

CARBIDE



Being the best through innovation






DREAM DRILLS -INOX DREAM DRILLS - INOX

- WITH COOLANT HOLES
Tough Materials like Stainless Steels, Nickel Alloys and Titanium up to HRc35.
- Mit Kühlkanälen
Für zähe Werkstoffe, wie rostfreier Stahl, Nickellegierungen und Titan bis zu HRc35

SELECTION GUIDE

SOLID CARBIDE DREAM DRILLS - INOX (with Coolant Holes)

Tough Materials like Stainless Steels, Nickel Alloys and Titanium up to HRc35.

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
3XD DH451		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>SHORT KURZ</i>	D3.0	D20.0	64
5XD DH452		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>LONG LANG</i>	D3.0	D20.0	67
8XD DH453		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>EXTRA LONG ÜBERLANG</i>	D3.0	D14.0	70
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN					72

SOLID CARBIDE DREAM DRILLS-INOX

◎ : Excellent
○ : Good

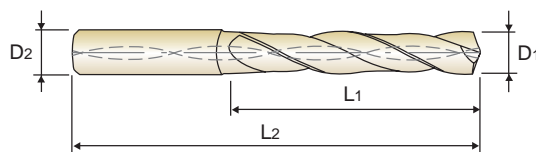
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
			HRc45~55	HRc55~							
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		
◎	◎	○				○	◎	○	○		
◎	◎	○				○	◎	○	○		



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES *SHORT*
VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL *KURZ*

- ▶ 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

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
DH451030	3.0	6	20	62	DH451059	5.9	6	28	66
DH451031	3.1	6	20	62	DH451060	6.0	6	28	66
DH451032	3.2	6	20	62	DH451061	6.1	8	34	79
DH451033	3.3	6	20	62	DH451062	6.2	8	34	79
DH451034	3.4	6	20	62	DH451063	6.3	8	34	79
DH451035	3.5	6	20	62	DH451064	6.4	8	34	79
DH451036	3.6	6	20	62	DH451065	6.5	8	34	79
DH451037	3.7	6	20	62	DH451066	6.6	8	34	79
DH451038	3.8	6	24	66	DH451067	6.7	8	34	79
DH451039	3.9	6	24	66	DH451068	6.8	8	34	79
DH451040	4.0	6	24	66	DH451069	6.9	8	34	79
DH451041	4.1	6	24	66	DH451070	7.0	8	34	79
DH451042	4.2	6	24	66	DH451071	7.1	8	41	79
DH451043	4.3	6	24	66	DH451072	7.2	8	41	79
DH451044	4.4	6	24	66	DH451073	7.3	8	41	79
DH451045	4.5	6	24	66	DH451074	7.4	8	41	79
DH451046	4.6	6	24	66	DH451075	7.5	8	41	79
DH451047	4.7	6	24	66	DH451076	7.6	8	41	79
DH451048	4.8	6	28	66	DH451077	7.7	8	41	79
DH451049	4.9	6	28	66	DH451078	7.8	8	41	79
DH451050	5.0	6	28	66	DH451079	7.9	8	41	79
DH451051	5.1	6	28	66	DH451080	8.0	8	41	79
DH451052	5.2	6	28	66	DH451081	8.1	10	47	89
DH451053	5.3	6	28	66	DH451082	8.2	10	47	89
DH451054	5.4	6	28	66	DH451083	8.3	10	47	89
DH451055	5.5	6	28	66	DH451084	8.4	10	47	89
DH451056	5.6	6	28	66	DH451085	8.5	10	47	89
DH451057	5.7	6	28	66	DH451086	8.6	10	47	89
DH451058	5.8	6	28	66	DH451087	8.7	10	47	89

