



Leading Through Innovation

# CARBIDE



# DREAM DRILLS -INOX


## DREAM DRILLS - INOX

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

# SELECTION GUIDE

## SOLID CARBIDE DREAM DRILLS - INOX (with Coolant Holes)

Tough Materials like Stainless Steels, Nickel Alloys and Titanium

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
<b>3XD DH451</b>		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES <i>SHORT</i> HARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>KURZ</i>	D3.0	D20.0	<b>116</b>
<b>5XD DH452</b>		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES <i>LONG</i> VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>LANG</i>	D1.0	D20.0	<b>119</b>
<b>8XD DH453</b>		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES <i>EXTRA LONG</i> VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL <i>ÜBERLANG</i>	D3.0	D14.0	<b>122</b>
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN					<b>124</b>

# SOLID CARBIDE DREAM DRILLS-INOX

◎ : 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 -INOX**

**DH451 SERIES**

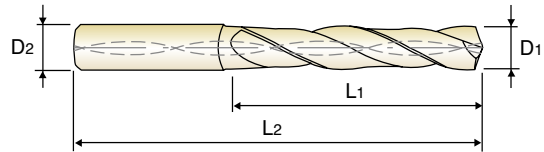
**CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES**

**SHORT  
KURZ  
COURTE  
CORTA**

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

- ▶ 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 TiAIN 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 TiAIN-Beschichtung verbessert die Oberflächengüte der Bohrung und verlängert die Lebensdauer der Bohrung.



DIN 6537
MG
30°
h6
m7
140°
20 bar

P.124

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
DH451030	3.0	6	20	62	DH451050	5.0	6	28	66
DH451031	3.1	6	20	62	DH451051	5.1	6	28	66
DH451032	3.2	6	20	62	DH451052	5.2	6	28	66
DH451033	3.3	6	20	62	DH451053	5.3	6	28	66
DH451034	3.4	6	20	62	DH451054	5.4	6	28	66
DH451035	3.5	6	20	62	DH451055	5.5	6	28	66
DH451036	3.6	6	20	62	DH451056	5.6	6	28	66
DH451037	3.7	6	20	62	DH451057	5.7	6	28	66
DH451038	3.8	6	24	66	DH451058	5.8	6	28	66
DH451039	3.9	6	24	66	DH451059	5.9	6	28	66
DH451040	4.0	6	24	66	DH451060	6.0	6	28	66
DH451041	4.1	6	24	66	DH451061	6.1	8	34	79
DH451042	4.2	6	24	66	DH451062	6.2	8	34	79
DH451043	4.3	6	24	66	DH451063	6.3	8	34	79
DH451044	4.4	6	24	66	DH451064	6.4	8	34	79
DH451045	4.5	6	24	66	DH451065	6.5	8	34	79
DH451046	4.6	6	24	66	DH451066	6.6	8	34	79
DH451047	4.7	6	24	66	DH451067	6.7	8	34	79
DH451048	4.8	6	28	66	DH451068	6.8	8	34	79
DH451049	4.9	6	28	66	DH451069	6.9	8	34	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~							
◎	◎	○			◎		○				○

◎ : Excellent ○ : Good

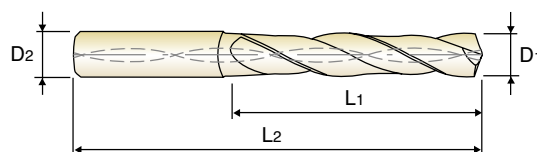
### CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

**SHORT**  
**KURZ**  
**COURTE**  
**CORTA**

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série courte
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DIN 6537
MG
30°
h6
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140°
20 bar
P.124

