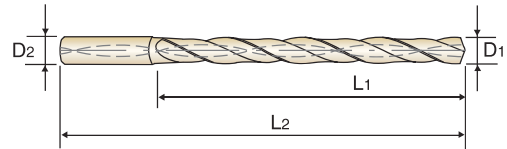




SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
- Excellent positioning - bushing is not necessary
- Special Design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 8×D

Unit : mm

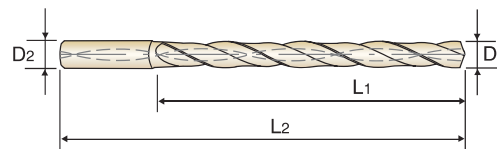
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TAIIN	D1			D2	L1	L2	TAIIN	D1			D2	L1	L2
DH421030	3.0		.1181	6	34	72	DH421014F	5.556	7/32	.2188	6	57	95
DH421031	3.1		.1220	6	34	72	DH421056	5.6		.2205	6	57	95
DH421008F	3.175	1/8	.1250	6	34	72	DH421057	5.7		.2244	6	57	95
DH421032	3.2		.1260	6	34	72	DH421058	5.8		.2283	6	57	95
DH421033	3.3		.1299	6	34	72	DH421059	5.9		.2323	6	57	95
DH421034	3.4		.1339	6	34	72	DH421015F	5.953	15/64	.2344	6	57	95
DH421229G	3.450	#29	.1360	6	34	72	DH421060	6.0		.2362	6	57	95
DH421035	3.5		.1378	6	34	72	DH421061	6.1		.2402	8	76	114
DH421009F	3.572	9/64	.1406	6	34	72	DH421062	6.2		.2441	8	76	114
DH421036	3.6		.1417	6	34	72	DH421063	6.3		.2480	8	76	114
DH421037	3.7		.1457	6	34	72	DH421016F	6.350	1/4	.2500	8	76	114
DH421038	3.8		.1496	6	43	81	DH421064	6.4		.2520	8	76	114
DH421039	3.9		.1535	6	43	81	DH421065	6.5		.2559	8	76	114
DH421010F	3.969	5/32	.1563	6	43	81	DH421106L	6.53	F	.2570	8	76	114
DH421040	4.0		.1575	6	43	81	DH421066	6.6		.2598	8	76	114
DH421221G	4.040	#21	.1590	6	43	81	DH421067	6.7		.2638	8	76	114
DH421041	4.1		.1614	6	43	81	DH421017F	6.747	17/64	.2656	8	76	114
DH421042	4.2		.1654	6	43	81	DH421068	6.8		.2677	8	76	114
DH421043	4.3		.1693	6	43	81	DH421069	6.9		.2717	8	76	114
DH421011F	4.366	11/64	.1719	6	43	81	DH421070	7.0		.2756	8	76	114
DH421044	4.4		.1732	6	43	81	DH421071	7.1		.2795	8	76	114
DH421045	4.5		.1772	6	43	81	DH421018F	7.144	9/32	.2813	8	76	114
DH421046	4.6		.1811	6	43	81	DH421072	7.2		.2835	8	76	114
DH421047	4.7		.1850	6	43	81	DH421073	7.3		.2874	8	76	114
DH421012F	4.763	3/16	.1875	6	57	95	DH421074	7.4		.2913	8	76	114
DH421048	4.8		.1890	6	57	95	DH421075	7.5		.2953	8	76	114
DH421049	4.9		.1929	6	57	95	DH421019F	7.541	19/64	.2969	8	76	114
DH421050	5.0		.1969	6	57	95	DH421076	7.6		.2992	8	76	114
DH421051	5.1		.2008	6	57	95	DH421077	7.7		.3031	8	76	114
DH421013F	5.159	13/64	.2031	6	57	95	DH421078	7.8		.3071	8	76	114
DH421052	5.2		.2047	6	57	95	DH421079	7.9		.3110	8	76	114
DH421053	5.3		.2087	6	57	95	DH421020F	7.938	5/16	.3125	8	76	114
DH421054	5.4		.2126	6	57	95	DH421080	8.0		.3150	8	76	114
DH421055	5.5		.2165	6	57	95	DH421081	8.1		.3189	10	95	142

