



Leading Through Innovation

CARBIDE



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	82
3XD DH423		CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER <i>SHORT KURZ</i>	D3.0	D20.0	84
5XD DH424		CARBIDE, DREAM DRILLS VOLLHARTMETALL DREAM SPIRALBOHRER <i>LONG LANG</i>	D1.0	D20.0	86
3XD DH406		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL <i>SHORT KURZ</i>	D3.0	D20.0	89
5XD DH408		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL <i>LONG LANG</i>	D1.0	D20.0	91
8XD DH421		CARBIDE, DREAM DRILLS with COOLANT HOLES VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL <i>EXTRA LONG ÜBERLANG</i>	D3.0	D14.0	94
Recommended cutting conditions EMPFOHLENE SCHNEIDKONDITIONEN					96

SOLID CARBIDE DREAM DRILLS-GENERAL

◎ : 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~							
◎	◎	◎			○	○					
◎	◎	◎			○	○					
◎	◎	◎			○	○					
◎	◎	◎			○	○					
◎	◎	◎			○	○					
◎	◎	◎			○	○					

Y/G DREAM DRILLS -GENERAL

DH404 SERIES

CARBIDE, DREAM DRILLS

STUB

VOLLHARTMETALL DREAM SPIRALBOHRER

EXTRA KURZ

Forets DREAM DRILLS carbure, série extra-courte

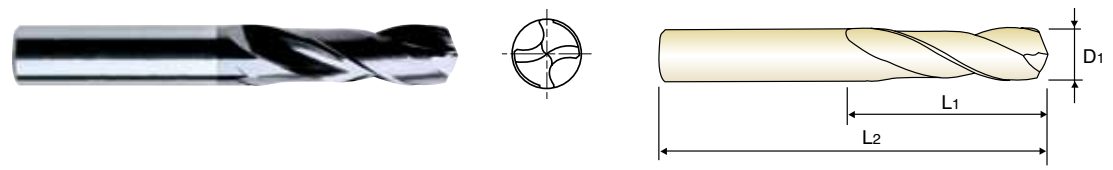
EXTRA-COURTE

PUNTE ELICOIDALI IN MD - DREAM DRILLS

EXTRA CORTA

- **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 30° h6 m7 140° P.96

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.

► NEXT PAGE

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

STUB

🇩🇪 VOLLHARTMETALL DREAM SPIRALBOHRER

EXTRA KURZ

🇫🇷 Forets DREAM DRILLS carbure, série extra-courte

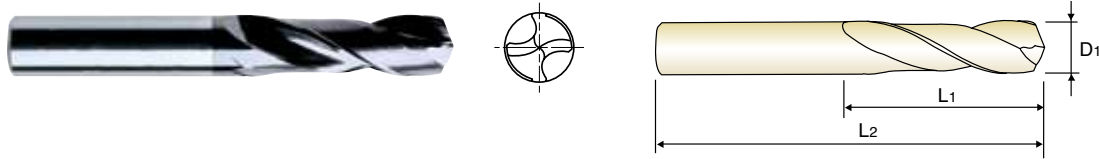
EXTRA-COURTE

🇮🇹 PUNTE ELICOIDALI IN MD - DREAM DRILLS

EXTRA CORTA

- **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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- center drilling is not required.
- Excellent positioning
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- Special Design
- reaming is not required.
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- **Verwendung** : Zum wirtschaftlichen Bohren von Stahl allgemein, Stahlguß, Hart-und Temperguß, Nichteisen Leichtmetallen, abrasiven Kunststoffen.
- **Vorteile** : Selbst zentrierend
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- Keine Führungsbuchse notwendig.
- Spezielles Design
- Räumen ist nicht notwendig
 - Gute Spanabfuhr
 - Leistungsfähiges Bohren



