



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -INOX

DREAM DRILLS - INOX

- For Tough Materials like Stainless Steels
- Für schwierig zerspanbare Materialien wie Edelstahl

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS X

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

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

SELECTION GUIDE



SOLID CARBIDE
DREAM DRILLS
INOX

For Tough Materials like Stainless Steels

Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A144

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC			
P	1	Non-alloy steel	About 0.15% C	Annealed	125				
	2		About 0.45% C	Annealed	190	13	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	○	○	○
	4		About 0.75% C	Annealed	270	28			
	5		About 0.75% C	Quenched & Tempered	300	32			
	6	Low alloy steel		Annealed	180	10	◎	◎	◎
	7			Quenched & Tempered	275	29	○	○	○
	8			Quenched & Tempered	300	32			
	9			Quenched & Tempered	350	38			
	10	High alloyed steel, and tool steel		Annealed	200	15			
	11			Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	◎	◎	◎
	13		Martensitic	Quenched & Tempered	240	23	◎	◎	◎
	14		Austenitic		180	10	◎	◎	◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10			
	16		Pearlitic (Martensitic)		260	26			
	17	Nodular cast iron	Ferritic		160	3			
	18		Pearlitic		250	25			
	19	Malleable cast iron	Ferritic		130				
	20		Pearlitic		230	21			
N	21	Aluminum-wrought alloy	Not Curable		60		◎	◎	◎
	22		Curable	Hardened	100		◎	◎	◎
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○
	24		≤ 12% Si, Curable	Hardened	90		○	○	○
	25		> 12% Si, Not Curable		130		○	○	○
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90				
	28		CuSn, lead-free copper and electrolytic copper		100				
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic						
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15			
	32			Cured	280	30			
	33		Ni or Co Based	Annealed	250	25			
	34			Cured	350	38			
	35			Cast	320	34			
	36	Titanium Alloys	Pure Titanium		400 Rm				
	37		Alpha + Beta Alloys	Hardened	1050 Rm	○	○	○	
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42			
	41	Hardened Cast Iron		Hardened	550	55			



DH451 SERIES

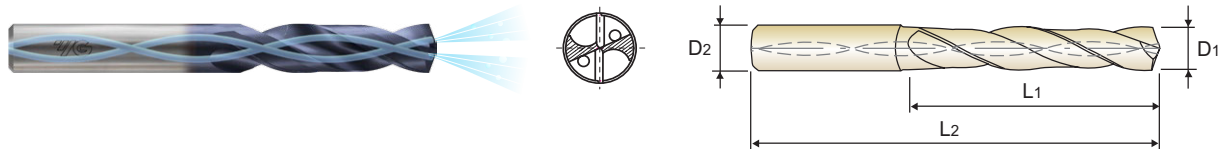
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

- 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)

SHORT

KURZ
COURTE
CORTA

- Special flute shape and geometry suitable for machining stainless steel
- Excellent chip evacuation from better surface treatment
- Point R-thinning achieves superior centering and chip curling
- TiAIN coating for better surface finishes and longer tool life
- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAIN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAIN

p.A144

3 × D

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		DH451055	5.5	6	28	66
DH451031	3.1	6	20	62		DH451056	5.6	6	28	66
DH451032	3.2	6	20	62		DH451057	5.7	6	28	66
DH451033	3.3	6	20	62		DH451058	5.8	6	28	66
DH451034	3.4	6	20	62		DH451059	5.9	6	28	66
DH451035	3.5	6	20	62		DH451060	6.0	6	28	66
DH451036	3.6	6	20	62		DH451061	6.1	8	34	79
DH451037	3.7	6	20	62		DH451062	6.2	8	34	79
DH451038	3.8	6	24	66		DH451063	6.3	8	34	79
DH451039	3.9	6	24	66		DH451064	6.4	8	34	79
DH451040	4.0	6	24	66		DH451065	6.5	8	34	79
DH451041	4.1	6	24	66		DH451066	6.6	8	34	79
DH451042	4.2	6	24	66		DH451067	6.7	8	34	79
DH451043	4.3	6	24	66		DH451068	6.8	8	34	79
DH451044	4.4	6	24	66		DH451069	6.9	8	34	79
DH451045	4.5	6	24	66		DH451070	7.0	8	34	79
DH451046	4.6	6	24	66		DH451071	7.1	8	41	79
DH451047	4.7	6	24	66		DH451072	7.2	8	41	79
DH451048	4.8	6	28	66		DH451073	7.3	8	41	79
DH451049	4.9	6	28	66		DH451074	7.4	8	41	79
DH451050	5.0	6	28	66		DH451075	7.5	8	41	79
DH451051	5.1	6	28	66		DH451076	7.6	8	41	79
DH451052	5.2	6	28	66		DH451077	7.7	8	41	79
DH451053	5.3	6	28	66		DH451078	7.8	8	41	79
DH451054	5.4	6	28	66		DH451079	7.9	8	41	79

Other shank types are available on your request.

NEXT PAGE

																				◎ : Excellent ○ : Good			
ISO	P										M				K								
Material Description	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	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	N										S										H		
Material Description	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			
HRC											15	30	25	38	34			55	60	42			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400			
Recommended	◎	◎	○	○	○												○						

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS X

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DREAM DRILLS -INOX

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DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

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DREAM DRILLS
- INOX

DH451

SERIES

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DIN 6537

CARBIDE











TiAIN



p.A144

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
DH451080	8.0	8	41	79	DH451108	10.8	12	55	102
DH451081	8.1	10	47	89	DH451109	10.9	12	55	102
DH451082	8.2	10	47	89	DH451110	11.0	12	55	102
DH451083	8.3	10	47	89	DH451111	11.1	12	55	102
DH451085	8.5	10	47	89	DH451113	11.3	12	55	102
DH451086	8.6	10	47	89	DH451114	11.4	12	55	102
DH451087	8.7	10	47	89	DH451115	11.5	12	55	102
DH451088	8.8	10	47	89	DH451117	11.7	12	55	102
DH451089	8.9	10	47	89	DH451118	11.8	12	55	102
DH451090	9.0	10	47	89	DH451119	11.9	12	55	102
DH451091	9.1	10	47	89	DH451120	12.0	12	55	102
DH451092	9.2	10	47	89	DH451125	12.5	14	60	107
DH451093	9.3	10	47	89	DH451130	13.0	14	60	107
DH451094	9.4	10	47	89	DH451135	13.5	14	60	107
DH451095	9.5	10	47	89	DH451140	14.0	14	60	107
DH451096	9.6	10	47	89	DH451145	14.5	16	65	115
DH451097	9.7	10	47	89	DH451150	15.0	16	65	115
DH451098	9.8	10	47	89	DH451155	15.5	16	65	115
DH451099	9.9	10	47	89	DH451160	16.0	16	65	115
DH451100	10.0	10	47	89	DH451165	16.5	18	73	123
DH451101	10.1	12	55	102	DH451170	17.0	18	73	123
DH451102	10.2	12	55	102	DH451175	17.5	18	73	123
DH451103	10.3	12	55	102	DH451180	18.0	18	73	123
DH451104	10.4	12	55	102	DH451185	18.5	20	79	131
DH451105	10.5	12	55	102	DH451190	19.0	20	79	131
DH451106	10.6	12	55	102	DH451195	19.5	20	79	131
DH451107	10.7	12	55	102	DH451200	20.0	20	79	131

► Other shank types are available on your request.

