

CARBIDE, DREAM DRILLS

LONG

LANG

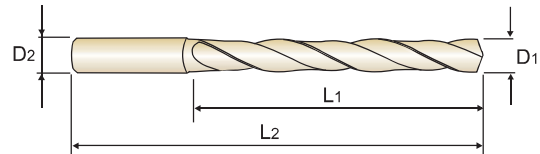
LONGUE

LUNGA

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

- ▶ Drilling for Steel, Cast Steel, Cast Iron, Malleable Cast Iron
- ▶ Self centering and chip breaking by R-thinning
- ▶ Wave shape and negative land on the cutting edge for low thrust, stable torque and long tool life
- ▶ Optimized flute shape for strength of drilling and smooth chip evacuation

- ▶ Bohren von Stahl, Stahlguss, Gusseisen, Temperguss, Nichteisenmetallen-Leichtmetallen, abrasiven Kunststoffen
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung
- ▶ Wellenform und Neagtivfase auf der Schneide bewirken geringen Schub, stabiles Drehmoment und lange Standzeit
- ▶ Optimierte Nutenform für Hochleistungsbohren und leichte Spanabfuhr



DIN 6537
CARBIDE
30°
h6
m7
140°
P.94-95

5 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D ₁	D ₂	L ₁	L ₂
TiAlN				
DH424010	1.0	3	8	55
DH424011	1.1	3	12	55
DH424012	1.2	3	12	55
DH424013	1.3	3	12	55
DH424014	1.4	3	12	55
DH424015	1.5	3	16	55
DH424016	1.6	3	16	55
DH424017	1.7	3	16	55
DH424018	1.8	3	16	55
DH424019	1.9	3	16	55
DH424020	2.0	4	21	57
DH424021	2.1	4	21	57
DH424022	2.2	4	21	57
DH424023	2.3	4	21	57
DH424024	2.4	4	21	57
DH424025	2.5	4	21	57
DH424026	2.6	4	21	57
DH424027	2.7	4	21	57
DH424028	2.8	4	21	57
DH424029	2.9	4	21	57
DH424030	3.0	6	28	66
DH424031	3.1	6	28	66
DH424032	3.2	6	28	66
DH424033	3.3	6	28	66

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D ₁	D ₂	L ₁	L ₂
TiAlN				
DH424034	3.4	6	28	66
DH424035	3.5	6	28	66
DH424036	3.6	6	28	66
DH424037	3.7	6	28	66
DH424038	3.8	6	36	74
DH424039	3.9	6	36	74
DH424040	4.0	6	36	74
DH424041	4.1	6	36	74
DH424042	4.2	6	36	74
DH424043	4.3	6	36	74
DH424044	4.4	6	36	74
DH424045	4.5	6	36	74
DH424046	4.6	6	36	74
DH424047	4.7	6	36	74
DH424048	4.8	6	44	82
DH424049	4.9	6	44	82
DH424050	5.0	6	44	82
DH424051	5.1	6	44	82
DH424052	5.2	6	44	82
DH424053	5.3	6	44	82
DH424054	5.4	6	44	82
DH424055	5.5	6	44	82
DH424056	5.6	6	44	82
DH424057	5.7	6	44	82

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K								
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc	13	25	28	32	38	10	29	32	38	45	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	◎	○	○	◎	◎	○	○	◎	○	○	○	○	◎	○	◎	○	◎	○			

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	36	37	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																					

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

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

CARBIDE, DREAM DRILLS

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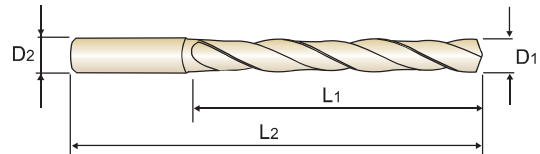
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DIN 6537
CARBIDE
30°
h6
m7
140°
P.94-95

5 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH424058	5.8	6	44	82
DH424059	5.9	6	44	82
DH424060	6.0	6	44	82
DH424061	6.1	8	53	91
DH424062	6.2	8	53	91
DH424063	6.3	8	53	91
DH424064	6.4	8	53	91
DH424065	6.5	8	53	91
DH424066	6.6	8	53	91
DH424067	6.7	8	53	91
DH424068	6.8	8	53	91
DH424069	6.9	8	53	91
DH424070	7.0	8	53	91
DH424071	7.1	8	53	91
DH424072	7.2	8	53	91
DH424073	7.3	8	53	91
DH424074	7.4	8	53	91
DH424075	7.5	8	53	91
DH424076	7.6	8	53	91
DH424077	7.7	8	53	91
DH424078	7.8	8	53	91
DH424079	7.9	8	53	91
DH424080	8.0	8	53	91
DH424081	8.1	10	61	103

