



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES LONG LANG VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL

- ▶ The tool has the special flute shape and geometry for suitable machining of stainless steels.
- ▶ Excellent chip evacuation due to better surface treatment.
- ▶ Point R-thinning makes superior centering and chip curling.
- ▶ Applied TiAlN coating achieves, the better surface finish of materials to be cut and the longer tool life.

- ▶ Der Bohrer hat eine besondere Nutenform, die sich besonders zur Bearbeitung von rostfreiem Stahl eignet.
- ▶ Ausgezeichnete Entspannung wegen der besseren Oberflächenqualität.
- ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung.
- ▶ Modifizierte TiAlN-Beschichtung verbessert die Oberflächengüte der Bohrung und verlängert die Lebensdauer der Bohrung.



DIN 6537
MG
h6
m7
140°
P.72

5 × D

					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452030	3.0	6	28	66	DH452059	5.9	6	44	82
DH452031	3.1	6	28	66	DH452060	6.0	6	44	82
DH452032	3.2	6	28	66	DH452061	6.1	8	53	91
DH452033	3.3	6	28	66	DH452062	6.2	8	53	91
DH452034	3.4	6	28	66	DH452063	6.3	8	53	91
DH452035	3.5	6	28	66	DH452064	6.4	8	53	91
DH452036	3.6	6	28	66	DH452065	6.5	8	53	91
DH452037	3.7	6	28	66	DH452066	6.6	8	53	91
DH452038	3.8	6	36	74	DH452067	6.7	8	53	91
DH452039	3.9	6	36	74	DH452068	6.8	8	53	91
DH452040	4.0	6	36	74	DH452069	6.9	8	53	91
DH452041	4.1	6	36	74	DH452070	7.0	8	53	91
DH452042	4.2	6	36	74	DH452071	7.1	8	53	91
DH452043	4.3	6	36	74	DH452072	7.2	8	53	91
DH452044	4.4	6	36	74	DH452073	7.3	8	53	91
DH452045	4.5	6	36	74	DH452074	7.4	8	53	91
DH452046	4.6	6	36	74	DH452075	7.5	8	53	91
DH452047	4.7	6	36	74	DH452076	7.6	8	53	91
DH452048	4.8	6	44	82	DH452077	7.7	8	53	91
DH452049	4.9	6	44	82	DH452078	7.8	8	53	91
DH452050	5.0	6	44	82	DH452079	7.9	8	53	91
DH452051	5.1	6	44	82	DH452080	8.0	8	53	91
DH452052	5.2	6	44	82	DH452081	8.1	10	61	103
DH452053	5.3	6	44	82	DH452082	8.2	10	61	103
DH452054	5.4	6	44	82	DH452083	8.3	10	61	103
DH452055	5.5	6	44	82	DH452084	8.4	10	61	103
DH452056	5.6	6	44	82	DH452085	8.5	10	61	103
DH452057	5.7	6	44	82	DH452086	8.6	10	61	103
DH452058	5.8	6	44	82	DH452087	8.7	10	61	103

◎ : 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~							
◎	◎	○				○	◎	○	○		



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TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452088	8.8	10	61	103	DH452117	11.7	12	71	118
DH452089	8.9	10	61	103	DH452118	11.8	12	71	118
DH452090	9.0	10	61	103	DH452119	11.9	12	71	118
DH452091	9.1	10	61	103	DH452120	12.0	12	71	118
DH452092	9.2	10	61	103	DH452121	12.1	14	77	124
DH452093	9.3	10	61	103	DH452122	12.2	14	77	124
DH452094	9.4	10	61	103	DH452123	12.3	14	77	124
DH452095	9.5	10	61	103	DH452124	12.4	14	77	124
DH452096	9.6	10	61	103	DH452125	12.5	14	77	124
DH452097	9.7	10	61	103	DH452126	12.6	14	77	124
DH452098	9.8	10	61	103	DH452127	12.7	14	77	124
DH452099	9.9	10	61	103	DH452128	12.8	14	77	124
DH452100	10.0	10	61	103	DH452129	12.9	14	77	124
DH452101	10.1	12	71	118	DH452130	13.0	14	77	124
DH452102	10.2	12	71	118	DH452131	13.1	14	77	124
DH452103	10.3	12	71	118	DH452132	13.2	14	77	124
DH452104	10.4	12	71	118	DH452133	13.3	14	77	124
DH452105	10.5	12	71	118	DH452134	13.4	14	77	124
DH452106	10.6	12	71	118	DH452135	13.5	14	77	124
DH452107	10.7	12	71	118	DH452136	13.6	14	77	124
DH452108	10.8	12	71	118	DH452137	13.7	14	77	124
DH452109	10.9	12	71	118	DH452138	13.8	14	77	124
DH452110	11.0	12	71	118	DH452139	13.9	14	77	124
DH452111	11.1	12	71	118	DH452140	14.0	14	77	124
DH452112	11.2	12	71	118	DH452141	14.1	16	83	133
DH452113	11.3	12	71	118	DH452142	14.2	16	83	133
DH452114	11.4	12	71	118	DH452143	14.3	16	83	133
DH452115	11.5	12	71	118	DH452144	14.4	16	83	133
DH452116	11.6	12	71	118	DH452145	14.5	16	83	133

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~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		

**DREAM DRILLS
-INOX****RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN****CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER - INOX mit KÜHLKANAL, TiAIN-BESCHICHTET****DH451, DH452, DH453 SERIES**

Unit : mm

WORK MATERIAL	STAINLESS STEELS		STAINLESS STEELS		ALUMINUM		ALUMINUM		TITANIUM Ti ALLOYS		CARBON STEELS ALLOY STEELS		TITANIUM NON FRERROUS	
	< 800 N/mm ²		> 800 N/mm ²		< 10% Si		> 10% Si							
STRENGTH														
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S
3	7400	0.04	4700	0.02	23000	0.12	18500	0.10	5300	0.03	13000	0.04	16000	0.08
4	5600	0.05	3600	0.03	17500	0.18	13900	0.15	4000	0.04	10000	0.05	11900	0.10
5	4400	0.05	2800	0.03	14000	0.20	11000	0.18	3200	0.05	8000	0.05	9500	0.12
6	3700	0.06	2400	0.04	11700	0.25	9300	0.25	2650	0.06	6600	0.06	8000	0.15
8	2800	0.08	1800	0.06	8800	0.30	7000	0.30	2000	0.07	5000	0.08	6000	0.18
10	2200	0.10	1400	0.08	7000	0.40	5600	0.35	1600	0.08	4000	0.10	4800	0.22
12	1900	0.12	1200	0.10	5800	0.50	4600	0.40	1300	0.10	3300	0.12	4000	0.26
14	1600	0.15	1000	0.12	5000	0.60	4000	0.50	1100	0.12	2800	0.15	3400	0.30
16	1400	0.20	900	0.15	4380	0.80	3500	0.60	1000	0.14	2500	0.20	3000	0.40
18	1250	0.22	800	0.17	3900	1.00	3100	0.70	900	0.16	2200	0.22	2650	0.45
20	1120	0.24	720	0.19	3500	1.20	2800	0.80	800	0.18	2000	0.24	2400	0.50

Feed 100% : DH451(3xD), DH452(5XD)

Feed 85% : DH453(8xD)

N = R.P.M

S = Feed per Revolution (mm/rev.)