DREAM DRILLS -GENERAL

DH408 SERIES

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

▶ **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.

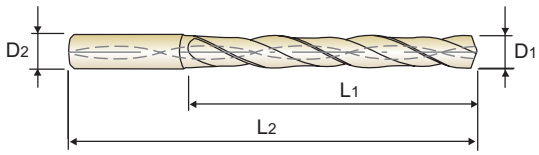
Special Design
- reaming is not required.
- good chip removal
- powerful drilling

▶ **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

5 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH408114	11.4	12	71	118
DH408115	11.5	12	71	118
DH408116	11.6	12	71	118
DH408117	11.7	12	71	118
DH408118	11.8	12	71	118
DH408119	11.9	12	71	118
DH408120	12.0	12	71	118
DH408125	12.5	14	77	124
DH408130	13.0	14	77	124
DH408135	13.5	14	77	124
DH408140	14.0	14	77	124
DH408145	14.5	16	83	133

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH408150	15.0	16	83	133
DH408155	15.5	16	83	133
DH408160	16.0	16	83	133
DH408165	16.5	18	93	143
DH408170	17.0	18	93	143
DH408175	17.5	18	93	143
DH408180	18.0	18	93	143
DH408185	18.5	20	101	153
DH408190	19.0	20	101	153
DH408195	19.5	20	101	153
DH408200	20.0	20	101	153

▶ 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)