# DREAM DRILLS - ALU

**D5432** SERIES

## CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

*SHORT*

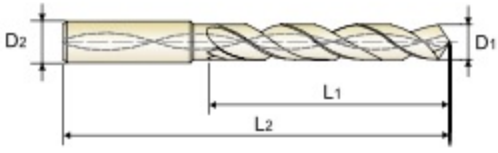
VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL *KURZ*

Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série courte *COURTE*

PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione) *CORTA*

- Optimized thining for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes

- Optimierte Ausspitzung für Aluminum & Aluminumlegierungen zur Vermeidung von Verstopfungen durch das Aufschweißen der Späne
- Breitere und tiefere Spannuten für maximale Spanabfuhr
- Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen




DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright | p.A139 | 3× D

Recommended ToolHolder

| | PlainShank | Page |
|---|---|---|
| ◎ | SHRINKFITHOLDER | D47-72 |
| ◎ | HYDRAULICCHUCK | D15-46 |
| ○ | ERCOLLETCHUCK | D73-115 |

Unit : mm

| EDP No. | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|---|---|---|---|---|
| D5432030 | 3.0 | 6 | 20 | 62 |
| D5432031 | 3.1 | 6 | 20 | 62 |
| D5432032 | 3.2 | 6 | 20 | 62 |
| D5432033 | 3.3 | 6 | 20 | 62 |
| D5432034 | 3.4 | 6 | 20 | 62 |
| D5432035 | 3.5 | 6 | 20 | 62 |
| D5432036 | 3.6 | 6 | 20 | 62 |
| D5432037 | 3.7 | 6 | 20 | 62 |
| D5432038 | 3.8 | 6 | 24 | 66 |
| D5432039 | 3.9 | 6 | 24 | 66 |
| D5432040 | 4.0 | 6 | 24 | 66 |
| D5432041 | 4.1 | 6 | 24 | 66 |
| D5432042 | 4.2 | 6 | 24 | 66 |
| D5432043 | 4.3 | 6 | 24 | 66 |
| D5432044 | 4.4 | 6 | 24 | 66 |
| D5432045 | 4.5 | 6 | 24 | 66 |
| D5432046 | 4.6 | 6 | 24 | 66 |
| D5432047 | 4.7 | 6 | 24 | 66 |
| D5432048 | 4.8 | 6 | 28 | 66 |
| D5432049 | 4.9 | 6 | 28 | 66 |
| D5432050 | 5.0 | 6 | 28 | 66 |
| D5432051 | 5.1 | 6 | 28 | 66 |
| D5432052 | 5.2 | 6 | 28 | 66 |
| D5432053 | 5.3 | 6 | 28 | 66 |

| EDP No. | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|---|---|---|---|---|
| D5432054 | 5.4 | 6 | 28 | 66 |
| D5432055 | 5.5 | 6 | 28 | 66 |
| D5432056 | 5.6 | 6 | 28 | 66 |
| D5432057 | 5.7 | 6 | 28 | 66 |
| D5432058 | 5.8 | 6 | 28 | 66 |
| D5432059 | 5.9 | 6 | 28 | 66 |
| D5432060 | 6.0 | 6 | 28 | 66 |
| D5432061 | 6.1 | 8 | 34 | 79 |
| D5432062 | 6.2 | 8 | 34 | 79 |
| D5432063 | 6.3 | 8 | 34 | 79 |
| D5432064 | 6.4 | 8 | 34 | 79 |
| D5432065 | 6.5 | 8 | 34 | 79 |
| D5432066 | 6.6 | 8 | 34 | 79 |
| D5432067 | 6.7 | 8 | 34 | 79 |
| D5432068 | 6.8 | 8 | 34 | 79 |
| D5432069 | 6.9 | 8 | 34 | 79 |
| D5432070 | 7.0 | 8 | 34 | 79 |
| D5432071 | 7.1 | 8 | 41 | 79 |
| D5432072 | 7.2 | 8 | 41 | 79 |
| D5432073 | 7.3 | 8 | 41 | 79 |
| D5432074 | 7.4 | 8 | 41 | 79 |
| D5432075 | 7.5 | 8 | 41 | 79 |
| D5432076 | 7.6 | 8 | 41 | 79 |
| D5432077 | 7.7 | 8 | 41 | 79 |

- DLC coating is available on your request.
- 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 |
| Recommendad | | | | | | | | | | | | | | | | | | | | |

| 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 | 1060Rm | 550 | 630 | 400 | 550 |
| Recommendad | ◎ | ◎ | ◎ | ◎ | | | | | | | | | | | | | | | | | |

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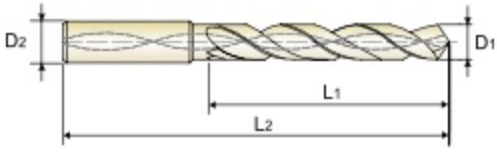


DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright | p.A139 | 3× D

Recommended ToolHolder

| | PlainShank | Page |
|---|---|---|
| ◎ | SHRINKFITHOLDER | D47-72 |
| ◎ | HYDRAULICCHUCK | D15-46 |
| ○ | ERCOLLETCHUCK | D73-115 |

