



i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HIGH HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILLS & COUNTERSINK

SPADE DRILLS

TECHNICAL DATA

HSS & HSSCo5, STRAIGHT SHANK, GOLD-P COATED

D1GP182, D1GP139, D1GP138, D2GP185, D2GP186, D2GP187, DLGP195, SERIES

WORK MATERIAL			P						M	
			CARBON STEELS		CARBON STEELS		ALLOY STEELS		STAINLESS STEELS	
HARDNESS					~ HRC23		HRC23 ~ 34		~ HRC23	
STRENGTH			~ 570N/mm ²		~ 830N/mm ²		830~1110N/mm ²		~ 830N/mm ²	
DIAMETER			N	S	N	S	N	S	N	S
Fractional	Decimal	Metric								
3/64	.0469	1.0	14000	.0008	12500	.0008	7700	.0008	7000	.0008
#47	.0785	2.0	7000	.0023	6100	.0024	3850	.0024	3500	.0024
#32	.1160	3.0	4650	.0038	4100	.0031	2550	.0031	2350	.0031
#22	.1570	4.0	3500	.0044	3050	.0043	1950	.0039	1750	.0039
#9	.1960	5.0	2800	.0049	2450	.0043	1550	.0039	1400	.0039
B	.2380	6.0	2350	.0056	2050	.0051	1300	.0047	1150	.0047
J	.2770	7.0	2000	.0064	1750	.0059	1100	.0055	1000	.0055
O	.3160	8.0	1750	.0072	1550	.0071	960	.0059	875	.0059
T	.3580	9.0	1550	.0077	1350	.0087	855	.0071	780	.0071
X	.3970	10.0	1400	.0084	1250	.0087	770	.0071	700	.0071
7/16	.4375	11.0	1250	.0087	1100	.0087	700	.0071	650	.0071
15/32	.4688	12.0	1150	.0090	1000	.0087	650	.0079	585	.0079
1/2	.5000	13.0	1050	.0090	950	.0087	595	.0079	540	.0079

WORK MATERIAL			N				S	
			ALUMINUM ALLOYS, ZINC ALLOYS		MAGNESIUM ALLOYS		TITANIUM ALLOYS	
HARDNESS								
STRENGTH							~410N/mm ²	
DIAMETER			N	S	N	S	N	S
Fractional	Decimal	Metric						
3/64	.0469	1.0	30000	.0008	11500	.0012	8050	.0008
#47	.0785	2.0	15000	.0023	5800	.0035	4050	.0024
#32	.1160	3.0	9900	.0038	3850	.0051	2700	.0031
#22	.1570	4.0	7450	.0044	2900	.0059	2000	.0035
#9	.1960	5.0	5950	.0049	2300	.0067	1600	.0039
B	.2380	6.0	14950	.0056	1950	.0075	1350	.0047
J	.2770	7.0	4250	.0064	1650	.0087	1150	.0055
O	.3160	8.0	3700	.0072	1450	.0094	1000	.0059
T	.3580	9.0	3300	.0079	1280	.0106	895	.0067
X	.3970	10.0	3000	.0090	1150	.0114	805	.0071
7/16	.4375	11.0	2700	.0090	1050	.0118	730	.0071
15/32	.4688	12.0	2480	.0090	960	.0122	670	.0079
1/2	.5000	13.0	2300	.0090	890	.0122	620	.0079

N = R.P.M
S = Inch per Revolution (inch/rev.)