

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

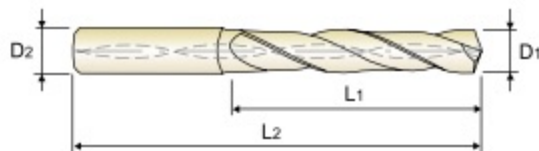
COURTE

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

CORTA

- ▶ Special flute shape and geometry suitable for machining stainless steel
- ▶ Excellent chip evacuation from better surface treatment
- ▶ Point R-thinning achieves superior centering and chip curling
- ▶ TiAlN coating for better surface finishes and longer tool life

- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit

DIN
6537

CARBIDE



h6



140°



20 bar



p.A127

3x D



PlainShank

Page

SHRINKAGE DUE TO DRYING 79

④	2016年11月15日	041-12
④	2016年11月15日	041-12

© HYDRAULICCHUCK D15-46

ERIC ERODLETSCHUK D73-116

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2
DH451030	3.0	6	20	62
DH451031	3.1	6	20	62
DH451032	3.2	6	20	62
DH451033	3.3	6	20	62
DH451034	3.4	6	20	62
DH451035	3.5	6	20	62
DH451036	3.6	6	20	62
DH451037	3.7	6	20	62
DH451038	3.8	6	24	66
DH451039	3.9	6	24	66
DH451040	4.0	6	24	66
DH451041	4.1	6	24	66
DH451042	4.2	6	24	66
DH451043	4.3	6	24	66
DH451044	4.4	6	24	66
DH451045	4.5	6	24	66
DH451046	4.6	6	24	66
DH451047	4.7	6	24	66
DH451048	4.8	6	28	66
DH451049	4.9	6	28	66
DH451050	5.0	6	28	66
DH451051	5.1	6	28	66
DH451052	5.2	6	28	66
DH451053	5.3	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2
DH451054	5.4	6	28	66
DH451055	5.5	6	28	66
DH451056	5.6	6	28	66
DH451057	5.7	6	28	66
DH451058	5.8	6	28	66
DH451059	5.9	6	28	66
DH451060	6.0	6	28	66
DH451061	6.1	8	34	79
DH451062	6.2	8	34	79
DH451063	6.3	8	34	79
DH451064	6.4	8	34	79
DH451065	6.5	8	34	79
DH451066	6.6	8	34	79
DH451067	6.7	8	34	79
DH451068	6.8	8	34	79
DH451069	6.9	8	34	79
DH451070	7.0	8	34	79
DH451071	7.1	8	41	79
DH451072	7.2	8	41	79
DH451073	7.3	8	41	79
DH451074	7.4	8	41	79
DH451075	7.5	8	41	79
DH451076	7.6	8	41	79
DH451077	7.7	8	41	79

► 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			
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	⊗	⊗	○	○	○												○						

CARBIDE. DREAM DRILLS - INOX with COOLANT HOLES

SHORT

 **VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL**

KURZ

Forests DREAM DRILLS carbure pour INOX, avec arrosage central, série courte

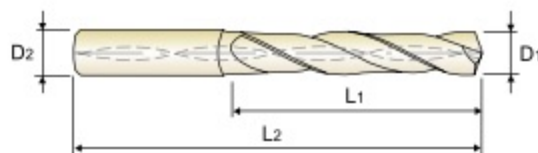
COURTE

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

CORTA

- ▶ Special flute shape and geometry suitable for machining stainless steel
- ▶ Excellent chip evacuation from better surface treatment
- ▶ Point R-thinning achieves superior centering and chip curling
- ▶ TiAlN coating for better surface finishes and longer tool life

- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit

DIN
6537

CARBIDE

h6


140°

20 bar



p.A127

3 x D



PlainShank

Page

© SHANKS & PARTNERS 1997 047-72

© 2014 WILEY-VCH Verlag GmbH & Co. KGaA, Weinheim	041-72
© 2014 WILEY-VCH Verlag GmbH & Co. KGaA, Weinheim	041-72

© HYDRAULICCHUCK D15-46

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2
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
TiAIN	D1	D2	L1	L2
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

► 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 alloy steel, 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																							
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	⊗	⊗	○	○	○												○						



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

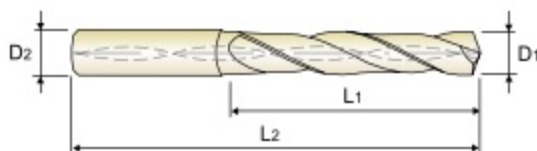
COURTE

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

CORTA

- Special flute shape and geometry suitable for machining stainless steel
- Excellent chip evacuation from better surface treatment
- Point R-thinning achieves superior centering and chip curling
- TiAlN coating for better surface finishes and longer tool life

- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



p.A127

3 x D



Plain Shank	Page
☉ SHANKHOLDERS	D47-72
☉ HYDRAULIC CHUCK	D15-46
☉ ERCOLLETT CHUCK	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									
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	☉	☉	○	○	○												○							