



Leading Through Innovation

CARBIDE



DREAM DRILLS -ALU

DREAM DRILLS - ALU

- with Coolant Holes
For Drilling Aluminum & Aluminum Alloys
- Mit Kühlkanälen
Zum Bohren von Aluminium und Aluminium-Legierungen

SELECTION GUIDE

SOLID CARBIDE DREAM DRILLS - ALU (with Coolant Holes) For Drilling Aluminum & Aluminum Alloys

ITEM	MODEL	DESCRIPTION	SIZE		PAGE	
			MIN	MAX		
3XD D5432		CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL	<i>SHORT KURZ</i>	D3.0	D20.0	128
5XD D5433		CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL	<i>LONG LANG</i>	D3.0	D20.0	130
8XD D5434		CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL	<i>EXTRA LONG ÜBERLANG</i>	D3.0	D14.0	132
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN						134

SOLID CARBIDE DREAM DRILLS-ALU

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
							◎				
							◎				
							◎				

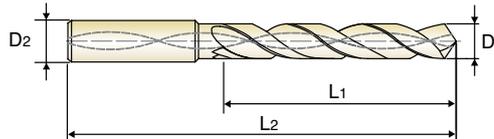
CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

**SHORT
KURZ
COURTE
CORTA**

🇩🇪 VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL
🇫🇷 Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série courte
🇮🇹 PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione)

▶ Good chip treatment due to flute geometry & chip space
 ▶ Better finish & built-up edge preventive

▶ Bessere Entspannung durch eine angepasste Spann-Geometrie & großem Span-Volumen
 ▶ Verbesserte Schlifffüte & Schneidkanten-Präparation



DIN 6537
MG
30°
h6
m7
118°
20 bar

P.134

3 × D

Unit : mm

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
D5432030	3.0	6	20	62	D5432057	5.7	6	28	66
D5432031	3.1	6	20	62	D5432058	5.8	6	28	66
D5432032	3.2	6	20	62	D5432059	5.9	6	28	66
D5432033	3.3	6	20	62	D5432060	6.0	6	28	66
D5432034	3.4	6	20	62	D5432061	6.1	8	34	79
D5432035	3.5	6	20	62	D5432062	6.2	8	34	79
D5432036	3.6	6	20	62	D5432063	6.3	8	34	79
D5432037	3.7	6	20	62	D5432064	6.4	8	34	79
D5432038	3.8	6	24	66	D5432065	6.5	8	34	79
D5432039	3.9	6	24	66	D5432066	6.6	8	34	79
D5432040	4.0	6	24	66	D5432067	6.7	8	34	79
D5432041	4.1	6	24	66	D5432068	6.8	8	34	79
D5432042	4.2	6	24	66	D5432069	6.9	8	34	79
D5432043	4.3	6	24	66	D5432070	7.0	8	34	79
D5432044	4.4	6	24	66	D5432071	7.1	8	41	79
D5432045	4.5	6	24	66	D5432072	7.2	8	41	79
D5432046	4.6	6	24	66	D5432073	7.3	8	41	79
D5432047	4.7	6	24	66	D5432074	7.4	8	41	79
D5432048	4.8	6	28	66	D5432075	7.5	8	41	79
D5432049	4.9	6	28	66	D5432076	7.6	8	41	79
D5432050	5.0	6	28	66	D5432077	7.7	8	41	79
D5432051	5.1	6	28	66	D5432078	7.8	8	41	79
D5432052	5.2	6	28	66	D5432079	7.9	8	41	79
D5432053	5.3	6	28	66	D5432080	8.0	8	41	79
D5432054	5.4	6	28	66	D5432081	8.1	10	47	89
D5432055	5.5	6	28	66	D5432082	8.2	10	47	89
D5432056	5.6	6	28	66	D5432083	8.3	10	47	89

▶ DLC coating is available on your request.
 ▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎											

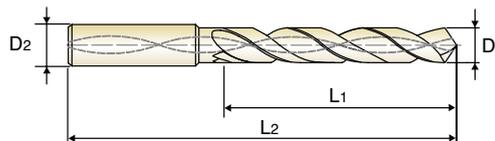
CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

 VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL
 Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série courte
 PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione)

SHORT
KURZ
COURTE
CORTA

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spannut-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schligfgüte & Schneidkanten-Präparation