D1=D2

3 x D

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiAIN	D1	L1	L2
DH404084	8.4	37	79
DH404085	8.5	37	79
DH404086	8.6	40	84
DH404087	8.7	40	84
DH404088	8.8	40	84
DH404089	8.9	40	84
DH404090	9.0	40	84
DH404091	9.1	40	84
DH404092	9.2	40	84
DH404093	9.3	40	84
DH404094	9.4	40	84
DH404095	9.5	40	84
DH404096	9.6	43	89
DH404097	9.7	43	89
DH404098	9.8	43	89
DH404099	9.9	43	89
DH404100	10.0	43	89
DH404102	10.2	43	89
DH404105	10.5	43	89

EDP No.	Drill Diameter	Flute Length	Overall Length
TiAIN	D1	L1	L2
DH404110	11.0	47	95
DH404115	11.5	47	95
DH404120	12.0	51	102
DH404130	13.0	51	102
DH404135	13.5	54	107
DH404140	14.0	54	107
DH404145	14.5	56	111
DH404150	15.0	56	111
DH404155	15.5	58	115
DH404160	16.0	58	115
DH404165	16.5	60	119
DH404170	17.0	60	119
DH404175	17.5	62	123
DH404180	18.0	62	123
DH404185	18.5	64	127
DH404190	19.0	64	127
DH404195	19.5	66	131
DH404200	20.0	66	131

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◎ : Excellent ○ : Good

P				H	M	K	N				S
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~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	◎			○	○					

Y/G DREAM DRILLS -GENERAL

DH423 SERIES

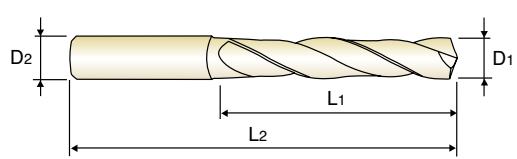
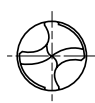
CARBIDE, DREAM DRILLS

- VOLLHARTMETALL DREAM SPIRALBOHRER**
- Forets DREAM DRILLS carbure, série courte**
- PUNTE ELICOIDALI IN MD - DREAM DRILLS**

SHORT
KURZ
COURTE
CORTA

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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. ► 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~							
◎	◎	◎			○	○					

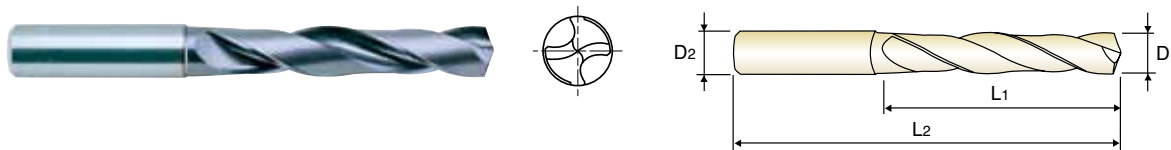
CARBIDE, DREAM DRILLS

 **VOLLHARTMETALL DREAM SPIRALBOHRER**
 **Forets DREAM DRILLS carbure, série courte**
 **PUNTE ELICOIDALI IN MD - DREAM DRILLS**

SHORT
KURZ
COURTE
CORTA

- **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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◎ : 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~							
◎	◎	◎			○	○					

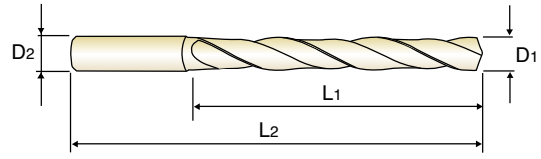
CARBIDE, DREAM DRILLS

**LONG
LANG
LONGUE
LUNGA**

DE VOLLHARTMETALL DREAM SPIRALBOHRER
FR Forets DREAM DRILLS carbure, série longue
IT PUNTE ELICOIDALI IN MD - DREAM DRILLS

- **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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DIN 6539 **MG** **30°** **h6** **m7** **140°** **P.96**

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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► NEXT PAGE

