

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

SHORT

KURZ

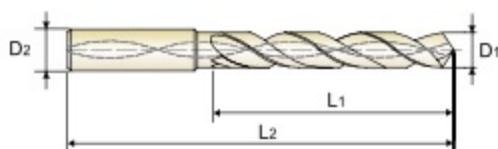
COURTE

CORTA

-  **VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL**
 **Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série courte**
 **PUNTE ELICOIDALI IN MD. DREAM DRILLS - ALU (con fori di refrigerazione)**

- ▶ Optimized thinning 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 & Aluminiumlegierungen 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



h6



118°



20 bar

Bright



p.A139

3 x D



PlainSho

Page

SHARKEITHOLDER D47.72

④	STRENGTHENING	D41-12
④	STRENGTHENING	D41-12

© HYDRAULICCHUCK D15-46

ERDOLLECHUK D73-115

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	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	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	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

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	⊗	⊗	⊗	⊗																		

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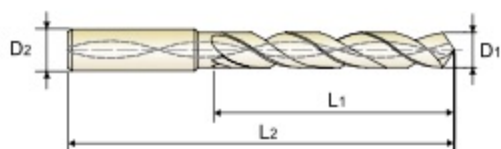
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Bright



p_A139

3 x D



PlainShank Page

 SHARINETHOLIER D47.72

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Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	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	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	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

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▶ NEXT PAGE

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 HrC HB	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
	125	130	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 HrC HB	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55		
Recommended	②	③	②	④							200	280	250	350	320								

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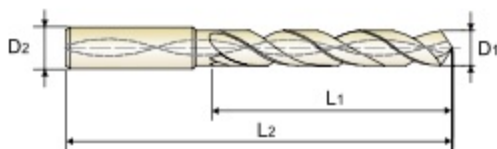
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3 x D



	PlainShank	Page
⊗	SHRINKFITHOLDER	D47-72
⊙	HYDRAULICCHUCK	D15-46
○	ERCOLETSCHUCK	D73-115

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
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	Shank Diameter	Flute Length	Overall Length
	D ₁	D ₂	L ₁	L ₂
D5432190	19.0	20	79	131
D5432195	19.5	20	79	131
D5432200	20.0	20	79	131

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