

palbit 

2D | 3D | 4D | 5D

MAXPRO DRILL

Maximum performance to a great drilling experience

HOLEMAKING

Indexable system

NEW

CHIPBREAKER
FOR ALUMINIUM



SINCE 1916

MAXPRO DRILL

XCS TOOLHOLDERS

Palbit's MaxPro Drill indexable drilling tool is a versatile and high-performance tool designed for holemaking operations on various surfaces.

With cutting diameters ranging from Ø14mm to Ø60mm and drilling lengths from 2xDC to 5xDC, the MaxPro Drill is capable of handling a wide range of holemaking requirements.

Its specialized cutting inserts allow for efficient and precise drilling on flat surfaces, inclined surfaces, as well as for making crossing holes, chain drilling, and stack drilling.

Whether drilling through multiple layers of materials or working on complex drilling projects, the MaxPro Drill offers reliable performance and exceptional results.

Its modular design and quick-change inserts also help to reduce tool changeover times and increase productivity.



From DC Ø14mm
to Ø60mm and
with drilling from
2xDC to 5xDC

SOK(H)X & XOK(H)X INSERTS



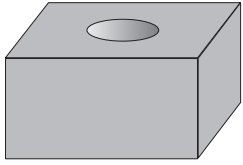
ISO material	Chip breaker	SOK(H)X (Outer insert)	XOK(H)X (Inner insert)
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<div style="background-color: #FFD700; color: black; padding: 2px; display: inline-block; margin-bottom: 5px;">M</div> <div style="background-color: #FF8C00; color: white; padding: 2px; display: inline-block;">S</div>	-MS		
NEW <div style="background-color: #008080; color: white; padding: 2px; display: inline-block;">N</div>	-LN		

■ Choose the right insert. Maximize performance.

MaxPro Drill combines precision toolholders with a complete range of inserts optimized for various ISO materials. Whether you're machining steels, stainless steels, non-ferrous alloys or superalloys, each chipbreaker geometry ensures effective chip control, longer tool life, and excellent hole quality. Adaptability and performance, engineered into every insert.

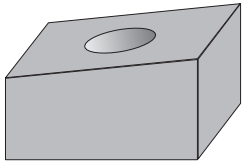
MAXPRO DRILL

APPLICABILITY



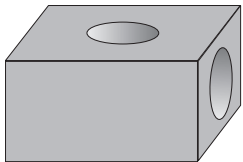
■ Flat Surface

MaxPro Drill is designed to perform efficient and precise drilling on flat surfaces. Its cutting inserts are carefully selected to deliver optimal performance on various materials.



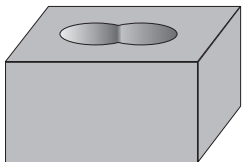
■ Inclined Surface

The MaxPro Drill is also suitable for drilling on inclined surfaces. Its specialized inserts can handle the cutting forces and torque required to cut through materials at different angles.



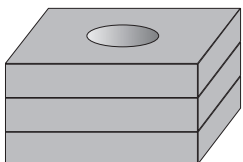
■ Crossing Hole

With its precise positioning and excellent stability, MaxPro Drill is ideal for making crossing holes. It allows for accurate and efficient holemaking operations without compromising the quality of the finished product.



■ Chain Drilling

The MaxPro Drill is capable of performing chain drilling operations, thanks to its cutting-edge design and high-quality cutting inserts. It allows for faster drilling speeds and improved productivity, while also reducing tool changeover times.



■ Stack Drilling

The MaxPro Drill is also well-suited for stack holemaking applications. Its modular design and reliable performance make it an excellent choice for drilling multiple layers of materials with precision and ease.

ALUMINIUM MACHINING

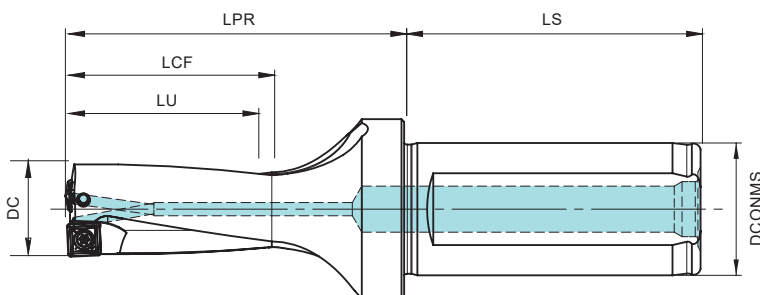
Aluminium is a cornerstone material across a wide range of industries, from aerospace and automotive to electronics and general manufacturing. Its unique combination of light weight, strength, and corrosion resistance makes it a preferred choice for applications demanding high efficiency and performance. However, aluminium also presents specific machining challenges that require dedicated solutions, particularly in drilling operations.

Unlike harder ferrous metals, aluminium's ductility and tendency to adhere to cutting tools can lead to chip buildup, increased heat generation, and premature tool wear. Furthermore, the wide variety of aluminium alloys, ranging from soft, pure grades to harder, more abrasive series, demands tooling that can adapt to these varying conditions without compromising productivity or part quality.
























The new drilling inserts design is intended to optimize performance on aluminium alloys, where factors such as high cutting speeds, effective chip evacuation, and sustained sharpness are critical to achieving proper results. Standard drilling inserts often face challenges in aluminium applications, including chip buildup, tool wear and high temperatures due to adhesive material properties. Addressing these issues required a targeted approach, resulting in a product engineered with sharp edges, polished surfaces, and adequate wear resistance, suited to aluminium's ductile characteristics and abrasiveness (depending on the chosen alloy).




MAXPRO DRILL | XCS 2D



DCONMS	LS	BP	2D		
			DC	Drill tolerance	Hole tolerance
20	50	PT - 1/8	14-29,5	0/-0,15	-0,10/+0,20
25	56	PT - 1/8	30-42	0/-0,15	-0,10/+0,25
32	60	PT - 1/4	43-60	0/-0,15	-0,10/+0,28

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock 
		DC	DCONMS	LU	LCF	LPR					
184316800	XCS 14020-2D	14,0	20	28	31	51	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184316900	XCS 14520-2D	14,5	20	29	32	52	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184317000	XCS 15020-2D	15,0	20	30	33	53	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184317100	XCS 15520-2D	15,5	20	31	34	54	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184317200	XCS 16020-2D	16,0	20	32	35	55	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184317300	XCS 16525-2D	16,5	25	33	36	61	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317400	XCS 17025-2D	17,0	25	34	37	62	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317500	XCS 17525-2D	17,5	25	35	38	63	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317600	XCS 18025-2D	18,0	25	36	39	64	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317700	XCS 18525-2D	18,5	25	37	40	65	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317800	XCS 19025-2D	19,0	25	38	41	66	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184317900	XCS 19525-2D	19,5	25	39	42	67	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184318000	XCS 20025-2D	20,0	25	40	43	68	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318100	XCS 20525-2D	20,5	25	41	44	69	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318200	XCS 21025-2D	21,0	25	42	45	70	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318300	XCS 21525-2D	21,5	25	43	46	71	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318400	XCS 22025-2D	22,0	25	44	47	72	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318500	XCS 22525-2D	22,5	25	45	48	73	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318600	XCS 23025-2D	23,0	25	46	49	74	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184318700	XCS 23525-2D	23,5	25	47	50	75	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	