► NEXT PAGE

◎ : Excellent ○ : Good																								
ISO	P										M				K									
Material Description	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	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	N										S										H			
Material Description	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	42	43	
HRc											15	30	25	38	34	36	37	55	60	42		55	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400		550	550	
Recommended	◎	◎	○	○	○												○							

DREAM DRILLS
- INOX

DH452

SERIES

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LONG
LANG
LONGUE
LUNGA

- Special flute shape and geometry suitable for machining stainless steel

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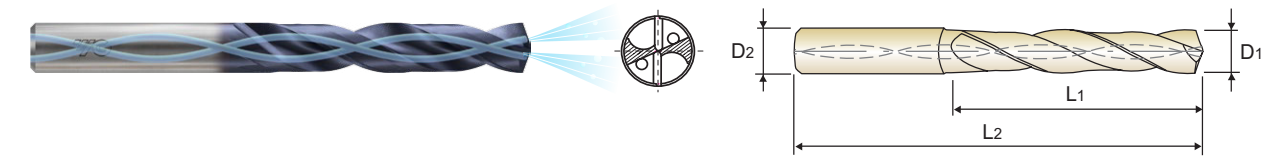
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DIN 6537

CARBIDE











TiAIN



p.A144

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

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Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron					
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HRc		13	25	28	32	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	N										S					H								
Material Description	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	42	43	
HRc											15	30	25	38	34			55	60	42	55	55	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550			
Recommended	◎	◎	○	○	○												○							

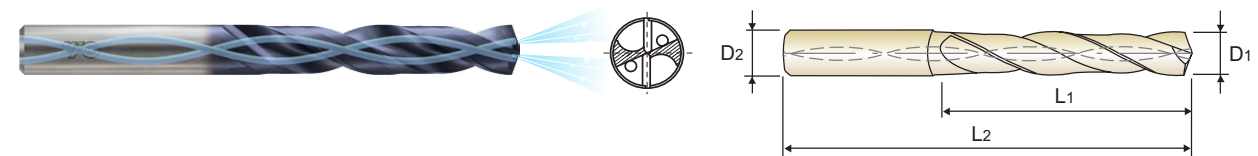
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LONG

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DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAIN

p.A144

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
DH452058	5.8	6	44	82	DH452082	8.2	10	61	103
DH452059	5.9	6	44	82	DH452083	8.3	10	61	103
DH452060	6.0	6	44	82	DH452084	8.4	10	61	103
DH452061	6.1	8	53	91	DH452085	8.5	10	61	103
DH452062	6.2	8	53	91	DH452086	8.6	10	61	103
DH452063	6.3	8	53	91	DH452087	8.7	10	61	103
DH452064	6.4	8	53	91	DH452088	8.8	10	61	103
DH452065	6.5	8	53	91	DH452089	8.9	10	61	103
DH452066	6.6	8	53	91	DH452090	9.0	10	61	103
DH452067	6.7	8	53	91	DH452091	9.1	10	61	103
DH452068	6.8	8	53	91	DH452092	9.2	10	61	103
DH452069	6.9	8	53	91	DH452093	9.3	10	61	103
DH452070	7.0	8	53	91	DH452094	9.4	10	61	103
DH452071	7.1	8	53	91	DH452095	9.5	10	61	103
DH452072	7.2	8	53	91	DH452096	9.6	10	61	103
DH452073	7.3	8	53	91	DH452097	9.7	10	61	103
DH452074	7.4	8	53	91	DH452098	9.8	10	61	103
DH452075	7.5	8	53	91	DH452099	9.9	10	61	103
DH452076	7.6	8	53	91	DH452100	10.0	10	61	103
DH452077	7.7	8	53	91	DH452101	10.1	12	71	118
DH452078	7.8	8	53	91	DH452102	10.2	12	71	118
DH452079	7.9	8	53	91	DH452103	10.3	12	71	118
DH452080	8.0	8	53	91	DH452104	10.4	12	71	118
DH452081	8.1	10	61	103	DH452105	10.5	12	71	118

► Other shank types are available on your request.

