

CARBIDE



Being the best through innovation



DREAM DRILLS -GENERAL





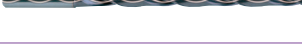
DREAM DRILLS - UNIVERSAL

- WITH & WITHOUT COOLANT HOLES
General Purpose usually HRc30 to HRc50
- Mit und ohne Kühlkanäle
Für allgemeinen Einsatz von HRc30 bis HRc50

SELECTION GUIDE

SOLID CARBIDE DREAM DRILLS - GENERAL (with & without Coolant Holes)

General Purpose usually HRC30 to HRC50

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
3XD DH404		CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER	<i>STUB EXTRA KURZ</i>	D3.0 D20.0	46
3XD DH423		CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER	<i>SHORT KURZ</i>	D3.0 D20.0	48
5XD DH424		CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER	<i>LONG LANG</i>	D1.0 D20.0	50
3XD DH406		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL	<i>SHORT KURZ</i>	D3.0 D20.0	53
5XD DH408		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL	<i>LONG LANG</i>	D1.0 D20.0	55
8XD DH421		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL	<i>EXTRA LONG ÜBERLANG</i>	D3.0 D14.0	58
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN					60

SOLID CARBIDE DREAM DRILLS-GENERAL

◎ : Excellent
○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
			HRc45~55	HRc55~							
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				
○	◎	◎			○		○				
○	◎	◎			○		○				
○	◎	◎			○		○				
○	◎	◎			○		○				
○	◎	◎			○		○				

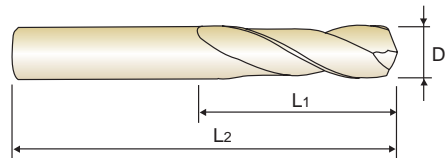
CARBIDE, DREAM DRILLS
VOLLHARTMETALL DREAM SPIRALBOHRER

STUB

EXTRA KURZ

- **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 6539
MG
h6
h7
140°
P.60

D₁=D₂

3 × D

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
TiAlN	D ₁	L ₁	L ₂	TiAlN	D ₁	L ₁	L ₂
DH404030	3.0	16	46	DH404057	5.7	28	66
DH404031	3.1	18	49	DH404058	5.8	28	66
DH404032	3.2	18	49	DH404059	5.9	28	66
DH404033	3.3	18	49	DH404060	6.0	28	66
DH404034	3.4	20	52	DH404061	6.1	31	70
DH404035	3.5	20	52	DH404062	6.2	31	70
DH404036	3.6	20	52	DH404063	6.3	31	70
DH404037	3.7	20	52	DH404064	6.4	31	70
DH404038	3.8	22	55	DH404065	6.5	31	70
DH404039	3.9	22	55	DH404066	6.6	31	70
DH404040	4.0	22	55	DH404067	6.7	31	70
DH404041	4.1	22	55	DH404068	6.8	34	74
DH404042	4.2	22	55	DH404069	6.9	34	74
DH404043	4.3	24	58	DH404070	7.0	34	74
DH404044	4.4	24	58	DH404071	7.1	34	74
DH404045	4.5	24	58	DH404072	7.2	34	74
DH404046	4.6	24	58	DH404073	7.3	34	74
DH404047	4.7	24	58	DH404074	7.4	34	74
DH404048	4.8	26	62	DH404075	7.5	34	74
DH404049	4.9	26	62	DH404076	7.6	37	79
DH404050	5.0	26	62	DH404077	7.7	37	79
DH404051	5.1	26	62	DH404078	7.8	37	79
DH404052	5.2	26	62	DH404079	7.9	37	79
DH404053	5.3	26	62	DH404080	8.0	37	79
DH404054	5.4	28	66	DH404081	8.1	37	79
DH404055	5.5	28	66	DH404082	8.2	37	79
DH404056	5.6	28	66	DH404083	8.3	37	79

► 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~							
○	◎	◎			○		○				

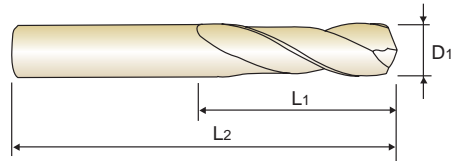
CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER

STUB

EXTRA KURZ

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 - Leistungsfähiges Bohren



$D_1 = D_2$

$3 \times D$

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
TiAlN	D1	L1	L2	TiAlN	D1	L1	L2
DH404084	8.4	37	79	DH404110	11.0	47	95
DH404085	8.5	37	79	DH404115	11.5	47	95
DH404086	8.6	40	84	DH404120	12.0	51	102
DH404087	8.7	40	84	DH404130	13.0	51	102
DH404088	8.8	40	84	DH404135	13.5	54	107
DH404089	8.9	40	84	DH404140	14.0	54	107
DH404090	9.0	40	84	DH404145	14.5	56	111
DH404091	9.1	40	84	DH404150	15.0	56	111
DH404092	9.2	40	84	DH404155	15.5	58	115
DH404093	9.3	40	84	DH404160	16.0	58	115
DH404094	9.4	40	84	DH404165	16.5	60	119
DH404095	9.5	40	84	DH404170	17.0	60	119
DH404096	9.6	43	89	DH404175	17.5	62	123
DH404097	9.7	43	89	DH404180	18.0	62	123
DH404098	9.8	43	89	DH404185	18.5	64	127
DH404099	9.9	43	89	DH404190	19.0	64	127
DH404100	10.0	43	89	DH404195	19.5	66	131
DH404102	10.2	43	89	DH404200	20.0	66	131
DH404105	10.5	43	89				

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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~							
○	◎	◎			○		○				

◎ : Excellent ○ : Good

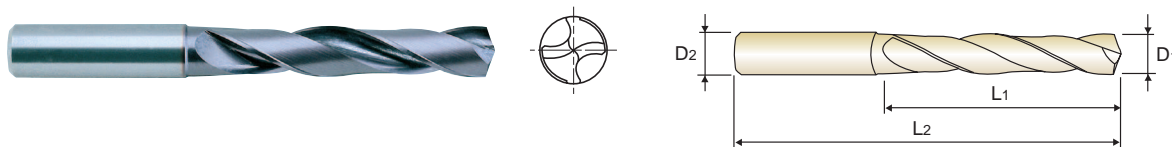


CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER

SHORT
KURZ

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3 × 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
DH423030	3.0	6	20	62	DH423059	5.9	6	28	66
DH423031	3.1	6	20	62	DH423060	6.0	6	28	66
DH423032	3.2	6	20	62	DH423061	6.1	8	34	79
DH423033	3.3	6	20	62	DH423062	6.2	8	34	79
DH423034	3.4	6	20	62	DH423063	6.3	8	34	79
DH423035	3.5	6	20	62	DH423064	6.4	8	34	79
DH423036	3.6	6	20	62	DH423065	6.5	8	34	79
DH423037	3.7	6	20	62	DH423066	6.6	8	34	79
DH423038	3.8	6	24	66	DH423067	6.7	8	34	79
DH423039	3.9	6	24	66	DH423068	6.8	8	34	79
DH423040	4.0	6	24	66	DH423069	6.9	8	34	79
DH423041	4.1	6	24	66	DH423070	7.0	8	34	79
DH423042	4.2	6	24	66	DH423071	7.1	8	41	79
DH423043	4.3	6	24	66	DH423072	7.2	8	41	79
DH423044	4.4	6	24	66	DH423073	7.3	8	41	79
DH423045	4.5	6	24	66	DH423074	7.4	8	41	79
DH423046	4.6	6	24	66	DH423075	7.5	8	41	79
DH423047	4.7	6	24	66	DH423076	7.6	8	41	79
DH423048	4.8	6	28	66	DH423077	7.7	8	41	79
DH423049	4.9	6	28	66	DH423078	7.8	8	41	79
DH423050	5.0	6	28	66	DH423079	7.9	8	41	79
DH423051	5.1	6	28	66	DH423080	8.0	8	41	79
DH423052	5.2	6	28	66	DH423081	8.1	10	47	89
DH423053	5.3	6	28	66	DH423082	8.2	10	47	89
DH423054	5.4	6	28	66	DH423083	8.3	10	47	89
DH423055	5.5	6	28	66	DH423084	8.4	10	47	89
DH423056	5.6	6	28	66	DH423085	8.5	10	47	89
DH423057	5.7	6	28	66	DH423086	8.6	10	47	89
DH423058	5.8	6	28	66	DH423087	8.7	10	47	89

