

CARBIDE



Leading Through Innovation



DREAM DRILLS - HIGH FEED

DREAM DRILL - HIGH FEED

WITH COOLANT HOLES

- for Carbon Steels, Alloy Steels (up to HRc35) and Cast Iron

Mit Kühlkanäle

- Für Kohlenstoffstähle, Legiertem Stahl (bis HRc35) und Gusseisen

SELECTION GUIDE

SOLID CARBIDE DREAM DRILLS - HIGH FEED (with Coolant Holes)

Carbon Steels, Alloy Steels (up to HRc35) and Cast Iron

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
3 X D DGR493		CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES <i>SHORT</i> HARTMETALL DREAM SPIRALBOHRER - HIGH FEED mit KÜHLKANAL <i>KURZ</i>	D5.0	D16.0	100
5 X D DGR495		CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES <i>LONG</i> HARTMETALL DREAM SPIRALBOHRER - HIGH FEED mit KÜHLKANAL <i>LANG</i>	D5.0	D16.0	102
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			104

SOLID CARBIDE DREAM DRILLS - HIGH FEED

◎ : 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
-HIGH FEED**

DGR493 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

**SHORT
KURZ
COURTE
CORTA**

DREAM DRILLS HIGH FEED mit KÜHLKANAL

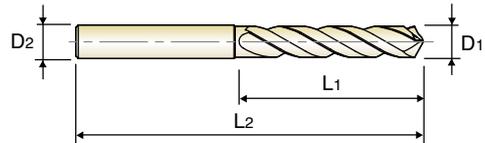
Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série courte

PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)

- ▶ Application : Carbon Steels, Alloy Steels (~ HRC35), Cast Iron
- ▶ Advantage : - Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
- Multi-Layer coating delivers much better productivity and reliability.
- Self-Centering

- ▶ Anwendung: Kohlenstoffstähle, legierte Stähle (~ HRC35), Gusseisen.

- ▶ Vorteile: - Steigerung der Produktivität durch 1,5- bis 2-mal höhere Vorschubgeschwindigkeit als 2-schneidige Bohrer.
- Eine Multi-Layer-Beschichtung ergibt eine höhere Produktivität und Zuverlässigkeit.
- Selbstzentrierend.



DIN 6537
MG
30°
h6
m7
140°
20 bar

P.104

3 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2	H-Coating	D1	D2	L1	L2
DGR493050	5.00	6	28	66	DGR493078	7.80	8	41	79
DGR493051	5.10	6	28	66	DGR493079	7.90	8	41	79
DGR493052	5.20	6	28	66	DGR493080	8.00	8	41	79
DGR493053	5.30	6	28	66	DGR493081	8.10	10	47	89
DGR493054	5.40	6	28	66	DGR493082	8.20	10	47	89
DGR493055	5.50	6	28	66	DGR493083	8.30	10	47	89
DGR493056	5.60	6	28	66	DGR493084	8.40	10	47	89
DGR493057	5.70	6	28	66	DGR493085	8.50	10	47	89
DGR493058	5.80	6	28	66	DGR493086	8.60	10	47	89
DGR493059	5.90	6	28	66	DGR493087	8.70	10	47	89
DGR493060	6.00	6	28	66	DGR493088	8.80	10	47	89
DGR493061	6.10	8	34	79	DGR493089	8.90	10	47	89
DGR493062	6.20	8	34	79	DGR493090	9.00	10	47	89
DGR493063	6.30	8	34	79	DGR493091	9.10	10	47	89
DGR493064	6.40	8	34	79	DGR493092	9.20	10	47	89
DGR493065	6.50	8	34	79	DGR493093	9.30	10	47	89
DGR493066	6.60	8	34	79	DGR493094	9.40	10	47	89
DGR493067	6.70	8	34	79	DGR493095	9.50	10	47	89
DGR493068	6.80	8	34	79	DGR493096	9.60	10	47	89
DGR493069	6.90	8	34	79	DGR493097	9.70	10	47	89
DGR493070	7.00	8	34	79	DGR493098	9.80	10	47	89
DGR493071	7.10	8	41	79	DGR493099	9.90	10	47	89
DGR493072	7.20	8	41	79	DGR493100	10.00	10	47	89
DGR493073	7.30	8	41	79	DGR493101	10.10	12	55	102
DGR493074	7.40	8	41	79	DGR493102	10.20	12	55	102
DGR493075	7.50	8	41	79	DGR493103	10.30	12	55	102
DGR493076	7.60	8	41	79	DGR493104	10.40	12	55	102
DGR493077	7.70	8	41	79	DGR493105	10.50	12	55	102