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~							
◎	◎	◎			○	○					

◎ : Excellent ○ : Good

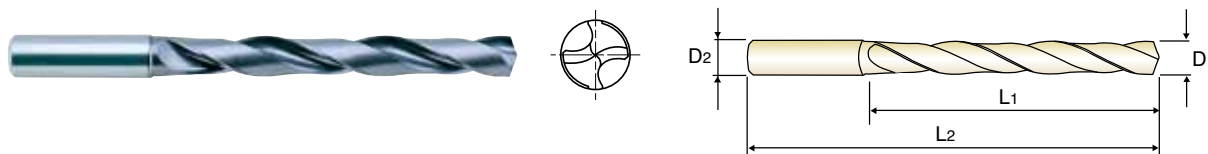
CARBIDE, DREAM DRILLS

VOLLHARTMETALL DREAM SPIRALBOHRER
Forets DREAM DRILLS carbure, série longue
PUNTE ELICOIDALI IN MD - DREAM DRILLS

LONG LANG
LONGUE LUNGA

- **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 30° h6 m7 140° P.96

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.

► 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~							
◎	◎	◎			○	○					

YG DREAM DRILLS -GENERAL

DH424 SERIES

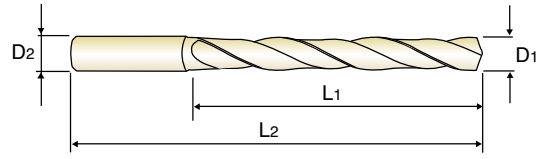
CARBIDE, DREAM DRILLS

LONG LANG LONGUE LUNGA

 **VOLLHARTMETALL DREAM SPIRALBOHRER**
 **Forets DREAM DRILLS carbure, série longue**
 **PUNTE ELICOIDALI IN MD - DREAM DRILLS**

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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
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	DH424160	16.0	16	83	133
DH424117	11.7	12	71	118	DH424165	16.5	18	93	143
DH424118	11.8	12	71	118	DH424170	17.0	18	93	143
DH424119	11.9	12	71	118	DH424175	17.5	18	93	143
DH424120	12.0	12	71	118	DH424180	18.0	18	93	143
DH424125	12.5	14	77	124	DH424185	18.5	20	101	153
DH424130	13.0	14	77	124	DH424190	19.0	20	101	153
DH424135	13.5	14	77	124	DH424195	19.5	20	101	153
DH424140	14.0	14	77	124	DH424200	20.0	20	101	153
DH424145	14.5	16	83	133					

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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~							
◎	◎	◎			○	○					

◎ : Excellent ○ : Good

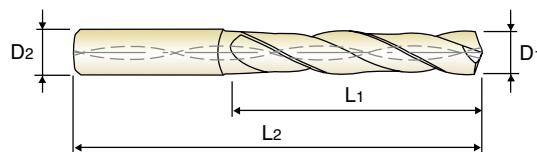
CARBIDE, DREAM DRILLS with COOLANT HOLES

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

SHORT
KURZ
COURTE
CORTA

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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
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

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► NEXT PAGE

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P				H	M	K	N			S	
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~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	◎			○	○					

- CARBIDE
- HSS
- i-ONE DRILLS
- i-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -HIGH FEED
- DREAM DRILLS -FLAT BOTTOM
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MOL
- DREAM DRILLS for HIGH HARDENED STEELS
- GENERAL CARBIDE DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- SUPER-GP DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA

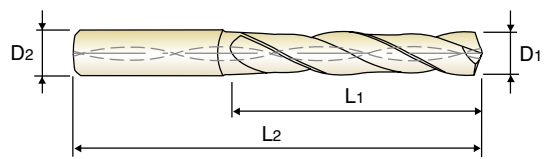
CARBIDE, DREAM DRILLS with COOLANT HOLES

**SHORT
KURZ
COURTE
CORTA**

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
Forets DREAM DRILLS carbure, avec arrosage central, série courte
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DIN 6539 **MG** **30°** **h6** **m7** **140°** **20 bar**

