YE-DD24 EUROPE

YG

SOLID CARBIDE
DREAM DRILLS

PRO with/without Coolant Holes
NEW **X** with/without Coolant Holes
GENERAL with/without Coolant Holes
HIGH FEED with Coolant Holes
FLAT BOTTOM with/without Coolant Holes
INOX with Coolant Holes
ALU with Coolant Holes
MQL TYPE with Coolant Holes(10xD - 40xD)
for HIGH HARDENED STEELS HRc50-70

SELECTION GUIDE

METRIC

SOLID CARBIDE

DREAM DRILLS

	PRO				X
SERIES	DGN523	DGN526	DGN506	DGN508	DTX404
DRILLING DEPTH	3XD	5XD	3XD	5XD	3XD
TOOL MATERIAL	CARBIDE				CARBIDE
LENGTH	SHORT	LONG	SHORT	LONG	STUB
SIZE MIN	D3.0	D1.0	D3.0	D1.0	D3.0
SIZE MAX	D20.0	D20.0	D20.0	D20.0	D20.0
PAGE	10	12	15	17	26
SURFACE TREATMENT	Z-Coating				RCH-Coating

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

ISO		VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc						
P	1		Non-alloy steel	About 0.15% C	Annealed	125							1
	2			About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	2
	3			About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎	◎	3
	4			About 0.75% C	Annealed	270	28	◎	◎	◎	◎	◎	4
	5			About 0.75% C	Quenched & Tempered	300	32	○	○	○	○	○	5
	6		Low alloy steel		Annealed	180	10	◎	◎	◎	◎	◎	6
	7				Quenched & Tempered	275	29	◎	◎	◎	◎	◎	7
	8				Quenched & Tempered	300	32	○	○	○	○	○	8
	9				Quenched & Tempered	350	38	○	○	○	○	○	9
	10		High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎	◎	◎	10
	11				Quenched & Tempered	325	35	○	○	○	○	○	11
M	12		Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	○	○	12
	13			Martensitic	Quenched & Tempered	240	23	○	○	○	○	○	13
	14			Austenitic		180	10						14
K	15		Grey cast iron	Pearlitic / ferritic		180	10	◎	◎	◎	◎	◎	15
	16			Pearlitic (Martensitic)		260	26	○	○	○	○	○	16
	17		Nodular cast iron	Ferritic		160	3	◎	◎	◎	◎	◎	17
	18			Pearlitic		250	25	○	○	○	○	○	18
	19		Malleable cast iron	Ferritic		130		◎	◎	◎	◎	◎	19
	20			Pearlitic		230	21	○	○	○	○	○	20
N	21		Aluminum-wrought alloy	Not Curable		60							21
	22			Curable	Hardened	100							22
	23		Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75							23
	24			≤ 12% Si, Curable	Hardened	90							24
	25			> 12% Si, Not Curable		130							25
	26		Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110							26
	27			CuZn, CuSnZn (Brass)		90							27
	28			CuSn, lead-free copper and electrolytic copper		100							28
	29		Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic									29
	30			Rubber, Wood, etc.									30
S	31		Heat Resistant Super Alloys	Fe Based	Annealed	200	15						31
	32				Cured	280	30						32
	33			Ni or Co Based	Annealed	250	25						33
	34				Cured	350	38						34
	35				Cast	320	34						35
	36		Titanium Alloys	Pure Titanium		400 Rm							36
	37			Alpha + Beta Alloys	Hardened	1050 Rm							37
H	38		Hardened steel		Hardened	550	55	○	○	○	○	○	38
	39				Hardened	630	60						39
	40		Chilled Cast Iron		Cast	400	42						40
	41		Hardened Cast Iron		Hardened	550	55						41

	X					GENERAL					
	DTX423	DTX424	DTX406	DTX408	DTX421	DH404	DH423 DH443	DH424 DH444	DH406 DH446	DH408 DH448	DH421
	3XD	5XD	3XD	5XD	8XD	3XD	3XD	5XD	3XD	5XD	8XD
	CARBIDE					CARBIDE					
	SHORT	LONG	SHORT	LONG	EXTRA LONG	STUB	SHORT	LONG	SHORT	LONG	EXTRA LONG
	D3.0	D1.0	D3.0	D1.0	D3.0	D3.0	D3.0	D1.0	D3.0	D1.0	D3.0
	D20.0	D20.0	D20.0	D20.0	D14.0	D20.0	D20.0	D20.0	D20.0	D20.0	D14.0
	28	30	33	35	38	46	48	50	53	55	58
	RCH-Coating					TiAlN					

