

INDEXABLE DRILLS

Pages 471-493



Indexable
Drills

INDEXABLE DRILLS	PAGES
WDX Drills	
WDX Features & Benefits	472
WDXT Insert Selction Guide.....	472
WDX 2XD - 5XD (INCH) & 4XD Side Port	473-475
WDX 2XD - 5XD (<i>METRIC</i>)	476-477
Cutting Conditions	478-479
PDL/PCT	480-483
SR Reamer Series	
SR Reamer	484-493



FEATURES & BENEFITS

WDX

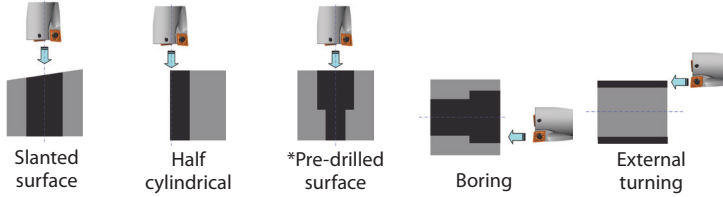
WDX Features & Benefits



■ Features & Benefits

- New balanced design for stable drilling
- Three chipbreakers available for superior chip control
- Four-cornered insert design for easy tool management
- **New grades:** DLC coated DL1500 inserts for aluminum and ACP100 for steel now available

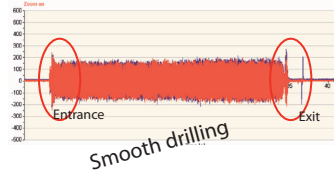
Applications



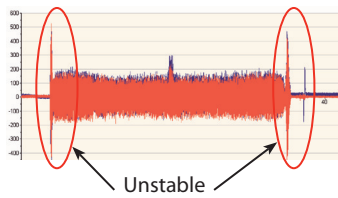
*For pre-drilled surface: secondary OD must be at least 1/16 larger than drill diameter.

Stable Drilling

SumiDrill WDX type

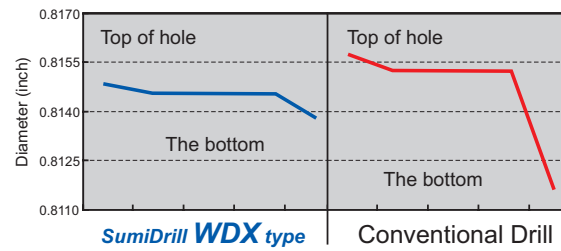


Conventional Drill

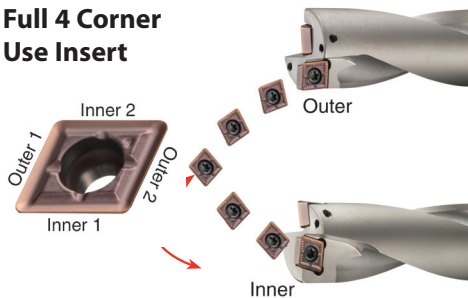


Stable hole accuracy

Hole Accuracy Comparison

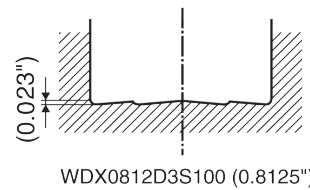


Full 4 Corner Use Insert



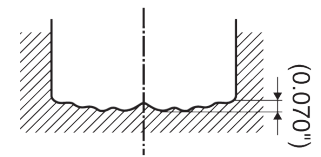
Flat Bottom Surface

SumiDrill WDX type



WDX0812D3S100 (0.8125")

Conventional Drill



Conventional drill (0.8125")

■ Hardware

Applicable Holders		Screw	Wrench	Wrench	Recommended Tightening Torque (N·m)	Recommended Tightening Torque (in / lbs)	
Inch	Metric	WDX0562D□S075 to WDX0594D□S075	WDX130D□S20 to WDX150D□S20	BFTX01604N	TRX06	0.3	2.65
		WDX0625D□S100 to WDX0687D□S100	WDX155D□S20 to WDX180D□S25	BFTX0204N	TRX06	0.5	4.43
		WDX0750D□S100 to WDX0875D□S100	WDX185D□S25 to WDX225D□S25	BFTY02206	TRD07	1.0	8.85
		WDX0937D□S125 to WDX1125D□S125	WDX230D□S25 to WDX285D□S32	BFTX02506N	TRD08	1.5	13.28
		WDX1187D□S125 to WDX1437D□S150	WDX290D□S32 to WDX360D□S40	BFTX03584	TRD15	3.5	30.98
		WDX1500D□S150 to WDX1750D□S150	WDX370D□S40 to WDX450D□S40	BFTX0511N	TRD20	5.0	44.25
		WDX1812D□S150 to WDX2625D□S150	WDX460D□S40 to WDX680D□S40	BFTX0615N	TRD25	5.0	44.25



Insert Selection – WDX Type Insert Series Offers Wide Selection

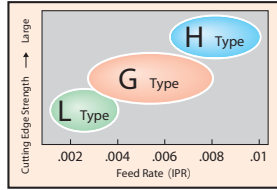
4

Four material grades

Grade	ACP100	ACP300	ACK300	DL1500
Work Material				
P Steel (General Machining)	○	○		
P Steel (High-Speed Machining)			○	
M Stainless Steel	○	○		
K Cast Iron			○	
N Non-Ferrous Metal				○

3

Three types of chip breakers



10

Ten possible combinations

	ACP100	ACP300	ACK300	DL1500
P Steel (General Machining)	L Type	L Type	L Type	
P Steel (High-Speed Machining)				N
M Stainless Steel	G Type	G Type	G Type	
K Cast Iron				
N Non-Ferrous Metal				

2nd Recommendation
P Steel

P Steel

Low Feed, Chip Management Type

L type
ACP300
ACP100

- For machining SS400, SCM415, SCM420, etc.
- In case of chip control problem, high speed with low feed rate is recommended.
- In case of vibration due to burnt chips, reduce the feed rate.

P Steel

Strong Edge Type

H type ACP300

- For interrupted machining (at entrance/exit) of angled surfaces, reduce the feed rate (to approximately f 0.05) at each interruption.
- Ideal to use when the cutting edge is weakened due to machining hardened material (heat treatment)

P Steel

General Purpose

G type ACK300

For application where severe flank wear may be caused by machining general alloy or alloy steel

P Steel

Low Feed, Chip Management Type

L type ACK300

For low feed rate conditions

P Steel Improvement of chip control (low-carbon steel, etc.)

P Steel Reduction of initial chipping (caused by interrupted machining, machining hard material, etc.)

P Steel Lack of wear resistance

1st Recommendation
P Steel, M Stainless Steel, K Cast Iron, N Non-Ferrous Metal

Breaker

General Purpose

G type

Grade

P Steel, **M Stainless Steel**
ACP300
ACP100

For machining general steel, alloy steel or stainless steel

K Cast Iron
ACK300

For machining cast iron

N Non-Ferrous Metal
DL1500

For machining non-ferrous metals

M Stainless Steel Improvement of chip control

K Cast Iron Reduction of initial chipping (interrupted/high feed rate machining, etc.)

2nd Recommendation
M Stainless Steel, K Cast Iron

M Stainless Steel

Low feed, chip management type

L type ACP300
ACP100

- L Type ACP300 is ideal to solve chip evacuation problem caused by low cutting speed and low feed rate due to facility reasons.

K Cast Iron

Strong Edge Type

H type ACK300

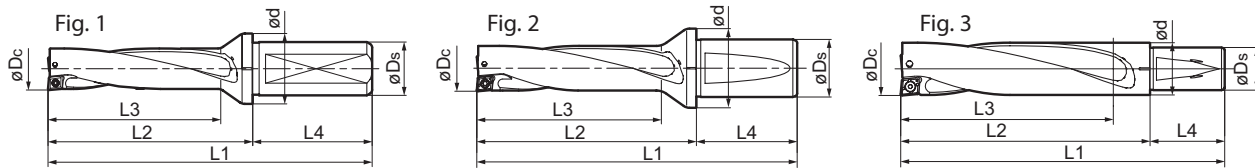
- Similar to steel machining, H Type ACK300 is ideal for interrupted machining on angled surfaces.
- With strong edges, it is ideal for machining workpieces at high feed rate.