P.96

3 × 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
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					

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P		H		M	K	N			S		
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~HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎	◎	◎			○	○					

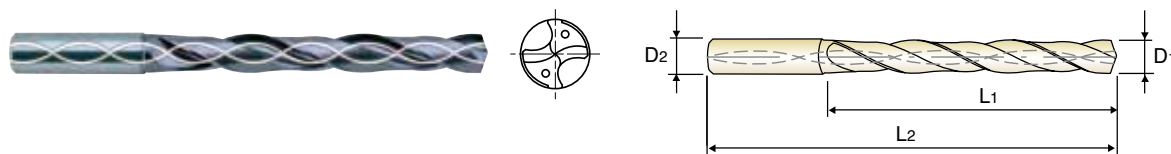
CARBIDE, DREAM DRILLS with COOLANT HOLES

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

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5 × D

Unit : mm					Unit : mm				
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TiAlN	D1	D2	L1	L2	TiAlN	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

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► NEXT PAGE

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◎	◎	◎			○	○					

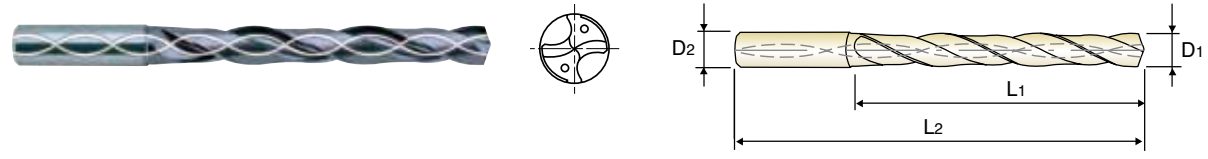
CARBIDE, DREAM DRILLS with COOLANT HOLES

LONG LANG LONGUE LUNGA

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MG
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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. ► NEXT PAGE

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~							
◎	◎	◎			○	○					

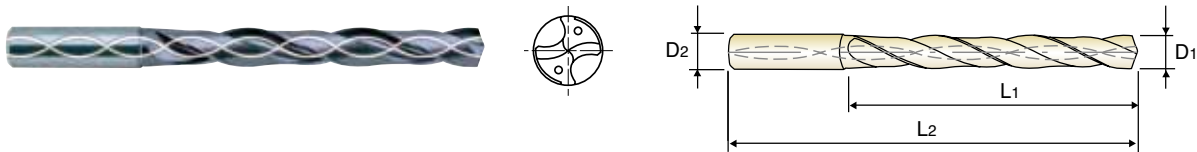
CARBIDE, DREAM DRILLS with COOLANT HOLES

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

LONG
LANG
LONGUE
LUNGA

- **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 | 30° | h6 | m7 | 140° | 20 bar | P.96

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.

© : 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~							
◎	◎	◎			○	○					

Y/G DREAM DRILLS -GENERAL

DH421 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

EXTRA LONG

ÜBERLANG

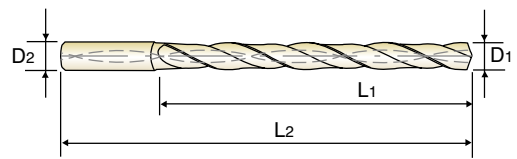
EXTRA-LONGUE

EXTRA LUNGA

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

- **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
30°
h6
m7
140°
20 bar
P.96

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.

► NEXT PAGE

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~							
◎	◎	◎		○	○						

◎ : Excellent ○ : Good

CARBIDE, DREAM DRILLS with COOLANT HOLES

EXTRA LONG

🇩🇪 **VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL**

ÜBERLANG

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

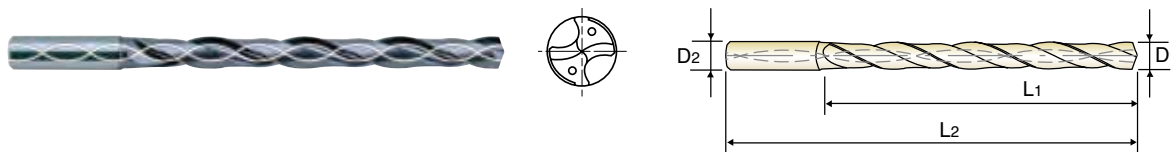
EXTRA-LONGUE

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

EXTRA LUNGA

- **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



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.