**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
DH451070	7.0	8	34	79	DH451090	9.0	10	47	89
DH451071	7.1	8	41	79	DH451091	9.1	10	47	89
DH451072	7.2	8	41	79	DH451092	9.2	10	47	89
DH451073	7.3	8	41	79	DH451093	9.3	10	47	89
DH451074	7.4	8	41	79	DH451094	9.4	10	47	89
DH451075	7.5	8	41	79	DH451095	9.5	10	47	89
DH451076	7.6	8	41	79	DH451096	9.6	10	47	89
DH451077	7.7	8	41	79	DH451097	9.7	10	47	89
DH451078	7.8	8	41	79	DH451098	9.8	10	47	89
DH451079	7.9	8	41	79	DH451099	9.9	10	47	89
DH451080	8.0	8	41	79	DH451100	10.0	10	47	89
DH451081	8.1	10	47	89	DH451101	10.1	12	55	102
DH451082	8.2	10	47	89	DH451102	10.2	12	55	102
DH451083	8.3	10	47	89	DH451103	10.3	12	55	102
DH451084	8.4	10	47	89	DH451104	10.4	12	55	102
DH451085	8.5	10	47	89	DH451105	10.5	12	55	102
DH451086	8.6	10	47	89	DH451106	10.6	12	55	102
DH451087	8.7	10	47	89	DH451107	10.7	12	55	102
DH451088	8.8	10	47	89	DH451108	10.8	12	55	102
DH451089	8.9	10	47	89	DH451109	10.9	12	55	102

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▶ NEXT PAGE

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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~							
◎	◎	○			◎		○				○

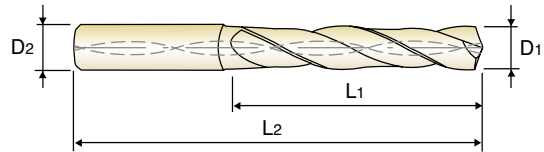
- CARBIDE
- HSS
- I-ONE DRILLS
- I-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -HIGH FEED
- DREAM DRILLS -FLAT BOTTOM
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MQL
- DREAM DRILLS for HIGH HARDENED STEELS
- GENERAL CARBIDE DRILLS
- MULTI-1 DRILLS
- HPD DRILLS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

**CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES**

**SHORT  
KURZ  
COURTE  
CORTA**

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DIN 6537
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P.124

**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
DH451110	11.0	12	55	102	DH451140	14.0	14	60	107
DH451111	11.1	12	55	102	DH451145	14.5	16	65	115
DH451112	11.2	12	55	102	DH451150	15.0	16	65	115
DH451113	11.3	12	55	102	DH451155	15.5	16	65	115
DH451114	11.4	12	55	102	DH451160	16.0	16	65	115
DH451115	11.5	12	55	102	DH451165	16.5	18	73	123
DH451116	11.6	12	55	102	DH451170	17.0	18	73	123
DH451117	11.7	12	55	102	DH451175	17.5	18	73	123
DH451118	11.8	12	55	102	DH451180	18.0	18	73	123
DH451119	11.9	12	55	102	DH451185	18.5	20	79	131
DH451120	12.0	12	55	102	DH451190	19.0	20	79	131
DH451125	12.5	14	60	107	DH451195	19.5	20	79	131
DH451130	13.0	14	60	107	DH451200	20.0	20	79	131
DH451135	13.5	14	60	107					

▶ Other shank types are available on your request.

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

◎ : Excellent ○ : Good

### CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

▼ VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL

LANG

▼ Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série longue

LONGUE

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

LUNGA

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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
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452010	1.0	3	8	55	DH452035	3.5	6	28	66
DH452011	1.1	3	12	55	DH452036	3.6	6	28	66
DH452012	1.2	3	12	55	DH452037	3.7	6	28	66
DH452013	1.3	3	12	55	DH452038	3.8	6	36	74
DH452014	1.4	3	12	55	DH452039	3.9	6	36	74
DH452015	1.5	3	16	55	DH452040	4.0	6	36	74
DH452016	1.6	3	16	55	DH452041	4.1	6	36	74
DH452017	1.7	3	16	55	DH452042	4.2	6	36	74
DH452018	1.8	3	16	55	DH452043	4.3	6	36	74
DH452019	1.9	3	16	55	DH452044	4.4	6	36	74
DH452020	2.0	4	21	57	DH452045	4.5	6	36	74
DH452021	2.1	4	21	57	DH452046	4.6	6	36	74
DH452022	2.2	4	21	57	DH452047	4.7	6	36	74
DH452023	2.3	4	21	57	DH452048	4.8	6	44	82
DH452024	2.4	4	21	57	DH452049	4.9	6	44	82
DH452025	2.5	4	21	57	DH452050	5.0	6	44	82
DH452026	2.6	4	21	57	DH452051	5.1	6	44	82
DH452027	2.7	4	21	57	DH452052	5.2	6	44	82
DH452028	2.8	4	21	57	DH452053	5.3	6	44	82
DH452029	2.9	4	21	57	DH452054	5.4	6	44	82
DH452030	3.0	6	28	66	DH452055	5.5	6	44	82
DH452031	3.1	6	28	66	DH452056	5.6	6	44	82
DH452032	3.2	6	28	66	DH452057	5.7	6	44	82
DH452033	3.3	6	28	66	DH452058	5.8	6	44	82
DH452034	3.4	6	28	66	DH452059	5.9	6	44	82