Indexable Drills



2XD & 3XD-INCH WDX

WDX Indexable Coolant Through Drills



SumiDrill WDX Bodies - 2XD - INCH												
Catalog Number	Stock	øDc	L1	L2	L3	ød	øDs	L4	Fig.	Screw	Wrench	Insert
WDX0562D2S075	●	0.5625	3.8330	1.8330	1.2420	1.1020	0.7500	2.0000	1	BFTX01604N	TRX06	WDX042004
WDX0594D2S075	●	0.5937	3.8960	1.8960	1.3060	1.1020	0.7500	2.0000		BFTX01604N	TRX06	WDX042004
WDX0625D2S100	●	0.6250	4.4590	1.9590	1.3680	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0656D2S100	●	0.6562	4.5210	2.0210	1.4300	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0687D2S100	●	0.6875	4.5830	2.0830	1.4920	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0750D2S100	●	0.7500	4.7090	2.2090	1.6180	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0787D2S100	●	0.7870	4.7830	2.2830	1.6920	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0812D2S100	●	0.8125	4.8340	2.3340	1.7430	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0875D2S100	●	0.8750	4.9590	2.4590	1.8680	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0937D2S125	●	0.9375	5.2020	2.7020	1.9930	1.6140	1.2500	2.5000		2	BFTX02506N	TRD08
WDX1000D2S125	●	1.0000	5.3270	2.8270	2.1180	1.6140	1.2500	2.5000	BFTX02506N		TRD08	WDX073506
WDX1062D2S125	●	1.0625	5.9520	2.9520	2.2430	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1125D2S125	●	1.1250	6.0770	3.0770	2.3680	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1187D2S125	●	1.1875	6.3590	3.3590	2.5320	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1250D2S125	●	1.2500	6.4840	3.4840	2.6570	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1312D2S150	●	1.3125	6.7270	3.7270	2.7820	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1375D2S150	●	1.3750	6.8520	3.8520	2.9070	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1437D2S150	●	1.4375	6.9770	3.9770	3.0320	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1500D2S150	●	1.5000	7.1020	4.1020	3.1570	1.9490	1.5000	3.0000	BFTX0511N		TRD20	WDX125012
WDX1562D2S150	●	1.5625	7.2260	4.2260	3.2810	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1625D2S150	●	1.6250	7.3520	4.3520	3.4070	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1687D2S150	●	1.6875	7.4780	4.4780	3.5330	1.9490	1.5000	3.0000	3	BFTX0511N	TRD20	WDX125012
WDX1750D2S150	●	1.7500	7.6020	4.6020	3.6570	1.9490	1.5000	3.0000		BFTX0511N	TRD20	WDX125012
WDX1812D2S150	●	1.8125	7.7280	4.7280	3.7830	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1875D2S150	●	1.8750	7.8520	4.8520	3.9070	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1937D2S150	●	1.9375	7.9780	4.9780	4.0330	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2000D2S150	●	2.0000	8.1020	5.1020	4.1570	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2125D2S150	●	2.1250	8.3520	5.3520	4.4070	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2250D2S150	●	2.2500	9.0750	6.0750	4.8150	2.1730	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2375D2S150	●	2.3750	9.3270	6.3270	5.0670	2.2950	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2500D2S150	●	2.5000	9.5750	6.5750	5.3150	2.4210	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2625D2S150	●	2.6250	9.8270	6.8270	5.5670	2.5470	1.5000	3.0000	BFTX0615N	TRD25	WDX186012	

● = USA Stocked item

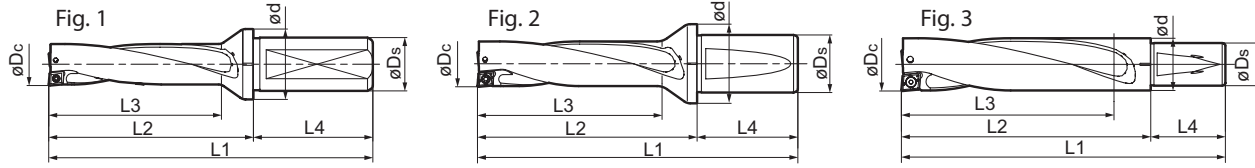
SumiDrill WDX Bodies - 3XD - INCH												
Catalog Number	Stock	øDc	L1	L2	L3	ød	øDs	L4	Fig.	Screw	Wrench	Insert
WDX0562D3S075	●	0.5625	4.3950	2.3950	1.8040	1.1020	0.7500	2.0000	1	BFTX01604N	TRX06	WDX042004
WDX0594D3S075	●	0.5937	4.4910	2.4910	1.9000	1.1020	0.7500	2.0000		BFTX01604N	TRX06	WDX042004
WDX0625D3S100	●	0.6250	5.0840	2.5840	1.9930	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0656D3S100	●	0.6562	5.1770	2.6770	2.0860	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0687D3S100	●	0.6875	5.2700	2.7700	2.1790	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0750D3S100	●	0.7500	5.4590	2.9590	2.3680	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0787D3S100	●	0.7870	5.5700	3.0700	2.4790	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0812D3S100	●	0.8125	5.6460	3.1460	2.5660	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0875D3S100	●	0.8750	5.8340	3.3340	2.7430	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0937D3S125	●	0.9375	6.1390	3.6390	2.9310	1.6140	1.2500	2.5000		2	BFTX02506N	TRD08
WDX1000D3S125	●	1.0000	6.3270	3.8270	3.1180	1.6140	1.2500	2.5000	BFTX02506N		TRD08	WDX073506
WDX1062D3S125	●	1.0625	7.0140	4.0140	3.3060	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1125D3S125	●	1.1250	7.2020	4.2020	3.4930	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1187D3S125	●	1.1875	7.5470	4.5470	3.7200	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1250D3S125	●	1.2500	7.7340	4.7340	3.9070	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1312D3S150	●	1.3125	8.0400	5.0400	4.0950	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1375D3S150	●	1.3750	8.2270	5.2270	4.2820	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1437D3S150	●	1.4375	8.4150	5.4150	4.4700	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1500D3S150	●	1.5000	8.8780	5.8780	4.6970	1.9490	1.5000	3.0000	BFTX0511N		TRD20	WDX125012
WDX1562D3S150	●	1.5625	9.0640	6.0640	4.8830	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1625D3S150	●	1.6250	9.2530	6.2530	5.0720	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1687D3S150	●	1.6875	9.4420	6.4420	5.2610	1.9490	1.5000	3.0000	3	BFTX0511N	TRD20	WDX125012
WDX1750D3S150	●	1.7500	9.6280	6.6280	5.4470	1.9490	1.5000	3.0000		BFTX0511N	TRD20	WDX125012
WDX1812D3S150	●	1.8125	9.8170	6.8170	5.6360	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1875D3S150	●	1.8750	10.0030	7.0030	5.8820	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1937D3S150	●	1.9375	10.1920	7.1920	6.0110	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2000D3S150	●	2.0000	10.3780	7.3780	6.1970	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2125D3S150	●	2.1250	10.7530	7.7530	6.5720	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2250D3S150	●	2.2500	11.3270	8.3270	7.0670	2.1730	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2375D3S150	●	2.3750	11.7010	8.7010	7.4410	2.2950	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2500D3S150	●	2.5000	12.0750	9.0750	7.8150	2.4210	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2625D3S150	●	2.6250	12.4490	9.4490	8.1890	2.5470	1.5000	3.0000	BFTX0615N	TRD25	WDX186012	

