



DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRC50~HRC70)

SHORT

● VOLLHARTMETALL DREAM SPIRALBOHRER FÜR HOCHGEHARTETE STAHL

KURZ

● Forets DREAM DRILLS carbure pour Aciers Trempés (50 HRC ~ 70 HRC)

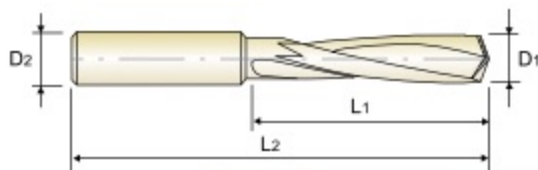
COURTE

● PUNTE ELICOIDALI IN MD, DREAM DRILL - ACCIAI HRC 50 - 70

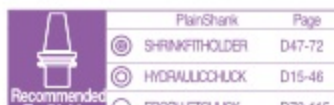
CORTA

- ▶ Drilling for High Hardened Steels; Quenched Steels, Tempered Steels (under HRC 70)
- ▶ Special geometry design for Hardened Steels
- ▶ Minimum of cutting load through special thinning
- ▶ Performing good chip removal and powerful drilling

- ▶ Bohren von hoch gehärteten Stählen, Vergütungsstähle, angelassenen Stählen bis HRC 70
- ▶ Spezielle Bohrergeometrie für gehärtete Stähle
- ▶ Minimaler Schnedruck durch spezielle Ausspitzung
- ▶ Gute Spanabfuhr und Hochleistungsbohren



3 x D



Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TAIN	D1	D2	L1	L2
DH500026	2.6	3	14	44
DH500030	3.0	3	16	46
DH500033	3.3	4	18	48
DH500034	3.4	4	20	50
DH500035	3.5	4	20	50
DH500040	4.0	4	22	52
DH500042	4.2	6	25	65
DH500043	4.3	6	28	68
DH500044	4.4	6	28	68
DH500045	4.5	6	28	68
DH500050	5.0	6	32	72
DH500051	5.1	6	32	72
DH500052	5.2	6	32	72
DH500055	5.5	6	35	75
DH500060	6.0	6	35	75
DH500065	6.5	8	40	80
DH500068	6.8	8	45	85
DH500069	6.9	8	45	85

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TAIN	D1	D2	L1	L2
DH500070	7.0	8	45	85
DH500075	7.5	8	45	85
DH500080	8.0	8	50	98
DH500085	8.5	10	50	98
DH500086	8.6	10	57	105
DH500088	8.8	10	57	105
DH500090	9.0	10	57	105
DH500095	9.5	10	57	105
DH500100	10.0	10	63	111
DH500102	10.2	12	63	111
DH500103	10.3	12	63	111
DH500105	10.5	12	63	111
DH500108	10.8	12	71	119
DH500110	11.0	12	71	119
DH500115	11.5	12	71	119
DH500120	12.0	12	71	119
DH500140	14.0	14	77	125

CUTTING CONDITIONS

DH500 SERIES DREAM DRILLS for HIGH HARDENED STEELS

VC = m/min
FPM = rev/min
FEED = mm/rev

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)								
					2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0
H	38	Hardened steel	20	FPM	2550	2120	1590	1270	1060	800	640	530	450
	FEED			0.01-0.03	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06	0.01-0.06	
	39.1			FPM	1910	1590	1190	950	800	600	480	400	340
	39.3		12	FPM	1530	1270	950	760	640	480	380	320	270
				FEED	0.01-0.03	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06

◎ : 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																						
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											15	30	25	38	34			55	60	70	42	55
HRC											200	280	250	350	320			550	630		400	550
HB	60	100	75	90	130	110	90	100									400Rm	1050Rm				
Recommended																		◎	◎	◎		