													1
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	2	P
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	3	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	4	
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◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	6	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	7	
○	○	○	○	○	○	○	○	○	○	○	○	8	
○	○	○	○	○	○	○	○	○	○	○	○	9	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	10	
○	○	○	○	○	○	○	○	○	○	○	○	11	
○	○	○	○	○	○	○	○	○	○	○	○	12	M
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○	○	○	○	○	○	○	○	○	○	○	○	16	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	17	
○	○	○	○	○	○	○	○	○	○	○	○	18	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	19	
○	○	○	○	○	○	○	○	○	○	○	○	20	
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○	○	○	○	○	○	○	○	○	○	○	○	38	H
												39	
												40	
												41	

SELECTION GUIDE METRIC

SOLID CARBIDE DREAM DRILLS

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

						HIGH FEED		FLAT BOTTOM	
					SERIES	DGR493	DGR495	DPP447	DH450
					DRILLING DEPTH	3XD	5XD	2XD	5XD
					TOOL MATERIAL	CARBIDE		CARBIDE	
					LENGTH	SHORT	LONG	SHORT	LONG
					SIZE MIN	D5.0	D5.0	D3.0	D3.0
					SIZE MAX	D20.0	D20.0	D20.0	D20.0
					PAGE	66	68	74	76
					SURFACE TREATMENT	H-Coating		X-Coating	TiAlN
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc				
P	1	Non-alloy steel	About 0.15% C	Annealed	125				◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	○	○
	5		About 0.75% C	Quenched & Tempered	300	32	○	○	○	○
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎
	7			Quenched & Tempered	275	29	◎	◎	○	○
	8			Quenched & Tempered	300	32	○	○	○	○
	9			Quenched & Tempered	350	38	○	○	○	○
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎		
	11			Quenched & Tempered	325	35	○	○		
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15			○	○
	13		Martensitic	Quenched & Tempered	240	23				
	14		Austenitic		180	10				
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	◎	◎	◎
	16		Pearlitic (Martensitic)		260	26	○	○	○	○
	17	Nodular cast iron	Ferritic		160	3	◎	◎		
	18		Pearlitic		250	25	○	○		
	19	Malleable cast iron	Ferritic		130		◎	◎		
	20		Pearlitic		230	21	○	○		
N	21	Aluminum-wrought alloy	Not Curable		60				○	○
	22		Curable	Hardened	100				○	○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75					
	24		≤ 12% Si, Curable	Hardened	90					
	25		> 12% Si, Not Curable		130					
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110					
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	28		CuSn, lead-free copper and electrolytic copper		100					
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15				
	32			Cured	280	30				
	33		Ni or Co Based	Annealed	250	25				
	34			Cured	350	38				
	35			Cast	320	34				
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm					
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				

	INOX			ALU			MQL TYPE			
SERIES	DH451	DH452	DH453	D5432	D5433	D5434	DH510	DH515	DH520	DHM10
DRILLING DEPTH	3XD	5XD	8XD	3XD	5XD	8XD	10XD	15XD	20XD	10XD
TOOL MATERIAL	CARBIDE			CARBIDE			CARBIDE			
LENGTH	SHORT	LONG	EXTRA LONG	SHORT	LONG	EXTRA LONG	EXTRA LONG			
SIZE MIN	D3.0	D1.0	D3.0	D3.0	D3.0	D3.0	D3.0	D3.0	D3.0	D3.0
SIZE MAX	D20.0	D20.0	D14.0	D20.0	D20.0	D14.0	D14.0	D12.0	D12.0	D14.0
PAGE	84	86	89	96	98	100	106	107	107	108
SURFACE TREATMENT	TiAlN			Bright			TiAlN			
							◎	◎	◎	◎
	◎	◎	◎				◎	◎	◎	◎
	○	○	○				○	○	○	○
	◎	◎	◎				◎	◎	◎	◎
	○	○	○				○	○	○	○
							○	○	○	○
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	◎	◎	◎				○	○	○	○
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	○	○	○	◎	◎	◎				
	○	○	○							
	○	○	○							

