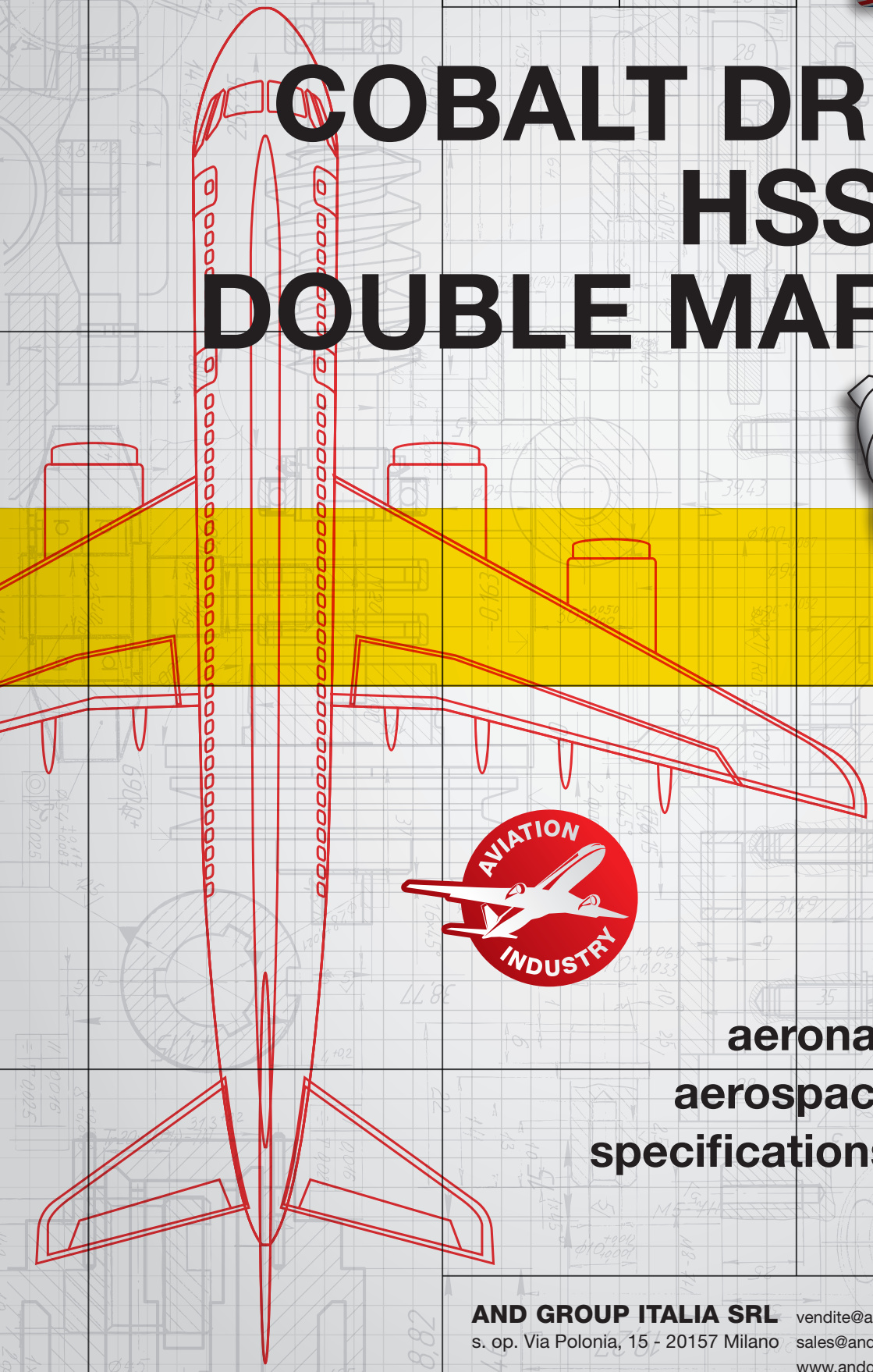
DREX® TOOLS

UTENSILI DI PRECISIONE PER L'INDUSTRIA MECCANICA - AERONAUTICA - AEROSPAZIALE

PRECISION TOOLS FOR THE MECHANICAL AVIATION - AEROSPACE MANUFACTURING

COBALT DRILLS HSS+Co DOUBLE MARGIN

Dimensions INCHES



AVIATION INDUSTRY

aeronautical and aerospace industry specifications NAS 937 Type “D”

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Double margin drill shave an additional margin ground behind the leading margin, providing twice the number of conctat point. The second margin performs various functions to improve hole quality.