 Stock item | Produto de stock | Itens de stock

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MAXPRO DRILL

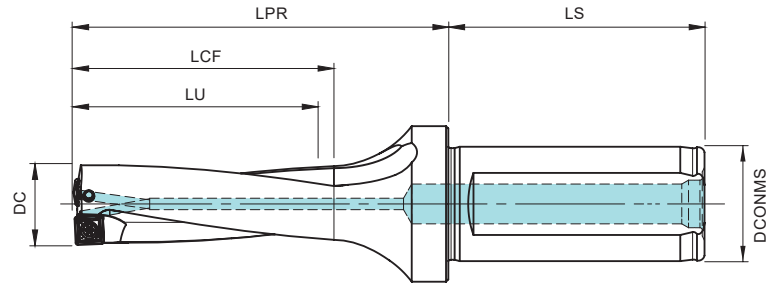
XCS 2D

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock
		DC	DONMS	LU	LCF	LPR					
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184318900	XCS 24532-2D	24,5	32	49	52	82	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319000	XCS 25032-2D	25,0	32	50	53	83	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319100	XCS 25532-2D	25,5	32	51	54	84	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319200	XCS 26032-2D	26,0	32	52	55	85	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319300	XCS 26532-2D	26,5	32	53	56	86	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319400	XCS 27032-2D	27,0	32	54	57	87	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319500	XCS 27532-2D	27,5	32	55	58	88	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319600	XCS 28032-2D	28,0	32	56	59	89	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319700	XCS 28532-2D	28,5	32	57	60	90	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319800	XCS 29032-2D	29,0	32	58	61	91	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184319900	XCS 29532-2D	29,5	32	59	62	92	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184320000	XCS 30032-2D	30,0	32	60	65	95	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320100	XCS 31032-2D	31,0	32	62	67	97	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320200	XCS 32032-2D	32,0	32	64	69	99	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320300	XCS 33032-2D	33,0	32	66	71	101	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320400	XCS 34032-2D	34,0	32	68	73	103	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320500	XCS 35032-2D	35,0	32	70	75	105	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184320600	XCS 36040-2D	36,0	40	72	77	112	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184320700	XCS 37040-2D	37,0	40	74	79	114	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184320800	XCS 38040-2D	38,0	40	76	81	116	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184320900	XCS 39040-2D	39,0	40	78	83	118	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184321000	XCS 40040-2D	40,0	40	80	85	120	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184321100	XCS 41040-2D	41,0	40	82	87	122	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184321200	XCS 42040-2D	42,0	40	84	89	124	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184321300	XCS 43040-2D	43,0	40	86	91	126	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321400	XCS 44040-2D	44,0	40	88	93	128	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321500	XCS 45040-2D	45,0	40	90	95	130	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321600	XCS 46040-2D	46,0	40	92	97	132	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321700	XCS 47040-2D	47,0	40	94	99	134	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321800	XCS 48040-2D	48,0	40	96	101	136	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184321900	XCS 49040-2D	49,0	40	98	103	138	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184322000	XCS 50040-2D	50,0	40	100	105	140	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184340200	XCS 51040-2D	51,0	40	102	107	142	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340300	XCS 52040-2D	52,0	40	104	109	144	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340400	XCS 53040-2D	53,0	40	106	111	146	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340500	XCS 54040-2D	54,0	40	108	113	148	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340600	XCS 55040-2D	55,0	40	110	115	150	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340700	XCS 56040-2D	56,0	40	112	117	152	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340800	XCS 57040-2D	57,0	40	114	119	154	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184340900	XCS 58040-2D	58,0	40	116	121	156	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341000	XCS 59040-2D	59,0	40	118	123	158	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
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

📦 Stock item | Produto de stock | Itens de stock

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MAXPRO DRILL | XCS 3D



DC	DCONMS	BP	3D		
			DC	Drill tolerance	Hole tolerance
20	50	PT - 1/8	14-29,5	0/-0,15	-0,10/+0,20
25	56	PT - 1/8	30-42	0/-0,15	-0,10/+0,25
32	60	PT - 1/4	43-60	0/-0,15	-0,10/+0,28

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock
		DC	DCONMS	LU	LCF	LPR					
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184322200	XCS 14520-3D	14,5	20	44	47	67	XOKX 050204	SOKX 050204	P02004IP	XT06IP	🇧🇷
184322300	XCS 15020-3D	15,0	20	45	48	68	XOKX 050204	SOKX 050204	P02004IP	XT06IP	🇧🇷
184322400	XCS 15520-3D	15,5	20	47	50	70	XOKX 050204	SOKX 050204	P02004IP	XT06IP	🇧🇷
184322500	XCS 16020-3D	16,0	20	48	51	71	XOKX 050204	SOKX 050204	P02004IP	XT06IP	🇧🇷
184322600	XCS 16525-3D	16,5	25	50	53	78	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184322700	XCS 17025-3D	17,0	25	51	54	79	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184322800	XCS 17525-3D	17,5	25	53	56	81	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184322900	XCS 18025-3D	18,0	25	54	57	82	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184323000	XCS 18525-3D	18,5	25	56	59	84	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184323100	XCS 19025-3D	19,0	25	57	60	85	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184323200	XCS 19525-3D	19,5	25	59	62	87	XOKX 060204	SOKX 060205	P02205IP	XT06IP	🇧🇷
184323300	XCS 20025-3D	20,0	25	60	63	88	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323400	XCS 20525-3D	20,5	25	62	65	90	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323500	XCS 21025-3D	21,0	25	63	66	91	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323600	XCS 21525-3D	21,5	25	65	68	93	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323700	XCS 22025-3D	22,0	25	66	69	94	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323800	XCS 22525-3D	22,5	25	68	71	96	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184323900	XCS 23025-3D	23,0	25	69	72	97	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷
184324000	XCS 23525-3D	23,5	25	71	74	99	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	🇧🇷



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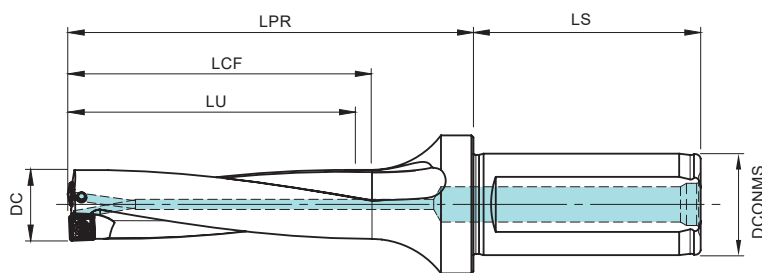
XCS 3D

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184324200	XCS 24532-3D	24,5	32	74	77	107	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324300	XCS 25032-3D	25,0	32	75	78	108	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324400	XCS 25532-3D	25,5	32	77	80	110	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324500	XCS 26032-3D	26,0	32	78	81	111	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324600	XCS 26532-3D	26,5	32	80	83	113	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324700	XCS 27032-3D	27,0	32	81	84	114	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324800	XCS 27532-3D	27,5	32	83	86	116	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184324900	XCS 28032-3D	28,0	32	84	87	117	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184325000	XCS 28532-3D	28,5	32	86	89	119	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184325100	XCS 29032-3D	29,0	32	87	90	120	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184325200	XCS 29532-3D	29,5	32	89	92	122	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184325300	XCS 30032-3D	30,0	32	90	95	125	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325400	XCS 31032-3D	31,0	32	93	98	128	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325500	XCS 32032-3D	32,0	32	96	101	131	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325600	XCS 33032-3D	33,0	32	99	104	134	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325700	XCS 34032-3D	34,0	32	102	107	137	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325800	XCS 35032-3D	35,0	32	105	110	140	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184325900	XCS 36040-3D	36,0	40	108	113	148	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326000	XCS 37040-3D	37,0	40	111	116	151	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326100	XCS 38040-3D	38,0	40	114	119	154	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326200	XCS 39040-3D	39,0	40	117	122	157	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326300	XCS 40040-3D	40,0	40	120	125	160	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326400	XCS 41040-3D	41,0	40	123	128	163	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326500	XCS 42040-3D	42,0	40	126	131	166	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184326600	XCS 43040-3D	43,0	40	129	134	169	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184326700	XCS 44040-3D	44,0	40	132	137	172	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184310700	XCS 45040-3D	45,0	40	135	140	175	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184310800	XCS 46040-3D	46,0	40	138	143	178	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184326800	XCS 47040-3D	47,0	40	141	146	181	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184326900	XCS 48040-3D	48,0	40	144	149	184	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184327000	XCS 49040-3D	49,0	40	147	152	187	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184327100	XCS 50040-3D	50,0	40	150	155	190	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184341200	XCS 51040-3D	51,0	40	153	158	193	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341300	XCS 52040-3D	52,0	40	156	161	196	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341400	XCS 53040-3D	53,0	40	159	164	199	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341500	XCS 54040-3D	54,0	40	162	167	202	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341600	XCS 55040-3D	55,0	40	165	170	205	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341700	XCS 56040-3D	56,0	40	168	173	208	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341800	XCS 57040-3D	57,0	40	171	176	211	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184341900	XCS 58040-3D	58,0	40	174	179	214	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342000	XCS 59040-3D	59,0	40	177	182	217	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342100	XCS 60040-3D	60,0	40	180	185	220	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
























📦 Stock item | Produto de stock | Itens de stock


○ Available under request | Disponível sobre consulta | Disponible bajo consulta

MAXPRO DRILL | XCS 4D



DCONMS	LS	BP	4D		
			DC	Drill tolerance	Hole tolerance
20	50	PT - 1/8	14-29,5	0/-0,15	-0,05/+0,25
25	56	PT - 1/8	30-42	0/-0,15	-0,05/+0,30
32	60	PT - 1/4	43-60	0/-0,15	-0,05/+0,33

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock 
		DC	DCONMS	LU	LCF	LPR					
184327200	XCS 14020-4D	14,0	20	56	59	79	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184327300	XCS 14520-4D	14,5	20	58	61	81	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184327400	XCS 15020-4D	15,0	20	60	63	83	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184327500	XCS 15520-4D	15,5	20	62	65	85	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184327600	XCS 16020-4D	16,0	20	64	67	87	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184327700	XCS 16525-4D	16,5	25	66	69	94	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184327800	XCS 17025-4D	17,0	25	68	71	96	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184327900	XCS 17525-4D	17,5	25	70	73	98	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184328000	XCS 18025-4D	18,0	25	72	75	100	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184328100	XCS 18525-4D	18,5	25	74	77	102	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184328200	XCS 19025-4D	19,0	25	76	79	104	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184328300	XCS 19525-4D	19,5	25	78	81	106	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184328400	XCS 20025-4D	20,0	25	80	83	108	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184328500	XCS 20525-4D	20,5	25	82	85	110	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184328600	XCS 21025-4D	21,0	25	84	87	112	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184328700	XCS 21525-4D	21,5	25	86	89	114	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184328800	XCS 22025-4D	22,0	25	88	91	116	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184328900	XCS 22525-4D	22,5	25	90	93	118	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184329000	XCS 23025-4D	23,0	25	92	95	120	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184329100	XCS 23525-4D	23,5	25	94	97	122	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	