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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~							
◎	◎	○			◎		○				○

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 -MQL

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 - INOX with COOLANT HOLES**

**LONG**

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

**LANG**

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

**LONGUE**

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

**LUNGA**

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DIN 6537
MG
30°
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20 bar

P.124

**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
DH452060	6.0	6	44	82	DH452085	8.5	10	61	103
DH452061	6.1	8	53	91	DH452086	8.6	10	61	103
DH452062	6.2	8	53	91	DH452087	8.7	10	61	103
DH452063	6.3	8	53	91	DH452088	8.8	10	61	103
DH452064	6.4	8	53	91	DH452089	8.9	10	61	103
DH452065	6.5	8	53	91	DH452090	9.0	10	61	103
DH452066	6.6	8	53	91	DH452091	9.1	10	61	103
DH452067	6.7	8	53	91	DH452092	9.2	10	61	103
DH452068	6.8	8	53	91	DH452093	9.3	10	61	103
DH452069	6.9	8	53	91	DH452094	9.4	10	61	103
DH452070	7.0	8	53	91	DH452095	9.5	10	61	103
DH452071	7.1	8	53	91	DH452096	9.6	10	61	103
DH452072	7.2	8	53	91	DH452097	9.7	10	61	103
DH452073	7.3	8	53	91	DH452098	9.8	10	61	103
DH452074	7.4	8	53	91	DH452099	9.9	10	61	103
DH452075	7.5	8	53	91	DH452100	10.0	10	61	103
DH452076	7.6	8	53	91	DH452101	10.1	12	71	118
DH452077	7.7	8	53	91	DH452102	10.2	12	71	118
DH452078	7.8	8	53	91	DH452103	10.3	12	71	118
DH452079	7.9	8	53	91	DH452104	10.4	12	71	118
DH452080	8.0	8	53	91	DH452105	10.5	12	71	118
DH452081	8.1	10	61	103	DH452106	10.6	12	71	118
DH452082	8.2	10	61	103	DH452107	10.7	12	71	118
DH452083	8.3	10	61	103	DH452108	10.8	12	71	118
DH452084	8.4	10	61	103	DH452109	10.9	12	71	118

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▶ NEXT PAGE

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P		H		M	K	N			S		
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◎	◎	○			◎		○				○

### CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

🇩🇪 VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL

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

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

LONG

LANG

LONGUE

LUNGA

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P.124

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
DH452110	11.0	12	71	118	DH452140	14.0	14	77	124
DH452111	11.1	12	71	118	DH452145	14.5	16	83	133
DH452112	11.2	12	71	118	DH452150	15.0	16	83	133
DH452113	11.3	12	71	118	DH452155	15.5	16	83	133
DH452114	11.4	12	71	118	DH452160	16.0	16	83	133
DH452115	11.5	12	71	118	DH452165	16.5	18	93	143
DH452116	11.6	12	71	118	DH452170	17.0	18	93	143
DH452117	11.7	12	71	118	DH452175	17.5	18	93	143
DH452118	11.8	12	71	118	DH452180	18.0	18	93	143
DH452119	11.9	12	71	118	DH452185	18.5	20	101	153
DH452120	12.0	12	71	118	DH452190	19.0	20	101	153
DH452125	12.5	14	77	124	DH452195	19.5	20	101	153
DH452130	13.0	14	77	124	DH452200	20.0	20	101	153
DH452135	13.5	14	77	124					

▶ 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



**DREAM DRILLS  
-INOX**

**DH453 SERIES**

**CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES**

**EXTRA LONG**

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

**ÜBERLANG**

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

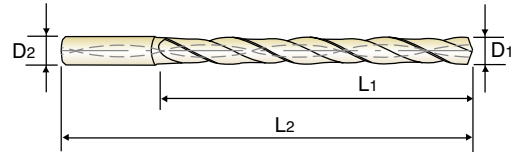
**EXTRA-LONGUE**

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

**EXTRA LUNGA**

- ▶ 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 TiAIN 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 TiAIN-Beschichtung verbessert die Oberflächengüte der Bohrung und verlängert die Lebensdauer der Bohrung.