▶ NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
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- good chip removal
- powerful drilling



DIN 6537
MG
h6
m7
140°
P.26

DREAM DRILLS | 8×D

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TA1N	D1			D2	L1	L2	TA1N	D1			D2	L1	L2
DH421082	8.2		.3228	10	95	142	DH421026F	10.319	13/32	.4063	12	114	162
DH421083	8.3		.3268	10	95	142	DH421104	10.4		.4094	12	114	162
DH421021F	8.334	21/64	.3281	10	95	142	DH421105	10.5		.4134	12	114	162
DH421084	8.4		.3307	10	95	142	DH421106	10.6		.4173	12	114	162
DH421117L	8.430	Q	.3320	10	95	142	DH421107	10.7		.4212	12	114	162
DH421085	8.5		.3346	10	95	142	DH421027F	10.716	27/64	.4219	12	114	162
DH421086	8.6		.3386	10	95	142	DH421108	10.8		.4252	12	114	162
DH421087	8.7		.3425	10	95	142	DH421109	10.9		.4291	12	114	162
DH421022F	8.731	11/32	.3438	10	95	142	DH421110	11.0		.4330	12	114	162
DH421088	8.8		.3465	10	95	142	DH421111	11.1		.4370	12	114	162
DH421089	8.9		.3504	10	95	142	DH421028F	11.113	7/16	.4375	12	114	162
DH421090	9.0		.3543	10	95	142	DH421112	11.2		.4409	12	114	162
DH421091	9.1		.3583	10	95	142	DH421113	11.3		.4448	12	114	162
DH421023F	9.128	23/64	.3594	10	95	142	DH421114	11.4		.4488	12	114	162
DH421092	9.2		.3622	10	95	142	DH421115	11.5		.4527	12	114	162
DH421093	9.3		.3661	10	95	142	DH421116	11.6		.4566	12	114	162
DH421121L	9.350	U	.3680	10	95	142	DH421117	11.7		.4606	12	114	162
DH421094	9.4		.3701	10	95	142	DH421118	11.8		.4645	12	114	162
DH421095	9.5		.3740	10	95	142	DH421119	11.9		.4685	12	114	162
DH421024F	9.525	3/8	.3750	10	95	142	DH421030F	11.906	15/32	.4688	12	114	162
DH421096	9.6		.3780	10	95	142	DH421120	12.0		.4724	12	114	162
DH421097	9.7		.3819	10	95	142	DH421031F	12.303	31/64	.4844	14	133	178
DH421098	9.8		.3858	10	95	142	DH421125	12.5		.4921	14	133	178
DH421099	9.9		.3898	10	95	142	DH421032F	12.700	1/2	.5000	14	133	178
DH421025F	9.922	25/64	.3906	10	95	142	DH421130	13.0		.5118	14	133	178
DH421100	10.0		.3937	10	95	142	DH421033F	13.097	33/64	.5156	14	133	178
DH421101	10.1		.3976	12	114	162	DH421135	13.5		.5314	14	133	178
DH421102	10.2		.4016	12	114	162	DH421140	14.0		.5512	14	133	178
DH421103	10.3		.4055	12	114	162							