 Stock item | Produto de stock | Itens de stock

 Available under request | Disponível sobre consulta | Disponible bajo consulta

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MAXPRO DRILL

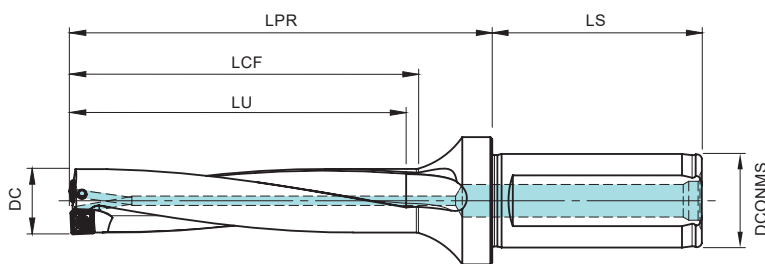
XCS 4D

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock
		DC	DCONMS	LU	LCF	LPR					
184329200	XCS 24032-4D	24,0	32	96	99	129	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329300	XCS 24532-4D	24,5	32	98	101	131	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329400	XCS 25032-4D	25,0	32	100	103	133	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329500	XCS 25532-4D	25,5	32	102	105	135	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329600	XCS 26032-4D	26,0	32	104	107	137	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329700	XCS 26532-4D	26,5	32	106	109	139	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329800	XCS 27032-4D	27,0	32	108	111	141	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184329900	XCS 27532-4D	27,5	32	110	113	143	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184330000	XCS 28032-4D	28,0	32	112	115	145	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184330100	XCS 28532-4D	28,5	32	114	117	147	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184330200	XCS 29032-4D	29,0	32	116	119	149	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184330300	XCS 29532-4D	29,5	32	118	121	151	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184330400	XCS 30032-4D	30,0	32	120	125	155	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184330500	XCS 31032-4D	31,0	32	124	129	159	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184330600	XCS 32032-4D	32,0	32	128	133	163	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184330700	XCS 33032-4D	33,0	32	132	137	167	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184330800	XCS 34032-4D	34,0	32	136	141	171	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184330900	XCS 35032-4D	35,0	32	140	145	175	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184331000	XCS 36040-4D	36,0	40	144	149	184	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331100	XCS 37040-4D	37,0	40	148	153	188	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331200	XCS 38040-4D	38,0	40	152	157	192	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331300	XCS 39040-4D	39,0	40	156	161	196	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331400	XCS 40040-4D	40,0	40	160	165	200	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331500	XCS 41040-4D	41,0	40	164	169	204	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331600	XCS 42040-4D	42,0	40	168	173	208	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184331700	XCS 43040-4D	43,0	40	172	177	212	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184331800	XCS 44040-4D	44,0	40	176	181	216	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184331900	XCS 45040-4D	45,0	40	180	185	220	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184332000	XCS 46040-4D	46,0	40	184	189	224	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184332100	XCS 47040-4D	47,0	40	188	193	228	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184332200	XCS 48040-4D	48,0	40	192	197	232	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184332300	XCS 49040-4D	49,0	40	196	201	236	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184332400	XCS 50040-4D	50,0	40	200	205	240	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184342200	XCS 51040-4D	51,0	40	204	209	244	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342300	XCS 52040-4D	52,0	40	208	213	248	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342400	XCS 53040-4D	53,0	40	212	217	252	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342500	XCS 54040-4D	54,0	40	216	221	256	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342600	XCS 55040-4D	55,0	40	220	225	260	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342700	XCS 56040-4D	56,0	40	224	229	264	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342800	XCS 57040-4D	57,0	40	228	233	264	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184342900	XCS 58040-4D	58,0	40	232	237	272	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343000	XCS 59040-4D	59,0	40	236	241	276	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343100	XCS 60040-4D	60,0	40	240	245	280	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
























📦 Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

MAXPRO DRILL | XCS 5D



DCONMS	LS	BP	5D		
			DC	Drill tolerance	Hole tolerance
20	50	PT - 1/8	14-29,5	0/-0,15	-0,05/+0,25
25	56	PT - 1/8	30-42	0/-0,15	-0,05/+0,30
32	60	PT - 1/4	43-60	0/-0,15	-0,05/+0,33

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock 
		DC	DCONMS	LU	LCF	LPR					
184332500	XCS 14020-5D	14,0	20	70	73	88	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184332600	XCS 14520-5D	14,5	20	73	76	91	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184332700	XCS 15020-5D	15,0	20	75	78	93	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184332800	XCS 15520-5D	15,5	20	78	81	96	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184332900	XCS 16020-5D	16,0	20	80	83	98	XOKX 050204	SOKX 050204	P02004IP	XT06IP	
184333000	XCS 16525-5D	16,5	25	83	86	106	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333100	XCS 17025-5D	17,0	25	85	88	108	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333200	XCS 17525-5D	17,5	25	88	91	111	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333300	XCS 18025-5D	18,0	25	90	93	113	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333400	XCS 18525-5D	18,5	25	93	96	116	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333500	XCS 19025-5D	19,0	25	95	98	118	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333600	XCS 19525-5D	19,5	25	98	101	121	XOKX 060204	SOKX 060205	P02205IP	XT06IP	
184333700	XCS 20025-5D	20,0	25	100	103	123	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184333800	XCS 20525-5D	20,5	25	103	106	126	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184333900	XCS 21025-5D	21,0	25	105	108	128	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184334000	XCS 21525-5D	21,5	25	108	111	131	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184334100	XCS 22025-5D	22,0	25	110	113	133	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184334200	XCS 22525-5D	22,5	25	113	116	136	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184334300	XCS 23025-5D	23,0	25	115	118	138	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	
184334400	XCS 23525-5D	23,5	25	118	121	141	XOKX 07T205	SOKX 07T208	P02507IP	XT08IP	



 Stock item | Produto de stock | Itens de stock

 Available under request | Disponível sobre consulta | Disponible bajo consulta

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MAXPRO DRILL

XCS 5D

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inner Insert	Outer Insert	Insert Screw 	Torx key 	Stock
		DC	DCONMS	LU	LCF	LPR					
184334500	XCS 24032-5D	24,0	32	120	123	148	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184334600	XCS 24532-5D	24,5	32	123	126	151	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184334700	XCS 25032-5D	25,0	32	125	128	153	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184334800	XCS 25532-5D	25,5	32	128	131	156	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184334900	XCS 26032-5D	26,0	32	130	133	158	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335000	XCS 26532-5D	26,5	32	133	136	161	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335100	XCS 27032-5D	27,0	32	135	138	163	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335200	XCS 27532-5D	27,5	32	138	141	176	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335300	XCS 28032-5D	28,0	32	140	143	168	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335400	XCS 28532-5D	28,5	32	143	146	171	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335500	XCS 29032-5D	29,0	32	145	148	173	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335600	XCS 29532-5D	29,5	32	148	151	176	XOKX 090305	SOKX 090308	P03007IP	XT08IP	📦
184335700	XCS 30032-5D	30,0	32	150	155	180	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184335800	XCS 31032-5D	31,0	32	155	160	185	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184335900	XCS 32032-5D	32,0	32	160	165	190	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184336000	XCS 33032-5D	33,0	32	165	170	195	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184336100	XCS 34032-5D	34,0	32	170	175	200	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184336200	XCS 35032-5D	35,0	32	175	180	205	XOKX 11T306	SOKX 11T308	P03508IP	XT15IP-S35	📦
184336300	XCS 36040-5D	36,0	40	180	185	215	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336400	XCS 37040-5D	37,0	40	185	190	220	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336500	XCS 38040-5D	38,0	40	190	195	225	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336600	XCS 39040-5D	39,0	40	195	200	230	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336700	XCS 40040-5D	40,0	40	200	205	235	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336800	XCS 41040-5D	41,0	40	205	210	240	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184336900	XCS 42040-5D	42,0	40	210	215	245	XOKX 130406	SOKX 130410	P04010IP	XT15IP-S35	📦
184337000	XCS 43040-5D	43,0	40	215	220	250	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337100	XCS 44040-5D	44,0	40	220	225	255	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337200	XCS 45040-5D	45,0	40	225	230	260	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337300	XCS 46040-5D	46,0	40	230	235	265	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337400	XCS 47040-5D	47,0	40	235	240	270	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337500	XCS 48040-5D	48,0	40	240	245	275	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337600	XCS 49040-5D	49,0	40	245	250	280	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184337700	XCS 50040-5D	50,0	40	250	255	285	XOKX 150508	SOKX 150510	P05013IP	XT20IP-S40	📦
184343200	XCS 51040-5D	51,0	40	255	260	290	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343300	XCS 52040-5D	52,0	40	260	265	295	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343400	XCS 53040-5D	53,0	40	265	270	300	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343500	XCS 54040-5D	54,0	40	270	275	305	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343600	XCS 55040-5D	55,0	40	275	280	310	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343700	XCS 56040-5D	56,0	40	280	285	315	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343800	XCS 57040-5D	57,0	40	285	290	320	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184343900	XCS 58040-5D	58,0	40	290	295	325	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184344000	XCS 59040-5D	59,0	40	295	300	330	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦
184344100	XCS 60040-5D	60,0	40	300	305	335	XOKX 180508	SOKX 180510	P05013IP	XT20IP-S40	📦

