



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

● VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL

KURZ

● Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série courte

COURTE

● PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione)

CORTA

► Special flute shape and geometry suitable for machining stainless steel

► Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl

► Excellent chip evacuation from better surface treatment

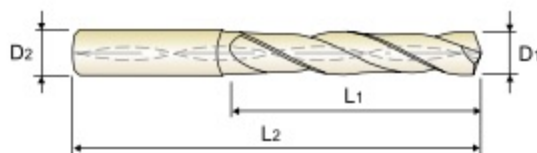
► Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung

► Point R-thinning achieves superior centering and chip curling

► Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung

► TiAlN coating for better surface finishes and longer tool life

► TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAlN



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3 x D



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

| EDP No. | Drill Diameter | Shank Diameter | Flute Length | Overall Length |
|----------|----------------|----------------|--------------|----------------|
| | D1 | D2 | L1 | L2 |
| TiAlN | | | | |
| DH451078 | 7.8 | 8 | 41 | 79 |
| DH451079 | 7.9 | 8 | 41 | 79 |
| DH451080 | 8.0 | 8 | 41 | 79 |
| DH451081 | 8.1 | 10 | 47 | 89 |
| DH451082 | 8.2 | 10 | 47 | 89 |
| DH451083 | 8.3 | 10 | 47 | 89 |
| DH451084 | 8.4 | 10 | 47 | 89 |
| DH451085 | 8.5 | 10 | 47 | 89 |
| DH451086 | 8.6 | 10 | 47 | 89 |
| DH451087 | 8.7 | 10 | 47 | 89 |
| DH451088 | 8.8 | 10 | 47 | 89 |
| DH451089 | 8.9 | 10 | 47 | 89 |
| DH451090 | 9.0 | 10 | 47 | 89 |
| DH451091 | 9.1 | 10 | 47 | 89 |
| DH451092 | 9.2 | 10 | 47 | 89 |
| DH451093 | 9.3 | 10 | 47 | 89 |
| DH451094 | 9.4 | 10 | 47 | 89 |
| DH451095 | 9.5 | 10 | 47 | 89 |
| DH451096 | 9.6 | 10 | 47 | 89 |
| DH451097 | 9.7 | 10 | 47 | 89 |
| DH451098 | 9.8 | 10 | 47 | 89 |
| DH451099 | 9.9 | 10 | 47 | 89 |
| DH451100 | 10.0 | 10 | 47 | 89 |
| DH451101 | 10.1 | 12 | 55 | 102 |

| EDP No. | Drill Diameter | Shank Diameter | Flute Length | Overall Length |
|----------|----------------|----------------|--------------|----------------|
| | D1 | D2 | L1 | L2 |
| TiAlN | | | | |
| DH451102 | 10.2 | 12 | 55 | 102 |
| DH451103 | 10.3 | 12 | 55 | 102 |
| DH451104 | 10.4 | 12 | 55 | 102 |
| DH451105 | 10.5 | 12 | 55 | 102 |
| DH451106 | 10.6 | 12 | 55 | 102 |
| DH451107 | 10.7 | 12 | 55 | 102 |
| DH451108 | 10.8 | 12 | 55 | 102 |
| DH451109 | 10.9 | 12 | 55 | 102 |
| DH451110 | 11.0 | 12 | 55 | 102 |
| DH451111 | 11.1 | 12 | 55 | 102 |
| DH451112 | 11.2 | 12 | 55 | 102 |
| DH451113 | 11.3 | 12 | 55 | 102 |
| DH451114 | 11.4 | 12 | 55 | 102 |
| DH451115 | 11.5 | 12 | 55 | 102 |
| DH451116 | 11.6 | 12 | 55 | 102 |
| DH451117 | 11.7 | 12 | 55 | 102 |
| DH451118 | 11.8 | 12 | 55 | 102 |
| DH451119 | 11.9 | 12 | 55 | 102 |
| DH451120 | 12.0 | 12 | 55 | 102 |
| DH451125 | 12.5 | 14 | 60 | 107 |
| DH451130 | 13.0 | 14 | 60 | 107 |
| DH451135 | 13.5 | 14 | 60 | 107 |
| DH451140 | 14.0 | 14 | 60 | 107 |
| DH451145 | 14.5 | 16 | 65 | 115 |

Unit : mm

► 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 | |
| Material Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | |
| VDI 3323 | 13 | 25 | 28 | 32 | 32 | 10 | 29 | 32 | 38 | 15 | 35 | 15 | 23 | 10 | 10 | 26 | 3 | 25 | 21 | 21 | |
| HRC | 125 | 190 | 250 | 270 | 300 | 180 | 275 | 300 | 350 | 200 | 325 | 200 | 240 | 180 | 180 | 260 | 160 | 250 | 130 | 230 | |
| 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 | 40 | 41 |
| 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 | 400Rm | 1050Rm | 550 | 630 | 400 | 550 |
| Recommended | ◎ | ◎ | ○ | ○ | ○ | | | | | | | | | | | | ○ | | | | |

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KURZ

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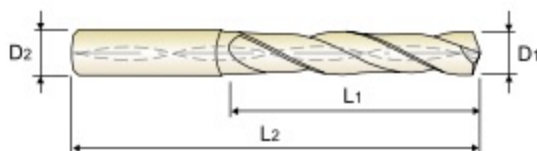
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3 x D



Recommended ToolHolder

| PlainShank | Page |
|------------------|---------|
| ☉ SHRINKHOLDER | D47-72 |
| ☉ HYDRAULICCHUCK | D15-46 |
| ☉ ERDOLLECHUCK | D73-115 |

| EDP No. | Drill Diameter | Shank Diameter | Flute Length | Overall Length |
|----------|----------------|----------------|--------------|----------------|
| TiAlN | D1 | D2 | L1 | L2 |
| DH451150 | 15.0 | 16 | 65 | 115 |
| DH451155 | 15.5 | 16 | 65 | 115 |
| DH451160 | 16.0 | 16 | 65 | 115 |
| DH451165 | 16.5 | 18 | 73 | 123 |
| DH451170 | 17.0 | 18 | 73 | 123 |
| DH451175 | 17.5 | 18 | 73 | 123 |

| EDP No. | Drill Diameter | Shank Diameter | Flute Length | Overall Length |
|----------|----------------|----------------|--------------|----------------|
| TiAlN | D1 | D2 | L1 | L2 |
| DH451180 | 18.0 | 18 | 73 | 123 |
| DH451185 | 18.5 | 20 | 79 | 131 |
| DH451190 | 19.0 | 20 | 79 | 131 |
| DH451195 | 19.5 | 20 | 79 | 131 |
| DH451200 | 20.0 | 20 | 79 | 131 |

Unit : mm

▶ Other shank types are available on your request.

☉ : 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 | | | | | | | | | | | | | | | | | | | | |
| HRc | | | | | | | | | | | | | | | | | | | | |
| 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 | 40 | 41 |
| VDI 3323 | | | | | | | | | | | | | | | | | | | | | |
| 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 | ☉ | ☉ | ○ | ○ | ○ | | | | | | | | | | | | ○ | | | | |