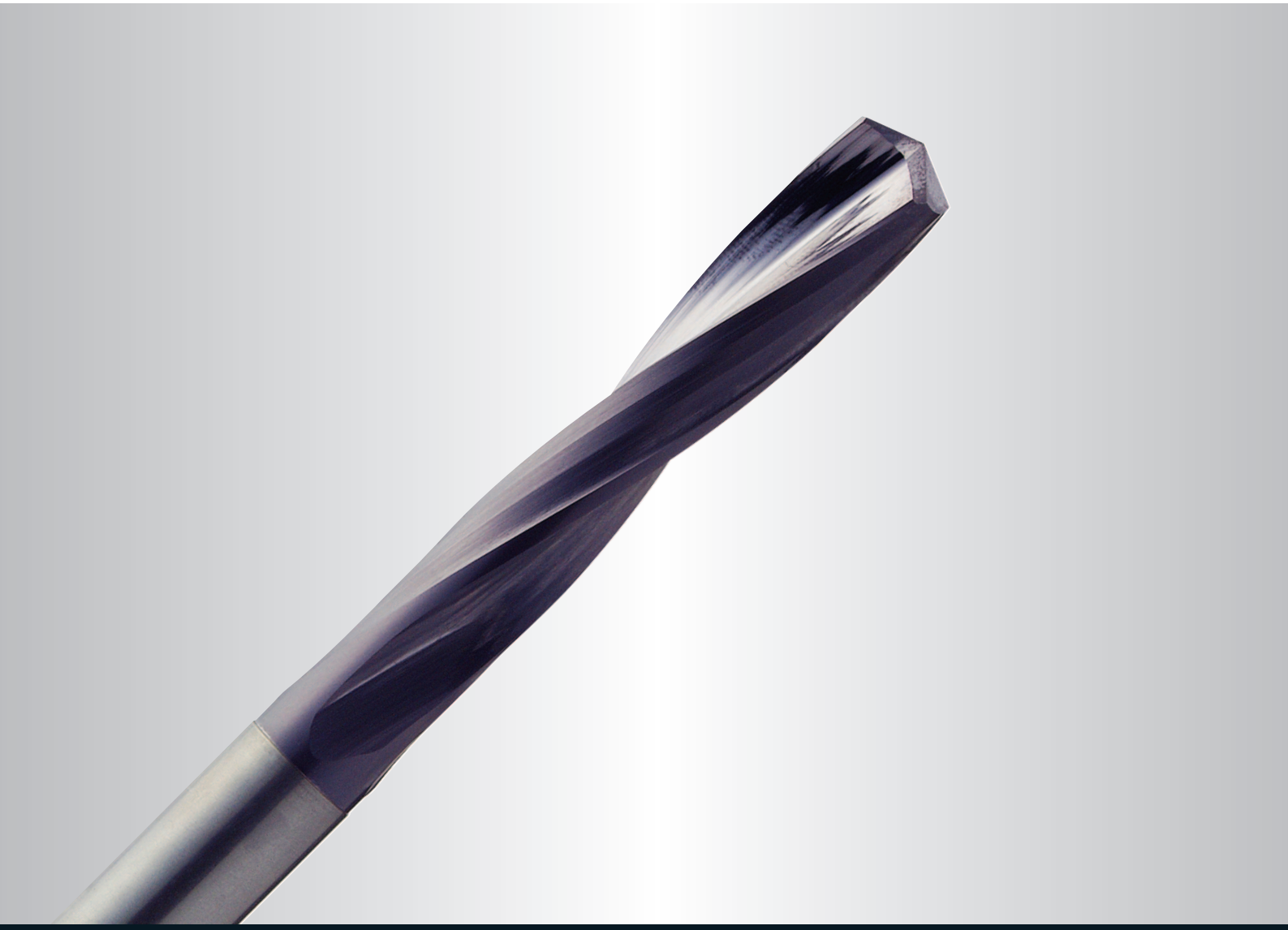
CARBIDE

Being the best through innovation



DREAM DRILLS
- For HIGH HARDENED STEELS
DREAM DRILLS
- FÜR HOCHGEHÄRTETE STÄHLE

- HIGH HARDENED STEELS, HRc50~HRc70
- HOCHGEHÄRTETE STÄHLE HRc50 TO HRc70

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

High Hardened Steels, HRc50~HRc70

◎ : 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~							
			◎	◎							

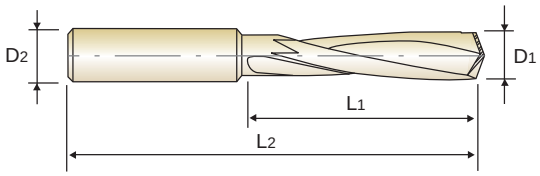
DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70)
VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHÄRTETE STAHLE

▶ **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)
▶ **Advantage** : Special Design
Minimum of cutting load through special thinning
Good chip removal
Powerful Drilling

▶ **Verwendung** : Hoch gehärtete Stähle (Vergütungsstähle, angelassene Stähle) bis HRc 70
▶ **Vorteile** : Spezielle Bohrergeometrie
Minimaler Schneidendruck durch besondere Ausspitzung
Gute Spanabfuhr
Hochleistungsbohren



MG | 15° | h6 | h7 | 140° P.83

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH500026	2.6	3	14	44
DH500030	3.0	3	16	46
DH500033	3.3	4	18	48
DH500034	3.4	4	20	50
DH500035	3.5	4	20	50
DH500040	4.0	4	22	52
DH500042	4.2	6	25	65
DH500043	4.3	6	28	68
DH500044	4.4	6	28	68
DH500045	4.5	6	28	68
DH500050	5.0	6	32	72
DH500051	5.1	6	32	72
DH500052	5.2	6	32	72
DH500055	5.5	6	35	75
DH500060	6.0	6	35	75
DH500065	6.5	8	40	80
DH500068	6.8	8	45	85
DH500069	6.9	8	45	85

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D_1	D_2	L_1	L_2
DH500070	7.0	8	45	85
DH500075	7.5	8	45	85
DH500080	8.0	8	50	98
DH500085	8.5	10	50	98
DH500086	8.6	10	57	105
DH500088	8.8	10	57	105
DH500090	9.0	10	57	105
DH500095	9.5	10	57	105
DH500100	10.0	10	63	111
DH500102	10.2	12	63	111
DH500103	10.3	12	63	111
DH500105	10.5	12	63	111
DH500108	10.8	12	71	119
DH500110	11.0	12	71	119
DH500115	11.5	12	71	119
DH500120	12.0	12	71	119
DH500140	14.0	14	77	125

◎ : 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 for HIGH HARDENED STEELS (HRc50~HRc70), TiAlN COATED
VOLLHARTMETALL DREAM BOHRER für HOCHGEHÄRTETE STÄHLE, TiAlN-BESCHICHTET

DH500 SERIES

Unit : mm

WORK MATERIAL	HARDENED STEELS					
	HRc 50~55		HRc 55~60		HRc 60~70	
DRILLING SPEED	14 ~ 22 m/min		10 ~ 16 m/min		8 ~ 13 m/min	
DIAMETER	N	S	N	S	N	S
3	1900	0.04	1330	0.04	1250	0.04
4	1430	0.04	1000	0.04	950	0.04
5	1150	0.04	800	0.04	750	0.04
6	960	0.04	670	0.04	630	0.04
8	720	0.04	500	0.04	480	0.04
10	570	0.04	400	0.04	380	0.04
12	480	0.04	330	0.04	320	0.04
14	438	0.04	282	0.04	272	0.04

N = R.P.M
S = Feed per Revolution (mm/rev.)