

D423TX-20 / 25 / 30

Oil-Feed High Performance Drills

MG Carbide

AlTiSiN TX

20XD
25XD
30XD

2

20X138°
>25X135°

Work Material

P	H	M	K	N	S
●	●	●	●	○	○

P Steel

H <38HRC Hardened Steel

H <48HRC Hardened Steel

H <56HRC Hardened Steel

M Stainless Steel

K Cast Iron

S Titanium

S Nickel

S High Temp Alloys



Dc	Lc	L	d	20XD
h7	mm	mm	h6	D423TX-20
3	75	123	3	●
3.1	88	136	4	●
3.2	88	136	4	●
3.3	88	136	4	●
3.4	88	136	4	●
3.5	88	136	4	●
3.6	100	148	4	●
3.7	100	148	4	●
3.8	100	148	4	●
3.9	100	148	4	●
4	100	148	4	●
4.1	113	163	5	●
4.2	113	163	5	●
4.3	113	163	5	●
4.4	113	163	5	●
4.5	113	163	5	●
4.6	125	175	5	●
4.7	125	175	5	●
4.8	125	175	5	●
4.9	125	175	5	●
5	125	175	5	●
5.1	140	192	6	●
5.2	140	192	6	●
5.3	140	192	6	●
5.4	140	192	6	●
5.5	140	192	6	●
5.6	150	202	6	●
5.7	150	202	6	●
5.8	150	202	6	●
5.9	150	202	6	●
6	150	202	6	●
6.1	163	216	7	●
6.2	163	216	7	●
6.3	163	216	7	●
6.4	163	216	7	●
6.5	163	216	7	●
6.6	175	228	7	●
6.7	175	228	7	●
6.8	175	228	7	●
6.9	175	228	7	●
7	175	228	7	●
7.1	188	242	8	●
7.2	188	242	8	●
7.3	188	242	8	●
7.4	188	242	8	●
7.5	188	242	8	●
7.6	200	254	8	●
7.7	200	254	8	●
7.8	200	254	8	●
7.9	200	254	8	●
8	200	254	9	●
8.5	213	268	9	●
9	225	280	9	●
9.5	238	294	10	●
10	250	306	10	●

Code No. D423TX-20-Dc
D423TX-25-Dc

Dc	Lc	L	d	25XD
h7	mm	mm	h6	D423TX-25
3	90	138	3	●
3.5	105	153	4	●
4	120	168	4	●
4.5	135	185	5	●
5	150	200	5	●
5.5	165	217	6	●
6	180	232	6	●
6.5	195	248	7	●
7	210	263	7	●
7.5	225	279	8	●
8	240	294	8	●

Code No. D423TX-30-Dc

Dc	Lc	L	d	30XD
h7	mm	mm	h6	D423TX-30
3	105	153	3	●
3.5	123	171	4	●
4	140	188	4	●
4.5	158	208	5	●
5	175	225	5	●
5.5	193	245	6	●
6	210	262	6	●
6.5	228	281	7	●
7	245	298	7	●
7.5	263	317	8	●
8	280	334	8	●

Feature of product:

D423TX-20 JIS 20XD Drills with Oil-Feed

Suitable for drilling with 20XD depth.

D423TX-25 JIS 25XD Drills with Oil-Feed

Suitable for drilling with 25XD depth.

D423TX-30 JIS 30XD Drills with Oil-Feed

Suitable for drilling with 30XD depth.

135° S-shape drill tip design to reduce axial force.

Design with groove shape to provide higher chip removal rates.

Good wear resistance and lubrication with Nano multilayer coating.

Oil-feed design could reduce temperature effectively and increase chip removal rates during cutting process.

Application for drilling with Steels which is below HRC48, Cast Iron... etc.

Borehole parameters

Work Material		GR.1 Carbon Steel		GR.2 Low-alloyed Steel (~24HRC)		GR.3 Hi-alloyed Steel (~30HRC)		GR.4 Hardened Steel (30-38HRC)		GR.8 Stainless Steel		GR.9 Cast Iron	
Vc m/min		60~125		60~125		60~125		40~80		40~80		50~80	
Code No.	Dc	RPM (min-1)	Feed (mm/rev)	RPM (min-1)	Feed (mm/rev)	RPM (min-1)	Feed (mm/rev)	RPM (min-1)	Feed (mm/rev)	RPM (min-1)	Feed (mm/rev)	RPM (min-1)	Feed (mm/rev)
D423TX-20-25-30-3	3	7,500	0.06	7,500	0.06	7,500	0.06	5,300	0.06	5,300	0.06	5,300	0.06
D423TX-20-25-30-3.5	3.5	6,950	0.07	6,950	0.07	6,950	0.07	5,150	0.07	5,150	0.07	5,150	0.07
D423TX-20-25-30-4	4	6,400	0.08	6,400	0.08	6,400	0.08	5,000	0.08	5,000	0.08	5,000	0.08
D423TX-20-25-30-4.5	4.5	6,100	0.09	6,100	0.09	6,100	0.09	4,750	0.09	4,750	0.09	4,750	0.09
D423TX-20-25-30-5	5	5,800	0.10	5,800	0.10	5,800	0.10	4,500	0.10	4,500	0.10	4,500	0.10
D423TX-20-25-30-5.5	5.5	5,300	0.11	5,300	0.11	5,300	0.11	4,150	0.11	4,150	0.11	4,150	0.11
D423TX-20-25-30-6	6	4,800	0.12	4,800	0.12	4,800	0.12	3,800	0.12	3,800	0.12	3,800	0.12
D423TX-20-25-30-6.5	6.5	4,500	0.13	4,500	0.13	4,500	0.13	3,550	0.13	3,550	0.13	3,550	0.13
D423TX-20-25-30-7	7	4,200	0.14	4,200	0.14	4,200	0.14	3,300	0.14	3,300	0.14	3,300	0.14
D423TX-20-25-30-7.5	7.5	3,900	0.15	3,900	0.15	3,900	0.15	3,050	0.15	3,050	0.15	3,050	0.15
D423TX-20-25-30-8	8	3,600	0.16	3,600	0.16	3,600	0.16	2,800	0.16	2,800	0.16	2,800	0.16
D423TX-20-25-30-8.5	8.5	3,410	0.17	3,410	0.17	3,410	0.17	2,675	0.17	2,675	0.17	2,675	0.17
D423TX-20-25-30-9	9	3,250	0.18	3,250	0.18	3,250	0.18	2,550	0.18	2,550	0.18	2,550	0.18
D423TX-20-25-30-9.5	9.5	3,060	0.19	3,060	0.19	3,060	0.19	2,425	0.19	2,425	0.19	2,425	0.19
D423TX-20-25-30-10	10	2,900	0.20	2,900	0.20	2,900	0.20	2,300	0.20	2,300	0.20	2,300	0.20
D423TX-20-25-30-10.5	10.5	2,775	0.21	2,775	0.21	2,775	0.21	2,200	0.21	2,200	0.21	2,200	0.21
D423TX-20-25-30-11	11	2,650	0.22	2,650	0.22	2,650	0.22	2,100	0.22	2,100	0.22	2,100	0.22
D423TX-20-25-30-11.5	11.5	2,525	0.23	2,525	0.23	2,525	0.23	2,000	0.23	2,000	0.23	2,000	0.23
D423TX-20-25-30-12	12	2,400	0.24	2,400	0.24	2,400	0.24	1,900	0.24	1,900	0.24	1,900	0.24

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.