.6406"~0.7812" |             |
|-----------------------|----------|------------------|-------------|-----------------|-------------|-----------------|-------------|-----------------|-------------|
|                       |          | Speed (sfm)      | Feed (ipr)  | Speed (sfm)     | Feed (ipr)  | Speed (sfm)     | Feed (ipr)  | Speed (sfm)     | Feed (ipr)  |
| Carbon steels         | ~250     | 130~250          | 0.006~0.010 | 130~265         | 0.006~0.012 | 130~265         | 0.008~0.016 | 130~265         | 0.010~0.020 |
|                       | 250~     | 130~200          | 0.004~0.008 | 130~250         | 0.006~0.010 | 130~250         | 0.006~0.012 | 130~250         | 0.008~0.016 |
| Alloy steels          | ~250     | 130~230          | 0.006~0.010 | 130~265         | 0.006~0.012 | 130~265         | 0.008~0.016 | 130~265         | 0.010~0.020 |
|                       | 250~     | 130~200          | 0.004~0.008 | 130~250         | 0.006~0.010 | 130~250         | 0.006~0.012 | 130~250         | 0.008~0.016 |
| Die steels            | ~280     | 65~130           | 0.002~0.008 | 65~130          | 0.004~0.010 | 65~130          | 0.004~0.012 | 65~130          | 0.006~0.012 |
| Stainless steels      | ~200     | 65~130           | 0.002~0.008 | 65~130          | 0.004~0.010 | 65~130          | 0.004~0.012 | 65~130          | 0.006~0.012 |
| Ductile irons         | ~200     | 130~250          | 0.006~0.012 | 130~265         | 0.008~0.016 | 130~265         | 0.010~0.020 | 130~265         | 0.012~0.024 |
| Hardened steels       | 40~45Rc  | 30~100           | 0.001~0.003 | 30~100          | 0.002~0.004 | 30~100          | 0.003~0.005 | 30~100          | 0.003~0.005 |
| Titanium steels       | -        | 65~130           | 0.004~0.008 | -               | 0.006~0.010 | -               | 0.006~0.012 | -               | 0.008~0.016 |
| Heat resistant alloys | 250HB<   | 30~100           | 0.001~0.003 | 250HB<          | 0.002~0.004 | 250HB<          | 0.003~0.005 | 250HB<          | 0.003~0.005 |

## Promo Details:

- Orders must be drop shipped
- Promotional pricing not applicable when ordering online or EDI
- Promo code must be used when ordering
- Prices valid in U.S. only

**\* EQUIVALENT SIZE OR SMALLER FREE \***



# Tungaloy America, Inc.

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