GUIDE LINE TO ICONS

Standard of Tools
DIN 6539
Number of DIN Standard

Coolant Supply Pressure
45 bar
20 bar

Tool Material
CARBIDE

Point Angle
140°

Surface Treatment
TiAlN
Titanium Aluminum Nitride Coating
RCH-Coating
YG-1 RCH-Coating
X-Coating
YG-1 X-Coating
H-Coating
YG-1 H-Coating
Diamond
Diamond Coating
Bright
Bright Finish

Tolerance of Dimension
m7
Tolerance of Outside Diameter
h6
Tolerance of Shank Diameter

Cutting Condition

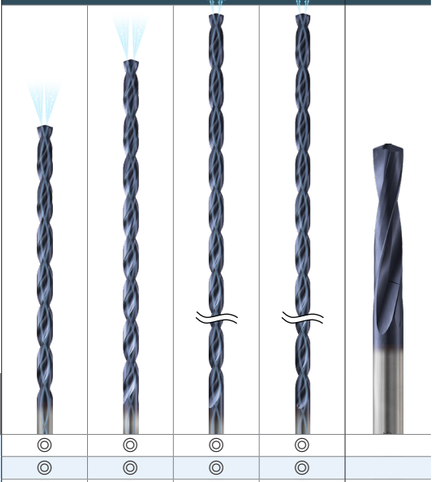
SELECTION GUIDE METRIC

SOLID CARBIDE DREAM DRILLS

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

			MQL TYPE				HARDENED STEEL
		SERIES	DHM15	DHM20	DHM25	DHM30	DH500
		DRILLING DEPTH	15XD	20XD	25XD	30XD	3XD
		TOOL MATERIAL	CARBIDE				CARBIDE
		LENGTH	EXTRA LONG				SHORT
		SIZE MIN	D3.0	D3.0	D3.0	D3.0	D2.6
		SIZE MAX	D12.0	D12.0	D10.0	D8.0	D14.0
		PAGE	108	108	109	109	114
		SURFACE TREATMENT	TiAlN				TiAlN



ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc					
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎	
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	
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	4		About 0.75% C	Annealed	270	28					
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	7			Quenched & Tempered	275	29	○	○	○	○	
	8			Quenched & Tempered	300	32	○	○	○	○	
	9			Quenched & Tempered	350	38					
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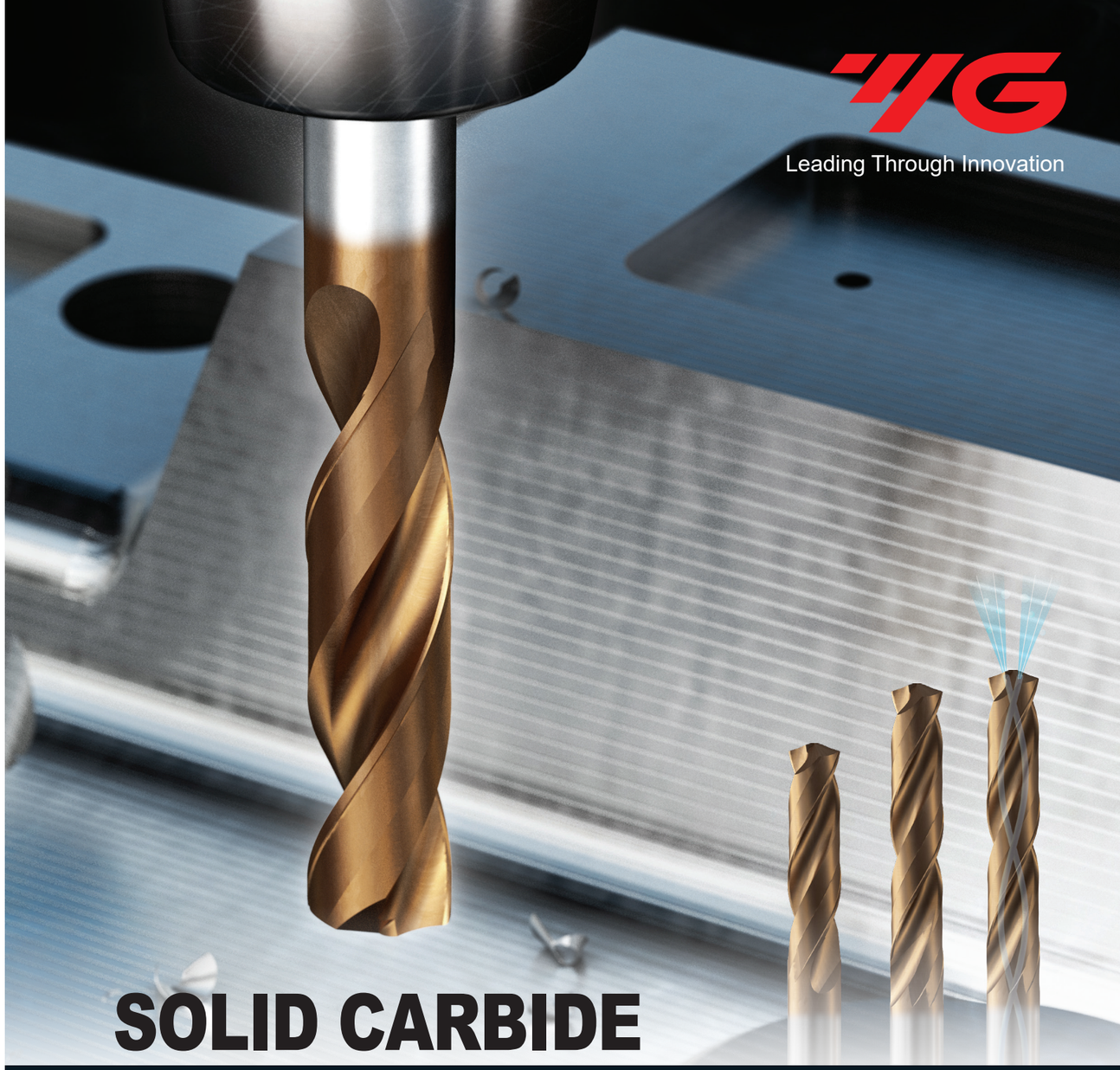
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15					
	13		Martensitic	Quenched & Tempered	240	23					
	14		Austenitic		180	10					
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	◎	◎	◎	
	16		Pearlitic (Martensitic)		260	26	○	○	○	○	
	17	Nodular cast iron	Ferritic		160	3	◎	◎	◎	◎	
	18		Pearlitic		250	25	○	○	○	○	
	19	Malleable cast iron	Ferritic		130		◎	◎	◎	◎	
	20		Pearlitic		230	21	○	○	○	○	
N	21	Aluminum-wrought alloy	Not Curable		60						
	22		Curable	Hardened	100						
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75						
	24		≤ 12% Si, Curable	Hardened	90						
	25		> 12% Si, Not Curable		130						
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110						
	27		CuZn, CuSnZn (Brass)		90						
	28		CuSn, lead-free copper and electrolytic copper		100						
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic								
	30		Rubber, Wood, etc.								
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15					
	32			Cured	280	30					
	33		Ni or Co Based	Annealed	250	25					
	34			Cured	350	38					
	35			Cast	320	34					
	36	Titanium Alloys	Pure Titanium		400 Rm						
	37		Alpha + Beta Alloys	Hardened	1050 Rm						
H	38	Hardened steel		Hardened	550	55					◎
	39			Hardened	630	60					◎
	40	Chilled Cast Iron		Cast	400	42					
	41	Hardened Cast Iron		Hardened	550	55					

Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -PRO

- For General Purpose (up to HRc50)
- Extremely High hardness and Heat resistance due to YG-1 special Z-Coating technology