▶ 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 - HIGH FEED with COOLANT HOLES **SHORT**

DREAM DRILLS HIGH FEED mit KÜHLKANAL

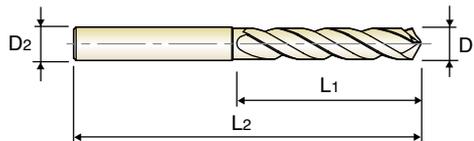
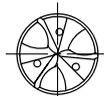
Folets DREAM DRILLS carbure Grande Avance avec arrosage central, série courte

PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)

**SHORT
KURZ
COURTE
CORTA**

- ▶ Application : Carbon Steels, Alloy Steels (~ HRC35), Cast Iron
- ▶ Advantage : - Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
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- ▶ Anwendung: Kohlenstoffstähle, legierte Stähle (~ HRC35), Gusseisen.
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DIN 6537
MG
30°
h6
m7
140°
20 bar

P.104

3 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2
DGR493106	10.60	12	55	102
DGR493107	10.70	12	55	102
DGR493108	10.80	12	55	102
DGR493109	10.90	12	55	102
DGR493110	11.00	12	55	102
DGR493111	11.10	12	55	102
DGR493112	11.20	12	55	102
DGR493113	11.30	12	55	102
DGR493114	11.40	12	55	102
DGR493115	11.50	12	55	102
DGR493116	11.60	12	55	102
DGR493117	11.70	12	55	102
DGR493118	11.80	12	55	102
DGR493119	11.90	12	55	102
DGR493120	12.00	12	55	102
DGR493125	12.50	14	60	107

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2
DGR493130	13.00	14	60	107
DGR493135	13.50	14	60	107
DGR493140	14.00	14	60	107
DGR493145	14.50	16	65	115
DGR493150	15.00	16	65	115
DGR493155	15.50	16	65	115
DGR493160	16.00	16	65	115
DGR493165	16.50	18	73	123
DGR493170	17.00	18	73	123
DGR493175	17.50	18	73	123
DGR493180	18.00	18	73	123
DGR493185	18.50	20	79	131
DGR493190	19.00	20	79	131
DGR493195	19.50	20	79	131
DGR493200	20.00	20	79	131

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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



**DREAM DRILLS
-HIGH FEED**

DGR495 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

LONG

DREAM DRILLS HIGH FEED MIT KÜHLKANAL

KURZ

Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série longue

LONGUE

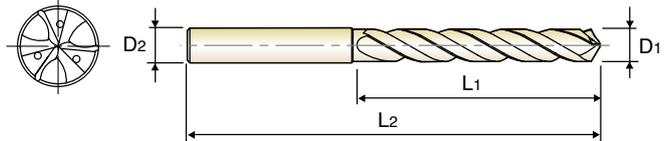
PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)

LUNGA

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DIN 6537
MG
30°
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140°
20 bar

P.104

5 × D

Unit : mm

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H-Coating	D1	D2	L1	L2	H-Coating	D1	D2	L1	L2
DGR495050	5.00	6	44	82	DGR495078	7.80	8	53	91
DGR495051	5.10	6	44	82	DGR495079	7.90	8	53	91
DGR495052	5.20	6	44	82	DGR495080	8.00	8	53	91
DGR495053	5.30	6	44	82	DGR495081	8.10	10	61	103
DGR495054	5.40	6	44	82	DGR495082	8.20	10	61	103
DGR495055	5.50	6	44	82	DGR495083	8.30	10	61	103
DGR495056	5.60	6	44	82	DGR495084	8.40	10	61	103
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DGR495071	7.10	8	53	91	DGR495099	9.90	10	61	103
DGR495072	7.20	8	53	91	DGR495100	10.00	10	61	103
DGR495073	7.30	8	53	91	DGR495101	10.10	12	71	118
DGR495074	7.40	8	53	91	DGR495102	10.20	12	71	118
DGR495075	7.50	8	53	91	DGR495103	10.30	12	71	118
DGR495076	7.60	8	53	91	DGR495104	10.40	12	71	118
DGR495077	7.70	8	53	91	DGR495105	10.50	12	71	118