DIN 6537

MG

30°

h6

m7

118°

20 bar



P.134

3 × D

					Unit : mm				
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
D5432084	8.4	10	47	89	D5432111	11.1	12	55	102
D5432085	8.5	10	47	89	D5432112	11.2	12	55	102
D5432086	8.6	10	47	89	D5432113	11.3	12	55	102
D5432087	8.7	10	47	89	D5432114	11.4	12	55	102
D5432088	8.8	10	47	89	D5432115	11.5	12	55	102
D5432089	8.9	10	47	89	D5432116	11.6	12	55	102
D5432090	9.0	10	47	89	D5432117	11.7	12	55	102
D5432091	9.1	10	47	89	D5432118	11.8	12	55	102
D5432092	9.2	10	47	89	D5432119	11.9	12	55	102
D5432093	9.3	10	47	89	D5432120	12.0	12	55	102
D5432094	9.4	10	47	89	D5432125	12.5	14	60	107
D5432095	9.5	10	47	89	D5432130	13.0	14	60	107
D5432096	9.6	10	47	89	D5432135	13.5	14	60	107
D5432097	9.7	10	47	89	D5432140	14.0	14	60	107
D5432098	9.8	10	47	89	D5432145	14.5	16	65	115
D5432099	9.9	10	47	89	D5432150	15.0	16	65	115
D5432100	10.0	10	47	89	D5432155	15.5	16	65	115
D5432101	10.1	12	55	102	D5432160	16.0	16	65	115
D5432102	10.2	12	55	102	D5432165	16.5	18	73	123
D5432103	10.3	12	55	102	D5432170	17.0	18	73	123
D5432104	10.4	12	55	102	D5432175	17.5	18	73	123
D5432105	10.5	12	55	102	D5432180	18.0	18	73	123
D5432106	10.6	12	55	102	D5432185	18.5	20	79	131
D5432107	10.7	12	55	102	D5432190	19.0	20	79	131
D5432108	10.8	12	55	102	D5432195	19.5	20	79	131
D5432109	10.9	12	55	102	D5432200	20.0	20	79	131
D5432110	11.0	12	55	102					

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
							◎				



**DREAM DRILLS
-ALU**

D5433 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

LONG

🇩🇪 **VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL**

LANG

🇫🇷 **Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série longue**

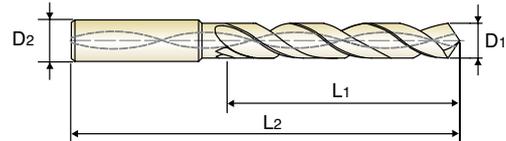
LONGUE

🇮🇹 **PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (CON FORI DI REFRIGERAZIONE)**

LUNGA

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spann-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schliffgüte & Schneidkanten-Präparation



DIN 6537

MG

30°

h6

m7

118°

20 bar



P.134

5 × D

Unit : mm

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
D5433030	3.0	6	28	66	D5433057	5.7	6	44	82
D5433031	3.1	6	28	66	D5433058	5.8	6	44	82
D5433032	3.2	6	28	66	D5433059	5.9	6	44	82
D5433033	3.3	6	28	66	D5433060	6.0	6	44	82
D5433034	3.4	6	28	66	D5433061	6.1	8	53	91
D5433035	3.5	6	28	66	D5433062	6.2	8	53	91
D5433036	3.6	6	28	66	D5433063	6.3	8	53	91
D5433037	3.7	6	28	66	D5433064	6.4	8	53	91
D5433038	3.8	6	36	74	D5433065	6.5	8	53	91
D5433039	3.9	6	36	74	D5433066	6.6	8	53	91
D5433040	4.0	6	36	74	D5433067	6.7	8	53	91
D5433041	4.1	6	36	74	D5433068	6.8	8	53	91
D5433042	4.2	6	36	74	D5433069	6.9	8	53	91
D5433043	4.3	6	36	74	D5433070	7.0	8	53	91
D5433044	4.4	6	36	74	D5433071	7.1	8	53	91
D5433045	4.5	6	36	74	D5433072	7.2	8	53	91
D5433046	4.6	6	36	74	D5433073	7.3	8	53	91
D5433047	4.7	6	36	74	D5433074	7.4	8	53	91
D5433048	4.8	6	44	82	D5433075	7.5	8	53	91
D5433049	4.9	6	44	82	D5433076	7.6	8	53	91
D5433050	5.0	6	44	82	D5433077	7.7	8	53	91
D5433051	5.1	6	44	82	D5433078	7.8	8	53	91
D5433052	5.2	6	44	82	D5433079	7.9	8	53	91
D5433053	5.3	6	44	82	D5433080	8.0	8	53	91
D5433054	5.4	6	44	82	D5433081	8.1	10	61	103
D5433055	5.5	6	44	82	D5433082	8.2	10	61	103
D5433056	5.6	6	44	82	D5433083	8.3	10	61	103