**DIN 6537**

**MG**

**30°**

**h6**

**m7**

**140°**

**20 bar**



P.124

**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
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

▶ Other shank types are available on your request.

▶ NEXT PAGE

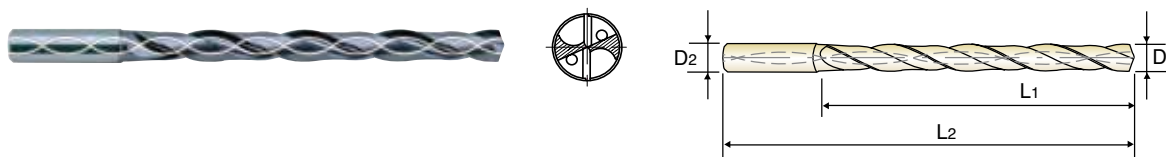
◎ : Excellent ○ : Good

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 - INOX with COOLANT HOLES**
**EXTRA LONG**
**GERMANY VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL**
**ÜBERLANG**
**FRANCE Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série extra-longue**
**EXTRA-LONGUE**
**ITALY PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione)**
**EXTRA LUNGA**

- ▶ 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					

▶ 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~							
◎	◎	○			◎		○				○

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 -MQL

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 - INOX with COOLANT HOLES, TiAIN COATED  
VOLLHARTMETALL DREAM BOHRER - INOX mit KÜHLKANAL, TiAIN-BESCHICHTET**

**DH451, DH452, DH453 SERIES**

WORK MATERIAL	P		M				N				S			
	CARBON STEELS ALLOY STEELS		STAINLESS STEELS		STAINLESS STEELS		ALUMINUM		ALUMINUM		NON FERROUS		TITANIUM Ti ALLOYS	
STRENGTH			< 800 N/mm <sup>2</sup>		> 800 N/mm <sup>2</sup>		< 10% Si		> 10% Si					
DRILLING SPEED	105 ~ 125 m/min		60 ~ 70 m/min		35 ~ 45 m/min		200 ~ 220 m/min		155 ~ 175 m/min		105 ~ 125 m/min		40 ~ 50 m/min	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
	1.0	26000	0.02	12000	0.02	6200	0.02	48000	0.04	38000	0.03	38000	0.02	8100
1.5	18000	0.03	9000	0.03	5400	0.02	43000	0.05	32000	0.04	25500	0.03	7500	0.01
2.5	10800	0.05	7000	0.04	4200	0.03	25500	0.08	19500	0.06	15500	0.05	4500	0.02
3.0	13000	0.04	7400	0.04	4700	0.02	23000	0.12	18500	0.10	16000	0.08	5300	0.03
4.0	10000	0.05	5600	0.05	3600	0.03	17500	0.18	13900	0.15	11900	0.10	4000	0.04
5.0	8000	0.05	4400	0.05	2800	0.03	14000	0.20	11000	0.18	9500	0.12	3200	0.05
6.0	6600	0.06	3700	0.06	2400	0.04	11700	0.25	9300	0.25	8000	0.15	2650	0.06
8.0	5000	0.08	2800	0.08	1800	0.06	8800	0.30	7000	0.30	6000	0.18	2000	0.07
10.0	4000	0.10	2200	0.10	1400	0.08	7000	0.40	5600	0.35	4800	0.22	1600	0.08
12.0	3300	0.12	1900	0.12	1200	0.10	5800	0.50	4600	0.40	4000	0.26	1300	0.10
14.0	2800	0.15	1600	0.15	1000	0.12	5000	0.60	4000	0.50	3400	0.30	1100	0.12
16.0	2500	0.20	1400	0.20	900	0.15	4380	0.80	3500	0.60	3000	0.40	1000	0.14
18.0	2200	0.22	1250	0.22	800	0.17	3900	1.00	3100	0.70	2650	0.45	900	0.16
20.0	2000	0.24	1120	0.24	720	0.19	3500	1.20	2800	0.80	2400	0.50	800	0.18

▶ Recommend to reduce the feed rate as following

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

**Feed 100%** : DH451(3xD), DH452(5xD)  
**Feed 85%** : DH453(8xD)

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  
-MQL

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