► 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~							
○	◎	◎			○		○				

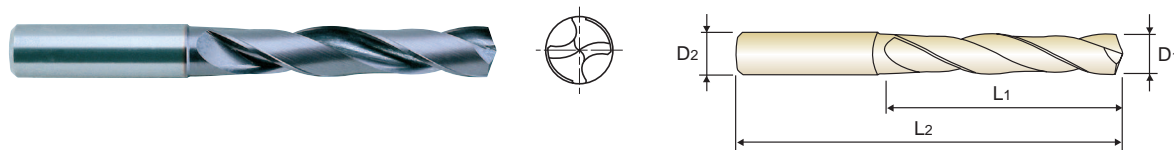
CARBIDE, DREAM DRILLS

VOLLHARTMETALL DREAM SPIRALBOHRER

SHORT
KURZ

- **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.
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**3 × 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
DH423088	8.8	10	47	89	DH423117	11.7	12	55	102
DH423089	8.9	10	47	89	DH423118	11.8	12	55	102
DH423090	9.0	10	47	89	DH423119	11.9	12	55	102
DH423091	9.1	10	47	89	DH423120	12.0	12	55	102
DH423092	9.2	10	47	89	DH423123	12.3	14	60	107
DH423093	9.3	10	47	89	DH423125	12.5	14	60	107
DH423094	9.4	10	47	89	DH423128	12.8	14	60	107
DH423095	9.5	10	47	89	DH423130	13.0	14	60	107
DH423096	9.6	10	47	89	DH423135	13.5	14	60	107
DH423097	9.7	10	47	89	DH423138	13.8	14	60	107
DH423098	9.8	10	47	89	DH423140	14.0	14	60	107
DH423099	9.9	10	47	89	DH423145	14.5	16	65	115
DH423100	10.0	10	47	89	DH423148	14.8	16	65	115
DH423101	10.1	12	55	102	DH423150	15.0	16	65	115
DH423102	10.2	12	55	102	DH423155	15.5	16	65	115
DH423103	10.3	12	55	102	DH423158	15.8	16	65	115
DH423104	10.4	12	55	102	DH423160	16.0	16	65	115
DH423105	10.5	12	55	102	DH423165	16.5	18	73	123
DH423106	10.6	12	55	102	DH423168	16.8	18	73	123
DH423107	10.7	12	55	102	DH423170	17.0	18	73	123
DH423108	10.8	12	55	102	DH423175	17.5	18	73	123
DH423109	10.9	12	55	102	DH423178	17.8	18	73	123
DH423110	11.0	12	55	102	DH423180	18.0	18	73	123
DH423111	11.1	12	55	102	DH423185	18.5	20	79	131
DH423112	11.2	12	55	102	DH423190	19.0	20	79	131
DH423113	11.3	12	55	102	DH423195	19.5	20	79	131
DH423114	11.4	12	55	102	DH423198	19.8	20	79	131
DH423115	11.5	12	55	102	DH423200	20.0	20	79	131
DH423116	11.6	12	55	102					

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~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				

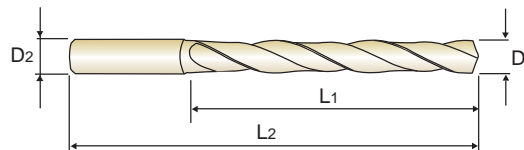
- CARBIDE
- HSS
- i-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -INOX
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- GENERAL CARBIDE DRILLS
- NC-SPOTTING DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- WORM PATTERN DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA

CARBIDE, DREAM DRILLS
VOLLHARTMETALL DREAM SPIRALBOHRER

LONG
LANG

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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
TiAIN	D1	D2	L1	L2	TiAIN	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

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○	◎	◎			○		○				

CARBIDE, DREAM DRILLS

VOLLHARTMETALL DREAM SPIRALBOHRER

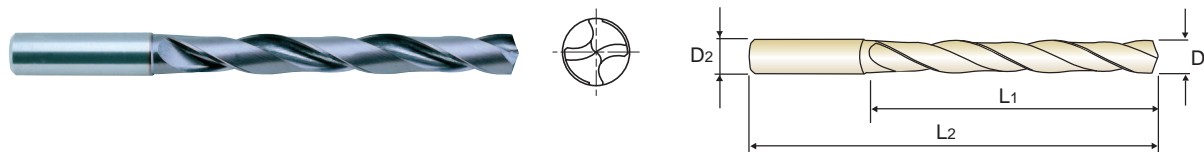
LONG
LANG

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- 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
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~							
○	◎	◎			○		○				

