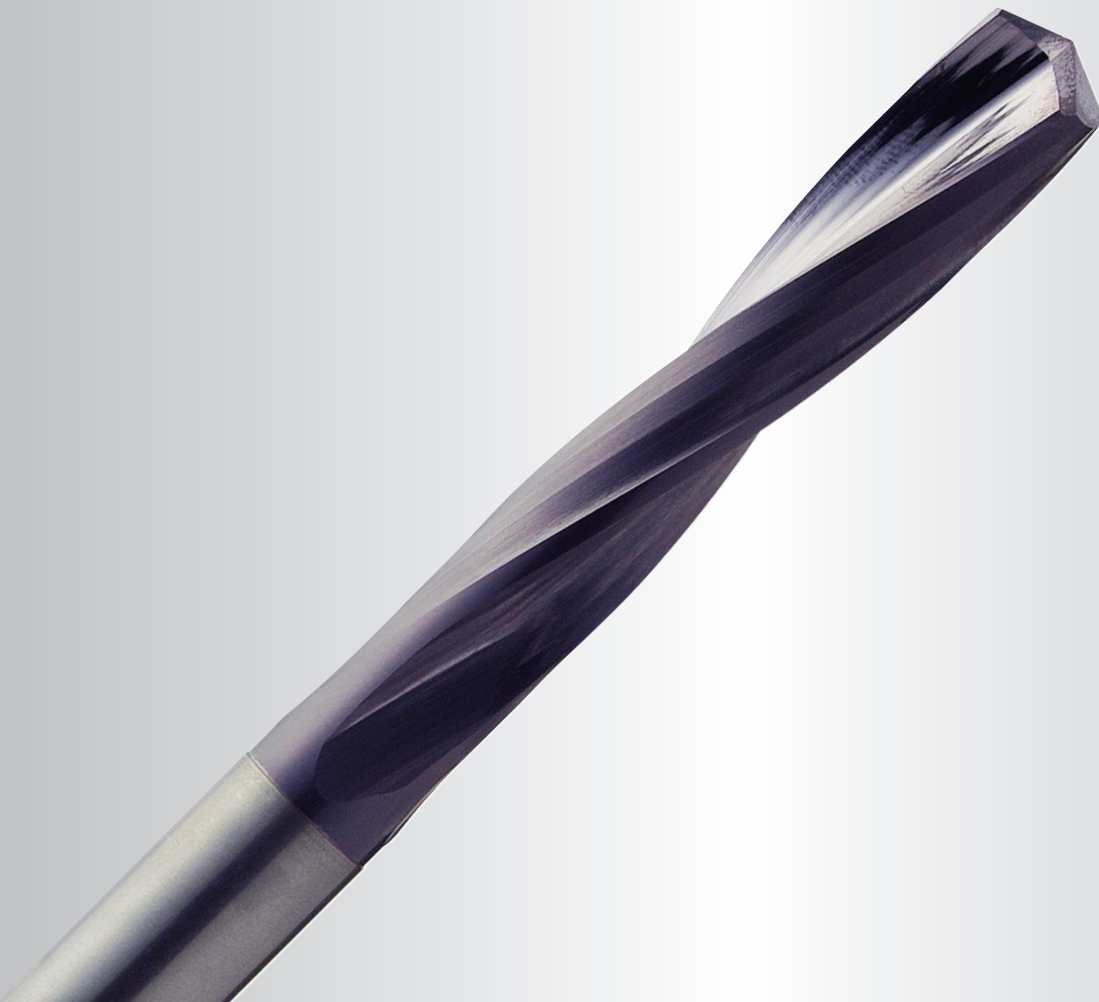


CARBIDE



Being the best through innovation




DREAM DRILLS
- For HIGH HARDENED STEELS
DREAM DRILLS
- FÜR HOCHGEHÄRTETE STÄHLE

- HIGH HARDENED STEELS, HRc50~HRc70
- HOCHGEHÄRTETE STÄHLE HRc50 TO HRc70

SELECTION GUIDE

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

High Hardened Steels, HRc50~HRc70

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
DH500		CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHARTETE STAHL	D2.6	D14.0	110
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			111

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

◎ : Excellent
○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
			HRc45~55	HRc55~								
~HB225	HB225~325	HRc30~45	○	○								

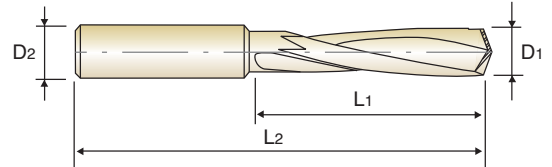
Y/G DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

**CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70)
VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHARTETE STAHL**

- ▶ **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- ▶ **Advantage** : Special Design
Minimum of cutting load through special thinning
Good chip removal
Powerful Drilling

- ▶ **Verwendung** : Hoch gehärtete Stähle (Vergütungsstähle, angelassene Stähle) bis HRc 70
- ▶ **Vorteile** : Spezielle Bohrergeometrie
Minimaler Schneidendruck durch besondere Ausspitzung
Gute Spanabfuhr
Hochleistungsbohren



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
DH500026	2.6	3	14	44	DH500070	7.0	8	45	85
DH500030	3.0	3	16	46	DH500075	7.5	8	45	85
DH500033	3.3	4	18	48	DH500080	8.0	8	50	98
DH500034	3.4	4	20	50	DH500085	8.5	10	50	98
DH500035	3.5	4	20	50	DH500086	8.6	10	57	105
DH500040	4.0	4	22	52	DH500088	8.8	10	57	105
DH500042	4.2	6	25	65	DH500090	9.0	10	57	105
DH500043	4.3	6	28	68	DH500095	9.5	10	57	105
DH500044	4.4	6	28	68	DH500100	10.0	10	63	111
DH500045	4.5	6	28	68	DH500102	10.2	12	63	111
DH500050	5.0	6	32	72	DH500103	10.3	12	63	111
DH500051	5.1	6	32	72	DH500105	10.5	12	63	111
DH500052	5.2	6	32	72	DH500108	10.8	12	71	119
DH500055	5.5	6	35	75	DH500110	11.0	12	71	119
DH500060	6.0	6	35	75	DH500115	11.5	12	71	119
DH500065	6.5	8	40	80	DH500120	12.0	12	71	119
DH500068	6.8	8	45	85	DH500140	14.0	14	77	125
DH500069	6.9	8	45	85					

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
			◎	◎								

YG DREAM DRILLS
for HIGH HARDENED STEELS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70), TiAIN COATED
VOLLHARTMETALL DREAM BOHRER für HOCHGEHÄRTETE STÄHLE, TiAIN-BESCHICHTET

DH500 SERIES

WORK MATERIAL	HARDENED STEELS					
	HRc 50~55		HRc 55~60		HRc 60~70	
DRILLING SPEED	14 ~ 22 m/min		10 ~ 16 m/min		8 ~ 13 m/min	
DIAMETER	N	S	N	S	N	S
3.0	1900	0.04	1330	0.04	1250	0.04
4.0	1430	0.04	1000	0.04	950	0.04
5.0	1150	0.04	800	0.04	750	0.04
6.0	960	0.04	670	0.04	630	0.04
8.0	720	0.04	500	0.04	480	0.04
10.0	570	0.04	400	0.04	380	0.04
12.0	480	0.04	330	0.04	320	0.04
14.0	438	0.04	282	0.04	272	0.04

N = R.P.M
S = Feed per Revolution (mm/rev.)

HSS

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



Global Cutting Tool Leader **YG-1**

