

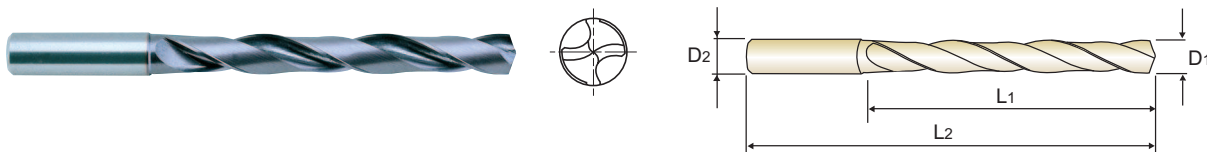


CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER

LONG
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	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH424114	11.4	12	71	118	DH424150	15.0	16	83	133
DH424115	11.5	12	71	118	DH424155	15.5	16	83	133
DH424116	11.6	12	71	118	DH424158	15.8	16	83	133
DH424117	11.7	12	71	118	DH424160	16.0	16	83	133
DH424118	11.8	12	71	118	DH424165	16.5	18	93	143
DH424119	11.9	12	71	118	DH424168	16.8	18	93	143
DH424120	12.0	12	71	118	DH424170	17.0	18	93	143
DH424123	12.3	14	77	124	DH424175	17.5	18	93	143
DH424125	12.5	14	77	124	DH424178	17.8	18	93	143
DH424128	12.8	14	77	124	DH424180	18.0	18	93	143
DH424130	13.0	14	77	124	DH424185	18.5	20	101	153
DH424135	13.5	14	77	124	DH424190	19.0	20	101	153
DH424138	13.8	14	77	124	DH424195	19.5	20	101	153
DH424140	14.0	14	77	124	DH424198	19.8	20	101	153
DH424145	14.5	16	83	133	DH424200	20.0	20	101	153
DH424148	14.8	16	83	133					

► 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~							
○	◎	◎			○		○				

**CARBIDE, DREAM DRILLS, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER, TiAIN-BESCHICHTET****DH404, DH423, DH424 SERIES**

Unit : mm

WORK MATERIAL DIAMETER	NON-ALLOY STEELS < 700 N/mm ²		ALLOY STEELS < 1000 N/mm ²		SOFT GREY CAST IRON < HB240, GG25		HARD GREY CAST IRON < HB300, GG40	
	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, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER mit KÜHLKANAL DIN6537, TiAIN-BESCHICHTET****DH406, DH408, DH421 SERIES**

Unit : mm

WORK MATERIAL DIAMETER	NON-ALLOY STEELS < 700 N/mm ²		ALLOY STEELS < 1000 N/mm ²		SOFT GREY CAST IRON < HB240, GG25		HARD GREY CAST IRON < HB300, GG40	
	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)