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~							
◎	◎	◎			○	○					

◎ : Excellent ○ : Good



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, DREAM DRILLS, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER, TiAIN-BESCHICHTET

DH404, DH423, DH424 SERIES

WORK MATERIAL	P						K											
	NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON								
	STRENGTH < 700 N/mm ²						STRENGTH < 1000 N/mm ²						STRENGTH < HB240, GG25			STRENGTH < HB300, GG40		
DRILLING SPEED	Ø1.0 ~ Ø2.9 : 40 ~ 80 m/min			Ø1.0 ~ Ø2.9 : 35 ~ 70 m/min			Ø1.0 ~ Ø2.9 : 60 ~ 130 m/min			Ø1.0 ~ Ø2.9 : 40 ~ 90 m/min			Ø3.0 ~ : 100 m/min			Ø3.0 ~ : 80 m/min		
DRILLING DIAMETER	RPM	FEED		RPM	FEED		RPM	FEED		RPM	FEED		RPM	FEED				
		Min	Max		Min	Max		Min	Max		Min	Max		Min	Max			
1.0	13000	0.03	0.05	11250	0.03	0.05	21300	0.03	0.05	14200	0.03	0.05	14200	0.03	0.05			
2.0	13000	0.05	0.07	11250	0.05	0.07	21300	0.05	0.07	14200	0.05	0.07	14200	0.05	0.07			
3.0	10500	0.06	0.12	7890	0.06	0.12	10500	0.06	0.12	8410	0.06	0.12	8410	0.06	0.12			
4.0	7920	0.08	0.16	5920	0.08	0.16	7920	0.08	0.16	6310	0.08	0.16	6310	0.08	0.16			
5.0	6310	0.10	0.20	4740	0.10	0.20	6310	0.10	0.20	5050	0.10	0.20	5050	0.10	0.20			
6.0	5270	0.12	0.24	3950	0.12	0.24	5270	0.12	0.24	4220	0.12	0.24	4220	0.12	0.24			
7.0	4510	0.14	0.26	3400	0.14	0.26	4510	0.14	0.26	3610	0.14	0.26	3610	0.14	0.26			
8.0	3950	0.16	0.28	2970	0.16	0.28	3950	0.16	0.28	3160	0.16	0.28	3160	0.16	0.28			
9.0	3510	0.18	0.30	2640	0.18	0.30	3510	0.18	0.30	2820	0.18	0.30	2820	0.18	0.30			
10.0	3160	0.20	0.30	2370	0.20	0.30	3160	0.20	0.30	2530	0.20	0.30	2530	0.20	0.30			
11.0	2880	0.20	0.30	2160	0.20	0.30	2880	0.20	0.30	2310	0.20	0.30	2310	0.20	0.30			
12.0	2640	0.21	0.30	1980	0.21	0.30	2640	0.21	0.30	2120	0.21	0.30	2120	0.21	0.30			
13.0	2430	0.21	0.33	1830	0.21	0.33	2430	0.21	0.33	1950	0.21	0.33	1950	0.21	0.33			
14.0	2260	0.22	0.35	1710	0.22	0.35	2260	0.22	0.35	1810	0.22	0.35	1810	0.22	0.35			
16.0	1980	0.25	0.36	1490	0.25	0.36	1980	0.25	0.36	1590	0.25	0.36	1590	0.25	0.36			
18.0	1760	0.28	0.38	1330	0.28	0.38	1760	0.28	0.38	1420	0.28	0.38	1420	0.28	0.38			
20.0	1590	0.30	0.40	1180	0.30	0.40	1590	0.30	0.40	1270	0.30	0.40	1270	0.30	0.40			

