



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
DH452146	14.6	16	83	133	DH452174	17.4	18	93	143
DH452147	14.7	16	83	133	DH452175	17.5	18	93	143
DH452148	14.8	16	83	133	DH452176	17.6	18	93	143
DH452149	14.9	16	83	133	DH452177	17.7	18	93	143
DH452150	15.0	16	83	133	DH452178	17.8	18	93	143
DH452151	15.1	16	83	133	DH452179	17.9	18	93	143
DH452152	15.2	16	83	133	DH452180	18.0	18	93	143
DH452153	15.3	16	83	133	DH452181	18.1	20	101	153
DH452154	15.4	16	83	133	DH452182	18.2	20	101	153
DH452155	15.5	16	83	133	DH452183	18.3	20	101	153
DH452156	15.6	16	83	133	DH452184	18.4	20	101	153
DH452157	15.7	16	83	133	DH452185	18.5	20	101	153
DH452158	15.8	16	83	133	DH452186	18.6	20	101	153
DH452159	15.9	16	83	133	DH452187	18.7	20	101	153
DH452160	16.0	16	83	133	DH452188	18.8	20	101	153
DH452161	16.1	18	93	143	DH452189	18.9	20	101	153
DH452162	16.2	18	93	143	DH452190	19.0	20	101	153
DH452163	16.3	18	93	143	DH452191	19.1	20	101	153
DH452164	16.4	18	93	143	DH452192	19.2	20	101	153
DH452165	16.5	18	93	143	DH452193	19.3	20	101	153
DH452166	16.6	18	93	143	DH452194	19.4	20	101	153
DH452167	16.7	18	93	143	DH452195	19.5	20	101	153
DH452168	16.8	18	93	143	DH452196	19.6	20	101	153
DH452169	16.9	18	93	143	DH452197	19.7	20	101	153
DH452170	17.0	18	93	143	DH452198	19.8	20	101	153
DH452171	17.1	18	93	143	DH452199	19.9	20	101	153
DH452172	17.2	18	93	143	DH452200	20.0	20	101	153
DH452173	17.3	18	93	143					

◎ : 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
-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.)