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

- ▶ 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

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
DH451088	8.8	10	47	89	DH451117	11.7	12	55	102
DH451089	8.9	10	47	89	DH451118	11.8	12	55	102
DH451090	9.0	10	47	89	DH451119	11.9	12	55	102
DH451091	9.1	10	47	89	DH451120	12.0	12	55	102
DH451092	9.2	10	47	89	DH451121	12.1	14	60	107
DH451093	9.3	10	47	89	DH451122	12.2	14	60	107
DH451094	9.4	10	47	89	DH451123	12.3	14	60	107
DH451095	9.5	10	47	89	DH451124	12.4	14	60	107
DH451096	9.6	10	47	89	DH451125	12.5	14	60	107
DH451097	9.7	10	47	89	DH451126	12.6	14	60	107
DH451098	9.8	10	47	89	DH451127	12.7	14	60	107
DH451099	9.9	10	47	89	DH451128	12.8	14	60	107
DH451100	10.0	10	47	89	DH451129	12.9	14	60	107
DH451101	10.1	12	55	102	DH451130	13.0	14	60	107
DH451102	10.2	12	55	102	DH451131	13.1	14	60	107
DH451103	10.3	12	55	102	DH451132	13.2	14	60	107
DH451104	10.4	12	55	102	DH451133	13.3	14	60	107
DH451105	10.5	12	55	102	DH451134	13.4	14	60	107
DH451106	10.6	12	55	102	DH451135	13.5	14	60	107
DH451107	10.7	12	55	102	DH451136	13.6	14	60	107
DH451108	10.8	12	55	102	DH451137	13.7	14	60	107
DH451109	10.9	12	55	102	DH451138	13.8	14	60	107
DH451110	11.0	12	55	102	DH451139	13.9	14	60	107
DH451111	11.1	12	55	102	DH451140	14.0	14	60	107
DH451112	11.2	12	55	102	DH451141	14.1	16	65	115
DH451113	11.3	12	55	102	DH451142	14.2	16	65	115
DH451114	11.4	12	55	102	DH451143	14.3	16	65	115
DH451115	11.5	12	55	102	DH451144	14.4	16	65	115
DH451116	11.6	12	55	102	DH451145	14.5	16	65	115

◎ : Excellent ○ : Good

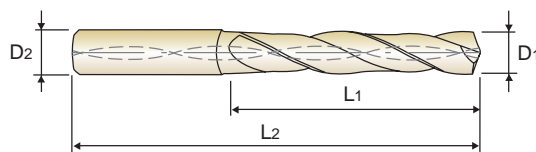
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES **SHORT**
VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL **KURZ**

- ▶ 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

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
DH451146	14.6	16	65	115	DH451174	17.4	18	73	123
DH451147	14.7	16	65	115	DH451175	17.5	18	73	123
DH451148	14.8	16	65	115	DH451176	17.6	18	73	123
DH451149	14.9	16	65	115	DH451177	17.7	18	73	123
DH451150	15.0	16	65	115	DH451178	17.8	18	73	123
DH451151	15.1	16	65	115	DH451179	17.9	18	73	123
DH451152	15.2	16	65	115	DH451180	18.0	18	73	123
DH451153	15.3	16	65	115	DH451181	18.1	20	79	131
DH451154	15.4	16	65	115	DH451182	18.2	20	79	131
DH451155	15.5	16	65	115	DH451183	18.3	20	79	131
DH451156	15.6	16	65	115	DH451184	18.4	20	79	131
DH451157	15.7	16	65	115	DH451185	18.5	20	79	131
DH451158	15.8	16	65	115	DH451186	18.6	20	79	131
DH451159	15.9	16	65	115	DH451187	18.7	20	79	131
DH451160	16.0	16	65	115	DH451188	18.8	20	79	131
DH451161	16.1	18	73	123	DH451189	18.9	20	79	131
DH451162	16.2	18	73	123	DH451190	19.0	20	79	131
DH451163	16.3	18	73	123	DH451191	19.1	20	79	131
DH451164	16.4	18	73	123	DH451192	19.2	20	79	131
DH451165	16.5	18	73	123	DH451193	19.3	20	79	131
DH451166	16.6	18	73	123	DH451194	19.4	20	79	131
DH451167	16.7	18	73	123	DH451195	19.5	20	79	131
DH451168	16.8	18	73	123	DH451196	19.6	20	79	131
DH451169	16.9	18	73	123	DH451197	19.7	20	79	131
DH451170	17.0	18	73	123	DH451198	19.8	20	79	131
DH451171	17.1	18	73	123	DH451199	19.9	20	79	131
DH451172	17.2	18	73	123	DH451200	20.0	20	79	131
DH451173	17.3	18	73	123					

◎ : 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 - INOX with COOLANT HOLES

VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL

LONG
LANG

- ▶ 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
DH452030	3.0	6	28	66	DH452059	5.9	6	44	82
DH452031	3.1	6	28	66	DH452060	6.0	6	44	82
DH452032	3.2	6	28	66	DH452061	6.1	8	53	91
DH452033	3.3	6	28	66	DH452062	6.2	8	53	91
DH452034	3.4	6	28	66	DH452063	6.3	8	53	91
DH452035	3.5	6	28	66	DH452064	6.4	8	53	91
DH452036	3.6	6	28	66	DH452065	6.5	8	53	91
DH452037	3.7	6	28	66	DH452066	6.6	8	53	91
DH452038	3.8	6	36	74	DH452067	6.7	8	53	91
DH452039	3.9	6	36	74	DH452068	6.8	8	53	91
DH452040	4.0	6	36	74	DH452069	6.9	8	53	91
DH452041	4.1	6	36	74	DH452070	7.0	8	53	91
DH452042	4.2	6	36	74	DH452071	7.1	8	53	91
DH452043	4.3	6	36	74	DH452072	7.2	8	53	91
DH452044	4.4	6	36	74	DH452073	7.3	8	53	91
DH452045	4.5	6	36	74	DH452074	7.4	8	53	91
DH452046	4.6	6	36	74	DH452075	7.5	8	53	91
DH452047	4.7	6	36	74	DH452076	7.6	8	53	91
DH452048	4.8	6	44	82	DH452077	7.7	8	53	91
DH452049	4.9	6	44	82	DH452078	7.8	8	53	91
DH452050	5.0	6	44	82	DH452079	7.9	8	53	91
DH452051	5.1	6	44	82	DH452080	8.0	8	53	91
DH452052	5.2	6	44	82	DH452081	8.1	10	61	103
DH452053	5.3	6	44	82	DH452082	8.2	10	61	103
DH452054	5.4	6	44	82	DH452083	8.3	10	61	103
DH452055	5.5	6	44	82	DH452084	8.4	10	61	103
DH452056	5.6	6	44	82	DH452085	8.5	10	61	103
DH452057	5.7	6	44	82	DH452086	8.6	10	61	103
DH452058	5.8	6	44	82	DH452087	8.7	10	61	103

◎ : 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 - INOX with COOLANT HOLES **LONG**
VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL **LANG**

- ▶ 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.



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
DH452088	8.8	10	61	103	DH452117	11.7	12	71	118
DH452089	8.9	10	61	103	DH452118	11.8	12	71	118
DH452090	9.0	10	61	103	DH452119	11.9	12	71	118
DH452091	9.1	10	61	103	DH452120	12.0	12	71	118
DH452092	9.2	10	61	103	DH452121	12.1	14	77	124
DH452093	9.3	10	61	103	DH452122	12.2	14	77	124
DH452094	9.4	10	61	103	DH452123	12.3	14	77	124
DH452095	9.5	10	61	103	DH452124	12.4	14	77	124
DH452096	9.6	10	61	103	DH452125	12.5	14	77	124
DH452097	9.7	10	61	103	DH452126	12.6	14	77	124
DH452098	9.8	10	61	103	DH452127	12.7	14	77	124
DH452099	9.9	10	61	103	DH452128	12.8	14	77	124
DH452100	10.0	10	61	103	DH452129	12.9	14	77	124
DH452101	10.1	12	71	118	DH452130	13.0	14	77	124
DH452102	10.2	12	71	118	DH452131	13.1	14	77	124
DH452103	10.3	12	71	118	DH452132	13.2	14	77	124
DH452104	10.4	12	71	118	DH452133	13.3	14	77	124
DH452105	10.5	12	71	118	DH452134	13.4	14	77	124
DH452106	10.6	12	71	118	DH452135	13.5	14	77	124
DH452107	10.7	12	71	118	DH452136	13.6	14	77	124
DH452108	10.8	12	71	118	DH452137	13.7	14	77	124
DH452109	10.9	12	71	118	DH452138	13.8	14	77	124
DH452110	11.0	12	71	118	DH452139	13.9	14	77	124
DH452111	11.1	12	71	118	DH452140	14.0	14	77	124
DH452112	11.2	12	71	118	DH452141	14.1	16	83	133
DH452113	11.3	12	71	118	DH452142	14.2	16	83	133
DH452114	11.4	12	71	118	DH452143	14.3	16	83	133
DH452115	11.5	12	71	118	DH452144	14.4	16	83	133
DH452116	11.6	12	71	118	DH452145	14.5	16	83	133