● = USA Stocked item



WDX Indexable
Coolant Through Drills

4XD & 5XD-INCH
WDX



SumiDrill WDX Bodies - 4XD - INCH

Catalog Number	Stock	øDc	L1	L2	L3	ød	øDs	L4	Fig.	Screw	Wrench	Insert
WDX0562D4S075	●	0.5625	4.9570	2.9570	2.3660	1.1020	0.7500	2.0000	1	BFTX01604N	TRX06	WDX042004
WDX0594D4S075	●	0.5937	5.0850	3.0850	2.4940	1.1020	0.7500	2.0000		BFTX01604N	TRX06	WDX042004
WDX0625D4S100	●	0.6250	5.7090	3.2090	2.6180	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0656D4S100	●	0.6562	5.8330	3.3330	2.7420	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0687D4S100	●	0.6875	5.9570	3.4570	2.8660	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0750D4S100	●	0.7500	6.2090	3.7090	3.1180	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0787D4S100	●	0.7870	6.3570	3.8570	3.2660	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0812D4S100	●	0.8125	6.4590	3.9590	3.3680	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0875D4S100	●	0.8750	6.7090	4.2090	3.6180	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0937D4S125	●	0.9375	7.0770	4.5770	3.8680	1.6140	1.2500	2.5000		2	BFTX02506N	TRD08
WDX1000D4S125	●	1.0000	7.3270	4.8270	4.1180	1.6140	1.2500	2.5000	BFTX02506N		TRD08	WDX073506
WDX1062D4S125	●	1.0625	8.0770	5.0770	4.3680	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1125D4S125	●	1.1250	8.3270	5.3270	4.6180	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1187D4S125	●	1.1875	8.7340	5.7340	4.9070	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1250D4S125	●	1.2500	8.9840	5.9840	5.1570	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1312D4S150	●	1.3125	9.3520	6.3520	5.4070	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1375D4S150	●	1.3750	9.6020	6.6020	5.6570	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1437D4S150	●	1.4375	9.8520	6.8520	5.9070	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1500D4S150	●	1.5000	10.3780	7.3780	6.1970	1.9490	1.5000	3.0000	BFTX0511N		TRD20	WDX125012
WDX1562D4S150	●	1.5625	10.6260	7.6260	6.4450	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1625D4S150	●	1.6250	10.8780	7.8780	6.6970	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1687D4S150	●	1.6875	11.1300	8.1300	6.9490	1.9490	1.5000	3.0000	3	BFTX0511N	TRD20	WDX125012
WDX1750D4S150	●	1.7500	11.3780	8.3780	7.1970	1.9490	1.5000	3.0000		BFTX0511N	TRD20	WDX125012
WDX1812D4S150	●	1.8125	11.6300	8.6300	7.4490	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1875D4S150	●	1.8750	11.8780	8.8780	7.6970	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX1937D4S150	●	1.9375	12.1300	9.1300	7.9490	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2000D4S150	●	2.0000	12.3780	9.3780	8.1970	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2125D4S150	●	2.1250	12.8780	9.8780	8.6970	1.9490	1.5000	3.0000		BFTX0615N	TRD25	WDX156012
WDX2250D4S150	●	2.2500	13.5750	10.5750	9.3150	2.1730	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2375D4S150	●	2.3750	14.0750	11.0750	9.8150	2.2950	1.5000	3.0000		BFTX0615N	TRD25	WDX186012
WDX2500D4S150	●	2.5000	14.5750	11.5750	10.3150	2.4210	1.5000	3.0000		BFTX0615N	TRD25	WDX186012

● = USA Stocked item

SumiDrill WDX Bodies - 5XD* - INCH

Catalog Number	Stock	øDc	L1	L2	L3	ød	øDs	L4	Fig.	Screw	Wrench	Insert
WDX0562D5S075	●	0.5620	5.5190	3.5190	2.9280	1.1020	0.7500	2.0000	1	BFTX01604N	TRX06	WDX042004
WDX0594D5S075	●	0.5940	5.6790	3.6790	3.0880	1.1020	0.7500	2.0000		BFTX01604N	TRX06	WDX042004
WDX0625D5S100	●	0.6250	6.3340	3.8340	3.2430	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0656D5S100	●	0.6560	6.4890	3.9890	3.3980	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0687D5S100	●	0.6870	6.6440	4.1440	3.5530	1.2600	1.0000	2.5000		BFTX0204N	TRX06	WDX052504
WDX0750D5S100	●	0.7500	6.9590	4.4590	3.8680	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0787D5S100	●	0.7870	7.1440	4.6440	4.0530	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0812D5S100	●	0.8120	7.2690	4.7690	4.1780	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0875D5S100	●	0.8750	7.5840	5.0840	4.4930	1.2990	1.0000	2.5000		BFTY02206	TRD07	WDX063006
WDX0937D5S125	●	0.9370	8.0120	5.5120	4.8030	1.6140	1.2500	2.5000		2	BFTX02506N	TRD08
WDX1000D5S125	●	1.0000	8.3270	5.8270	5.1180	1.6140	1.2500	2.5000	BFTX02506N		TRD08	WDX073506
WDX1062D5S125	●	1.0620	9.1370	6.1370	5.4280	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1125D5S125	●	1.1250	9.4520	6.4520	5.7430	1.6140	1.2500	3.0000	BFTX02506N		TRD08	WDX073506
WDX1187D5S125	●	1.1870	9.9200	6.9200	6.0930	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1250D5S125	●	1.2500	10.2350	7.2350	6.4080	1.9680	1.2500	3.0000	BFTX03584		TRX15	WDX094008
WDX1312D5S150	●	1.3120	10.6630	7.6630	6.7180	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1375D5S150	●	1.3750	10.9780	7.9780	7.0330	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1437D5S150	●	1.4370	11.2880	8.2880	7.3430	2.1260	1.5000	3.0000	BFTX03584		TRX15	WDX094008
WDX1500D5S150	●	1.5000	11.8780	8.8780	7.6970	1.9490	1.5000	3.0000	BFTX0511N		TRD20	WDX125012
WDX1562D5S150	●	1.5620	12.1880	9.1880	8.0070	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1625D5S150	●	1.6250	12.5030	9.5030	8.3220	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1687D5S150	●	1.6870	12.8130	9.8130	8.6320	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1750D5S150	●	1.7500	13.1280	10.1280	8.9470	1.9490	1.5000	3.0000	BFTX0511N	TRD20	WDX125012	
WDX1812D5S150	●	1.8120	13.4380	10.4380	9.2570	1.9490	1.5000	3.0000	BFTX0615N	TRD25	WDX156012	
WDX1875D5S150	●	1.8750	13.7530	10.7530	9.5720	1.9490	1.5000	3.0000	BFTX0615N	TRD25	WDX156012	
WDX1937D5S150	●	1.9370	14.0630	11.0630	9.8820	1.9490	1.5000	3.0000	BFTX0615N	TRD25	WDX156012	
WDX2000D5S150	●	2.0000	14.3780	11.3780	10.1970	1.9490	1.5000	3.0000	BFTX0615N	TRD25	WDX156012	
WDX2125D5S150	●	2.1250	15.0030	12.0030	10.8220	1.9490	1.5000	3.0000	BFTX0615N	TRD25	WDX156012	

● = USA Stocked item

*NOTE: Coolant adapter sleeves for lathes are available upon request.

** 5XD WDX Drills have 2 coolant holes in the back of the drill and no single threaded port



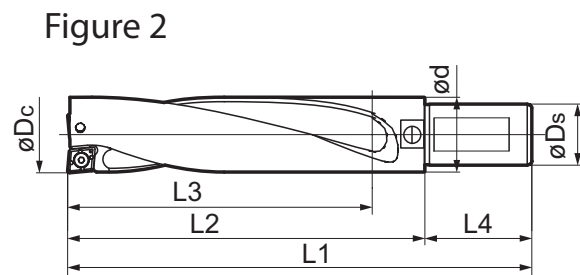
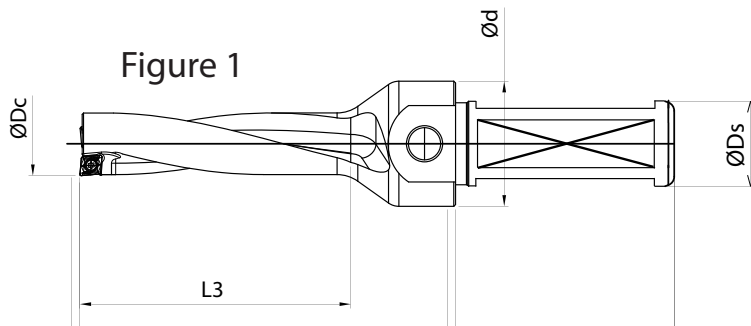
4XD Side Port - INCH WDX

WDX Indexable Coolant Through Drills

Sumitomo Electric Carbide, Inc. is now offering WDX-L Indexable Drill with side port coolant. Due to not all spindles being coolant-thru, the WDX-L allows for customers to use coolant through the side port.