📦 Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

MAXPRO DRILL

SOK(H)X OUTER INSERT



SOKX-MP

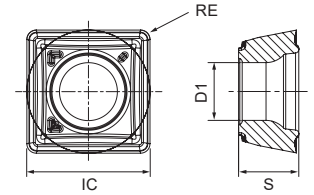


SOKX-MS



SOHX-LN

NEW



SOK(H)X-MP | MS | LN

(1) Geometry code	ISO Reference	P		M	K		N		S	Dimensions Dimensões Dimensiones (mm)			
		PVD	CVD	PVD	PVD	CVD	UNC	PVD	PVD	IC	S	D1	RE
		T1	2C	Y3	T1	2C	12	W1	Y3				
1142113	SOKX 050204-MP	⊗	⊗		⊗	⊗				5,10	2,50	2,40	0,40
1142115	SOKX 060205-MP	⊗	⊗		⊗	⊗				6,20	2,60	2,60	0,50
1142117	SOKX 07T208-MP	⊗	⊗		⊗	⊗				7,50	2,90	2,90	0,80
1142119	SOKX 090308-MP	⊗	⊗		⊗	⊗				9,20	3,50	3,50	0,80
1142121	SOKX 11T308-MP	⊗	⊗		⊗	⊗				11,00	4,20	4,10	0,80
1142123	SOKX 130410-MP	⊗	⊗		⊗	⊗				13,00	4,73	4,60	1,00
1142125	SOKX 150510-MP	⊗	⊗		⊗	⊗				15,20	5,30	5,60	1,00
1142160	SOKX 180510-MP	⊗	⊗		⊗	⊗				18,20	5,30	5,60	1,00
1142127	SOKX 050204-MS			⊗					⊗	5,10	2,50	2,40	0,40
1142129	SOKX 060205-MS			⊗					⊗	6,20	2,60	2,60	0,50
1142131	SOKX 07T208-MS			⊗					⊗	7,50	2,90	2,90	0,80
1142133	SOKX 090308-MS			⊗					⊗	9,20	3,50	3,50	0,80
1142135	SOKX 11T308-MS			⊗					⊗	11,00	4,20	4,10	0,80
1142137	SOKX 130410-MS			⊗					⊗	13,00	4,73	4,60	1,00
1142139	SOKX 150510-MS			⊗					⊗	15,20	5,30	5,60	1,00
1142162	SOKX 180510-MS			⊗					⊗	18,20	5,30	5,60	1,00
1142163	SOHX 050204-LN						⊗	⊗		5,10	2,50	2,40	0,40
1142171	SOHX 060205-LN						⊗	⊗		6,20	2,60	2,60	0,50
1142173	SOHX 07T208-LN						⊗	⊗		7,50	2,90	2,90	0,80
1142175	SOHX 090308-LN						⊗	⊗		9,20	3,50	3,50	0,80
1142177	SOHX 11T308-LN						⊗	⊗		11,00	4,20	4,10	0,80
1142179	SOHX 130410-LN						⊗	⊗		13,00	4,73	4,60	1,00
1142181	SOHX 150510-LN						⊗	⊗		15,20	5,30	5,60	1,00
1142183	SOHX 180510-LN						⊗	⊗		18,20	5,30	5,60	1,00

NEW

⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

XOK(H)X INNER INSERT



XOKX-MP

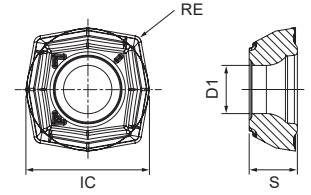


XOHX-MS



XOHX-LN

NEW



XOK(H)X-MP | MS | LN

		P	M	K	N		S	Dimensions Dimensões Dimensiones (mm)			
		PVD	PVD	PVD	UNC	PVD	PVD	IC	S	D1	RE
(2) Grade code	P4	X9	P4	12	W1	X9					
(1) Geometry code	ISO Reference	PHH930	PHH930	PHH930	PH0920	PHI920	PHH930				
1142112	XOKX 050204-MP	⊗		⊗				5,40	2,50	2,40	0,40
1142114	XOKX 060204-MP	⊗		⊗				6,56	2,50	2,60	0,40
1142116	XOKX 07T205-MP	⊗		⊗				7,80	2,90	2,90	0,50
1142118	XOKX 090305-MP	⊗		⊗				9,60	3,50	3,50	0,50
1142120	XOKX 11T306-MP	⊗		⊗				11,38	4,15	4,10	0,60
1142122	XOKX 130406-MP	⊗		⊗				13,60	4,68	4,60	0,60
1142124	XOKX 150508-MP	⊗		⊗				15,90	5,30	5,60	0,80
1142159	XOKX 180508-MP	⊗		⊗				18,20	5,30	5,60	0,80
1142126	XOKX 050204-MS		⊗				⊗	5,40	2,50	2,40	0,40
1142128	XOKX 060204-MS		⊗				⊗	6,56	2,50	2,60	0,40
1142130	XOKX 07T205-MS		⊗				⊗	7,80	2,90	2,90	0,50
1142132	XOKX 090305-MS		⊗				⊗	9,60	3,50	3,50	0,50
1142134	XOKX 11T306-MS		⊗				⊗	11,38	4,20	4,10	0,60
1142136	XOKX 130406-MS		⊗				⊗	13,60	4,68	4,60	0,60
1142138	XOKX 150508-MS		⊗				⊗	15,90	5,30	5,60	0,80
1142161	XOKX 180508-MS		⊗				⊗	18,20	5,30	5,60	0,80
1142164	XOHX 050204-LN				⊗	⊗		5,40	2,50	2,40	0,40
1142172	XOHX 060204-LN				⊗	⊗		6,56	2,50	2,60	0,40
1142174	XOHX 07T205-LN				⊗	⊗		7,80	2,90	2,90	0,50
1142176	XOHX 090305-LN				⊗	⊗		9,60	3,50	3,50	0,50
1142178	XOHX 11T306-LN				⊗	⊗		11,38	4,20	4,10	0,60
1142180	XOHX 130406-LN				⊗	⊗		13,60	4,68	4,60	0,60
1142182	XOHX 150508-LN				⊗	⊗		15,90	5,30	5,60	0,80
1142184	XOHX 180508-LN				⊗	⊗		18,20	5,30	5,60	0,80

NEW

⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

MAXPRO DRILL

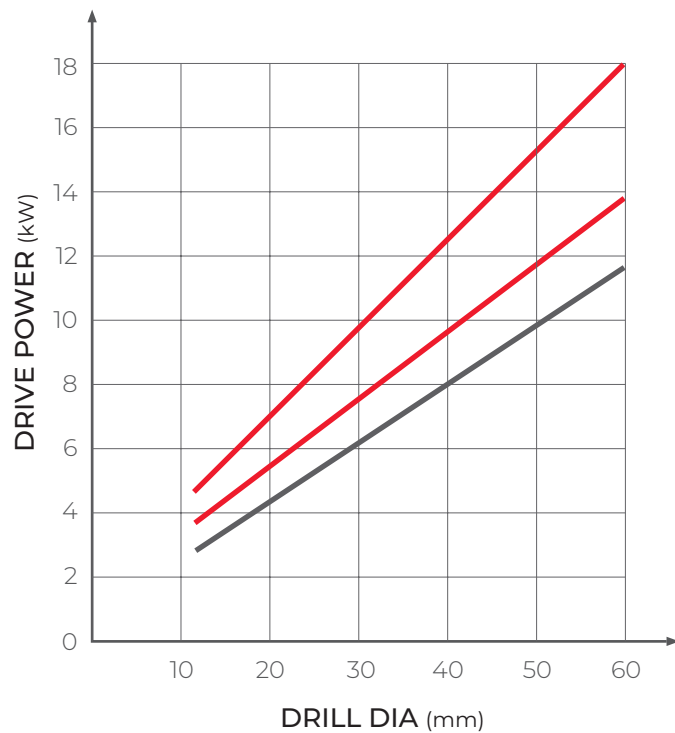
RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	Material Group	Vc (m/min)	fn (mm/rev)				
			Ø14-Ø16	Ø16,5-Ø23,5	Ø24-Ø29,5	Ø30-Ø42	Ø43-Ø60
P	Unalloyed steel (-0,25%)	160-250	0,04-0,08	0,04-0,08	0,04-0,10	0,05-0,12	0,05-0,14
	Low-alloy steel (0,25%-)	140-220	0,04-0,10	0,04-0,12	0,05-0,015	0,08-0,18	0,10-0,20
	Low-alloy steel	120-220	0,04-0,10	0,05-0,10	0,05-0,12	0,06-0,18	0,06-0,20
	High-alloy steel	120-180	0,04-0,12	0,05-0,12	0,07-0,16	0,08-0,18	0,08-0,20
M	Stainless steel	130-220	0,04-0,10	0,04-0,12	0,05-0,14	0,06-0,16	0,06-0,18
K	Grey cast iron	150-250	0,04-0,10	0,05-0,14	0,05-0,17	0,08-0,20	0,08-0,25
	Cast iron with nodular cast	100-200	0,04-0,12	0,04-0,12	0,05-0,14	0,06-0,15	0,06-0,18
N	Wrought alloys	150-700	0,08-0,20	0,12-0,26	0,20-0,30	0,20-0,35	0,20-0,35
	Cast alloys (<5% Si)	150-700	0,08-0,20	0,12-0,26	0,20-0,30	0,20-0,35	0,20-0,35
	cast alloys (>5% Si)	120-450	0,08-0,20	0,12-0,26	0,20-0,30	0,20-0,35	0,20-0,35
S	Super-alloys and titanium	30-90	0,04-0,08	0,04-0,08	0,04-0,11	0,07-0,12	0,08-0,15