DREAM DRILLS ALU

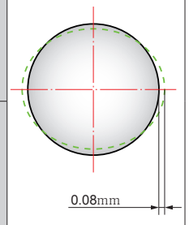
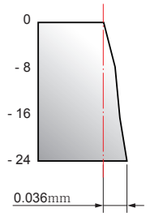
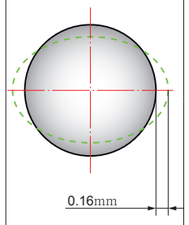
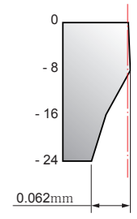
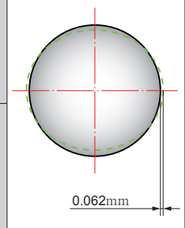
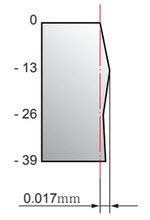
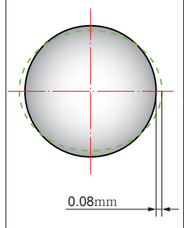
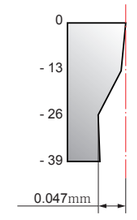
Design that optimized flute shape and geometry suitable **for Aluminum, Aluminum alloy.**

Optimized point thinning to prevent any **chip-clogging from chip welding.**

Polished flutes improve **chip control and evacuation.**

The Drilling of High Speed is possible while maintaining **the excellent surface roughness of workpiece.**

Ø6.0 & Ø10.0 TEST, Aluminum(6061)

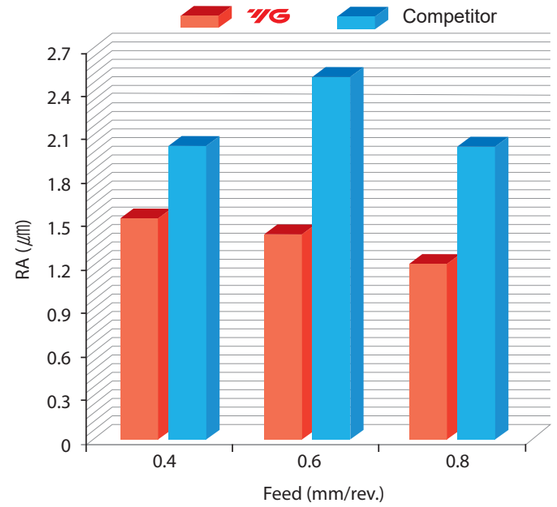
CUTTING CONDITION	YG DREAM DRILL-ALU		COMPETITOR A	
	Roundness	Straightness	Roundness	Straightness
SIZE Ø 6.0				
Drilling Holes 1200 Holes				
SIZE Ø10.0				
Drilling Holes 820 Holes				

· Phone: +82-32-526-0909, www.yg1.solutions, E-mail: yg1@yg1.solutions

CASE STUDY

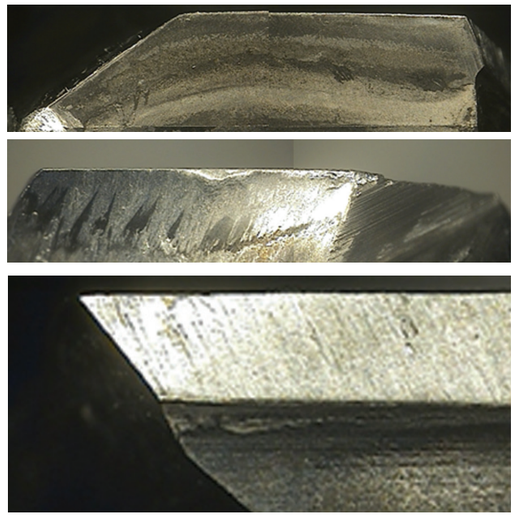
▶SOLID CARBIDE DREAM DRILLS - ALU with Coolant Holes

CUTTING CONDITION	
Tool	D5433100
Size(mm)	Ø10 × Ø10 × 61 × 103
Work Material	• DIN: AlMgSiCu • AISI: 6061 • JIS: A6061
RPM	6,367 rev./min.
Feed	0.4-0.8 mm/rev.
Drilling Depth	45 mm
Coolant	Wet cut