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH424082	8.2	10	61	103
DH424083	8.3	10	61	103
DH424084	8.4	10	61	103
DH424085	8.5	10	61	103
DH424086	8.6	10	61	103
DH424087	8.7	10	61	103
DH424088	8.8	10	61	103
DH424089	8.9	10	61	103
DH424090	9.0	10	61	103
DH424091	9.1	10	61	103
DH424092	9.2	10	61	103
DH424093	9.3	10	61	103
DH424094	9.4	10	61	103
DH424095	9.5	10	61	103
DH424096	9.6	10	61	103
DH424097	9.7	10	61	103
DH424098	9.8	10	61	103
DH424099	9.9	10	61	103
DH424100	10.0	10	61	103
DH424101	10.1	12	71	118
DH424102	10.2	12	71	118
DH424103	10.3	12	71	118
DH424104	10.4	12	71	118
DH424105	10.5	12	71	118

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	30	29	32	38	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

ISO	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					



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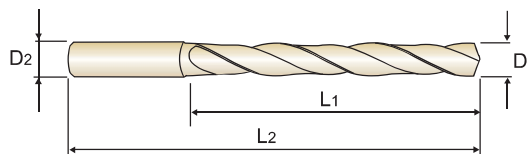
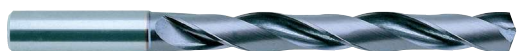
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5 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH424106	10.6	12	71	118
DH424107	10.7	12	71	118
DH424108	10.8	12	71	118
DH424109	10.9	12	71	118
DH424110	11.0	12	71	118
DH424111	11.1	12	71	118
DH424112	11.2	12	71	118
DH424113	11.3	12	71	118
DH424114	11.4	12	71	118
DH424115	11.5	12	71	118
DH424116	11.6	12	71	118
DH424117	11.7	12	71	118
DH424118	11.8	12	71	118
DH424119	11.9	12	71	118
DH424120	12.0	12	71	118
DH424125	12.5	14	77	124

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH424130	13.0	14	77	124
DH424135	13.5	14	77	124
DH424140	14.0	14	77	124
DH424145	14.5	16	83	133
DH424150	15.0	16	83	133
DH424155	15.5	16	83	133
DH424160	16.0	16	83	133
DH424165	16.5	18	93	143
DH424170	17.0	18	93	143
DH424175	17.5	18	93	143
DH424180	18.0	18	93	143
DH424185	18.5	20	101	153
DH424190	19.0	20	101	153
DH424195	19.5	20	101	153
DH424200	20.0	20	101	153

▶ Other shank types are available on your request.

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	
ISO Material Description	N										S						H				
	Aluminum- wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																					

⊙ : Excellent ○ : Good



DH404, DH423, DH424 SERIES

without COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)		Vc (m/min)	Parameter	Drill Diameter (mm)		
					1.0	2.0			3.0	4.0	5.0
P	1	Non-alloy steel	70	RPM	22280	11140	100	RPM	10610	7960	6370
	2			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	3			RPM	22280	11140		RPM	10610	7960	6370
	4			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	5			RPM	22280	11140		RPM	10610	7960	6370
	6	Low alloy steel	60	RPM	19100	9550	80	RPM	8490	6370	5090
	7			FEED	0.03-0.05	0.05-0.07		FEED	0.04-0.10	0.07-0.13	0.10-0.16
	8			RPM	22280	11140		RPM	10610	7960	6370
	9			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	10			RPM	19100	9550		RPM	8490	6370	5090
	11	High alloyed steel, and tool steel	30	RPM	19100	9550	40	RPM	4240	3180	2550
12	FEED			0.02-0.04	0.03-0.05	FEED		0.04-0.10	0.07-0.13	0.10-0.16	
13	RPM			9550	4770	RPM		4240	3180	2550	
14	FEED			0.02-0.04	0.03-0.05	FEED		0.03-0.08	0.05-0.11	0.08-0.14	
15	RPM			15920	7960	RPM		7430	5570	4460	
M	12	Stainless steel	50	RPM	15920	7960	70	RPM	7430	5570	4460
	13			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	14			RPM	11140	5570		RPM	4770	3580	2860
	15			FEED	0.02-0.04	0.03-0.05		FEED	0.04-0.10	0.07-0.13	0.10-0.16
	16			RPM	22280	11140		RPM	10610	7960	6370
K	15	Grey cast iron	70	RPM	22280	11140	100	RPM	10610	7960	6370
	16			FEED	0.04-0.06	0.04-0.06		FEED	0.08-0.14	0.12-0.18	0.18-0.24
	17	Nodular cast iron	65	RPM	20690	10350	80	RPM	8490	6370	5090
	18			FEED	0.04-0.06	0.04-0.06		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	19	Malleable cast iron	70	RPM	22280	11140	100	RPM	10610	7960	6370
20	FEED			0.04-0.06	0.04-0.06	FEED		0.08-0.14	0.12-0.18	0.18-0.24	
21	Aluminum-wrought alloy	50	RPM	15920	7960	70	RPM	7430	5570	4460	
22			FEED	0.04-0.06	0.04-0.06		FEED	0.06-0.12	0.08-0.14	0.14-0.20	
23			RPM	19100	9550		RPM	8490	6370	5090	
24			FEED	0.04-0.06	0.04-0.06		FEED	0.08-0.14	0.12-0.18	0.18-0.24	
25			RPM	22280	11140		RPM	10610	7960	6370	
N	26	Aluminum-cast, alloyed	60	RPM	19100	9550	80	RPM	8490	6370	5090
	27			FEED	0.04-0.06	0.04-0.06		FEED	0.08-0.14	0.12-0.18	0.18-0.24
	28			RPM	15920	7960		RPM	7430	5570	4460
	29			FEED	0.04-0.06	0.04-0.06		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	30			RPM	15920	7960		RPM	7430	5570	4460
S	31	Heat Resistant Super Alloys	50	RPM	15920	7960	70	RPM	7430	5570	4460
	32			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	33			RPM	15920	7960		RPM	7430	5570	4460
	34			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	35			RPM	15920	7960		RPM	7430	5570	4460
H	36	Titanium Alloys	50	RPM	15920	7960	70	RPM	7430	5570	4460
	37			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
H	38	Hardened steel	50	RPM	15920	7960	70	RPM	7430	5570	4460
	39			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20
	40			RPM	15920	7960		RPM	7430	5570	4460
H	41	Hardened Cast Iron	50	RPM	15920	7960	70	RPM	7430	5570	4460
	42			FEED	0.03-0.05	0.05-0.07		FEED	0.06-0.12	0.08-0.14	0.14-0.20