► NEXT PAGE

◎ : Excellent ○ : Good																					
ISO	P										M			K							
Material Description	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	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		230	
Recommended		◎	○			◎	○					◎	◎	◎							
ISO	N										S							H			
Material Description	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											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	◎	◎	○	○	○												◎				

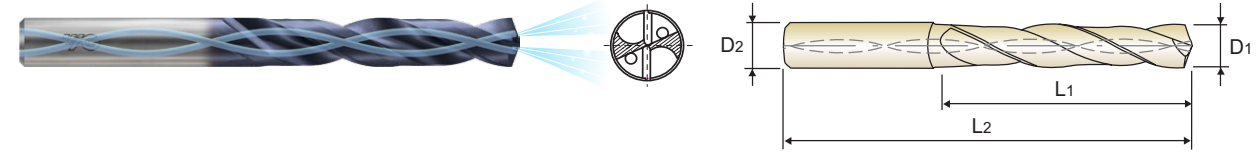
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

- 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)

LANG
LONGUE
LUNGA

- Special flute shape and geometry suitable for machining stainless steel
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 - TiAIN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAIN

p.A144

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
DH452106	10.6	12	71	118	DH452170	17.0	18	93	143
DH452107	10.7	12	71	118	DH452175	17.5	18	93	143
DH452108	10.8	12	71	118	DH452180	18.0	18	93	143
DH452109	10.9	12	71	118	DH452185	18.5	20	101	153
DH452110	11.0	12	71	118	DH452190	19.0	20	101	153
DH452111	11.1	12	71	118	DH452195	19.5	20	101	153
DH452112	11.2	12	71	118	DH452200	20.0	20	101	153
DH452113	11.3	12	71	118					
DH452114	11.4	12	71	118					
DH452115	11.5	12	71	118					
DH452116	11.6	12	71	118					
DH452117	11.7	12	71	118					
DH452118	11.8	12	71	118					
DH452119	11.9	12	71	118					
DH452120	12.0	12	71	118					
DH452125	12.5	14	77	124					
DH452130	13.0	14	77	124					
DH452135	13.5	14	77	124					
DH452140	14.0	14	77	124					
DH452145	14.5	16	83	133					
DH452150	15.0	16	83	133					
DH452155	15.5	16	83	133					
DH452160	16.0	16	83	133					
DH452165	16.5	18	93	143					

► Other shank types are available on your request.

		◎ : Excellent ○ : Good																			
ISO	P										M			K							
Material Description	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	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	N										S							H			
Material Description	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											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	◎	◎	○	○	○												○				

DREAM DRILLS
- INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

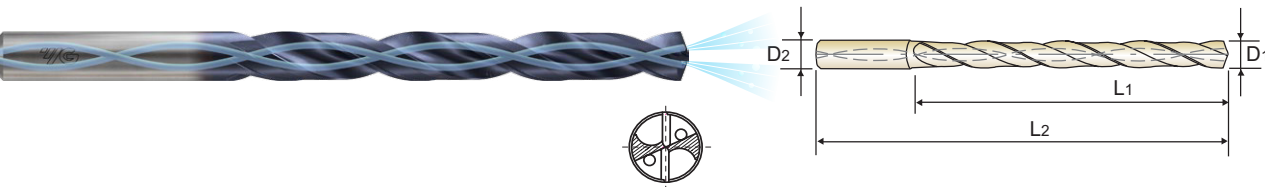
- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série extra-longue
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione)

ÜBERLANG

EXTRA-LONGUE

EXTRA LUNGA

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DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAIN

p.A144

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	DH453055	5.5	6	57	95
DH453031	3.1	6	34	72	DH453056	5.6	6	57	95
DH453032	3.2	6	34	72	DH453057	5.7	6	57	95
DH453033	3.3	6	34	72	DH453058	5.8	6	57	95
DH453034	3.4	6	34	72	DH453059	5.9	6	57	95
DH453035	3.5	6	34	72	DH453060	6.0	6	57	95
DH453036	3.6	6	34	72	DH453061	6.1	8	76	114
DH453037	3.7	6	34	72	DH453062	6.2	8	76	114
DH453038	3.8	6	43	81	DH453063	6.3	8	76	114
DH453039	3.9	6	43	81	DH453064	6.4	8	76	114
DH453040	4.0	6	43	81	DH453065	6.5	8	76	114
DH453041	4.1	6	43	81	DH453066	6.6	8	76	114
DH453042	4.2	6	43	81	DH453067	6.7	8	76	114
DH453044	4.4	6	43	81	DH453068	6.8	8	76	114
DH453045	4.5	6	43	81	DH453069	6.9	8	76	114
DH453046	4.6	6	43	81	DH453070	7.0	8	76	114
DH453047	4.7	6	43	81	DH453071	7.1	8	76	114
DH453048	4.8	6	57	95	DH453072	7.2	8	76	114
DH453049	4.9	6	57	95	DH453073	7.3	8	76	114
DH453050	5.0	6	57	95	DH453074	7.4	8	76	114
DH453051	5.1	6	57	95	DH453075	7.5	8	76	114
DH453052	5.2	6	57	95	DH453076	7.6	8	76	114
DH453053	5.3	6	57	95	DH453077	7.7	8	76	114
DH453054	5.4	6	57	95	DH453078	7.8	8	76	114

► Other shank types are available on your request. ► NEXT PAGE

																						◎ : Excellent ○ : Good					
ISO	P											M					K										
Material Description	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	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	N											S					H										
Material Description	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											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	◎	◎	○	○	○												◎										

DREAM DRILLS
- INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

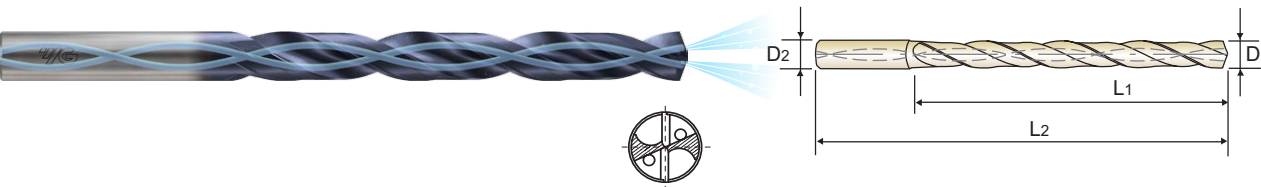
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- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série extra-longue
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ÜBERLANG

EXTRA-LONGUE

EXTRA LUNGA

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DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAIN

p.A144

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
DH453079	7.9	8	76	114	DH453103	10.3	12	114	162
DH453080	8.0	8	76	114	DH453104	10.4	12	114	162
DH453081	8.1	10	95	142	DH453105	10.5	12	114	162
DH453082	8.2	10	95	142	DH453107	10.7	12	114	162
DH453083	8.3	10	95	142	DH453108	10.8	12	114	162
DH453084	8.4	10	95	142	DH453110	11.0	12	114	162
DH453085	8.5	10	95	142	DH453111	11.1	12	114	162
DH453086	8.6	10	95	142	DH453112	11.2	12	114	162
DH453087	8.7	10	95	142	DH453113	11.3	12	114	162
DH453088	8.8	10	95	142	DH453114	11.4	12	114	162
DH453089	8.9	10	95	142	DH453115	11.5	12	114	162
DH453090	9.0	10	95	142	DH453116	11.6	12	114	162
DH453091	9.1	10	95	142	DH453117	11.7	12	114	162
DH453092	9.2	10	95	142	DH453118	11.8	12	114	162
DH453093	9.3	10	95	142	DH453119	11.9	12	114	162
DH453094	9.4	10	95	142	DH453120	12.0	12	114	162
DH453095	9.5	10	95	142	DH453125	12.5	14	133	178
DH453096	9.6	10	95	142	DH453130	13.0	14	133	178
DH453097	9.7	10	95	142	DH453135	13.5	14	133	178
DH453098	9.8	10	95	142	DH453140	14.0	14	133	178
DH453099	9.9	10	95	142					
DH453100	10.0	10	95	142					
DH453101	10.1	12	114	162					
DH453102	10.2	12	114	162					

► Other shank types are available on your request.