DOUBLE MARGIN DRILL CLOUSE UP

SINGLE MARGIN DRILL

DOUBLE MARGIN DRILL

The trailing margin burnishes the cavity, making a true hole and smoother finish, helping to provide a more concentric drilled hole

- A reamer finish can be achieved with double margin drills, eliminating a second operation.
- When a double margin drill is used with a drill bushing, the four margins locate in the bushing, providing increased bushing support in excess of 200%.
- When intermittent cutting is required, the double margin drill performs in two ways: Enhanced margin support in the first cavity cut and support on breakthrough, which stops the drill from wandering when in contact with the work space.
- Drill back taper is more tightly controlled than a regular drill, enhancing a rounder hole location.
- 135-degree split point provides immediate self-centering on contact with the work piece and reduces thrust, due to its notch-type web thinning at the chisel edge length. The split point is excellent for drilling harder materials (titanium, stainless steel, and high temperature alloys.)
- The bronze-gold drill color is an easy way to identify these tools as being cobalt aircraft drills and is easy to group when resharpening.
- With all these features incorporated in this double margin drill, it is excellent for hand drilling.

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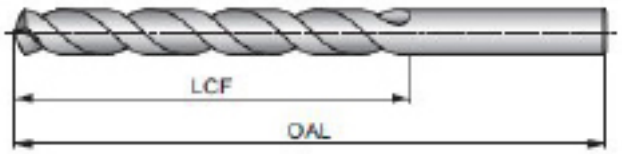
AERONAUTICAL AND AEROSPACE INDUSTRY DRILLS DOUBLE MARGIN SPECIFICATIONS NAS 937 "D" JOBBER LENGTH

Jobber Length Cobalt 135° Split Point
When the drill point penetrates enough for the second margin to contact the wall of the hole, the point is stabilized and true cylindrical geometry is established. Smooth accurate holes are produced and reaming can often be eliminated.

TYPE	HEAVY DUTY JOBBER DRILL DOUBLE MARGIN
ANGLE	135° SELF-CENTERING "SPLIT POINT"
COATING	BRONZE
SPECIFICATIONS	NAS 937 "D"
MATERIAL	HSS + CO 8%



CODE	DIAM inch	DIAM mm	DIAM inch	LCF	OAL	PKG
AV-13DXDM63	3/32	2,38	.0938	1-1/4	2-1/4	12
AV-13DXDM40	40	2,50	.0980	1-3/8	2-3/8	12
AV-13DXDM64	7/64	2,78	.1094	1-1/2	2-5/8	12
AV-13DXDM65	1/8	3,18	.1250	1-5/8	2-3/4	12
AV-13DXDM30	30	3,26	.1285	1-5/8	2-3/4	12
AV-13DXDM66	9/64	3,57	.1406	1-3/4	2-7/8	12
AV-13DXDM27	27	3,66	.1440	1-7/8	3	12
AV-13DXDM67	5/32	3,97	.1562	2	3-1/8	12
AV-13DXDM21	21	4,04	.1590	2-1/8	3-1/4	12
AV-13DXDM20	20	4,09	.1610	2-1/8	3-1/4	12
AV-13DXDM19	19	4,22	.1660	2-1/8	3-1/4	12
AV-13DXDM68	11/64	4,37	.1719	2-1/8	3-1/4	12
AV-13DXDM16	16	4,50	.1770	2-3/16	3-3/8	12
AV-13DXDM15	15	4,57	.1800	2-3/16	3-3/8	12
AV-13DXDM13	13	4,70	.1850	2-5/16	3-1/2	12
AV-13DXDM70A	---	4,75	.1870	2-5/16	3-1/2	12
AV-13DXDM69	3/16	4,76	.1875	2-5/16	3-1/2	12
AV-13DXDM12	12	4,80	.1890	2-5/16	3-1/2	12