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
						◎					

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

Germany: VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL

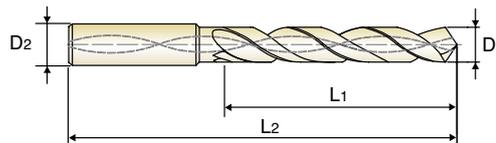
France: Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série longue

Italy: PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (CON FORI DI REFRIGERAZIONE)

LONG
LANG
LONGUE
LUNGA

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spann-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schliffgüte & Schneidkanten-Präparation



DIN 6537

MG

30°

h6

m7

118°

20 bar



P.134

5 × D

Unit : mm

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
D5433084	8.4	10	61	103	D5433111	11.1	12	71	118
D5433085	8.5	10	61	103	D5433112	11.2	12	71	118
D5433086	8.6	10	61	103	D5433113	11.3	12	71	118
D5433087	8.7	10	61	103	D5433114	11.4	12	71	118
D5433088	8.8	10	61	103	D5433115	11.5	12	71	118
D5433089	8.9	10	61	103	D5433116	11.6	12	71	118
D5433090	9.0	10	61	103	D5433117	11.7	12	71	118
D5433091	9.1	10	61	103	D5433118	11.8	12	71	118
D5433092	9.2	10	61	103	D5433119	11.9	12	71	118
D5433093	9.3	10	61	103	D5433120	12.0	12	71	118
D5433094	9.4	10	61	103	D5433125	12.5	14	77	124
D5433095	9.5	10	61	103	D5433130	13.0	14	77	124
D5433096	9.6	10	61	103	D5433135	13.5	14	77	124
D5433097	9.7	10	61	103	D5433140	14.0	14	77	124
D5433098	9.8	10	61	103	D5433145	14.5	16	83	133
D5433099	9.9	10	61	103	D5433150	15.0	16	83	133
D5433100	10.0	10	61	103	D5433155	15.5	16	83	133
D5433101	10.1	12	71	118	D5433160	16.0	16	83	133
D5433102	10.2	12	71	118	D5433165	16.5	18	93	143
D5433103	10.3	12	71	118	D5433170	17.0	18	93	143
D5433104	10.4	12	71	118	D5433175	17.5	18	93	143
D5433105	10.5	12	71	118	D5433180	18.0	18	93	143
D5433106	10.6	12	71	118	D5433185	18.5	20	101	153
D5433107	10.7	12	71	118	D5433190	19.0	20	101	153
D5433108	10.8	12	71	118	D5433195	19.5	20	101	153
D5433109	10.9	12	71	118	D5433200	20.0	20	101	153
D5433110	11.0	12	71	118					

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
							◎				

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

EXTRA LONG

🇩🇪 **VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL**

ÜBERLANG

🇫🇷 **Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série extra-longue**

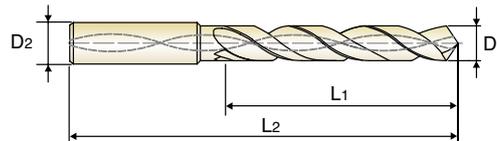
EXTRA-LONGUE

🇮🇹 **PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione)**

EXTRA LUNGA

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spann-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schliffgüte & Schneidkanten-Präparation