Unit : mm

| EDP No. | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|---|---|---|---|---|
| D5432078 | 7.8 | 8 | 41 | 79 |
| D5432079 | 7.9 | 8 | 41 | 79 |
| D5432080 | 8.0 | 8 | 41 | 79 |
| D5432081 | 8.1 | 10 | 47 | 89 |
| D5432082 | 8.2 | 10 | 47 | 89 |
| D5432083 | 8.3 | 10 | 47 | 89 |
| D5432084 | 8.4 | 10 | 47 | 89 |
| D5432085 | 8.5 | 10 | 47 | 89 |
| D5432086 | 8.6 | 10 | 47 | 89 |
| D5432087 | 8.7 | 10 | 47 | 89 |
| D5432088 | 8.8 | 10 | 47 | 89 |
| D5432089 | 8.9 | 10 | 47 | 89 |
| D5432090 | 9.0 | 10 | 47 | 89 |
| D5432091 | 9.1 | 10 | 47 | 89 |
| D5432092 | 9.2 | 10 | 47 | 89 |
| D5432093 | 9.3 | 10 | 47 | 89 |
| D5432094 | 9.4 | 10 | 47 | 89 |
| D5432095 | 9.5 | 10 | 47 | 89 |
| D5432096 | 9.6 | 10 | 47 | 89 |
| D5432097 | 9.7 | 10 | 47 | 89 |
| D5432098 | 9.8 | 10 | 47 | 89 |
| D5432099 | 9.9 | 10 | 47 | 89 |
| D5432100 | 10.0 | 10 | 47 | 89 |
| D5432101 | 10.1 | 12 | 55 | 102 |

| EDP No. | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|---|---|---|---|---|
| D5432102 | 10.2 | 12 | 55 | 102 |
| D5432103 | 10.3 | 12 | 55 | 102 |
| D5432104 | 10.4 | 12 | 55 | 102 |
| D5432105 | 10.5 | 12 | 55 | 102 |
| D5432106 | 10.6 | 12 | 55 | 102 |
| D5432107 | 10.7 | 12 | 55 | 102 |
| D5432108 | 10.8 | 12 | 55 | 102 |
| D5432109 | 10.9 | 12 | 55 | 102 |
| D5432110 | 11.0 | 12 | 55 | 102 |
| D5432111 | 11.1 | 12 | 55 | 102 |
| D5432112 | 11.2 | 12 | 55 | 102 |
| D5432113 | 11.3 | 12 | 55 | 102 |
| D5432114 | 11.4 | 12 | 55 | 102 |
| D5432115 | 11.5 | 12 | 55 | 102 |
| D5432116 | 11.6 | 12 | 55 | 102 |
| D5432117 | 11.7 | 12 | 55 | 102 |
| D5432118 | 11.8 | 12 | 55 | 102 |
| D5432119 | 11.9 | 12 | 55 | 102 |
| D5432120 | 12.0 | 12 | 55 | 102 |
| D5432125 | 12.5 | 14 | 60 | 107 |
| D5432130 | 13.0 | 14 | 60 | 107 |
| D5432135 | 13.5 | 14 | 60 | 107 |
| D5432140 | 14.0 | 14 | 60 | 107 |
| D5432145 | 14.5 | 16 | 65 | 115 |

- DLC coating is available on your request.
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▶ 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 | |
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| HB | 125 | 190 | 250 | 270 | 300 | 180 | 275 | 300 | 350 | 200 | 325 | 200 | 240 | 180 | 180 | 260 | 160 | 250 | 130 | 230 |
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| ISO | N | | | | | | | | | | S | | | | | | | H | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
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| 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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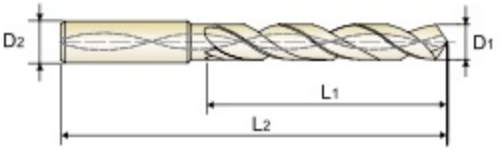


DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright | p.A139 | 3× D

Recommended ToolHolder

| PlainShank | Page |
|---|---|
| SHRINKFITHOLDER | D47-72 |
| HYDRAULICCHUCK | D15-46 |
| ERCOLLETCHUCK | D73-115 |

Unit : mm

| EDP No. | Drill Diameter $D_1$ | Shank Diameter $D_2$ | Flute Length $L_1$ | Overall Length $L_2$ |
|---|---|---|---|---|
| **D5432150** | **15.0** | 16 | 65 | 115 |
| **D5432155** | **15.5** | 16 | 65 | 115 |
| **D5432160** | **16.0** | 16 | 65 | 115 |
| **D5432165** | **16.5** | 18 | 73 | 123 |
| **D5432170** | **17.0** | 18 | 73 | 123 |
| **D5432175** | **17.5** | 18 | 73 | 123 |
| **D5432180** | **18.0** | 18 | 73 | 123 |
| **D5432185** | **18.5** | 20 | 79 | 131 |

| EDP No. | Drill Diameter $D_1$ | Shank Diameter $D_2$ | Flute Length $L_1$ | Overall Length $L_2$ |
|---|---|---|---|---|
| **D5432190** | **19.0** | 20 | 79 | 131 |
| **D5432195** | **19.5** | 20 | 79 | 131 |
| **D5432200** | **20.0** | 20 | 79 | 131 |

- DLC coating is available on your request.
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◎ : 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 | |
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| 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 | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
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| HB | 60 | 100 | 75 | 90 | 130 | 110 | 90 | 100 | | | 200 | 280 | 250 | 350 | 320 | 400Rm | 1050Rm | 550 | 630 | 400 | 550 |
| Recommended | ◎ | ◎ | ◎ | ◎ | | | | | | | | | | | | | | | | | |