► Recommend to reduce the feed rate as following RPM = rev./min.
FEED = 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

WORK MATERIAL	P						K											
	NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON								
	STRENGTH < 700 N/mm ²						STRENGTH < 1000 N/mm ²						STRENGTH < HB240, GG25			STRENGTH < HB300, GG40		
DRILLING SPEED	Ø1.0 ~ Ø2.9 : 50 ~ 100 m/min			Ø1.0 ~ Ø2.9 : 40 ~ 90 m/min			Ø1.0 ~ Ø2.9 : 80 ~ 160 m/min			Ø1.0 ~ Ø2.9 : 50 ~ 100 m/min			Ø3.0 ~ : 110 m/min			Ø3.0 ~ : 88 m/min		
DRILLING DIAMETER	RPM	FEED		RPM	FEED		RPM	FEED		RPM	FEED		RPM	FEED				
		Min	Max		Min	Max		Min	Max		Min	Max		Min	Max			
1.0	16250	0.04	0.06	14800	0.04	0.06	26600	0.04	0.06	17300	0.04	0.06	17300	0.04	0.06			
2.0	16250	0.06	0.08	14800	0.06	0.08	26600	0.06	0.08	17300	0.06	0.08	17300	0.06	0.08			
3.0	11660	0.06	0.12	8760	0.06	0.12	11660	0.06	0.12	9340	0.06	0.12	9340	0.06	0.12			
4.0	8800	0.08	0.16	6570	0.08	0.16	8800	0.08	0.16	7010	0.08	0.16	7010	0.08	0.16			
5.0	7010	0.10	0.20	5260	0.10	0.20	7010	0.10	0.20	5610	0.10	0.20	5610	0.10	0.20			
6.0	5850	0.12	0.24	4380	0.12	0.24	5850	0.12	0.24	4680	0.12	0.24	4680	0.12	0.24			
7.0	5010	0.14	0.26	3770	0.14	0.26	5010	0.14	0.26	4010	0.14	0.26	4010	0.14	0.26			
8.0	4380	0.16	0.28	2390	0.16	0.28	4380	0.16	0.28	3510	0.16	0.28	3510	0.16	0.28			
9.0	3900	0.18	0.30	2930	0.18	0.30	3900	0.18	0.30	3130	0.18	0.30	3130	0.18	0.30			
10.0	3510	0.20	0.30	2630	0.20	0.30	3510	0.20	0.30	2810	0.20	0.30	2810	0.20	0.30			
11.0	3190	0.20	0.30	2400	0.20	0.30	3190	0.20	0.30	2560	0.20	0.30	2560	0.20	0.30			
12.0	2930	0.21	0.30	2200	0.21	0.30	2930	0.21	0.30	2350	0.21	0.30	2350	0.21	0.30			
13.0	2700	0.21	0.33	2030	0.21	0.33	2700	0.21	0.33	2160	0.21	0.33	2160	0.21	0.33			
14.0	2510	0.22	0.35	1890	0.22	0.35	2510	0.22	0.35	2010	0.22	0.35	2010	0.22	0.35			
16.0	2190	0.25	0.36	1650	0.25	0.36	2190	0.25	0.36	1760	0.25	0.36	1760	0.25	0.36			
18.0	1950	0.28	0.38	1470	0.28	0.38	1950	0.28	0.38	1570	0.28	0.38	1570	0.28	0.38			
20.0	1760	0.30	0.40	1310	0.30	0.40	1760	0.30	0.40	1410	0.30	0.40	1410	0.30	0.40			

► Recommend to reduce the feed rate as following RPM = rev./min.
FEED = mm/rev.
Feed 100% : DH406(3×D) **Feed 85%** : DH408(5×D) **Feed 70%** : DH421(8×D)