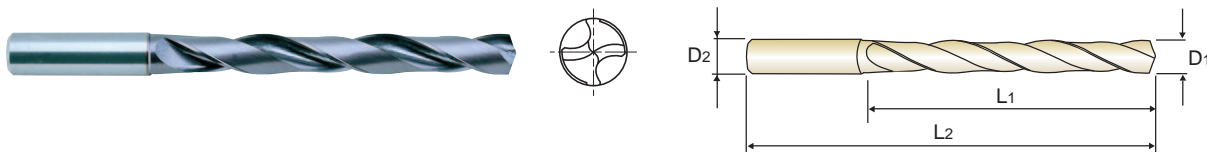


CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER

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

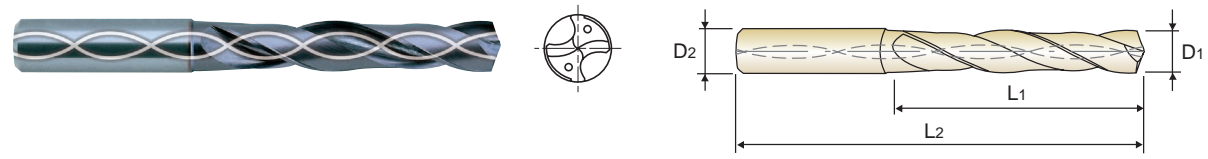
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				

CARBIDE, DREAM DRILLS with COOLANT HOLES SHORT

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL KURZ

- **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



3 × 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
DH406030	3.0	6	20	62	DH406057	5.7	6	28	66
DH406031	3.1	6	20	62	DH406058	5.8	6	28	66
DH406032	3.2	6	20	62	DH406059	5.9	6	28	66
DH406033	3.3	6	20	62	DH406060	6.0	6	28	66
DH406034	3.4	6	20	62	DH406061	6.1	8	34	79
DH406035	3.5	6	20	62	DH406062	6.2	8	34	79
DH406036	3.6	6	20	62	DH406063	6.3	8	34	79
DH406037	3.7	6	20	62	DH406064	6.4	8	34	79
DH406038	3.8	6	24	66	DH406065	6.5	8	34	79
DH406039	3.9	6	24	66	DH406066	6.6	8	34	79
DH406040	4.0	6	24	66	DH406067	6.7	8	34	79
DH406041	4.1	6	24	66	DH406068	6.8	8	34	79
DH406042	4.2	6	24	66	DH406069	6.9	8	34	79
DH406043	4.3	6	24	66	DH406070	7.0	8	34	79
DH406044	4.4	6	24	66	DH406071	7.1	8	41	79
DH406045	4.5	6	24	66	DH406072	7.2	8	41	79
DH406046	4.6	6	24	66	DH406073	7.3	8	41	79
DH406047	4.7	6	24	66	DH406074	7.4	8	41	79
DH406048	4.8	6	28	66	DH406075	7.5	8	41	79
DH406049	4.9	6	28	66	DH406076	7.6	8	41	79
DH406050	5.0	6	28	66	DH406077	7.7	8	41	79
DH406051	5.1	6	28	66	DH406078	7.8	8	41	79
DH406052	5.2	6	28	66	DH406079	7.9	8	41	79
DH406053	5.3	6	28	66	DH406080	8.0	8	41	79
DH406054	5.4	6	28	66	DH406081	8.1	10	47	89
DH406055	5.5	6	28	66	DH406082	8.2	10	47	89
DH406056	5.6	6	28	66	DH406083	8.3	10	47	89

► Other shank types are available on your request.

◎ : Excellent ○ : Good

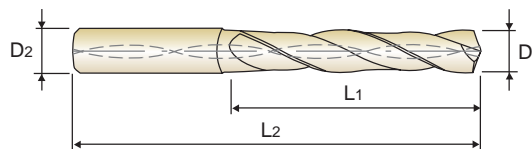
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				

- 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 with COOLANT HOLES **SHORT**
VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL **KURZ**