DIN 6537
MG
30°
h6
m7
118°
20 bar

P.134

8 × D

Unit : mm

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
D5434030	3.0	6	34	72	D5434057	5.7	6	57	95
D5434031	3.1	6	34	72	D5434058	5.8	6	57	95
D5434032	3.2	6	34	72	D5434059	5.9	6	57	95
D5434033	3.3	6	34	72	D5434060	6.0	6	57	95
D5434034	3.4	6	34	72	D5434061	6.1	8	76	114
D5434035	3.5	6	34	72	D5434062	6.2	8	76	114
D5434036	3.6	6	34	72	D5434063	6.3	8	76	114
D5434037	3.7	6	34	72	D5434064	6.4	8	76	114
D5434038	3.8	6	43	81	D5434065	6.5	8	76	114
D5434039	3.9	6	43	81	D5434066	6.6	8	76	114
D5434040	4.0	6	43	81	D5434067	6.7	8	76	114
D5434041	4.1	6	43	81	D5434068	6.8	8	76	114
D5434042	4.2	6	43	81	D5434069	6.9	8	76	114
D5434043	4.3	6	43	81	D5434070	7.0	8	76	114
D5434044	4.4	6	43	81	D5434071	7.1	8	76	114
D5434045	4.5	6	43	81	D5434072	7.2	8	76	114
D5434046	4.6	6	43	81	D5434073	7.3	8	76	114
D5434047	4.7	6	43	81	D5434074	7.4	8	76	114
D5434048	4.8	6	57	95	D5434075	7.5	8	76	114
D5434049	4.9	6	57	95	D5434076	7.6	8	76	114
D5434050	5.0	6	57	95	D5434077	7.7	8	76	114
D5434051	5.1	6	57	95	D5434078	7.8	8	76	114
D5434052	5.2	6	57	95	D5434079	7.9	8	76	114
D5434053	5.3	6	57	95	D5434080	8.0	8	76	114
D5434054	5.4	6	57	95	D5434081	8.1	10	95	142
D5434055	5.5	6	57	95	D5434082	8.2	10	95	142
D5434056	5.6	6	57	95	D5434083	8.3	10	95	142

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎											

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

EXTRA LONG

▼ VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL

ÜBERLANG

▼ Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série extra-longue

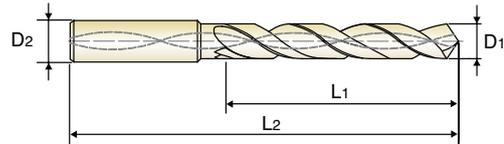
EXTRA-LONGUE

▼ PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione)

EXTRA LUNGA

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spannut-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schliffgüte & Schneidkanten-Präparation



DIN 6537

MG

30°

h6

m7

118°

20 bar



P.134

8 × D

Unit : mm

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
D5434084	8.4	10	95	142	D5434105	10.5	12	114	162
D5434085	8.5	10	95	142	D5434106	10.6	12	114	162
D5434086	8.6	10	95	142	D5434107	10.7	12	114	162
D5434087	8.7	10	95	142	D5434108	10.8	12	114	162
D5434088	8.8	10	95	142	D5434109	10.9	12	114	162
D5434089	8.9	10	95	142	D5434110	11.0	12	114	162
D5434090	9.0	10	95	142	D5434111	11.1	12	114	162
D5434091	9.1	10	95	142	D5434112	11.2	12	114	162
D5434092	9.2	10	95	142	D5434113	11.3	12	114	162
D5434093	9.3	10	95	142	D5434114	11.4	12	114	162
D5434094	9.4	10	95	142	D5434115	11.5	12	114	162
D5434095	9.5	10	95	142	D5434116	11.6	12	114	162
D5434096	9.6	10	95	142	D5434117	11.7	12	114	162
D5434097	9.7	10	95	142	D5434118	11.8	12	114	162
D5434098	9.8	10	95	142	D5434119	11.9	12	114	162
D5434099	9.9	10	95	142	D5434120	12.0	12	114	162
D5434100	10.0	10	95	142	D5434125	12.5	14	133	178
D5434101	10.1	12	114	162	D5434130	13.0	14	133	178
D5434102	10.2	12	114	162	D5434135	13.5	14	133	178
D5434103	10.3	12	114	162	D5434140	14.0	14	133	178
D5434104	10.4	12	114	162					

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
							◎				



**CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES
VOLLHARTMETALL DREAM BOHRER - ALU mit KÜHLKANAL**

D5432, D5433, D5434 SERIES

WORK MATERIAL	N					
	ALUMINIUM ALLOY CASTING ALUMINIUM DIE CASTING			WROUGHT ALUMINIUM ALLOYS		
DIAMETER	RPM	SPEED	FEED	RPM	SPEED	FEED
3.0 ~ 6.0	8,000~15,000	80~150	0.2~0.5	8,000~15,000	80~150	0.15~0.3
~10.0	6,000~10,500	100~200	0.3~1.0	6,000~10,500	100~200	0.2~0.4
~14.0	4,500~5,800	150~250	0.3~1.0	4,500~5,800	150~250	0.2~0.4
~20.0	3,200~4,600	150~200	0.3~1.0	3,200~4,600	150~200	0.2~0.4

RPM = rev./min.
SPEED = m/min.
FEED = mm/rev.