◎ : 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 - 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~							
◎	◎	○				○	◎	○	○		

- 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 - INOX with COOLANT HOLES EXTRA LONG
VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL ÜBERLANG

- ▶ 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

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
DH453030	3.0	6	34	72	DH453057	5.7	6	57	95
DH453031	3.1	6	34	72	DH453058	5.8	6	57	95
DH453032	3.2	6	34	72	DH453059	5.9	6	57	95
DH453033	3.3	6	34	72	DH453060	6.0	6	57	95
DH453034	3.4	6	34	72	DH453061	6.1	8	76	114
DH453035	3.5	6	34	72	DH453062	6.2	8	76	114
DH453036	3.6	6	34	72	DH453063	6.3	8	76	114
DH453037	3.7	6	34	72	DH453064	6.4	8	76	114
DH453038	3.8	6	43	81	DH453065	6.5	8	76	114
DH453039	3.9	6	43	81	DH453066	6.6	8	76	114
DH453040	4.0	6	43	81	DH453067	6.7	8	76	114
DH453041	4.1	6	43	81	DH453068	6.8	8	76	114
DH453042	4.2	6	43	81	DH453069	6.9	8	76	114
DH453043	4.3	6	43	81	DH453070	7.0	8	76	114
DH453044	4.4	6	43	81	DH453071	7.1	8	76	114
DH453045	4.5	6	43	81	DH453072	7.2	8	76	114
DH453046	4.6	6	43	81	DH453073	7.3	8	76	114
DH453047	4.7	6	43	81	DH453074	7.4	8	76	114
DH453048	4.8	6	57	95	DH453075	7.5	8	76	114
DH453049	4.9	6	57	95	DH453076	7.6	8	76	114
DH453050	5.0	6	57	95	DH453077	7.7	8	76	114
DH453051	5.1	6	57	95	DH453078	7.8	8	76	114
DH453052	5.2	6	57	95	DH453079	7.9	8	76	114
DH453053	5.3	6	57	95	DH453080	8.0	8	76	114
DH453054	5.4	6	57	95	DH453081	8.1	10	95	142
DH453055	5.5	6	57	95	DH453082	8.2	10	95	142
DH453056	5.6	6	57	95	DH453083	8.3	10	95	142

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 - INOX with COOLANT HOLES *EXTRA LONG*

VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL *ÜBERLANG*

- ▶ 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.



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
DH453084	8.4	10	95	142	DH453105	10.5	12	114	162
DH453085	8.5	10	95	142	DH453106	10.6	12	114	162
DH453086	8.6	10	95	142	DH453107	10.7	12	114	162
DH453087	8.7	10	95	142	DH453108	10.8	12	114	162
DH453088	8.8	10	95	142	DH453109	10.9	12	114	162
DH453089	8.9	10	95	142	DH453110	11.0	12	114	162
DH453090	9.0	10	95	142	DH453111	11.1	12	114	162
DH453091	9.1	10	95	142	DH453112	11.2	12	114	162
DH453092	9.2	10	95	142	DH453113	11.3	12	114	162
DH453093	9.3	10	95	142	DH453114	11.4	12	114	162
DH453094	9.4	10	95	142	DH453115	11.5	12	114	162
DH453095	9.5	10	95	142	DH453116	11.6	12	114	162
DH453096	9.6	10	95	142	DH453117	11.7	12	114	162
DH453097	9.7	10	95	142	DH453118	11.8	12	114	162
DH453098	9.8	10	95	142	DH453119	11.9	12	114	162
DH453099	9.9	10	95	142	DH453120	12.0	12	114	162
DH453100	10.0	10	95	142	DH453125	12.5	14	133	178
DH453101	10.1	12	114	162	DH453130	13.0	14	133	178
DH453102	10.2	12	114	162	DH453135	13.5	14	133	178
DH453103	10.3	12	114	162	DH453140	14.0	14	133	178
DH453104	10.4	12	114	162					

◎ : 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

**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 FERROUS	
	< 800 N/mm ²		> 800 N/mm ²		< 10% Si		> 10% Si		N	S	N	S	N	S
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.)