		P										M			K										
Material Description		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	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			◎	○			◎	○					◎	◎	◎										
		N										S					H								
Material Description		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												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		◎	◎	○	○	○																			

CARBIDE

HSS

i-ONE
DRILLS

i-DREAM
DRILLS

DREAM
DRILLS
-PRO

DREAM
DRILLS
-X

DREAM
DRILLS
-GENERAL

DREAM
DRILLS
-HIGH FEED

DREAM
DRILLS
-FLAT BOTTOM

DREAM
DRILLS
-INOX

DREAM
DRILLS
-ALU

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

DH451, DH452, DH453 SERIES with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)	
					1.0	2.0
P	2	Non-alloy steel	70	RPM	22280	11140
				FEED	0.02-0.04	0.04-0.06
	3		70	RPM	22280	11140
				FEED	0.02-0.04	0.04-0.06
P	6	Low alloy steel	70	RPM	22280	11140
				FEED	0.02-0.04	0.04-0.06
	7		50	RPM	15920	7960
				FEED	0.02-0.04	0.04-0.06
M	12	Stainless steel	40	RPM	12730	6370
				FEED	0.02-0.04	0.02-0.04
	13		25	RPM	7960	3980
M				FEED	0.02-0.04	0.02-0.04
	14		45	RPM	14320	7160
				FEED	0.02-0.04	0.02-0.04
N	21	Aluminum-wrought alloy	130	RPM	41380	20690
				FEED	0.04-0.10	0.08-0.14
	22		130	RPM	41380	20690
				FEED	0.04-0.10	0.08-0.14
	23	Aluminum-cast, alloyed	110	RPM	35010	17510
				FEED	0.04-0.10	0.08-0.14
	24		110	RPM	35010	17510
				FEED	0.04-0.10	0.08-0.14
N	25		90	RPM	28650	14320
				FEED	0.04-0.08	0.06-0.10
S	37	Titanium Alloys	25	RPM	7960	3980
				FEED	0.01-0.03	0.01-0.03

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)					
					8.0	10.0	12.0	14.0	16.0	20.0
P	2	Non-alloy steel	100	RPM	3980	3180	2650	2270	1990	1590
				FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.28-0.38
	3		100	RPM	3980	3180	2650	2270	1990	1590
				FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.28-0.38
P	6	Low alloy steel	100	RPM	3980	3180	2650	2270	1990	1590
				FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.28-0.38
	7		70	RPM	2790	2230	1860	1590	1390	1110
				FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.28-0.38
M	12	Stainless steel	50	RPM	1990	1590	1330	1140	990	800
				FEED	0.09-0.13	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.15-0.20
	13		40	RPM	1590	1270	1060	910	800	640
M				FEED	0.09-0.13	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.15-0.20
	14		60	RPM	2390	1910	1590	1360	1190	950
				FEED	0.10-0.14	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.16-0.21
N	21	Aluminum-wrought alloy	200	RPM	7960	6370	5310	4550	3980	3180
				FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.35-0.45
	22		200	RPM	7960	6370	5310	4550	3980	3180
				FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.35-0.45
	23	Aluminum-cast, alloyed	180	RPM	7160	5730	4770	4090	3580	2860
				FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.35-0.45
	24		180	RPM	7160	5730	4770	4090	3580	2860
				FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.35-0.45
N	25		150	RPM	5970	4770	3980	3410	2980	2390
				FEED	0.21-0.27	0.23-0.29	0.25-0.31	0.27-0.33	0.28-0.34	0.30-0.40
S	37	Titanium Alloys	40	RPM	1590	1270	1060	910	800	640
				FEED	0.08-0.12	0.09-0.14	0.10-0.15	0.11-0.16	0.12-0.17	0.14-0.19

► Recommend to reduce the feed rate as following
Feed 100% : DH451(3xD), DH452(5xD) Feed 85% : DH453(8xD)



SOLID CARBIDE

DREAM DRILLS
-ALU
DREAM DRILLS - ALU

- For Aluminum and Aluminum Alloys
- Für Aluminium und Aluminiumlegierungen