▶ Other shank types are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

DH404, DH423, DH424 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED(SFM)		130 ~ 400 ft/min			115 ~ 340 ft/min			220 ~ 650 ft/min			150 ~ 430 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	13000	0.04	.002	11250	0.04	.002	21300	0.04	.002	14200	0.04	.002
2.0	.0787	13000	0.06	.002	11250	0.06	.002	21300	0.06	.002	14200	0.06	.002
3.0	.1181	13000	0.13	.005	11000	0.13	.005	21000	0.13	.005	14000	0.13	.005
4.0	.1575	9500	0.14	.006	8400	0.14	.006	16000	0.14	.006	10500	0.14	.006
5.0	.1969	7600	0.15	.006	6700	0.15	.006	13000	0.15	.006	8300	0.15	.006
6.0	.2362	6400	0.17	.007	5600	0.17	.007	11000	0.17	.007	6900	0.17	.007
7.0	.2756	5500	0.19	.007	4800	0.19	.007	9100	0.19	.007	5900	0.19	.007
8.0	.3150	4800	0.21	.008	4200	0.21	.008	8000	0.21	.008	5200	0.21	.008
9.0	.3543	4200	0.23	.009	3700	0.23	.009	7100	0.23	.009	4600	0.23	.009
10.0	.3937	3800	0.25	.010	3350	0.25	.010	6400	0.25	.010	4150	0.25	.010
12.0	.4724	3200	0.27	.011	2800	0.27	.011	5300	0.27	.011	3450	0.27	.011
14.0	.5512	2750	0.29	.011	2400	0.29	.011	4550	0.29	.011	3000	0.29	.011
16.0	.6299	2400	0.31	.012	2100	0.31	.012	4000	0.31	.012	2600	0.31	.012
18.0	.7087	2100	0.33	.013	1850	0.33	.013	3550	0.33	.013	2300	0.33	.013
20.0	.7874	1900	0.35	.014	1650	0.35	.014	3200	0.35	.014	2100	0.35	.014

► Recommend to reduce the feed rate as following
 DH404(3xD), DH423(3xD) : Feed 100%
 DH424(5xD) : Feed 85%

N = R.P.M
 S= feed rate (mm/rev.)
 IPR= feed rate (Inch/rev.)

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH406, DH408, DH421 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED		160 ~ 490 ft/min			150 ~ 440 ft/min			270 ~ 820 ft/min			170 ~ 530 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	16250	0.05	.002	14800	0.05	.002	26600	0.05	.002	17300	0.05	.002
2.0	.0787	16250	0.07	.003	14800	0.07	.003	26600	0.07	.003	17300	0.07	.003
3.0	.1181	16000	0.16	.006	14500	0.16	.006	26000	0.16	.006	17000	0.16	.006
4.0	.1575	12000	0.17	.007	11000	0.17	.007	20000	0.17	.007	13000	0.17	.007
5.0	.1969	9550	0.18	.007	8600	0.18	.007	16000	0.18	.007	10000	0.18	.007
6.0	.2362	8000	0.20	.008	7200	0.20	.008	13000	0.20	.008	8500	0.20	.008
7.0	.2756	6800	0.22	.009	6100	0.22	.009	11500	0.22	.009	7300	0.22	.009
8.0	.3150	6000	0.24	.009	5400	0.24	.009	9900	0.24	.009	6400	0.24	.009
9.0	.3543	5300	0.27	.011	4800	0.27	.011	8800	0.27	.011	5700	0.27	.011
10.0	.3937	4800	0.30	.012	4300	0.30	.012	8000	0.30	.012	5100	0.30	.012
12.0	.4724	4000	0.33	.013	3600	0.33	.013	6600	0.33	.013	4250	0.33	.013
14.0	.5512	3400	0.36	.014	3050	0.36	.014	5700	0.36	.014	3650	0.36	.014
16.0	.6299	3000	0.39	.015	2700	0.39	.015	5000	0.39	.015	3200	0.39	.015
18.0	.7087	2650	0.42	.017	2400	0.42	.017	4400	0.42	.017	2850	0.42	.017
20.0	.7874	2400	0.45	.018	2150	0.45	.018	4000	0.45	.018	2550	0.45	.018

► Recommend to reduce the feed rate as following
 DH406(3xD) : Feed 100%, DH408(5xD) : Feed 85%
 DH421(8xD) : Feed 70%

N = R.P.M
 S= feed rate (mm/rev.)
 IPR= feed rate (Inch/rev.)