CARBIDE, DREAM DRILLS
VOLLHARTMETALL DREAM SPIRALBOHRER

SHORT
KURZ

▶ **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

▶ **Advantage** : Self centering
- center drilling is not required.

Excellent positioning
- bush is not necessary.

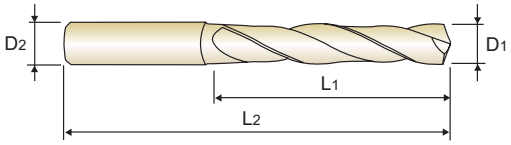
Special Design
- reaming is not required.
- good chip removal
- powerful drilling

▶ **Verwendung** : Zum wirtschaftlichen Bohren von Stahl allgemein, Stahlguß, Hart-und Temperguß, Nichteisen Leichtmetallen, abrasiven Kunststoffen.

▶ **Vorteile** : Selbst zentrierend
- Zentrierbohrung wird nicht benötigt.

Exzellente Positionierbarkeit
-Keine Führungsbuchse notwendig.

Spezielles Design
-Räumen ist nicht notwendig
-Gute Spanabfuhr
-Leistungsfähiges Bohren



DIN 6537 | MG | h6 | m7 | 140° | P.60

3 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH423088	8.8	10	47	89
DH423089	8.9	10	47	89
DH423090	9.0	10	47	89
DH423091	9.1	10	47	89
DH423092	9.2	10	47	89
DH423093	9.3	10	47	89
DH423094	9.4	10	47	89
DH423095	9.5	10	47	89
DH423096	9.6	10	47	89
DH423097	9.7	10	47	89
DH423098	9.8	10	47	89
DH423099	9.9	10	47	89
DH423100	10.0	10	47	89
DH423101	10.1	12	55	102
DH423102	10.2	12	55	102
DH423103	10.3	12	55	102
DH423104	10.4	12	55	102
DH423105	10.5	12	55	102
DH423106	10.6	12	55	102
DH423107	10.7	12	55	102
DH423108	10.8	12	55	102
DH423109	10.9	12	55	102
DH423110	11.0	12	55	102
DH423111	11.1	12	55	102
DH423112	11.2	12	55	102
DH423113	11.3	12	55	102
DH423114	11.4	12	55	102
DH423115	11.5	12	55	102
DH423116	11.6	12	55	102

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH423117	11.7	12	55	102
DH423118	11.8	12	55	102
DH423119	11.9	12	55	102
DH423120	12.0	12	55	102
DH423123	12.3	14	60	107
DH423125	12.5	14	60	107
DH423128	12.8	14	60	107
DH423130	13.0	14	60	107
DH423135	13.5	14	60	107
DH423138	13.8	14	60	107
DH423140	14.0	14	60	107
DH423145	14.5	16	65	115
DH423148	14.8	16	65	115
DH423150	15.0	16	65	115
DH423155	15.5	16	65	115
DH423158	15.8	16	65	115
DH423160	16.0	16	65	115
DH423165	16.5	18	73	123
DH423168	16.8	18	73	123
DH423170	17.0	18	73	123
DH423175	17.5	18	73	123
DH423178	17.8	18	73	123
DH423180	18.0	18	73	123
DH423185	18.5	20	79	131
DH423190	19.0	20	79	131
DH423195	19.5	20	79	131
DH423198	19.8	20	79	131
DH423200	20.0	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				

DREAM DRILLS -GENERAL

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, DREAM DRILLS, TiAlN COATED
VOLLHARTMETALL DREAM BOHRER, TiAlN-BESCHICHTET

DH404, DH423, DH424 SERIES

Unit : mm

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
STRENGTH	< 700 N/mm²		< 1000 N/mm²		< HB240, GG25		< HB300, GG40	
DIAMETER	N	S	N	S	N	S	N	S
1	13000	0.04	11250	0.04	21300	0.04	14200	0.04
2	13000	0.06	11250	0.06	21300	0.06	14200	0.06
3	13000	0.13	11000	0.13	21000	0.13	14000	0.13
4	9500	0.14	8400	0.14	16000	0.14	10500	0.14
5	7600	0.15	6700	0.15	13000	0.15	8300	0.15
6	6400	0.17	5600	0.17	11000	0.17	6900	0.17
7	5500	0.19	4800	0.19	9100	0.19	5900	0.19
8	4800	0.21	4200	0.21	8000	0.21	5200	0.21
9	4200	0.23	3700	0.23	7100	0.23	4600	0.23
10	3800	0.25	3350	0.25	6400	0.25	4150	0.25
12	3200	0.27	2800	0.27	5300	0.27	3450	0.27
14	2750	0.29	2400	0.29	4550	0.29	3000	0.29
16	2400	0.31	2100	0.31	4000	0.31	2600	0.31
18	2100	0.33	1850	0.33	3550	0.33	2300	0.33
20	1900	0.35	1650	0.35	3200	0.35	2100	0.35

▶ Recommend to reduce the feed rate as following

N = R.P.M
S = Feed per Revolution (mm/rev.)

Feed 100% : DH404(3×D), DH423(3×D)
Feed 85% : DH424(5×D)

CARBIDE, DREAM DRILLS with COOLANT HOLES DIN6537, TiAlN COATED
VOLLHARTMETALL DREAM BOHRER mit KÜHLKANAL DIN6537, TiAlN-BESCHICHTET

DH406, DH408, DH421 SERIES

Unit : mm

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
STRENGTH	< 700 N/mm²		< 1000 N/mm²		< HB240, GG25		< HB300, GG40	
DIAMETER	N	S	N	S	N	S	N	S
1	16250	0.05	14800	0.05	26600	0.05	17300	0.05
2	16250	0.07	14800	0.07	26600	0.07	17300	0.07
3	16000	0.16	14500	0.16	26000	0.16	17000	0.16
4	12000	0.17	11000	0.17	20000	0.17	13000	0.17
5	9550	0.18	8600	0.18	16000	0.18	10000	0.18
6	8000	0.20	7200	0.20	13000	0.20	8500	0.20
7	6800	0.22	6100	0.22	11500	0.22	7300	0.22
8	6000	0.24	5400	0.24	9900	0.24	6400	0.24
9	5300	0.27	4800	0.27	8800	0.27	5700	0.27
10	4800	0.30	4300	0.30	8000	0.30	5100	0.30
12	4000	0.33	3600	0.33	6600	0.33	4250	0.33
14	3400	0.36	3050	0.36	5700	0.36	3650	0.36
16	3000	0.39	2700	0.39	5000	0.39	3200	0.39
18	2650	0.42	2400	0.42	4400	0.42	2850	0.42
20	2400	0.45	2150	0.45	4000	0.45	2550	0.45

▶ Recommend to reduce the feed rate as following

N = R.P.M
S = Feed per Revolution (mm/rev.)

Feed 100% : DH406(3×D)
Feed 85% : DH408(5×D)
Feed 70% : DH421(8×D)