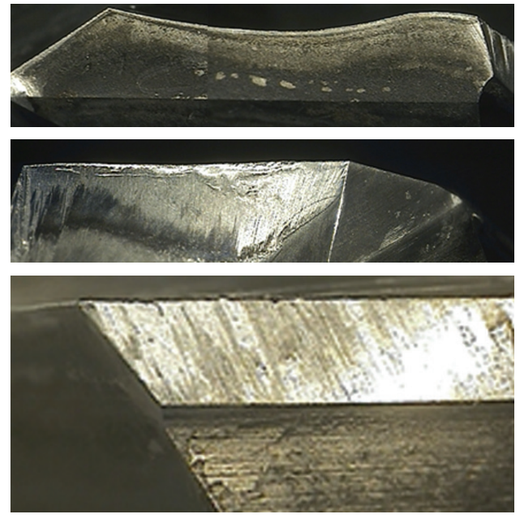


Surface Roughness of Work Piece

YG Total Drilling 820 Holes



Competitor A Total Drilling 820 Holes



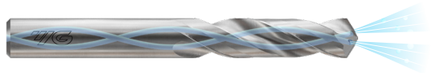
· Phone: +82-32-526-0909, www.yg1.solutions, E-mail: yg1@yg1.solutions

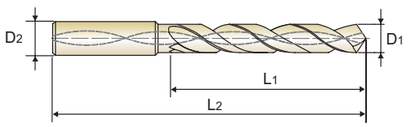
SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (3XD)

SERIES **D5432**

- 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





DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

SHORT 3 × D

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
D5432054	5.4	6	28	66
D5432055	5.5	6	28	66
D5432056	5.6	6	28	66
D5432057	5.7	6	28	66

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

▶ 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
Recommended																				

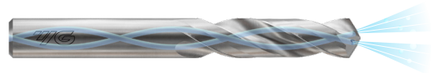
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	

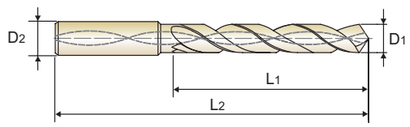
SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (3XD)

SERIES D5432

- 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





DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

SHORT 3 × D

Unit : mm

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

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

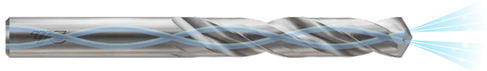
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	

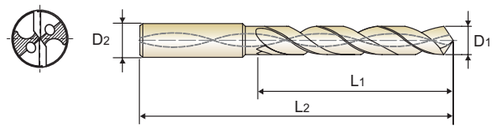
SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (5XD)

SERIES **D5433**

- 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





DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

LONG 5 × D

Unit : mm

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5433030	3.0	6	28	66
D5433031	3.1	6	28	66
D5433032	3.2	6	28	66
D5433033	3.3	6	28	66
D5433034	3.4	6	28	66
D5433035	3.5	6	28	66
D5433036	3.6	6	28	66
D5433037	3.7	6	28	66
D5433038	3.8	6	36	74
D5433039	3.9	6	36	74
D5433040	4.0	6	36	74
D5433041	4.1	6	36	74
D5433042	4.2	6	36	74
D5433043	4.3	6	36	74
D5433044	4.4	6	36	74
D5433045	4.5	6	36	74
D5433046	4.6	6	36	74
D5433047	4.7	6	36	74
D5433048	4.8	6	44	82
D5433049	4.9	6	44	82
D5433050	5.0	6	44	82
D5433051	5.1	6	44	82
D5433052	5.2	6	44	82
D5433053	5.3	6	44	82
D5433054	5.4	6	44	82
D5433055	5.5	6	44	82
D5433056	5.6	6	44	82
D5433057	5.7	6	44	82