Features & Benefits

- Diameters available in 0.5625" to 2.5000"
- WDX-L uses WDXT inserts (same as WDX style)
- Available in 4XD style



Indexable
Drills

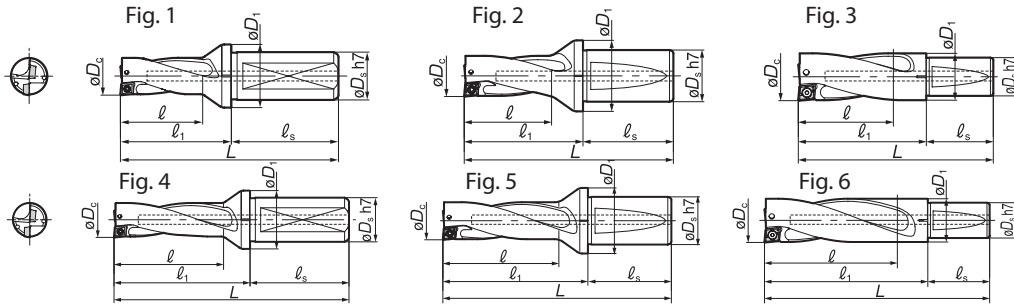
SumiDrill WDX Bodies - 4XD Side Port - INCH

Catalog Number	Stock	øDc	L1	L2	L3	ød	øDs	L4	Screw	Wrench	Insert	Pipe Plug	Fig.
WDX0562D4S100-L	●	0.5625	5.350	3.350	2.366	1.102	1.000	2.000	BFTX01604N	TRX06	WDXT042004	XP02	1
WDX0594D4S100-L	●	0.5937	5.478	3.478	2.494	1.102	1.000	2.000	BFTX01604N	TRX06	WDXT042004	XP02	
WDX0625D4S100-L	●	0.6250	6.181	3.681	2.618	1.260	1.000	2.500	BFTX0204N	TRX06	WDXT052504	XP04	
WDX0656D4S100-L	●	0.6562	6.305	3.805	2.742	1.260	1.000	2.500	BFTX0204N	TRX06	WDXT052504	XP04	
WDX0687D4S100-L	●	0.6875	6.429	3.929	2.866	1.260	1.000	2.500	BFTX0204N	TRX06	WDXT052504	XP04	
WDX0750D4S100-L	●	0.7500	6.681	4.181	3.118	1.299	1.000	2.500	BFTY02206	TRD07	WDXT063006	XP04	
WDX0787D4S100-L	●	0.7870	6.829	4.329	3.266	1.299	1.000	2.500	BFTY02206	TRD07	WDXT063006	XP04	
WDX0812D4S100-L	●	0.8125	6.931	4.431	3.368	1.299	1.000	2.500	BFTY02206	TRD07	WDXT063006	XP04	
WDX0875D4S100-L	●	0.8750	7.181	4.681	3.618	1.299	1.000	2.500	BFTY02206	TRD07	WDXT063006	XP04	
WDX0937D4S125-L	●	0.9375	7.549	5.049	3.868	1.614	1.250	2.500	BFTX02506N	TRD08	WDXT073506	XP04	
WDX1000D4S125-L	●	1.0000	7.799	5.299	4.118	1.614	1.250	2.500	BFTX02506N	TRD08	WDXT073506	XP04	
WDX1062D4S125-L	●	1.0625	8.549	5.549	4.368	1.614	1.250	3.000	BFTX02506N	TRD08	WDXT073506	XP04	
WDX1125D4S125-L	●	1.1250	8.799	5.799	4.618	1.614	1.250	3.000	BFTX02506N	TRD08	WDXT073506	XP04	
WDX1187D4S125-L	●	1.1875	9.206	6.206	4.907	1.968	1.250	3.000	BFTX03584	TRX15	WDXT094008	XP04	
WDX1250D4S125-L	●	1.2500	9.456	6.456	5.157	1.968	1.250	3.000	BFTX03584	TRX15	WDXT094008	XP04	
WDX1312D4S150-L	●	1.3125	9.824	6.824	5.407	2.126	1.500	3.000	BFTX03584	TRX15	WDXT094008	XP04	
WDX1375D4S150-L	●	1.3750	10.074	7.074	5.657	2.126	1.500	3.000	BFTX03584	TRX15	WDXT094008	XP04	
WDX1437D4S150-L	●	1.4375	10.324	7.324	5.907	2.126	1.500	3.000	BFTX03584	TRX15	WDXT094008	XP04	
WDX1500D4S150-L	●	1.5000	10.850	7.850	6.197	1.949	1.500	3.000	BFTX0511N	TRD20	WDXT125012	XP04	
WDX1562D4S150-L	●	1.5625	11.098	8.098	6.445	1.949	1.500	3.000	BFTX0511N	TRD20	WDXT125012	XP04	
WDX1625D4S150-L	●	1.6250	11.350	8.350	6.697	1.949	1.500	3.000	BFTX0511N	TRD20	WDXT125012	XP04	
WDX1687D4S150-L	●	1.6875	11.602	8.602	6.949	1.949	1.500	3.000	BFTX0511N	TRD20	WDXT125012	XP04	
WDX1750D4S150-L	●	1.7500	11.850	8.850	7.197	1.949	1.500	3.000	BFTX0511N	TRD20	WDXT125012	XP04	
WDX1812D4S150-L	●	1.8125	12.102	9.102	7.449	1.949	1.500	3.000	BFTX0615N	TRD25	WDXT156012	XP04	
WDX1875D4S150-L	●	1.8750	12.350	9.350	7.697	1.949	1.500	3.000	BFTX0615N	TRD25	WDXT156012	XP04	
WDX1937D4S150-L	●	1.9375	12.602	9.602	7.949	1.949	1.500	3.000	BFTX0615N	TRD25	WDXT156012	XP04	
WDX2000D4S150-L	●	2.0000	12.850	9.850	8.197	1.949	1.500	3.000	BFTX0615N	TRD25	WDXT156012	XP04	
WDX2125D4S150-L	●	2.1250	13.350	10.350	8.697	1.949	1.500	3.000	BFTX0615N	TRD25	WDXT156012	XP04	
WDX2250D4S150-L	●	2.2500	14.047	11.047	9.315	2.173	1.500	3.000	BFTX0615N	TRD25	WDXT186012	XP04	
WDX2375D4S150-L	●	2.3750	14.547	11.547	9.815	2.295	1.500	3.000	BFTX0615N	TRD25	WDXT186012	XP04	
WDX2500D4S150-L	●	2.5000	15.047	12.047	10.315	2.421	1.500	3.000	BFTX0615N	TRD25	WDXT186012	XP04	



