

YG DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

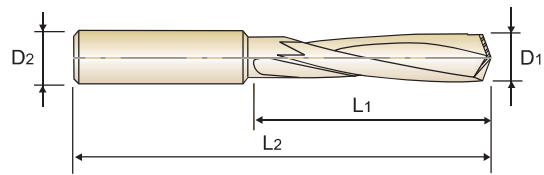
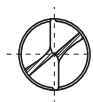
CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70)

SHORT
KURZ
COURTE
CORTA

- VOLLHARTMETALL DREAM SPIRALBOHRER FÜR HOCHGEHARTETE STAHL
- Forets DREAM DRILLS carbure pour Aciers Trempés (50 HRc ~ 70 HRc)
- PUNTE ELICOIDALI IN MD, DREAM DRILL - ACCIAI HRC 50 - 70

- ▶ Drilling for High Hardened Steels; Quenched Steels, Tempered Steels (under HRc 70)
- ▶ Special geometry design for Hardened Steels
- ▶ Minimum of cutting load through special thinning
- ▶ Performing good chip removal and powerful drilling

- ▶ Bohren von hoch gehärteten Stählen, Vergütungsstähle, angelassenen Stählen bis HRc 70
- ▶ Spezielle Bohrgeometrie für gehärtete Stähle
- ▶ Minimaler Schnedendruck durch spezielle Ausspitzung
- ▶ Gute Spanabfuhr und Hochleistungsbohren



CARBIDE 15° h6 h7 140° P.160

3 × D

EDP No.	Drill Diameter		Shank Diameter		Flute Length		Overall Length	
	TiAlN	D1	D2	L1	L2			
DH500026	2.6	3	14	44				
DH500030	3.0	3	16	46				
DH500033	3.3	4	18	48				
DH500034	3.4	4	20	50				
DH500035	3.5	4	20	50				
DH500040	4.0	4	22	52				
DH500042	4.2	6	25	65				
DH500043	4.3	6	28	68				
DH500044	4.4	6	28	68				
DH500045	4.5	6	28	68				
DH500050	5.0	6	32	72				
DH500051	5.1	6	32	72				
DH500052	5.2	6	32	72				
DH500055	5.5	6	35	75				
DH500060	6.0	6	35	75				
DH500065	6.5	8	40	80				
DH500068	6.8	8	45	85				
DH500069	6.9	8	45	85				

Unit : mm

EDP No.	Drill Diameter		Shank Diameter		Flute Length		Overall Length	
	TiAlN	D1	D2	L1	L2			
DH500070	7.0	8	45	85				
DH500075	7.5	8	45	85				
DH500080	8.0	8	50	98				
DH500085	8.5	10	50	98				
DH500086	8.6	10	57	105				
DH500088	8.8	10	57	105				
DH500090	9.0	10	57	105				
DH500095	9.5	10	57	105				
DH500100	10.0	10	63	111				
DH500102	10.2	12	63	111				
DH500103	10.3	12	63	111				
DH500105	10.5	12	63	111				
DH500108	10.8	12	71	119				
DH500110	11.0	12	71	119				
DH500115	11.5	12	71	119				
DH500120	12.0	12	71	119				
DH500140	14.0	14	77	125				

◎ : 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	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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	35	15	35	15	23	10	10	26	3	25	21	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		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39.1	39.3	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39.1	39.3	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34			55	60	70	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	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



DREAM DRILLS
for HIGH HARDENED STEELS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

DH500 SERIES

DREAM DRILLS for HIGH HARDENED STEELS

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
- REAMERS
- COUNTER SINKS
- COUNTER BORES
- TECHNICAL DATA

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	
P	1	Non-alloy steel											
	2												
	3												
	4												
	5												
	6	Low alloy steel											
	7												
	8												
	9												
	10		High alloyed steel, and tool steel										
	11												
M	12	Stainless steel											
	13												
	14												
K	15	Grey cast iron											
	16												
	17	Nodular cast iron											
	18												
19	Malleable cast iron												
20													
N	21	Aluminum-wrought alloy											
	22												
	23	Aluminum-cast, alloyed											
	24												
	25												
	26												
	27	Copper and Copper Alloys (Bronze / Brass)											
	28												
	29	Non Metallic Materials											
	30												
S	31	Heat Resistant Super Alloys											
	32												
	33												
	34												
	35												
	36	Titanium Alloys											
	37												
H	38	Hardened steel	20	RPM	2120	1590	1270	1060	800	640	530	450	
			FEED	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06		
			RPM	1590	1190	950	800	600	480	400	340		
	39.1		FEED	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06		
39.3		RPM	1270	950	760	640	480	380	320	270			
		FEED	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06			
40	Chilled Cast Iron												
41	Hardened Cast Iron												