NOTES

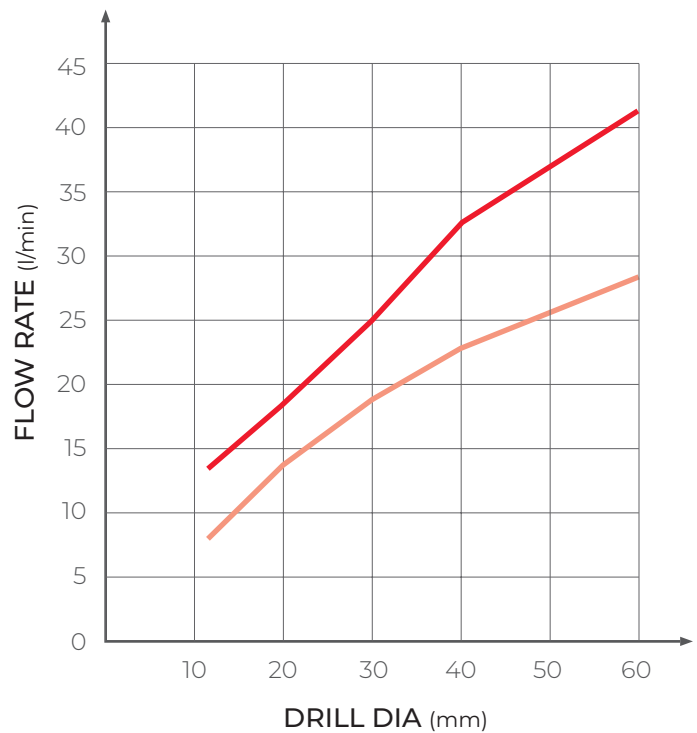
When working on irregular surfaces, please reduce the feed rate by 30%-50%. To ensure the best performance, make sure to use the proper oil pressure (over 5kg/cm²) and follow the cutting data parameters.

Power requirements



- F = 0,13 mm/r
- F = 0,10 mm/r
- F = 0,07 mm/r

Cutting oil quantity



- Recommended cutting oil quantity
- Min. cutting oil quantity

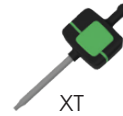
NOTES

Minimum pressure coolant: 5bar

SPARE PARTS Acessórios | Repuestos



Order code Código	Reference Referência Referencia	Torque (Nm)
290095800	P02004IP	0,4
290095900	P02205IP	0,8
290096000	P02507IP	0,8
290096100	P03007IP	1,2
290096200	P03508IP	3
290096300	P04010IP	3
290096400	P05013IP	5



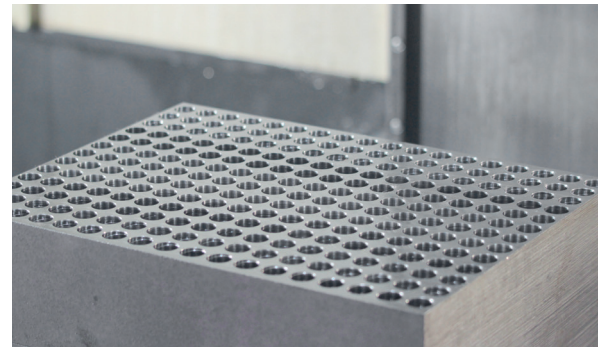
Order code Código	Reference Referência Referencia
290058600	XT06IP
290096500	XT08IP
290097300	XT15IP-S35
290097400	XT20IP-S40

Workpiece Material: 40 CrMnNiMo 8-6-4

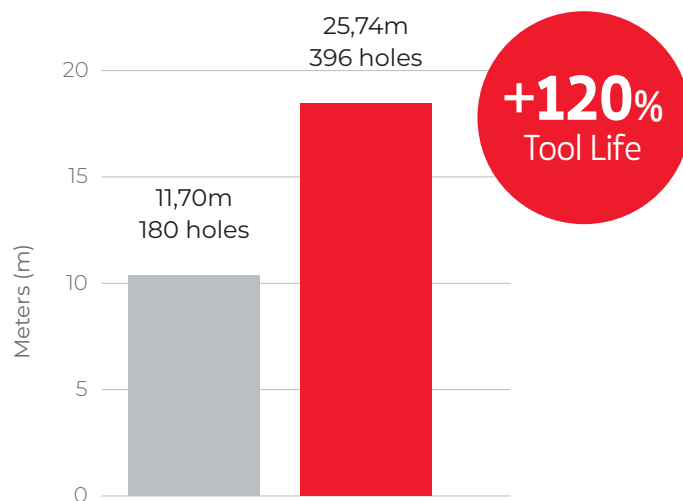
Coolant: Emulsion

■ TOOL LIFE

Toolholder	XCS 17525-4D
Outer Insert	SOKX 060205-MP PHS130
Inner Insert	XOKX 060204-MP PHP930
Cutting speed: Vc	180 m/min
Spindle speed: RPM	3274 rpm
Feed per tooth: fz	0,11 mm/t
Linear feed: F	179,998 mm/min
Drilling depth : Ap	65 mm



Machined workpiece



Palbit | Outer Insert



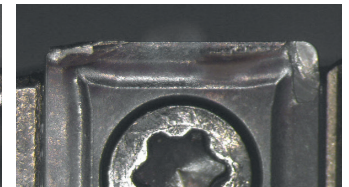
Palbit | Inner Insert



Competitor | Outer Insert

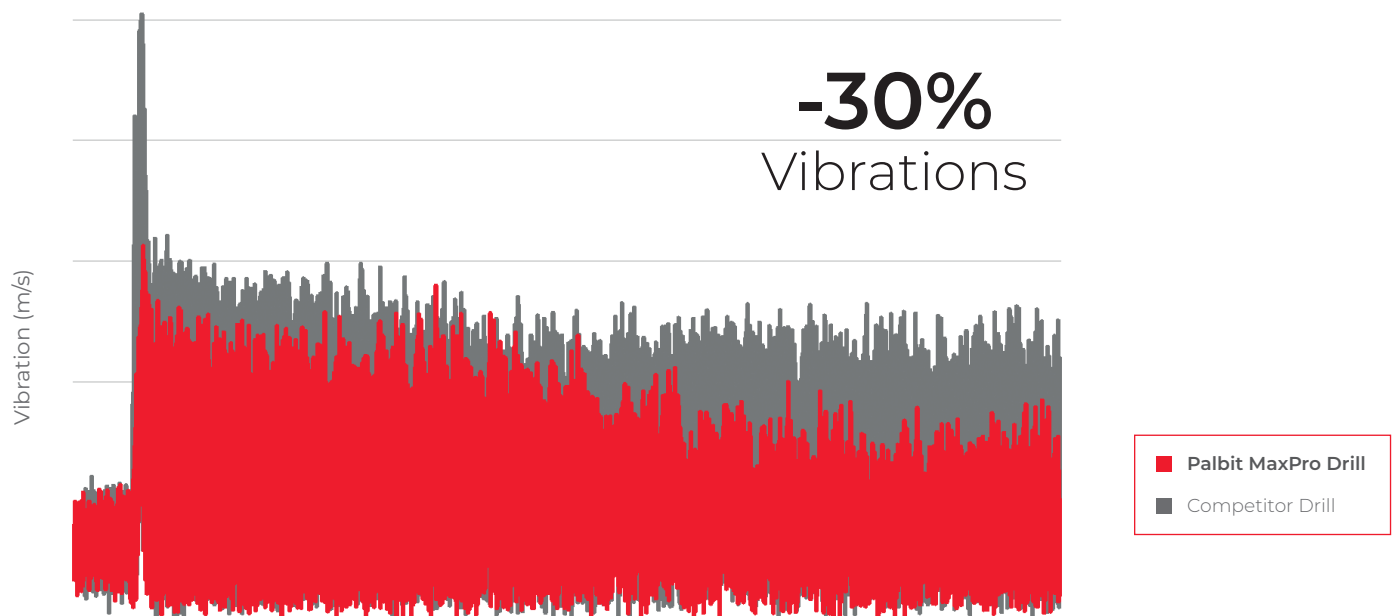


Competitor | Inner Insert



Tool wear after 16 hours of machining

■ VIBRATIONS COMPARISON

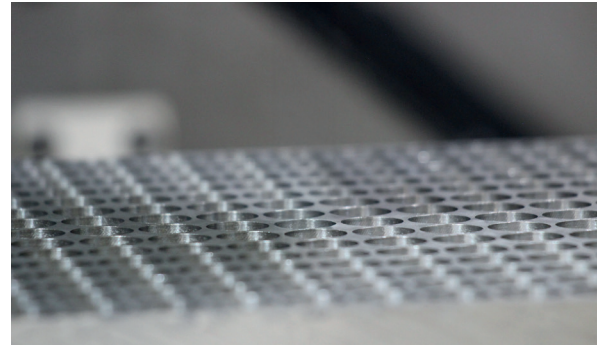


Workpiece Material: Aluminium AW2017A [Al Cu4MgSi(A)]