WDX Indexable Coolant Through Drills

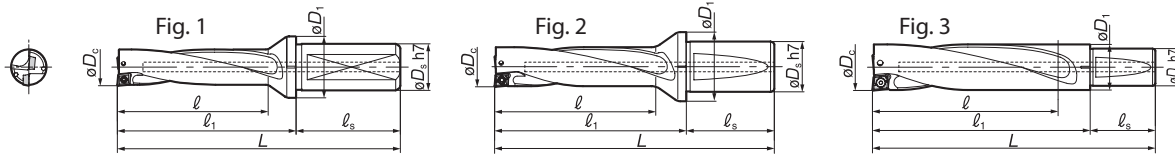
2XD & 3XD- Metric WDX



SumiDrill WDX Bodies - 2XD - METRIC										
Catalog Number	Stock	ϕD_c	L	ℓ_1	ℓ_s	ϕD_1	ϕD_s	ℓ_s	Insert	Fig.
WDX130D2S20	★	13.0	88	44	29					
WDX135D2S20	★	13.5	89	45	30					
WDX140D2S20	★	14.0	90	46	31	28.0	20	44	WDXT 042004	
WDX145D2S20	★	14.5	91	47	32					
WDX150D2S20	★	15.0	92	48	33					
WDX155D2S20	★	15.5	93	49	34					
WDX160D2S20	★	16.0	94	50	35					
WDX165D2S20	★	16.5	95	51	36	30.0	20	44	WDXT 052504	
WDX170D2S20	★	17.0	96	52	37					
WDX175D2S25	★	17.5	109	53	38					
WDX180D2S25	★	18.0	110	54	39	32.0	25	56		
WDX185D2S25	★	18.5	111	55	40					
WDX190D2S25	★	19.0	112	56	41					
WDX195D2S25	★	19.5	113	57	42					
WDX200D2S25	★	20.0	114	58	43					
WDX205D2S25	★	20.5	115	59	44	33.0	25	56	WDXT 063006	
WDX210D2S25	★	21.0	116	60	45					
WDX215D2S25	★	21.5	117	61	46					
WDX220D2S25	★	22.0	118	62	47					
WDX225D2S25	★	22.5	119	63	48					
WDX230D2S25	★	23.0	123	67	49					
WDX235D2S25	★	23.5	124	68	50					
WDX240D2S25	★	24.0	125	69	51	37.0	25	56		
WDX245D2S25	★	24.5	126	70	52					
WDX250D2S25	★	25.0	127	71	53					
WDX255D2S32	★	25.5	134	74	54					
WDX260D2S32	★	26.0	135	75	55					
WDX265D2S32	★	26.5	136	76	56					
WDX270D2S32	★	27.0	137	77	57	41.0	32	60	WDXT 073506	
WDX275D2S32	★	27.5	138	78	58					
WDX280D2S32	★	28.0	139	79	59					
WDX285D2S32	★	28.5	140	80	60					
WDX290D2S32	★	29.0	143	83	62					
WDX295D2S32	★	29.5	144	84	63	50.0	32	60		
WDX300D2S40	★	30.0	158	88	64					
WDX310D2S40	★	31.0	160	90	66					
WDX320D2S40	★	32.0	162	92	68					
WDX330D2S40	★	33.0	164	94	70	54.0	40	70	WDXT 094008	
WDX340D2S40	★	34.0	166	96	72					
WDX350D2S40	★	35.0	168	98	74					
WDX360D2S40	★	36.0	170	100	76					
WDX370D2S40	★	37.0	179	109	79					
WDX380D2S40	★	38.0	181	111	81					
WDX390D2S40	★	39.0	183	113	83					
WDX400D2S40	★	40.0	185	115	85					
WDX410D2S40	★	41.0	187	117	87	49.5	40	70	WDXT 125012	
WDX420D2S40	★	42.0	189	119	89					
WDX430D2S40	★	43.0	191	121	91					
WDX440D2S40	★	44.0	193	123	93					
WDX450D2S40	★	45.0	195	125	95					
WDX460D2S40	★	46.0	197	127	97					
WDX470D2S40	★	47.0	199	129	99					
WDX480D2S40	★	48.0	201	131	101	49.5				
WDX490D2S40	★	49.0	203	133	103					
WDX500D2S40	★	50.0	205	135	105					
WDX510D2S40	★	51.0	207	137	107					
WDX520D2S40	★	52.0	209	139	109	50.5				
WDX530D2S40	★	53.0	211	141	111	51.5				
WDX540D2S40	★	54.0	213	143	113	52.5				
WDX550D2S40	★	55.0	215	145	115	53.5				
WDX560D2S40	★	56.0	222	152	120	54.0				
WDX570D2S40	★	57.0	224	154	122	55.0				
WDX580D2S40	★	58.0	226	156	124	56.0				
WDX590D2S40	★	59.0	228	158	126	57.0				
WDX600D2S40	★	60.0	230	160	128	58.0				
WDX610D2S40	★	61.0	232	162	130	59.0				
WDX620D2S40	★	62.0	234	164	132	60.0				
WDX630D2S40	★	63.0	236	166	134	61.0				
WDX640D2S40	★	64.0	238	168	136	62.0				
WDX650D2S40	★	65.0	240	170	138	63.0				
WDX660D2S40	★	66.0	242	172	140	64.0				
WDX670D2S40	★	67.0	244	174	142	65.0				
WDX680D2S40	★	68.0	246	176	144	66.0				

★ = Worldwide Warehouse item

SumiDrill WDX Bodies - 3XD - METRIC										
Catalog Number	Stock	ϕD_c	L	ℓ_1	ℓ_s	ϕD_1	ϕD_s	ℓ_s	Insert	Fig.
WDX130D3S20	★	13.0	101.0	57.0	42.0					
WDX135D3S20	★	13.5	102.5	58.5	43.5					
WDX140D3S20	★	14.0	104.0	60.0	45.0	28.0	20	44	WDXT 042004	
WDX145D3S20	★	14.5	105.5	61.5	46.5					
WDX150D3S20	★	15.0	107.0	63.0	48.0					
WDX155D3S20	★	15.5	108.5	64.5	49.5					
WDX160D3S20	★	16.0	110.0	66.0	51.0					
WDX165D3S20	★	16.5	111.5	67.5	52.5	30.0	20	44	WDXT 052504	
WDX170D3S20	★	17.0	113.0	69.0	54.0					
WDX175D3S25	★	17.5	126.5	70.5	55.5					
WDX180D3S25	★	18.0	128.0	72.0	57.0	32.0	25	56		
WDX185D3S25	★	18.5	129.5	73.5	58.5					
WDX190D3S25	★	19.0	131.0	75.0	60.0					
WDX195D3S25	★	19.5	132.5	76.5	61.5					
WDX200D3S25	★	20.0	134.0	78.0	63.0					
WDX205D3S25	★	20.5	135.5	79.5	64.5	33.0	25	56	WDXT 063006	
WDX210D3S25	★	21.0	137.0	81.0	66.0					
WDX215D3S25	★	21.5	138.5	82.5	67.5					
WDX220D3S25	★	22.0	140.0	84.0	69.0					
WDX225D3S25	★	22.5	141.5	85.5	70.5					
WDX230D3S25	★	23.0	146.0	90.0	72.0					
WDX235D3S25	★	23.5	147.5	91.5	73.5					
WDX240D3S25	★	24.0	149.0	93.0	75.0	37.0	25	56		
WDX245D3S25	★	24.5	150.5	94.5	76.5					
WDX250D3S25	★	25.0	152.0	96.0	78.0					
WDX255D3S32	★	25.5	159.5	99.5	79.5					
WDX260D3S32	★	26.0	161.0	101.0	81.0					
WDX265D3S32	★	26.5	162.5	102.5	82.5					
WDX270D3S32	★	27.0	164.0	104.0	84.0	41.0	32	60	WDXT 073506	
WDX275D3S32	★	27.5	165.5	105.5	85.5					
WDX280D3S32	★	28.0	167.0	107.0	87.0					
WDX285D3S32	★	28.5	168.5	108.5	88.5					
WDX290D3S32	★	29.0	172.0	112.0	91.0					
WDX295D3S32	★	29.5	173.5	113.5	92.5	50.0	32	60		
WDX300D3S40	★	30.0	188.0	118.0	94.0					
WDX310D3S40	★	31.0	191.0	121.0	97.0					
WDX320D3S40	★	32.0	194.0	124.0	100.0					
WDX330D3S40	★	33.0	197.0	127.0	103.0	54.0	40	70	WDXT 094008	
WDX340D3S40	★	34.0	200.0	130.0	106.0					
WDX350D3S40	★	35.0	203.0	133.0	109.0					
WDX360D3S40	★	36.0	206.0	136.0	112.0					
WDX370D3S40	★	37.0	216.0	146.0	116.0					
WDX380D3S40	★	38.0	219.0	149.0	119.0					
WDX390D3S40	★	39.0	222.0	152.0	122.0					
WDX400D3S40	★	40.0	225.0	155.0	125.0					
WDX410D3S40	★	41.0	228.0	158.0	128.0	49.5	40	70	WDXT 125012	
WDX420D3S40	★	42.0	231.0	161.0	131.0					
WDX430D3S40	★	43.0	234.0	164.0	134.0					
WDX440D3S40	★	44.0	237.0	167.0	137.0					
WDX450D3S40	★	45.0	240.0	170.0	140.0					
WDX460D3S40	★	46.0	243.0	173.0	143.0					
WDX470D3S40	★	47.0	246.0	176.0	146.0					
WDX480D3S40	★	48.0	249.0	179.0	149.0	49.5				
WDX490D3S40	★	49.0	252.0	182.0	152.0					
WDX500D3S40	★	50.0	255.0	185.0	155.0					
WDX510D3S40	★	51.0	258.0	188.0	158.0					
WDX520D3S40	★	52.0	261.0	191.0	161.0	50.5				
WDX530D3S40	★	53.0	264.0	194.0	164.0	51.5				
WDX540D3S40	★	54.0	267.0	197.0	167.0	52.5				
WDX550D3S40	★	55.0	270.0	200.0	170.0	53.5				
WDX560D3S40	★	56.0	278.0	208.0	176.0	54.0				
WDX570D3S40	★	57.0	281.0	211.0	179.0	55.0				
WDX580D3S40	★	58.0	284.0	214.0	182.0	56.0				
WDX590D3S40	★	59.0	287.0	217.0	185.0	57.0				
WDX600D3S40	★	60.0	290.0	220.0	188.0	58.0				
WDX610D3S40	★	61.0	293.0	223.0	191.0	59.0				



