



**DREAM DRILLS
-GENERAL**

DH424 SERIES

**CARBIDE, DREAM DRILLS
VOLLHARTMETALL DREAM SPIRALBOHRER**

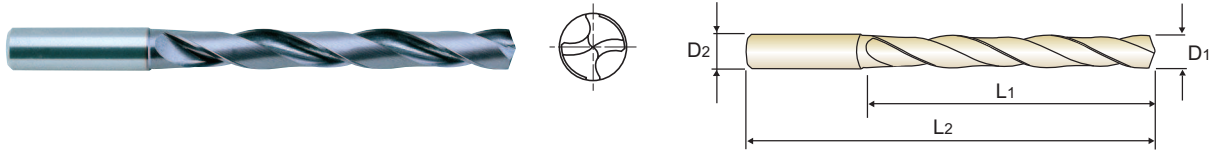
**LONG
LANG**

► **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

TiAlN					TiAlN				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2		D1	D2	L1	L2
DH424062	6.2	8	53	91	DH424088	8.8	10	61	103
DH424063	6.3	8	53	91	DH424089	8.9	10	61	103
DH424064	6.4	8	53	91	DH424090	9.0	10	61	103
DH424065	6.5	8	53	91	DH424091	9.1	10	61	103
DH424066	6.6	8	53	91	DH424092	9.2	10	61	103
DH424067	6.7	8	53	91	DH424093	9.3	10	61	103
DH424068	6.8	8	53	91	DH424094	9.4	10	61	103
DH424069	6.9	8	53	91	DH424095	9.5	10	61	103
DH424070	7.0	8	53	91	DH424096	9.6	10	61	103
DH424071	7.1	8	53	91	DH424097	9.7	10	61	103
DH424072	7.2	8	53	91	DH424098	9.8	10	61	103
DH424073	7.3	8	53	91	DH424099	9.9	10	61	103
DH424074	7.4	8	53	91	DH424100	10.0	10	61	103
DH424075	7.5	8	53	91	DH424101	10.1	12	71	118
DH424076	7.6	8	53	91	DH424102	10.2	12	71	118
DH424077	7.7	8	53	91	DH424103	10.3	12	71	118
DH424078	7.8	8	53	91	DH424104	10.4	12	71	118
DH424079	7.9	8	53	91	DH424105	10.5	12	71	118
DH424080	8.0	8	53	91	DH424106	10.6	12	71	118
DH424081	8.1	10	61	103	DH424107	10.7	12	71	118
DH424082	8.2	10	61	103	DH424108	10.8	12	71	118
DH424083	8.3	10	61	103	DH424109	10.9	12	71	118
DH424084	8.4	10	61	103	DH424110	11.0	12	71	118
DH424085	8.5	10	61	103	DH424111	11.1	12	71	118
DH424086	8.6	10	61	103	DH424112	11.2	12	71	118
DH424087	8.7	10	61	103	DH424113	11.3	12	71	118

► 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

HSS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

**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)