



**DREAM DRILLS -GENERAL**

**DH424 SERIES**

**CARBIDE, DREAM DRILLS**  
**VOLLHARTMETALL DREAM SPIRALBOHRER**

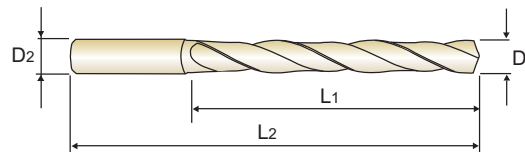
**LONG LANG**

► **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
DH424010	1.0	3	8	55	DH424036	3.6	6	28	66
DH424011	1.1	3	12	55	DH424037	3.7	6	28	66
DH424012	1.2	3	12	55	DH424038	3.8	6	36	74
DH424013	1.3	3	12	55	DH424039	3.9	6	36	74
DH424014	1.4	3	12	55	DH424040	4.0	6	36	74
DH424015	1.5	3	16	55	DH424041	4.1	6	36	74
DH424016	1.6	3	16	55	DH424042	4.2	6	36	74
DH424017	1.7	3	16	55	DH424043	4.3	6	36	74
DH424018	1.8	3	16	55	DH424044	4.4	6	36	74
DH424019	1.9	3	16	55	DH424045	4.5	6	36	74
DH424020	2.0	4	21	57	DH424046	4.6	6	36	74
DH424021	2.1	4	21	57	DH424047	4.7	6	36	74
DH424022	2.2	4	21	57	DH424048	4.8	6	44	82
DH424023	2.3	4	21	57	DH424049	4.9	6	44	82
DH424024	2.4	4	21	57	DH424050	5.0	6	44	82
DH424025	2.5	4	21	57	DH424051	5.1	6	44	82
DH424026	2.6	4	21	57	DH424052	5.2	6	44	82
DH424027	2.7	4	21	57	DH424053	5.3	6	44	82
DH424028	2.8	4	21	57	DH424054	5.4	6	44	82
DH424029	2.9	4	21	57	DH424055	5.5	6	44	82
DH424030	3.0	6	28	66	DH424056	5.6	6	44	82
DH424031	3.1	6	28	66	DH424057	5.7	6	44	82
DH424032	3.2	6	28	66	DH424058	5.8	6	44	82
DH424033	3.3	6	28	66	DH424059	5.9	6	44	82
DH424034	3.4	6	28	66	DH424060	6.0	6	44	82
DH424035	3.5	6	28	66	DH424061	6.1	8	53	91

► 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 <sup>2</sup>		ALLOY STEELS < 1000 N/mm <sup>2</sup>		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 <sup>2</sup>		ALLOY STEELS < 1000 N/mm <sup>2</sup>		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)