Indexable Drills

SumiDrill WDX Bodies - 4XD - METRIC										
Catalog Number	Stock	ϕD_c	L	ℓ_1	ℓ_2	ϕD_1	ϕD_s	ℓ_s	Insert	Fig.
WDX130D4S20	★	13.0	114	70	55					
WDX135D4S20	★	13.5	116	72	57					
WDX140D4S20	★	14.0	118	74	59	28.0	20	44	WDXT 042004	
WDX145D4S20	★	14.5	120	76	61					
WDX150D4S20	★	15.0	122	78	63					
WDX155D4S20	★	15.5	124	80	65					
WDX160D4S20	★	16.0	126	82	67	30.0	20	44	WDXT 052504	
WDX165D4S20	★	16.5	128	84	69					
WDX170D4S20	★	17.0	130	86	71					
WDX175D4S25	★	17.5	144	88	73	32.0	25	56		
WDX180D4S25	★	18.0	146	90	75					
WDX185D4S25	★	18.5	148	92	77					
WDX190D4S25	★	19.0	150	94	79					
WDX195D4S25	★	19.5	152	96	81					
WDX200D4S25	★	20.0	154	98	83					
WDX205D4S25	★	20.5	156	100	85	33.0	25	56	WDXT 063006	1
WDX210D4S25	★	21.0	158	102	87					
WDX215D4S25	★	21.5	160	104	89					
WDX220D4S25	★	22.0	162	106	91					
WDX225D4S25	★	22.5	164	108	93					
WDX230D4S25	★	23.0	169	113	95					
WDX235D4S25	★	23.5	171	115	97					
WDX240D4S25	★	24.0	173	117	99	37.0	25	56		
WDX245D4S25	★	24.5	175	119	101					
WDX250D4S25	★	25.0	177	121	103					
WDX255D4S32	★	25.5	185	125	105					
WDX260D4S32	★	26.0	187	127	107					
WDX265D4S32	★	26.5	189	129	109					
WDX270D4S32	★	27.0	191	131	111	41.0	32	60		
WDX275D4S32	★	27.5	193	133	113					
WDX280D4S32	★	28.0	195	135	115					
WDX285D4S32	★	28.5	197	137	117					
WDX290D4S32	★	29.0	201	141	120	50.0	32	60		
WDX295D4S32	★	29.5	203	143	122					
WDX300D4S40	★	30.0	218	148	124					
WDX310D4S40	★	31.0	222	152	128					
WDX320D4S40	★	32.0	226	156	132					
WDX330D4S40	★	33.0	230	160	136	54.0	40	70	WDXT 094008	2
WDX340D4S40	★	34.0	234	164	140					
WDX350D4S40	★	35.0	238	168	144					
WDX360D4S40	★	36.0	242	172	148					
WDX370D4S40	★	37.0	253	183	153					
WDX380D4S40	★	38.0	257	187	157					
WDX390D4S40	★	39.0	261	191	161					
WDX400D4S40	★	40.0	265	195	165					
WDX410D4S40	★	41.0	269	199	169	49.5	40	70	WDXT 125012	
WDX420D4S40	★	42.0	273	203	173					
WDX430D4S40	★	43.0	277	207	177					
WDX440D4S40	★	44.0	281	211	181					
WDX450D4S40	★	45.0	285	215	185					
WDX460D4S40	★	46.0	289	219	189					
WDX470D4S40	★	47.0	293	223	193					
WDX480D4S40	★	48.0	297	227	197	49.5				
WDX490D4S40	★	49.0	301	231	201					
WDX500D4S40	★	50.0	305	235	205					
WDX510D4S40	★	51.0	309	239	209		40	70	WDXT 156012	
WDX520D4S40	★	52.0	313	243	213	50.5				
WDX530D4S40	★	53.0	317	247	217	51.5				
WDX540D4S40	★	54.0	321	251	221	52.5				
WDX550D4S40	★	55.0	325	255	225	53.5				
WDX560D4S40	★	56.0	334	264	232	54.0				
WDX570D4S40	★	57.0	338	268	236	55.0				
WDX580D4S40	★	58.0	342	272	240	56.0				
WDX590D4S40	★	59.0	346	276	244	57.0				
WDX600D4S40	★	60.0	350	280	248	58.0				
WDX610D4S40	★	61.0	354	284	252	59.0				
WDX620D4S40	★	62.0	358	288	256	60.0				
WDX630D4S40	★	63.0	362	292	260	61.0				
										3

★ = Worldwide Warehouse item

SumiDrill WDX Bodies - 5XD - METRIC											
Catalog Number	Stock	ϕD_c	L	ℓ_1	ℓ_2	ϕD_1	ϕD_s	ℓ_s	Insert	Fig.	Coolant Sleeve**
WDX 130D5S20	★	13.0	127.0	83.0	68.0						
WDX 135D5S20	★	13.5	129.5	85.5	70.5						
WDX 140D5S20	★	14.0	132.0	88.0	73.0	28.0	20.0	44.0	WDXT 042004		SLV20M
WDX 145D5S20	★	14.5	134.5	90.5	75.5						
WDX 150D5S20	★	15.0	137.0	93.0	78.0						
WDX 155D5S20	★	15.5	139.5	95.5	80.5						
WDX 160D5S20	★	16.0	142.0	98.0	83.0	30.0	20.0	44.0	WDXT 052504		
WDX 165D5S20	★	16.5	144.5	100.5	85.5						
WDX 170D5S20	★	17.0	147.0	103.0	88.0						
WDX 175D5S25	★	17.5	161.5	105.5	90.5	32.0	25.0	56.0			
WDX 180D5S25	★	18.0	164.0	108.0	93.0						
WDX 185D5S25	★	18.5	166.5	110.5	95.5						
WDX 190D5S25	★	19.0	169.0	113.0	98.0						
WDX 195D5S25	★	19.5	171.5	115.5	100.5						
WDX 200D5S25	★	20.0	174.0	118.0	103.0						
WDX 205D5S25	★	20.5	176.5	120.5	105.5	33.0	25.0	56.0	WDXT 063006	1	SLV25M
WDX 210D5S25	★	21.0	179.0	123.0	108.0						
WDX 215D5S25	★	21.5	181.5	125.5	110.5						
WDX 220D5S25	★	22.0	184.0	128.0	113.0						
WDX 225D5S25	★	22.5	186.5	130.5	115.5						
WDX 230D5S25	★	23.0	192.0	136.0	118.0						
WDX 235D5S25	★	23.5	194.5	138.5	120.5						
WDX 240D5S25	★	24.0	197.0	141.0	123.0	37.0	25.0	56.0	WDXT 073506		
WDX 245D5S25	★	24.5	199.5	143.5	125.5						
WDX 250D5S25	★	25.0	202.0	146.0	128.0						
WDX 260D5S32	★	26.0	213.0	153.0	133.0						
WDX 270D5S32	★	27.0	218.0	158.0	138.0	41.0		60.0			
WDX 280D5S32	★	28.0	223.0	163.0	143.0						
WDX 290D5S32	★	29.0	230.0	170.0	149.0	50.0	32.0				SLV32M
WDX 300D5S32	★	30.0	238.0	178.0	154.0						
WDX 310D5S32	★	31.0	243.0	183.0	159.0						
WDX 320D5S32	★	32.0	248.0	188.0	164.0						
WDX 300D5S40	★	30.0	248.0	178.0	154.0						
WDX 310D5S40	★	31.0	253.0	183.0	159.0						
WDX 320D5S40	★	32.0	258.0	188.0	164.0	54.0					
WDX 330D5S40	★	33.0	263.0	193.0	169.0		40.0	70.0	WDXT 094008	2	SLV40M
WDX 340D5S40	★	34.0	268.0	198.0	174.0						
WDX 350D5S40	★	35.0	273.0	203.0	179.0						
WDX 360D5S40	★	36.0	278.0	208.0	184.0						