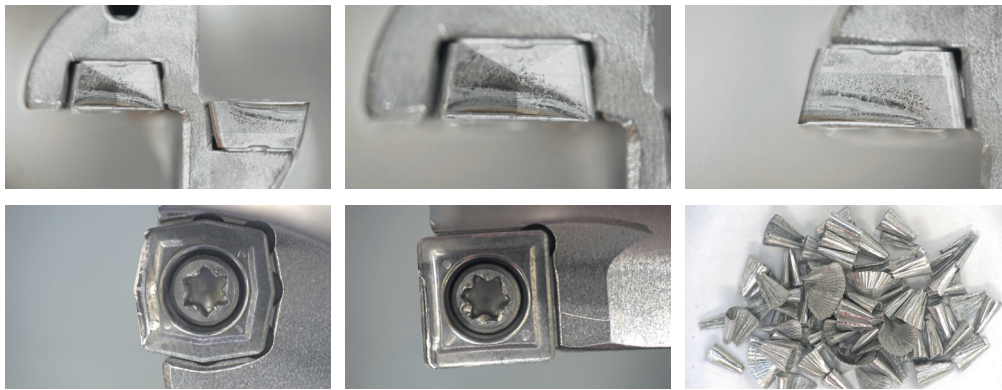
Coolant: Emulsion

TOOL LIFE

Toolholder	XCS 15020-3D
Outer Insert	SOHX 050204-LN PHT920
Inner Insert	XOHX 050204-LN PHT920
Cutting speed: Vc	700 m/min
Spindle speed: RPM	14854 rpm
Feed per tooth: fz	0,14 mm/t
Linear feed: F	2079,56 mm/min
Drilling depth : Ap	45 mm



Machined workpiece



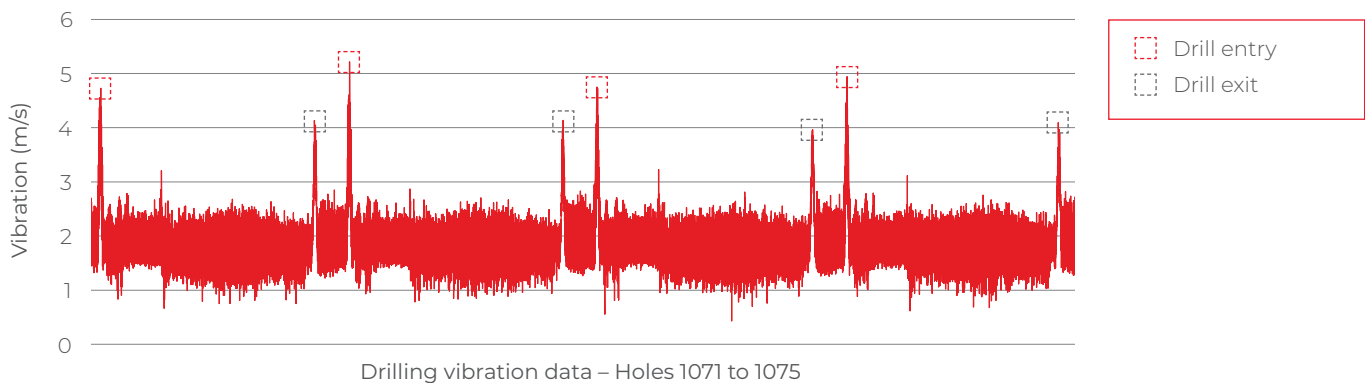
Tool wear results after drilling 1075 holes (48.375m)

4300*
holes

193,5*
m

*Per set of inserts

VIBRATIONS CHART



The tested solution delivered outstanding performance in aluminium drilling, with minimal wear, effective chip evacuation, and high process stability. These results highlight its suitability for demanding applications in the aerospace and automotive sectors, while reinforcing the value of this solution within Palbit's holemaking range.

- Minimal wear observed after 1075 holes
- Stable drilling and excellent chip evacuation
- Coated inserts, allowing extended tool life and durability
- Equivalent to drilling through ~5 Airbus A320s placed end-to-end
- Ideal for high-demand aluminium machining in automotive and aerospace industries

This level of endurance positions the solution as a high-value addition to our holemaking portfolio.

GRADE SELECTION INNER INSERT

PVD

Due to the reduced cutting speed in the central area of the drill, a tougher grade is recommended for the inner insert.

UNCOATED

Uncoated carbide with polished surface.

PHP930
P20-P40
K10-K30

PHH930
M20-M40
S20-S30

PHT920
N10-N30

PH0920
N10-N30

GRADE SELECTION OUTER INSERT

PVD

First choice for stable machining and improved surface finish.

Recommended for outer edge if chattering occurs.

CVD

First choice for high speeds and high efficiency machining, abrasion resistance and longer tool life.

UNCOATED

Uncoated carbide with polished surface.

PHP920
P10-P35
K10-K30

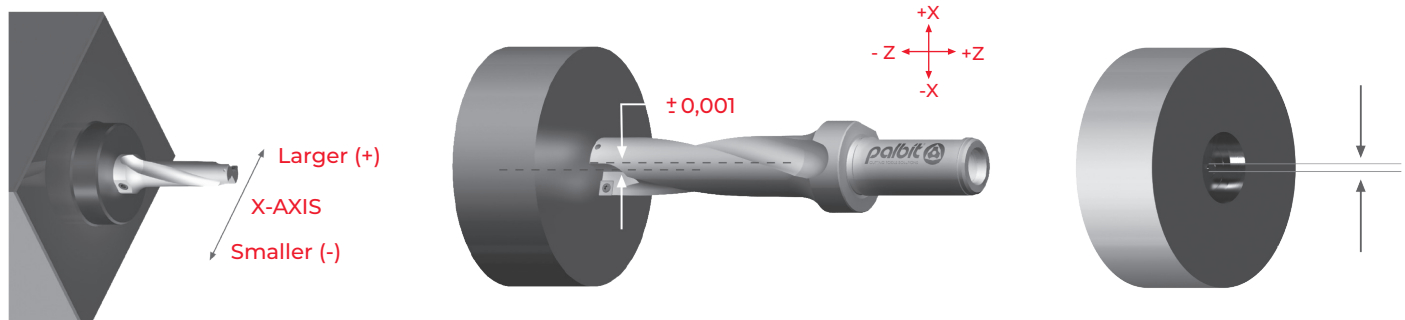
PHH920
M10-M25
S15-S30

PHT920
N10-N30

PHS130
P10-P35
K20-K40

PH0920
N10-N30

TECHNICAL INFORMATION FOR LATHE APPLICATIONS



The cutting edge of insert should be parallel to X-axis to make it possible to do offset cutting. Since a flat part on shank for side lock clamping has been made parallel with the cutting edge line of insert, operator can set the drill as per flat part of shank.

The outer insert should be located in the direction (+) of X-axis to allow offset cutting and then the inner insert should face the operator.

To check up the setting of drill before use, test it by drilling about 5mm depth and then measure the core size if it is around 0,2mm - 0,7mm.

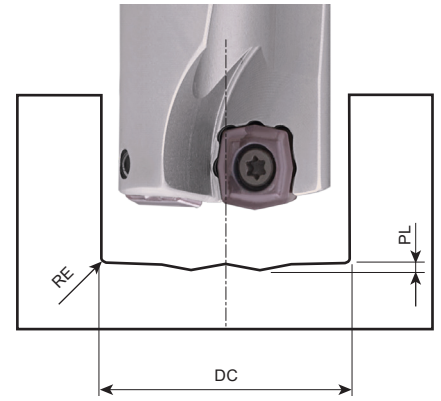
WARNING

In the course of through-hole operations, a slug or disc is formed as the tool breaks through the workpiece. When the drill is stationary while the workpiece is rotating, centrifugal force may eject this slug from the chuck. It is essential to have appropriate shielding in position to ensure the safety of bystanders.