- **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

3 × 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
DH406084	8.4	10	47	89	DH406111	11.1	12	55	102
DH406085	8.5	10	47	89	DH406112	11.2	12	55	102
DH406086	8.6	10	47	89	DH406113	11.3	12	55	102
DH406087	8.7	10	47	89	DH406114	11.4	12	55	102
DH406088	8.8	10	47	89	DH406115	11.5	12	55	102
DH406089	8.9	10	47	89	DH406116	11.6	12	55	102
DH406090	9.0	10	47	89	DH406117	11.7	12	55	102
DH406091	9.1	10	47	89	DH406118	11.8	12	55	102
DH406092	9.2	10	47	89	DH406119	11.9	12	55	102
DH406093	9.3	10	47	89	DH406120	12.0	12	55	102
DH406094	9.4	10	47	89	DH406125	12.5	14	60	107
DH406095	9.5	10	47	89	DH406130	13.0	14	60	107
DH406096	9.6	10	47	89	DH406135	13.5	14	60	107
DH406097	9.7	10	47	89	DH406140	14.0	14	60	107
DH406098	9.8	10	47	89	DH406145	14.5	16	65	115
DH406099	9.9	10	47	89	DH406150	15.0	16	65	115
DH406100	10.0	10	47	89	DH406155	15.5	16	65	115
DH406101	10.1	12	55	102	DH406160	16.0	16	65	115
DH406102	10.2	12	55	102	DH406165	16.5	18	73	123
DH406103	10.3	12	55	102	DH406170	17.0	18	73	123
DH406104	10.4	12	55	102	DH406175	17.5	18	73	123
DH406105	10.5	12	55	102	DH406180	18.0	18	73	123
DH406106	10.6	12	55	102	DH406185	18.5	20	79	131
DH406107	10.7	12	55	102	DH406190	19.0	20	79	131
DH406108	10.8	12	55	102	DH406195	19.5	20	79	131
DH406109	10.9	12	55	102	DH406200	20.0	20	79	131
DH406110	11.0	12	55	102					

► 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 with COOLANT HOLES

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL

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

**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
DH408010	1.0	3	8	55	DH408036	3.6	6	28	66
DH408011	1.1	3	12	55	DH408037	3.7	6	28	66
DH408012	1.2	3	12	55	DH408038	3.8	6	36	74
DH408013	1.3	3	12	55	DH408039	3.9	6	36	74
DH408014	1.4	3	12	55	DH408040	4.0	6	36	74
DH408015	1.5	3	16	55	DH408041	4.1	6	36	74
DH408016	1.6	3	16	55	DH408042	4.2	6	36	74
DH408017	1.7	3	16	55	DH408043	4.3	6	36	74
DH408018	1.8	3	16	55	DH408044	4.4	6	36	74
DH408019	1.9	3	16	55	DH408045	4.5	6	36	74
DH408020	2.0	4	21	57	DH408046	4.6	6	36	74
DH408021	2.1	4	21	57	DH408047	4.7	6	36	74
DH408022	2.2	4	21	57	DH408048	4.8	6	44	82
DH408023	2.3	4	21	57	DH408049	4.9	6	44	82
DH408024	2.4	4	21	57	DH408050	5.0	6	44	82
DH408025	2.5	4	21	57	DH408051	5.1	6	44	82
DH408026	2.6	4	21	57	DH408052	5.2	6	44	82
DH408027	2.7	4	21	57	DH408053	5.3	6	44	82
DH408028	2.8	4	21	57	DH408054	5.4	6	44	82
DH408029	2.9	4	21	57	DH408055	5.5	6	44	82
DH408030	3.0	6	28	66	DH408056	5.6	6	44	82
DH408031	3.1	6	28	66	DH408057	5.7	6	44	82
DH408032	3.2	6	28	66	DH408058	5.8	6	44	82
DH408033	3.3	6	28	66	DH408059	5.9	6	44	82
DH408034	3.4	6	28	66	DH408060	6.0	6	44	82
DH408035	3.5	6	28	66	DH408061	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~							
○	◎	◎			○		○				