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5433058	5.8	6	44	82
D5433059	5.9	6	44	82
D5433060	6.0	6	44	82
D5433061	6.1	8	53	91
D5433062	6.2	8	53	91
D5433063	6.3	8	53	91
D5433064	6.4	8	53	91
D5433065	6.5	8	53	91
D5433066	6.6	8	53	91
D5433067	6.7	8	53	91
D5433068	6.8	8	53	91
D5433069	6.9	8	53	91
D5433070	7.0	8	53	91
D5433071	7.1	8	53	91
D5433072	7.2	8	53	91
D5433073	7.3	8	53	91
D5433074	7.4	8	53	91
D5433075	7.5	8	53	91
D5433076	7.6	8	53	91
D5433077	7.7	8	53	91
D5433078	7.8	8	53	91
D5433079	7.9	8	53	91
D5433080	8.0	8	53	91
D5433081	8.1	10	61	103
D5433082	8.2	10	61	103
D5433083	8.3	10	61	103
D5433084	8.4	10	61	103
D5433085	8.5	10	61	103

▶ 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
Recommended																				

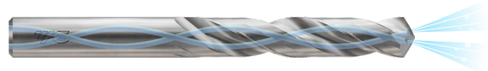
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	

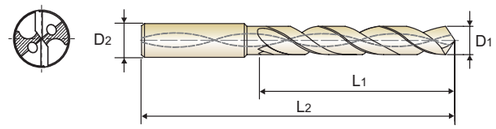
SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (5XD)

SERIES D5433

- 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





DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

LONG 5 × D

Unit : mm

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5433086	8.6	10	61	103
D5433087	8.7	10	61	103
D5433088	8.8	10	61	103
D5433089	8.9	10	61	103
D5433090	9.0	10	61	103
D5433091	9.1	10	61	103
D5433092	9.2	10	61	103
D5433093	9.3	10	61	103
D5433094	9.4	10	61	103
D5433095	9.5	10	61	103
D5433096	9.6	10	61	103
D5433097	9.7	10	61	103
D5433098	9.8	10	61	103
D5433099	9.9	10	61	103
D5433100	10.0	10	61	103
D5433101	10.1	12	71	118
D5433102	10.2	12	71	118
D5433103	10.3	12	71	118
D5433104	10.4	12	71	118
D5433105	10.5	12	71	118
D5433106	10.6	12	71	118
D5433107	10.7	12	71	118
D5433108	10.8	12	71	118
D5433109	10.9	12	71	118
D5433110	11.0	12	71	118
D5433111	11.1	12	71	118
D5433112	11.2	12	71	118
D5433113	11.3	12	71	118

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5433114	11.4	12	71	118
D5433115	11.5	12	71	118
D5433116	11.6	12	71	118
D5433117	11.7	12	71	118
D5433118	11.8	12	71	118
D5433119	11.9	12	71	118
D5433120	12.0	12	71	118
D5433125	12.5	14	77	124
D5433130	13.0	14	77	124
D5433135	13.5	14	77	124
D5433140	14.0	14	77	124
D5433145	14.5	16	83	133
D5433150	15.0	16	83	133
D5433155	15.5	16	83	133
D5433160	16.0	16	83	133
D5433165	16.5	18	93	143
D5433170	17.0	18	93	143
D5433175	17.5	18	93	143
D5433180	18.0	18	93	143
D5433185	18.5	20	101	153
D5433190	19.0	20	101	153
D5433195	19.5	20	101	153
D5433200	20.0	20	101	153

▶ DLC coating is available on your request.
▶ 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																				

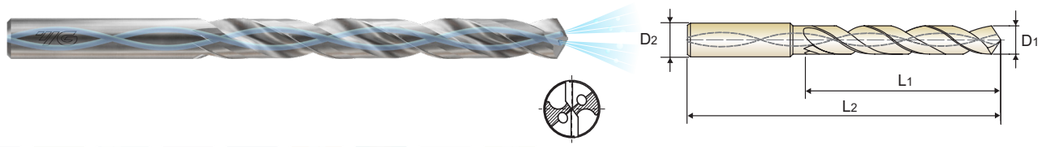
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	

SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (8XD)