RADIAL ADJUSTMENT Ajuste radial | Ajuste radial

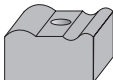
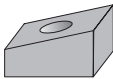
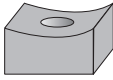
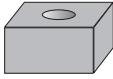
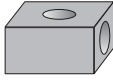
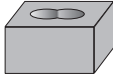
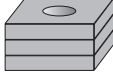
Drill diameter (Ø)	Diameter range (Ø)	Drill diameter (Ø)	Diameter range (Ø)	Drill diameter (Ø)	Diameter range (Ø)
Ø14,0	13,6~14,5	Ø28,0	27,4~28,6	Ø42,0	41,3~42,7
Ø14,5	14,1~15,0	Ø28,5	27,9~29,1	Ø42,5	41,8~43,2
Ø15,0	14,6~15,5	Ø29,0	28,4~29,6	Ø43,0	42,2~43,7
Ø15,5	15,1~16,0	Ø29,5	28,9~30,1	Ø43,5	42,7~44,2
Ø16,0	15,6~16,5	Ø30,0	29,3~30,7	Ø44,0	43,2~44,7
Ø16,5	16,0~17,0	Ø30,5	29,8~31,2	Ø44,5	43,7~45,2
Ø17,0	16,5~17,5	Ø31,0	30,3~31,7	Ø45,0	44,2~45,7
Ø17,5	17,0~18,0	Ø31,5	30,8~32,2	Ø45,5	44,7~46,2
Ø18,0	17,5~18,5	Ø32,0	31,3~32,7	Ø46,0	45,2~46,7
Ø18,5	18,0~19,0	Ø32,5	31,8~33,2	Ø46,5	45,7~47,2
Ø19,0	18,5~19,5	Ø33,0	32,3~33,7	Ø47,0	46,2~47,7
Ø19,5	19,0~20,0	Ø33,5	32,8~34,2	Ø47,5	46,7~48,2
Ø20,0	19,4~20,6	Ø34,0	33,3~34,7	Ø48,0	47,2~48,7
Ø20,5	19,9~21,1	Ø34,5	33,8~35,2	Ø48,5	47,7~49,2
Ø21,0	20,4~21,6	Ø35,0	34,3~35,7	Ø49,0	48,2~49,7
Ø21,5	20,9~22,1	Ø35,5	34,8~36,2	Ø49,5	48,7~50,2
Ø22,0	21,4~22,6	Ø36,0	35,3~36,7	Ø50,0	49,2~50,7
Ø22,5	21,9~23,1	Ø36,5	35,8~37,2	Ø51,0	50,2~51,7
Ø23,0	22,4~23,6	Ø37,0	36,3~37,7	Ø52,0	51,2~52,7
Ø23,5	22,9~24,1	Ø37,5	36,8~38,2	Ø53,0	52,2~53,7
Ø24,0	23,4~24,6	Ø38,0	37,3~38,7	Ø54,0	53,2~54,7
Ø24,5	23,9~25,1	Ø38,5	37,8~39,2	Ø55,0	54,2~55,7
Ø25,0	24,4~25,6	Ø39,0	38,3~39,7	Ø56,0	55,2~56,7
Ø25,5	24,9~26,1	Ø39,5	38,8~40,2	Ø57,0	56,2~57,7
Ø26,0	25,4~26,6	Ø40,0	39,3~40,7	Ø58,0	57,2~58,7
Ø26,5	25,9~27,1	Ø40,5	39,8~41,2	Ø59,0	58,2~59,7
Ø27,0	26,4~27,6	Ø41,0	40,3~41,7	Ø60,0	59,2~60,7
Ø27,5	26,9~28,1	Ø41,5	40,8~42,2		

BOTTOM OF BLIND HOLE Fundo do furo cego | Fondo del agujero ciego



Drill diameter (mm)	Outer insert	Inner insert	PL	RE
Ø14,0-16,0	SOKX 050204	XOKX 050204	0,4	0,4
Ø16,5-19,5	SOKX 060205	XOKX 060205	0,5	0,5
Ø20,0-24,0	SOKX 07T208	XOKX 07T208	0,5	0,8
Ø24,5-30,0	SOKX 090308	XOKX 090308	0,7	0,8
Ø31,0-35,0	SOKX 11T308	XOKX 11T308	0,8	0,8
Ø36,0-42,0	SOKX 130410	XOKX 130410	1,0	1,0
Ø43,0-50,0	SOKX 150510	XOKX 150508	1,1	1,0
Ø51,0-60,0	SOKX 180510	XOKX 180508	1,2	1,0

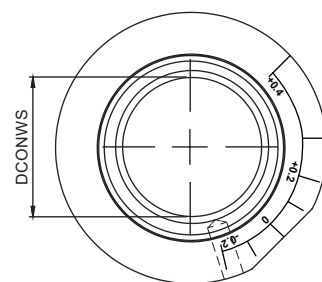
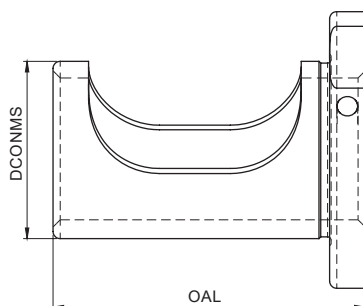
RULES & TIPS Regras e dicas | Reglas y consejos

Workpiece	Machining
 Irregular surface	<ul style="list-style-type: none"> · Decrease the feed by 25%; · Potential chipping and fracture;
 Inclined surface	<ul style="list-style-type: none"> · Decrease the feed by 50%.
 Convex / Concave surface	<ul style="list-style-type: none"> · Decrease the feed by 50% until both inserts are engaged; · Potential initial contact with the central insert identified (convex surface);
 Boring	<ul style="list-style-type: none"> · Decrease the feed by 50%.
 Crossing holes	<ul style="list-style-type: none"> · Decrease the feed by 50% in the overlapped section.
 Chain holemaking	<ul style="list-style-type: none"> · Decrease the feed by 50%.
 Stack holemaking	<ul style="list-style-type: none"> · Decrease the feed by 25%; · Potential chipping and fracture;

Failure	Solution
 <p>Chattering</p>	<ul style="list-style-type: none">• Reduce the cutting speed and feed rate;• Ensure stable clamping;• Set the drill overhang;• Verify the machine torque;
 <p>Poor chip evacuation</p>	<ul style="list-style-type: none">• If long chip: Increase the cutting speed and feed rate.• If short chip: Reduce the cutting speed and feed rate, and increase the coolant pressure.
 <p>Poor surface quality</p>	<ul style="list-style-type: none">• Establish the cutting condition for improved chip control;• Reduce the feed rates or increase the cutting speed;• Increase the coolant flow and verify the coolant evacuation;• Shorten the overhang of the drill and ensure a more stable clamping;
 <p>Excessive wear or chipping</p>	<ul style="list-style-type: none">• Verify the cutting condition;• Increase the coolant flow and verify the coolant evacuation;• Shorten the overhang of the drill and ensure a more stable clamping;• Consider changing the insert grade;

ECENTRIC SLEEVES Mangas excêntricas | Casquillos excéntricos

ECENTRIC SLEEVES Mangas excêntricas | Casquillos excéntricos



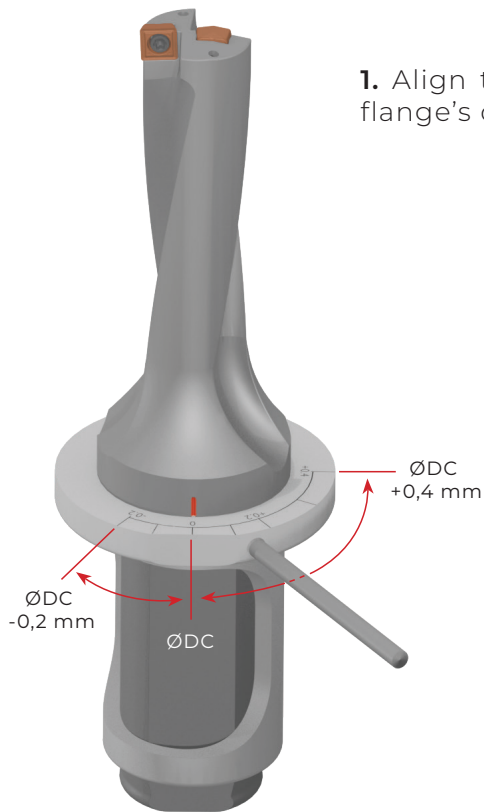
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)			Stock
		DCONWS	DCONMS	OAL	
214345100	2025-L44	20	25	44	⊗
214345200	2532-L46	25	32	46	⊗
214345300	3240-L55	32	40	55	⊗
214345400	4050-L62	40	50	62	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

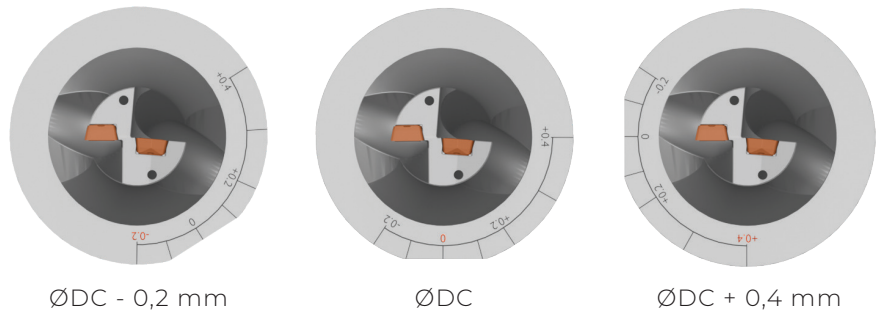


MOUNTING PROCEDURE Procedimentos de montagem | Procedimiento de montaje



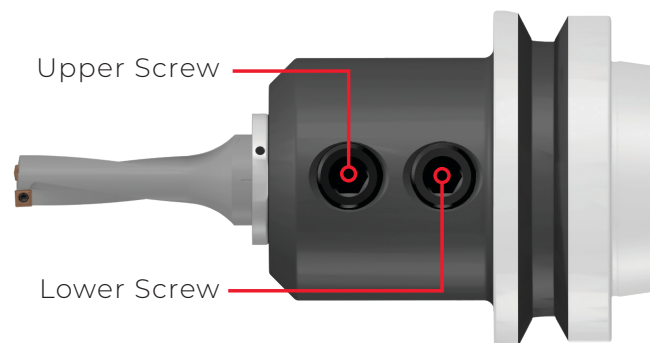
1. Align the adjustment markings perpendicular to the flat on the drill flange's circumference.

2. Rotation of the sleeve is achieved through the hole on the eccentric flange.



3. Ensure the upper screw on the chuck is firmly tightened against the Weldon flat of the drill.

4. Tighten the lower screw on the chuck just enough to contact the drill.



NOTES: Reduce the feed rate by approximately 20% for 2D and 3D drills, and by 30% for 4D and 5D drills.
Designed for use with DIN 1835.
Not for use with lathe tools.