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▶ NEXT PAGE

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◎	◎	○			◎						

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

DEUTSCH DREAM DRILLS HIGH FEED MIT KÜHLKANAL

FRAZSES DREAM DRILLS carbure Grande Avance avec arrosage central, série longue

ITALIANO PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)

LONG

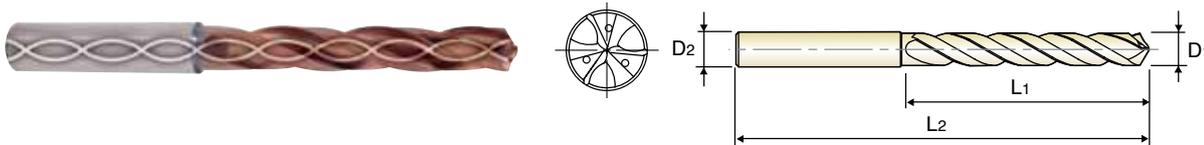
KURZ

LONGUE

LUNGA

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DIN 6537
MG
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P.104

5 × D

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DGR495106	10.60	12	71	118	DGR495130	13.00	14	77	124
DGR495107	10.70	12	71	118	DGR495135	13.50	14	77	124
DGR495108	10.80	12	71	118	DGR495140	14.00	14	77	124
DGR495109	10.90	12	71	118	DGR495145	14.50	16	83	133
DGR495110	11.00	12	71	118	DGR495150	15.00	16	83	133
DGR495111	11.10	12	71	118	DGR495155	15.50	16	83	133
DGR495112	11.20	12	71	118	DGR495160	16.00	16	83	133
DGR495113	11.30	12	71	118	DGR495165	16.50	18	93	143
DGR495114	11.40	12	71	118	DGR495170	17.00	18	93	143
DGR495115	11.50	12	71	118	DGR495175	17.50	18	93	143
DGR495116	11.60	12	71	118	DGR495180	18.00	18	93	143
DGR495117	11.70	12	71	118	DGR495185	18.50	20	101	153
DGR495118	11.80	12	71	118	DGR495190	19.00	20	101	153
DGR495119	11.90	12	71	118	DGR495195	19.50	20	101	153
DGR495120	12.00	12	71	118	DGR495200	20.00	20	101	153
DGR495125	12.50	14	77	124					

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

◎ : Excellent ○ : Good



**SOLID CARBIDE DREAM DRILLS - HIGH FEED with COOLANT HOLES
DREAM DRILLS HIGH FEED mit KÜHLKANAL**

DGR493, DGR495 SERIES

WORK MATERIAL	P						K					
	CARBON STEELS ALLOY STEELS			ALLOY STEELS			CAST IRON			DUCTILE CAST IRON		
HARDNESS	~ HRc 20			HRc 20 ~ 35			-			-		
DRILLING SPEED	100 m/min			75 m/min			100 m/min			80 m/min		
DIAMETER	RPM	FEED		RPM	FEED		RPM	FEED		RPM	FEED	
		Min	Max		Min	Max		Min	Max		Min	Max
5.0	6370	0.200	0.250	4780	0.200	0.250	6370	0.230	0.300	5100	0.200	0.250
6.0	5310	0.240	0.300	3980	0.240	0.300	5310	0.270	0.360	4250	0.240	0.300
7.0	4550	0.280	0.350	3420	0.280	0.350	4550	0.320	0.420	3640	0.280	0.350
8.0	3980	0.320	0.400	2990	0.320	0.400	3980	0.360	0.480	3190	0.320	0.400
9.0	3540	0.360	0.450	2660	0.360	0.450	3540	0.410	0.540	2840	0.360	0.450
10.0	3190	0.400	0.500	2390	0.400	0.500	3190	0.450	0.600	2550	0.400	0.500
12.0	2660	0.480	0.600	2000	0.480	0.540	2660	0.540	0.720	2130	0.480	0.600
14.0	2280	0.560	0.700	1710	0.560	0.630	2280	0.630	0.840	1820	0.560	0.700
16.0	1990	0.560	0.720	1500	0.560	0.640	1990	0.640	0.800	1600	0.560	0.720
18.0	1770	0.630	0.810	1330	0.630	0.720	1770	0.720	0.900	1420	0.630	0.810
20.0	1600	0.700	0.880	1190	0.680	0.810	1600	0.800	0.980	1280	0.700	0.900

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

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