DREAM DRILLS -GENERAL

DH408 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

LONG

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL

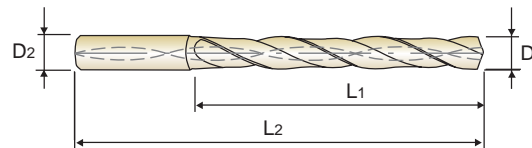
LANG

► **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	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH408062	6.2	8	53	91	DH408088	8.8	10	61	103
DH408063	6.3	8	53	91	DH408089	8.9	10	61	103
DH408064	6.4	8	53	91	DH408090	9.0	10	61	103
DH408065	6.5	8	53	91	DH408091	9.1	10	61	103
DH408066	6.6	8	53	91	DH408092	9.2	10	61	103
DH408067	6.7	8	53	91	DH408093	9.3	10	61	103
DH408068	6.8	8	53	91	DH408094	9.4	10	61	103
DH408069	6.9	8	53	91	DH408095	9.5	10	61	103
DH408070	7.0	8	53	91	DH408096	9.6	10	61	103
DH408071	7.1	8	53	91	DH408097	9.7	10	61	103
DH408072	7.2	8	53	91	DH408098	9.8	10	61	103
DH408073	7.3	8	53	91	DH408099	9.9	10	61	103
DH408074	7.4	8	53	91	DH408100	10.0	10	61	103
DH408075	7.5	8	53	91	DH408101	10.1	12	71	118
DH408076	7.6	8	53	91	DH408102	10.2	12	71	118
DH408077	7.7	8	53	91	DH408103	10.3	12	71	118
DH408078	7.8	8	53	91	DH408104	10.4	12	71	118
DH408079	7.9	8	53	91	DH408105	10.5	12	71	118
DH408080	8.0	8	53	91	DH408106	10.6	12	71	118
DH408081	8.1	10	61	103	DH408107	10.7	12	71	118
DH408082	8.2	10	61	103	DH408108	10.8	12	71	118
DH408083	8.3	10	61	103	DH408109	10.9	12	71	118
DH408084	8.4	10	61	103	DH408110	11.0	12	71	118
DH408085	8.5	10	61	103	DH408111	11.1	12	71	118
DH408086	8.6	10	61	103	DH408112	11.2	12	71	118
DH408087	8.7	10	61	103	DH408113	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, DREAM DRILLS with COOLANT HOLES

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL

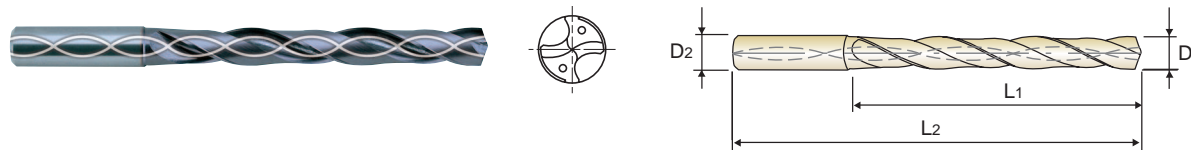
LONG
LANG

► **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
DH408114	11.4	12	71	118	DH408150	15.0	16	83	133
DH408115	11.5	12	71	118	DH408155	15.5	16	83	133
DH408116	11.6	12	71	118	DH408160	16.0	16	83	133
DH408117	11.7	12	71	118	DH408165	16.5	18	93	143
DH408118	11.8	12	71	118	DH408170	17.0	18	93	143
DH408119	11.9	12	71	118	DH408175	17.5	18	93	143
DH408120	12.0	12	71	118	DH408180	18.0	18	93	143
DH408125	12.5	14	77	124	DH408185	18.5	20	101	153
DH408130	13.0	14	77	124	DH408190	19.0	20	101	153
DH408135	13.5	14	77	124	DH408195	19.5	20	101	153
DH408140	14.0	14	77	124	DH408200	20.0	20	101	153
DH408145	14.5	16	83	133					

► Other shank types are available on your request.

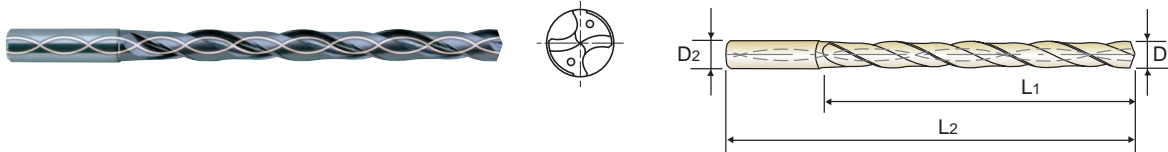
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				

◎ : Excellent ○ : Good

CARBIDE, DREAM DRILLS with COOLANT HOLES EXTRA LONG
VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL ÜBERLANG