★ = Worldwide Warehouse item

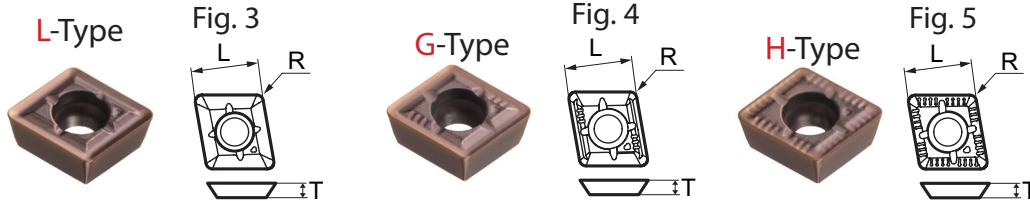
*NOTE: Coolant adapter sleeves for lathes are available upon request.

** : Coolant adapter sleeves sold separately

*** 5XD WDX Drills have 2 coolant holes in the back of the drill and no single threaded port



SumiDrill WDX Inserts



NEW GRADE

Catalog Number	Stock				Fig.	L	T	R	WDX Body
	ACP100	ACP300	ACK300	DL1500					
WDXT042004-L	●	●	●		3				
WDXT042004-G	●	●	●	●	4	0.1654	0.0788	0.0157	WDX0562D□ ~ WDX0594D□
WDXT042004-H	●	●	●		5				
WDXT052504-L	●	●	●		3				
WDXT052504-G	●	●	●	●	4	0.1969	0.0984	0.0157	WDX0625D□ ~ WDX0687D□
WDXT052504-H	●	●	●		5				
WDXT063006-L	●	●	●		3				
WDXT063006-G	●	●	●	●	4	0.2362	0.1181	0.0236	WDX0750D□ ~ WDX0875D□
WDXT063006-H	●	●	●		5				
WDXT073506-L	●	●	●		3				
WDXT073506-G	●	●	●	●	4	0.2953	0.1378	0.0236	WDX0937D□ ~ WDX1125D□
WDXT073506-H	●	●	●		5				
WDXT094008-L	●	●	●		3				
WDXT094008-G	●	●	●	●	4	0.3780	0.1575	0.0315	WDX1187D□ ~ WDX1437D□
WDXT094008-H	●	●	●		5				
WDXT125012-L	●	●	●		3				
WDXT125012-G	●	●	●	●	4	0.4882	0.1969	0.0472	WDX1500D□ ~ WDX1750D□
WDXT125012-H	●	●	●		5				
WDXT156012-L	●	●	●		3				
WDXT156012-G	●	●	●	●	4	0.5984	0.2362	0.0472	WDX1813D□ ~ WDX2125D□
WDXT156012-H	●	●	●		5				
WDXT186012-L	●	●	●		3				
WDXT186012-G	●	●	●		4	0.7087	0.2362	0.0472	WDX2250D□ ~ WDX2625D□
WDXT186012-H	●	●	●		5				

Indexable
Drills



Cutting Conditions WDX

WDX Indexable Coolant Through Drills

Indexable Drills

WDX		Work Material	Hardness HB	Chip Breaker	Insert Grade	Cutting Speed SFM	Feed Rate - IPR (Inches per revolution)				
							ø0.562 - ø1.00	ø1.062 - ø1.50	ø1.56 - ø2.125	ø2.25 - ø2.625	
2D	P	Low Carbon Steel	<190	G	ACP300	450 - 780	.002 - .006	.003 - .008	.005 - .010	.006 - .012	
				L	ACP300	450 - 750	.002 - .004	.002 - .005	.003 - .006	N/A	
			190 ~ 250	G	ACP300	400 - 700	.003 - .009	.004 - .010	.005 - .010	.006 - .012	
				L	ACP300	400 - 700	.002 - .004	.002 - .005	.003 - .006	N/A	
		250 ~ 300	G	ACP300	350 - 550	.003 - .007	.003 - .008	.004 - .009	.004 - .010		
			L	ACP300	350 - 525	.002 - .004	.002 - .004	.003 - .005	N/A		
			Medium Carbon Steel	180 ~ 275	G	ACP300	350 - 700	.002 - .007	.003 - .008	.005 - .010	.006 - .010
					L	ACP300	350 - 650	.002 - .004	.002 - .005	.003 - .006	N/A
		275 ~ 350	G	ACP300	300 - 500	.002 - .006	.003 - .007	.004 - .008	.006 - .009		
			L	ACP300	300 - 500	.002 - .003	.002 - .004	.003 - .005	N/A		
		Alloy Steel	200 ~ 350	G	ACP300	350 - 650	.003 - .006	.003 - .008	.006 - .010	.006 - .012	
				L	ACP300	300 - 450	.002 - .004	.003 - .005	.003 - .006	N/A	
	M	300 Austenitic Stainless Steel	160	G	ACP300	400 - 650	.003 - .007	.003 - .008	.005 - .010	.006 - .012	
			280	G	ACP300	325 - 500	.002 - .006	.003 - .006	.004 - .008	.006 - .010	
		400 Martensitic Stainless Steel	160	G	ACP300	400 - 650	.003 - .007	.003 - .008	.004 - .010	.006 - .012	
			240	G	ACP300	325 - 600	.002 - .006	.003 - .006	.004 - .008	.006 - .010	
	K	Cast Iron		H	ACK300	400 - 650	.004 - .008	.004 - .012	.006 - .014	.006 - .017	
		Ductile Iron		H	ACK300	300 - 500	.004 - .008	.004 - .012	.006 - .014	.006 - .017	
S	Exotic Alloys	200 ~ 375	G	ACP300	80 - 250	.002 - .005	.003 - .007	.003 - .008	.003 - .010		
N	Aluminum alloy		G	DL1500	650 - 1200	.003 - .006	.003 - .007	.004 - .008	.005 - .010		
	Copper Alloy		G	DL1500	600 - 900	.003 - .006	.003 - .007	.004 - .008	.005 - .010		