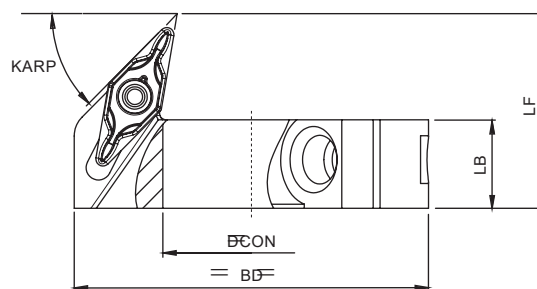


Check the QrCode for more information

CHAMFERING RINGS Anéis de chanfragem | Anillos de biselado



KAPR=45°



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Insert	Stock
		DC DRILL	DCON	BD	LB	LF		
184349800	CHR 130 VB1103	13,0	12,5	32,5	10,0	22,0	VB. 1103	○
184346300	CHR 135 VB1103	13,5	13,0	33,0	10,0	22,0	VB. 1103	⊗
184346400	CHR 140 VB1103	14,0	13,5	33,5	10,0	22,0	VB. 1103	○
184346500	CHR 145 VB1103	14,5	14,0	34,0	10,0	22,0	VB. 1103	⊗
184346600	CHR 150 VB1103	15,0	14,5	34,5	10,0	22,0	VB. 1103	○
184346700	CHR 160 VB1103	15,5-16	15,0	35,0	10,0	22,0	VB. 1103	⊗
184346800	CHR 165 VB1103	16,5	15,5	35,5	10,0	22,0	VB. 1103	○
184346900	CHR 170 VB1103	17,0	16,0	36,0	10,0	22,0	VB. 1103	⊗
184347000	CHR 175 VB1103	17,5	16,5	36,5	10,0	22,0	VB. 1103	○
184347100	CHR 180 VB1103	18,0	17,0	37,0	10,0	22,0	VB. 1103	⊗
184347200	CHR 185 VB1103	18,5	17,5	37,5	10,0	22,0	VB. 1103	○
184347300	CHR 190 VB1103	19,0	18,0	38,0	10,0	22,0	VB. 1103	⊗
184347400	CHR 195 VB1103	19,5	18,5	38,5	10,0	22,0	VB. 1103	○
184347500	CHR 200 VB1103	20,0	19,0	39,0	10,0	22,0	VB. 1103	⊗
184347600	CHR 205 VB1103	20,5	19,5	39,5	10,0	22,0	VB. 1103	○
184347700	CHR 210 VB1103	21,0	20,0	40,0	10,0	22,0	VB. 1103	⊗
184347800	CHR 215 VB1103	21,5	20,5	40,5	10,0	22,0	VB. 1103	○
184347900	CHR 220 VB1103	22,0	21,0	41,0	10,0	22,0	VB. 1103	⊗
184348000	CHR 225 VB1103	22,5	21,5	41,5	10,0	22,0	VB. 1103	○
184348100	CHR 230 VB1103	23,0	22,0	42,0	10,0	22,0	VB. 1103	⊗
184348200	CHR 235 VB1103	23,5	22,5	42,5	10,0	22,0	VB. 1103	○
184348300	CHR 240 VB1103	24,0	23,0	43,0	10,0	22,0	VB. 1103	⊗
184348400	CHR 245 VB1103	24,5	23,5	43,5	10,0	22,0	VB. 1103	○
184348500	CHR 250 VB1103	25,0	24,0	44,0	10,0	22,0	VB. 1103	⊗
184348600	CHR 255 VB1103	25,5	24,5	44,5	10,0	22,0	VB. 1103	○
184348700	CHR 260 VB1103	26,0	25,0	45,0	10,0	22,0	VB. 1103	⊗
184348800	CHR 265 VB1103	26,5	25,5	45,5	10,0	22,0	VB. 1103	○
184348900	CHR 270 VB1103	27,0	26,0	46,0	10,0	22,0	VB. 1103	⊗
184349000	CHR 275 VB1103	27,5	26,5	46,5	10,0	22,0	VB. 1103	○
184349100	CHR 280 VB1103	28,0	27,0	47,0	10,0	22,0	VB. 1103	⊗
184349200	CHR 285 VB1103	28,5	27,5	47,5	10,0	22,0	VB. 1103	○
184349300	CHR 290 VB1103	29,0	28,0	48,0	10,0	22,0	VB. 1103	⊗
184349400	CHR 295 VB1103	29,5	28,5	48,5	10,0	22,0	VB. 1103	○
184349500	CHR 300 VB1103	30,0	29,0	49,0	10,0	22,0	VB. 1103	⊗
184349600	CHR 305 VB1103	30,5	29,5	49,5	10,0	22,0	VB. 1103	○
184349700	CHR 310 VB1103	31,0	30,0	50,0	10,0	22,0	VB. 1103	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: For aluminium alloys, it is recommended to use a VCGT 1103.-LN insert.

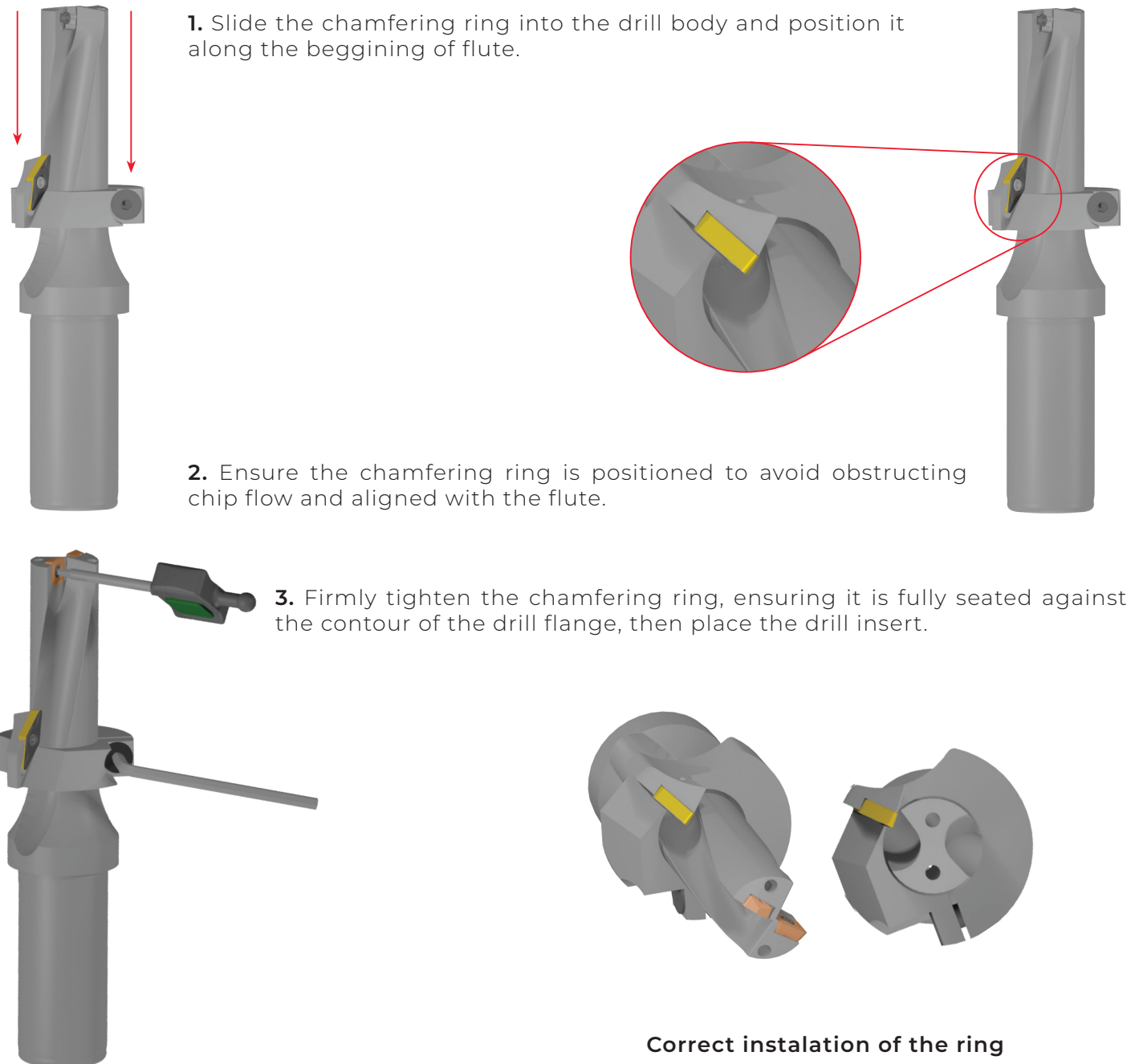
CHAMFERING RINGS

Anéis de chanfragem | Anillos de biselado

SPARE PARTS Acessórios | Repuestos

Ring Reference	Insert Screw	Key (Torx)	Hex Key	Adjustment screw
CHR 130 - 310	P02507IP	XT08IP	SS03	D0501496
Order code	290096000	290096500	290038400	290099100

MOUNTING PROCEDURE Procedimentos de montagem | Procedimiento de montaje



Check the QrCode for more information

2D | 3D | 4D | 5D

MAXPRO DRILL

Maximum performance to a great drilling experience



Check the QrCode for more information



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