CODE	DIAM inch	DIAM mm	DIAM inch	LCF	OAL	PKG
AV-13DXDM11	11	4,85	.1910	2-5/16	3-1/2	12
AV-13DXDM10	10	4,91	.1935	2-7/16	3-5/8	12
AV-13DXDM08	8	5,05	.1990	2-7/16	3-5/8	12
AV-13DXDM70	13/64	5,16	.2031	2-7/16	3-5/8	12
AV-13DXDM06	6	5,18	.2040	2-1/2	3-3/4	12
AV-13DXDM05	5	5,22	.2055	2-1/2	3-3/4	12
AV-13DXDM71	7/32	5,56	.2188	2-1/2	3-3/4	12
AV-13DXDM90	A	5,94	.2340	2-5/8	3-7/8	12
AV-13DXDM72	15/64	5,95	.2344	2-5/8	3-7/8	12
AV-13DXDM93	D	6,25	.2460	2-3/4	4	12
AV-13DXDM73	1/4	6,35	.2500	2-3/4	4	12
AV-13DXDM95	F	6,53	.2570	2-7/8	4-1/8	12
AV-13DXDM96	G	6,63	.2610	2-7/8	4-1/8	12
AV-13DXDM74	17/64	6,75	.2656	2-7/8	4-1/8	12
AV-13DXDM75	9/32	7,14	.2812	2-15/16	4-1/4	12
AV-13DXDM77	5/16	7,94	.3125	3-3/16	4-1/2	12
AV-13DXDM81	3/8	9,53	.3750	3-5/8	5	12

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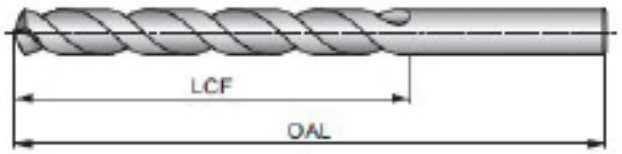
DRILLS FOR THE AERONAUTICAL AND AEROSPACE INDUSTRY DOUBLE MARGIN SPECIFICATIONS NAS 937 "D" 6" LENGTH

6" length Cobalt 135° Split Point
Designed for close tolerance drilling in titanium, stainless, heat treated material and aluminum alloys. When the drill point penetrates enough for the second margin to contact the wall of the hole, the point is stabiized and true cylindrical geometry is established. Smooth accurate holes are produced and reaming can often be eliminated.

TYPE	DRILL DOUBLE MARGIN - 6" OVERALL LENGTH EXTENSION DRILLS
ANGLE	135° SELF-CENTERING "SPLIT POINT"
COATING	BRONZE
SPECIFICATIONS	NAS 937 "D"
MATERIAL	HSS + CO 8%



CODE	DIAM inch	DIAM mm	DIAM inch	LCF	OAL	PKG
AV-14DXDM63	3/32	2,38	.0938	1-1/4	6	6
AV-14DXDM40	40	2,50	.0980	1-3/8	6	6
AV-14DXDM64	7/64	2,78	.1094	1-1/2	6	6
AV-14DXDM65	1/8	3,18	.1250	1-5/8	6	6
AV-14DXDM30	30	3,26	.1285	1-5/8	6	6
AV-14DXDM66	9/64	3,57	.1406	1-3/4	6	6
AV-14DXDM27	27	3,66	.1440	1-7/8	6	6
AV-14DXDM67	5/32	3,97	.1562	2	6	6
AV-14DXDM21	21	4,04	.1590	2-1/8	6	6
AV-14DXDM20	20	4,09	.1610	2-1/8	6	6
AV-14DXDM19	19	4,22	.1660	2-1/8	6	6
AV-14DXDM68	11/64	4,37	.1719	2-1/8	6	6
AV-14DXDM16	16	4,50	.1770	2-3/16	6	6
AV-14DXDM15	15	4,57	.1800	2-3/16	6	6
AV-14DXDM13	13	4,70	.1850	2-5/16	6	6

CODE	DIAM inch	DIAM mm	DIAM inch	LCF	OAL	PKG
AV-14DXDM69	3/16	4,76	.1875	2-5/16	6	6
AV-14DXDM12	12	4,80	.1890	2-5/16	6	6
AV-14DXDM11	11	4,85	.1910	2-5/16	6	6
AV-14DXDM10	10	4,91	.1935	2-7/16	6	6
AV-14DXDM08	8	5,05	.1990	2-7/16	6	6
AV-14DXDM06	6	5,18	.2040	2-1/2	6	6
AV-14DXDM05	5	5,22	.2055	2-1/2	6	6
AV-14DXDM71	7/32	5,56	.2188	2-1/2	6	6
AV-14DXDM93	D	6,25	.2460	2-3/4	6	6
AV-14DXDM73	1/4	6,35	.2500	2-3/4	6	6
AV-14DXDM95	F	6,53	.2570	2-7/8	6	6
AV-14DXDM96	G	6,63	.2610	2-7/8	6	6
AV-14DXDM77	5/16	7,94	.3125	3-3/16	6	6
AV-14DXDM81	3/8	9,53	.3750	3-5/8	6	6