► Recommend to reduce the feed rate as following

Feed 100% : DH404(3×D), DH423(3×D), DH424(5×D)

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

VDI 3323	Parameter	Drill Diameter (mm)							
		6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
1									
2	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
3	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
4	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.12-0.18	0.14-0.2	0.18-0.24	0.14-0.24	0.16-0.26	0.18-0.28	0.20-0.30	0.22-0.32
5	RPM	4240	3180	2550	2120	1820	1590	1410	1270
	FEED	0.12-0.18	0.14-0.2	0.18-0.24	0.14-0.24	0.16-0.26	0.18-0.28	0.20-0.30	0.22-0.32
6	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
7	RPM	4240	3180	2550	2120	1820	1590	1410	1270
	FEED	0.12-0.24	0.16-0.28	0.20-0.30	0.21-0.30	0.22-0.35	0.25-0.36	0.28-0.38	0.30-0.40
8	RPM	4240	3180	2550	2120	1820	1590	1410	1270
	FEED	0.12-0.18	0.14-0.2	0.18-0.24	0.14-0.24	0.16-0.26	0.18-0.28	0.20-0.30	0.22-0.32
9	RPM	2120	1590	1270	1060	910	800	710	640
	FEED	0.10-0.16	0.12-0.18	0.14-0.20	0.12-0.22	0.13-0.23	0.14-0.24	0.16-0.26	0.18-0.28
10	RPM	3710	2790	2230	1860	1590	1390	1240	1110
	FEED	0.12-0.18	0.14-0.20	0.18-0.24	0.14-0.24	0.16-0.26	0.18-0.28	0.20-0.30	0.22-0.32
11	RPM	2120	1590	1270	1060	910	800	710	640
	FEED	0.10-0.16	0.12-0.18	0.14-0.20	0.12-0.22	0.13-0.23	0.14-0.24	0.16-0.26	0.18-0.28
12	RPM	3710	2790	2230	1860	1590	1390	1240	1110
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
13	RPM	2390	1790	1430	1190	1020	900	800	720
	FEED	0.12-0.18	0.14-0.20	0.18-0.24	0.14-0.24	0.16-0.26	0.18-0.28	0.20-0.30	0.22-0.32
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15	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.14-0.26	0.16-0.28	0.24-0.34	0.26-0.36	0.28-0.38	0.30-0.40	0.32-0.42	0.34-0.44
16	RPM	4240	3180	2550	2120	1820	1590	1410	1270
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
17	RPM	5310	3980	3180	2650	2270	1990	1770	1590
	FEED	0.14-0.26	0.16-0.28	0.24-0.34	0.26-0.36	0.28-0.38	0.30-0.40	0.32-0.42	0.34-0.44
18	RPM	3710	2790	2230	1860	1590	1390	1240	1110
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
19	RPM	4240	3180	2550	2120	1820	1590	1410	1270
	FEED	0.14-0.26	0.16-0.28	0.24-0.34	0.26-0.36	0.28-0.38	0.30-0.40	0.32-0.42	0.34-0.44
20	RPM	3710	2790	2230	1860	1590	1390	1240	1110
	FEED	0.16-0.22	0.18-0.24	0.22-0.28	0.20-0.30	0.22-0.32	0.24-0.34	0.28-0.38	0.30-0.40
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