- **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

8 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2	TiAIN	D1	D2	L1	L2
DH421030	3.0	6	34	72	DH421055	5.5	6	57	95
DH421031	3.1	6	34	72	DH421056	5.6	6	57	95
DH421032	3.2	6	34	72	DH421057	5.7	6	57	95
DH421033	3.3	6	34	72	DH421058	5.8	6	57	95
DH421034	3.4	6	34	72	DH421059	5.9	6	57	95
DH421035	3.5	6	34	72	DH421060	6.0	6	57	95
DH421036	3.6	6	34	72	DH421061	6.1	8	76	114
DH421037	3.7	6	34	72	DH421062	6.2	8	76	114
DH421038	3.8	6	43	81	DH421063	6.3	8	76	114
DH421039	3.9	6	43	81	DH421064	6.4	8	76	114
DH421040	4.0	6	43	81	DH421065	6.5	8	76	114
DH421041	4.1	6	43	81	DH421066	6.6	8	76	114
DH421042	4.2	6	43	81	DH421067	6.7	8	76	114
DH421043	4.3	6	43	81	DH421068	6.8	8	76	114
DH421044	4.4	6	43	81	DH421069	6.9	8	76	114
DH421045	4.5	6	43	81	DH421070	7.0	8	76	114
DH421046	4.6	6	43	81	DH421071	7.1	8	76	114
DH421047	4.7	6	43	81	DH421072	7.2	8	76	114
DH421048	4.8	6	57	95	DH421073	7.3	8	76	114
DH421049	4.9	6	57	95	DH421074	7.4	8	76	114
DH421050	5.0	6	57	95	DH421075	7.5	8	76	114
DH421051	5.1	6	57	95	DH421076	7.6	8	76	114
DH421052	5.2	6	57	95	DH421077	7.7	8	76	114
DH421053	5.3	6	57	95	DH421078	7.8	8	76	114
DH421054	5.4	6	57	95	DH421079	7.9	8	76	114

► Other shank types are available on your request.

◎ : Excellent ○ : Good

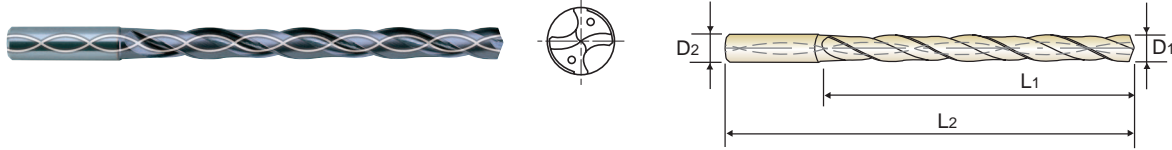
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				

CARBIDE, DREAM DRILLS with COOLANT HOLES EXTRA LONG

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL ÜBERLANG

- **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

8 × 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
DH421080	8.0	8	76	114	DH421103	10.3	12	114	162
DH421081	8.1	10	95	142	DH421104	10.4	12	114	162
DH421082	8.2	10	95	142	DH421105	10.5	12	114	162
DH421083	8.3	10	95	142	DH421106	10.6	12	114	162
DH421084	8.4	10	95	142	DH421107	10.7	12	114	162
DH421085	8.5	10	95	142	DH421108	10.8	12	114	162
DH421086	8.6	10	95	142	DH421109	10.9	12	114	162
DH421087	8.7	10	95	142	DH421110	11.0	12	114	162
DH421088	8.8	10	95	142	DH421111	11.1	12	114	162
DH421089	8.9	10	95	142	DH421112	11.2	12	114	162
DH421090	9.0	10	95	142	DH421113	11.3	12	114	162
DH421091	9.1	10	95	142	DH421114	11.4	12	114	162
DH421092	9.2	10	95	142	DH421115	11.5	12	114	162
DH421093	9.3	10	95	142	DH421116	11.6	12	114	162
DH421094	9.4	10	95	142	DH421117	11.7	12	114	162
DH421095	9.5	10	95	142	DH421118	11.8	12	114	162
DH421096	9.6	10	95	142	DH421119	11.9	12	114	162
DH421097	9.7	10	95	142	DH421120	12.0	12	114	162
DH421098	9.8	10	95	142	DH421125	12.5	14	133	178
DH421099	9.9	10	95	142	DH421130	13.0	14	133	178
DH421100	10.0	10	95	142	DH421135	13.5	14	133	178
DH421101	10.1	12	114	162	DH421140	14.0	14	133	178
DH421102	10.2	12	114	162					

► 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		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< 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		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< 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)