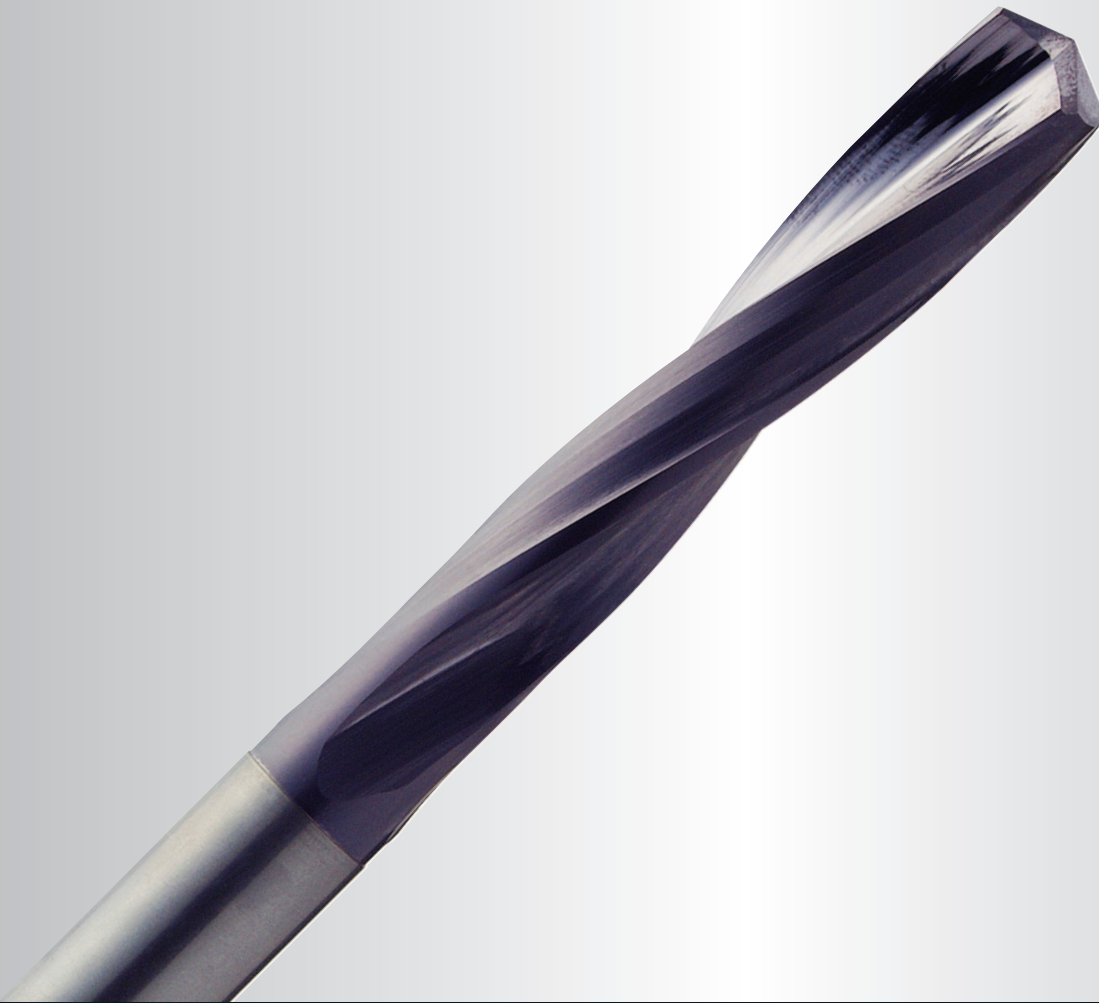


**CARBIDE**



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

# SELECTION GUIDE

## SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

High Hardened Steels, HRc50~HRc70

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
<b>DH500</b>		CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHARTETE STAHL	D3.0	D14.0	<b>82</b>
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			<b>83</b>

# SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

◎ : 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~							
			◎	◎							

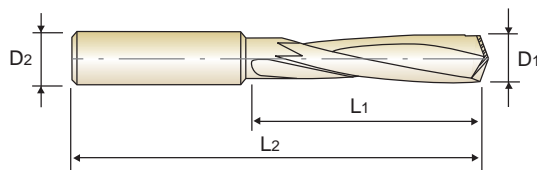
# Y/G DREAM DRILLS for HIGH HARDENED STEELS

## DH500 SERIES

### CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70) VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHARTETE STAHL

- ▶ **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



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
DH500026	2.6	3	14	44	DH500070	7.0	8	45	85
DH500030	3.0	3	16	46	DH500075	7.5	8	45	85
DH500033	3.3	4	18	48	DH500080	8.0	8	50	98
DH500034	3.4	4	20	50	DH500085	8.5	10	50	98
DH500035	3.5	4	20	50	DH500086	8.6	10	57	105
DH500040	4.0	4	22	52	DH500088	8.8	10	57	105
DH500042	4.2	6	25	65	DH500090	9.0	10	57	105
DH500043	4.3	6	28	68	DH500095	9.5	10	57	105
DH500044	4.4	6	28	68	DH500100	10.0	10	63	111
DH500045	4.5	6	28	68	DH500102	10.2	12	63	111
DH500050	5.0	6	32	72	DH500103	10.3	12	63	111
DH500051	5.1	6	32	72	DH500105	10.5	12	63	111
DH500052	5.2	6	32	72	DH500108	10.8	12	71	119
DH500055	5.5	6	35	75	DH500110	11.0	12	71	119
DH500060	6.0	6	35	75	DH500115	11.5	12	71	119
DH500065	6.5	8	40	80	DH500120	12.0	12	71	119
DH500068	6.8	8	45	85	DH500140	14.0	14	77	125
DH500069	6.9	8	45	85					

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



# DREAM DRILLS for HIGH HARDENED STEELS

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

### 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.)

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