SERIES **D5434**

- 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



DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

EXTRA LONG

8 × D

Unit : mm

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5434030	3.0	6	34	72
D5434031	3.1	6	34	72
D5434032	3.2	6	34	72
D5434033	3.3	6	34	72
D5434034	3.4	6	34	72
D5434035	3.5	6	34	72
D5434036	3.6	6	34	72
D5434037	3.7	6	34	72
D5434038	3.8	6	43	81
D5434039	3.9	6	43	81
D5434040	4.0	6	43	81
D5434041	4.1	6	43	81
D5434042	4.2	6	43	81
D5434043	4.3	6	43	81
D5434044	4.4	6	43	81
D5434045	4.5	6	43	81
D5434046	4.6	6	43	81
D5434047	4.7	6	43	81
D5434048	4.8	6	57	95
D5434049	4.9	6	57	95
D5434050	5.0	6	57	95
D5434051	5.1	6	57	95
D5434052	5.2	6	57	95
D5434053	5.3	6	57	95
D5434054	5.4	6	57	95
D5434055	5.5	6	57	95
D5434056	5.6	6	57	95
D5434057	5.7	6	57	95

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5434058	5.8	6	57	95
D5434059	5.9	6	57	95
D5434060	6.0	6	57	95
D5434061	6.1	8	76	114
D5434062	6.2	8	76	114
D5434063	6.3	8	76	114
D5434064	6.4	8	76	114
D5434065	6.5	8	76	114
D5434066	6.6	8	76	114
D5434067	6.7	8	76	114
D5434068	6.8	8	76	114
D5434069	6.9	8	76	114
D5434070	7.0	8	76	114
D5434071	7.1	8	76	114
D5434072	7.2	8	76	114
D5434073	7.3	8	76	114
D5434074	7.4	8	76	114
D5434075	7.5	8	76	114
D5434076	7.6	8	76	114
D5434077	7.7	8	76	114
D5434078	7.8	8	76	114
D5434079	7.9	8	76	114
D5434080	8.0	8	76	114
D5434081	8.1	10	95	142
D5434082	8.2	10	95	142
D5434083	8.3	10	95	142
D5434084	8.4	10	95	142
D5434085	8.5	10	95	142

▶ 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
Recommended																				

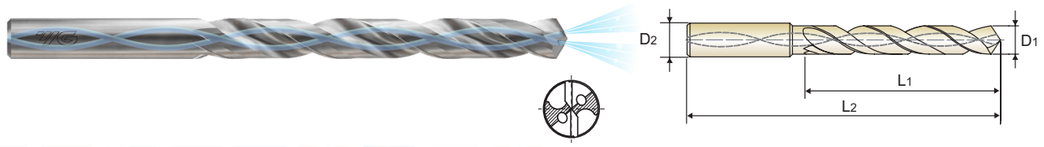
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	

SOLID CARBIDE

DREAM DRILLS ALU with COOLANT HOLES (8XD)

SERIES D5434

- 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



DIN 6537 | CARBIDE | 30° | h6 | m7 | 118° | 20 bar | Bright

p.102

EXTRA LONG

8 × D

Unit : mm

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5434086	8.6	10	95	142
D5434087	8.7	10	95	142
D5434088	8.8	10	95	142
D5434089	8.9	10	95	142
D5434090	9.0	10	95	142
D5434091	9.1	10	95	142
D5434092	9.2	10	95	142
D5434093	9.3	10	95	142
D5434094	9.4	10	95	142
D5434095	9.5	10	95	142
D5434096	9.6	10	95	142
D5434097	9.7	10	95	142
D5434098	9.8	10	95	142
D5434099	9.9	10	95	142
D5434100	10.0	10	95	142
D5434101	10.1	12	114	162
D5434102	10.2	12	114	162
D5434103	10.3	12	114	162
D5434104	10.4	12	114	162
D5434105	10.5	12	114	162
D5434106	10.6	12	114	162
D5434107	10.7	12	114	162
D5434108	10.8	12	114	162
D5434109	10.9	12	114	162
D5434110	11.0	12	114	162
D5434111	11.1	12	114	162
D5434112	11.2	12	114	162
D5434113	11.3	12	114	162

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D5434114	11.4	12	114	162
D5434115	11.5	12	114	162
D5434116	11.6	12	114	162
D5434117	11.7	12	114	162
D5434118	11.8	12	114	162
D5434119	11.9	12	114	162
D5434120	12.0	12	114	162
D5434125	12.5	14	133	178
D5434130	13.0	14	133	178
D5434135	13.5	14	133	178
D5434140	14.0	14	133	178

▶ DLC coating is available on your request.
▶ 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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	