WDX		Work Material	Hardness HB	Chip Breaker	Insert Grade	Cutting Speed SFM	Feed Rate - IPR (Inches per revolution)				
							ø0.562 - ø1.00	ø1.062 - ø1.50	ø1.56 - ø2.125	ø2.25 - ø2.625	
3D	P	Low Carbon Steel	<190	G	ACP300	450 - 780	.002 - .006	.003 - .008	.005 - .010	.006 - .012	
				L	ACP300	450 - 750	.002 - .004	.002 - .005	.003 - .006	N/A	
			190 ~ 250	G	ACP300	400 - 700	.003 - .009	.004 - .010	.005 - .010	.006 - .012	
				L	ACP300	400 - 700	.002 - .004	.002 - .005	.003 - .006	N/A	
		250 ~ 350	G	ACP300	350 - 550	.003 - .007	.003 - .008	.004 - .009	.004 - .010		
			L	ACP300	350 - 525	.002 - .004	.002 - .004	.003 - .005	N/A		
			Medium Carbon Steel	180 ~ 275	G	ACP300	350 - 700	.002 - .007	.003 - .008	.005 - .010	.006 - .010
					L	ACP300	350 - 650	.002 - .004	.002 - .005	.003 - .006	N/A
		275 ~ 350	G	ACP300	300 - 500	.002 - .006	.003 - .007	.004 - .008	.006 - .009		
			L	ACP300	300 - 500	.002 - .003	.002 - .004	.003 - .005	N/A		
		Alloy Steel	200 ~ 350	G	ACP300	350 - 650	.003 - .006	.003 - .008	.006 - .010	.006 - .012	
				L	ACP300	300 - 450	.002 - .004	.003 - .005	.003 - .006	N/A	
	M	300 Austenitic Stainless Steel	160	G	ACP300	400 - 650	.003 - .007	.003 - .008	.005 - .010	.006 - .012	
			280	G	ACP300	325 - 500	.002 - .006	.003 - .006	.004 - .008	.006 - .010	
		400 Martensitic Stainless Steel	160	G		400 - 650	.003 - .007	.003 - .008	.004 - .010	.006 - .012	
			240	G	ACP300	325 - 600	.002 - .006	.003 - .006	.004 - .008	.006 - .010	
	K	Cast Iron		H	ACK300	400 - 650	.004 - .008	.004 - .012	.006 - .014	.006 - .017	
		Ductile Iron		H	ACK300	300 - 500	.004 - .008	.004 - .012	.006 - .014	.006 - .017	
S	Exotic Alloys	200 ~ 375	G	ACP300	80 - 250	.002 - .005	.003 - .007	.003 - .008	.003 - .010		
N	Aluminum alloy		G	DL1500	650 - 1200	.003 - .006	.003 - .007	.004 - .008	.005 - .010		
	Copper Alloy		G	DL1500	600 - 900	.003 - .006	.003 - .007	.004 - .008	.005 - .010		



**WDX Indexable
Coolant Through Drills**

**Cutting Conditions
WDX**

WDX		Work Material	Hardness HB	Chip Breaker	Insert Grade	Cutting Speed SFM	Feed Rate - IPR (Inches per revolution)				
							Ø0.562 - Ø1.00	Ø1.062 - Ø1.50	Ø1.56 - Ø2.125	Ø2.25 - Ø2.625	
4D	P	Low Carbon Steel	<190	G	ACP300	450 - 780	.002 - .004	.003 - .006	.004 - .007	.004 - .008	
				L	ACP300	450 - 750	.002 - .004	.002 - .004	.003 - .005	N/A	
			190 ~ 250	G	ACP300	400 - 700	.003 - .006	.003 - .007	.005 - .008	.004 - .009	
				L	ACP300	400 - 700	.002 - .004	.002 - .005	.003 - .006	N/A	
		250 ~ 350	G	ACP300	350 - 550	.003 - .006	.003 - .007	.003 - .007	.004 - .008		
			L	ACP300	350 - 525	.002 - .004	.002 - .004	.003 - .005	N/A		
			Medium Carbon Steel	180 ~ 275	G	ACP300	350 - 700	.003 - .006	.003 - .008	.004 - .008	.006 - .010
					L	ACP300	350 - 650	.002 - .004	.002 - .005	.003 - .005	N/A
		275 ~ 350	G	ACP300	300 - 500	.003 - .005	.003 - .007	.004 - .008	.005 - .009		
			L	ACP300	300 - 500	.002 - .003	.002 - .004	.003 - .005	N/A		
		Alloy Steel	200 ~ 350	G	ACP300	350 - 650	.003 - .006	.003 - .008	.004 - .008	.006 - .010	
				L	ACP300	300 - 450	.002 - .004	.003 - .005	.003 - .006	N/A	
	M	300 Austenitic Stainless Steel	160	G	ACP300	400 - 650	.003 - .006	.003 - .007	.005 - .008	.005 - .009	
			280	G	ACP300	325 - 500	.002 - .005	.003 - .005	.004 - .006	.004 - .008	
		400 Martensitic Stainless Steel	160	G	ACP300	400 - 650	.003 - .006	.003 - .007	.004 - .008	.006 - .010	
			240	G	ACP300	325 - 600	.002 - .005	.003 - .005	.004 - .006	.005 - .008	
	K	Cast Iron		H	ACK300	400 - 650	.004 - .008	.004 - .012	.006 - .012	.006 - .014	
		Ductile Iron		H	ACK300	300 - 500	.004 - .008	.004 - .012	.006 - .012	.006 - .014	
S	Exotic Alloys	200 ~ 375	G	ACP300	80 - 250	.002 - .004	.002 - .005	.003 - .006	.004 - .007		
N	Aluminum alloy		G	DL1500	650 - 1200	.003 - .006	.003 - .007	.004 - .008	.005 - .010		
	Copper Alloy		G	DL1500	600 - 900	.003 - .006	.003 - .007	.004 - .008	.005 - .010		

WDX		Work Material	Hardness HB	Chip Breaker	Insert Grade	Cutting Speed SFM	Feed Rate - IPR (Inches per revolution)				
							Ø0.562 - Ø1.00	Ø1.062 - Ø1.50	Ø1.56 - Ø2.125	Ø2.25 - Ø2.625	
5D	P	Low Carbon Steel	<190	G	ACP300	450 - 780	.002 - .004	.003 - .006	.004 - .007		
				L	ACP300	450 - 750	.002 - .004	.002 - .005	.002 - .005		
			190 ~ 250	G	ACP300	400 - 700	.003 - .006	.003 - .007	.005 - .008		
				L	ACP300	400 - 700	.002 - .004	.002 - .005	.002 - .005		
		250 ~ 350	G	ACP300	350 - 550	.003 - .006	.003 - .007	.003 - .007			
			L	ACP300	350 - 525	.002 - .004	.002 - .004	.002 - .005			
			Medium Carbon Steel	180 ~ 275	G	ACP300	350 - 700	.003 - .006	.003 - .008	.004 - .008	
					L	ACP300	350 - 650	.002 - .004	.002 - .005	.002 - .005	
		275 ~ 350	G	ACP300	300 - 500	.003 - .005	.003 - .007	.004 - .008			
			L	ACP300	300 - 500	.002 - .003	.002 - .004	.002 - .005			
		Alloy Steel	200 ~ 350	G	ACP300	350 - 650	.003 - .006	.003 - .008	.004 - .008		
				L	ACP300	300 - 450	.002 - .004	.003 - .005	.003 - .006		
	M	300 Austenitic Stainless Steel	160	G	ACP300	400 - 650	.002 - .004	.003 - .006	.003 - .007		
			280	G	ACP300	325 - 500	.001 - .003	.003 - .005	.003 - .006		
		400 Martensitic Stainless Steel	160	G	ACP300	400 - 650	.002 - .004	.003 - .006	.003 - .007		
			240	G	ACP300	325 - 600	.001 - .003	.003 - .005	.003 - .006		
	K	Cast Iron		H	ACK300	400 - 650	.004 - .008	.004 - .010	.005 - .011		
		Ductile Iron		H	ACK300	300 - 500	.004 - .008	.004 - .010	.005 - .011		
S	Exotic Alloys	200 ~ 375	G	ACP300	80 - 250	.002 - .004	.003 - .006	.003 - .007			
N	Aluminum alloy		G	DL1500	650 - 1200	.003 - .006	.003 - .007	.004 - .008			
	Copper Alloy		G	DL1500	600 - 900	.003 - .006	.003 - .007	.004 - .008			

Indexable
Drills