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AERONAUTICAL AND AEROSPACE INDUSTRY DRILLS DOUBLE MARGIN WITH PILOT SPECIFICATIONS NAS 937 "D" - JOBBER LENGTH

Jobber Length Cobalt 135° Split Point.
Designed for close tolerance drilling in titanium, stainless, heat treated material and aluminum alloys. When the drill point penetrates enough for the second margin to contact the wall of the hole, the point is stabilized and true cylindrical geometry is established. Smooth accurate holes are produced and reaming can often be eliminated.

TYPE	JHEAVY DUTY JOBBER DRILL DOUBLE MARGIN
ANGLE	135° SELF-CENTERING "SPLIT POINT" WIHT PILOT
COATING	BRONZE
SPECIFICATIONS	NAS 337 "D"
MATERIAL	HSS + CO 8%

CODE	DIAM inch	DIAM DRILL mm	DIAM DRILL inch	DIAM PILOT mm	DIAM PILOT inch	LCF	OAL	PILOT LENGTH	PKG
AV-13DX100	30x40	3,26	.1285	2,50	.0980	1-5/8	2-3/4	1/4	6
AV-13DX106	27x40	3,66	.1440	2,50	.0980	1-7/8	3	1/4	6
AV-13DX114	21x40	4,04	.1590	2,50	.0980	2-1/8	3-1/4	1/4	6
AV-13DX107	21x30	4,04	.1590	3,26	.1285	2-1/8	3-1/4	1/4	6
AV-13DX117	20x40	4,09	.1610	2,50	.0980	2-1/8	3-1/4	1/4	6
AV-13DX115	20x30	4,09	.1610	3,26	.1285	2-1/8	3-1/4	1/4	6
AV-13DX118	16x40	4,50	.1770	2,50	.0980	2-3/16	3-3/8	1/4	6
AV-13DX119	16x30	4,50	.1770	3,26	.1285	2-3/16	3-3/8	1/4	6
AV-13DX121	13x40	4,70	.1850	2,50	.0980	2-5/16	3-1/2	1/4	6
AV-13DX128	13x30	4,70	.1850	3,26	.1285	2-5/16	3-1/2	1/4	6
AV-13DX135	13x21	4,70	.1850	4,04	.1590	2-5/16	3-1/2	1/4	6
AV-13DX142	12x40	4,80	.1890	2,50	.0980	2-5/16	3-1/2	1/4	6
AV-13DX149	12x30	4,80	.1890	3,26	.1285	2-5/16	3-1/2	1/4	6
AV-13DX156	12x21	4,80	.1890	4,04	.1590	2-5/16	3-1/2	1/4	6
AV-13DX170	11x30	4,85	.1910	3,26	.1285	2-5/16	3-1/2	1/4	6
AV-13DX163	11x21	4,85	.1910	4,04	.1590	2-5/16	3-1/2	1/4	6
AV-13DX184	10x40	4,91	.1935	2,50	.0980	2-7/16	3-5/8	1/4	6
AV-13DX177	10x30	4,91	.1935	3,26	.1285	2-7/16	3-5/8	1/4	6
AV-13DX191	10x21	4,91	.1935	4,04	.1590	2-7/16	3-5/8	1/4	6
AV-13DX205	Dx13	6,25	.2460	4,70	.1850	2-3/4	4	5/16	6
AV-13DX198	Dx3/16	6,25	.2460	4,76	.1875	2-3/4	4	5/16	6
AV-13DX230	1/4x30	6,35	.2500	3,26	.1285	2-3/4	4	5/16	6
AV-13DX327	1/4x21	6,35	.2500	4,04	.1590	2-3/4	4	5/16	6
AV-13DX223	1/4x11	6,35	.2500	4,85	.1910	2-3/4	4	5/16	6
AV-13DX216	1/4x10	6,35	.2500	4,91	.1935	2-3/4	4	5/16	6
AV-13DX244	5/16x1/4	7,94	.3125	6,35	.2500	3-3/16	4-1/2	5/16	6
AV-13DX250	3/8x1/4	9,53	.3750	6,35	.2500	3-5/8	5	3/8	6
AV-13DX255	3/8x5/16	9,53	.3750	7,94	.3125	3-5/8	5	3/8	6