

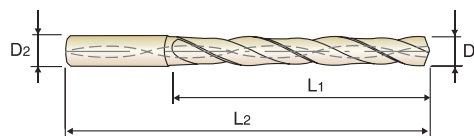


*** NEW SIZE**

SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES

- ▶ The tool has the special flute shape and geometry for suitable machining of stainless steel
- ▶ Excellent chip evacuation due to better surface treatment
- ▶ Point R-thinning makes the superior centering and chip curl
- ▶ TiAIN coating achieves the better surface finishes and longer tool life
- ▶ Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005

▶ FOR STAINLESS STEEL



P.38

DREAM DRILLS INOX | 5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal					Fractional	Decimal			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH464013	13/64	.2031	15/64	1-3/4	3-15/16	DH715022	11/32	.3438	3/8	2-27/32	5
* DH715013	13/64	.2031	1/4	1-3/4	3-15/16	DH715023	23/64	.3594	3/8	3	5-23/64
DH464014	7/32	.2188	15/64	1-57/64	3-15/16	DH464023	23/64	.3594	25/64	3	5-23/64
* DH715014	7/32	.2188	1/4	1-57/64	3-15/16	DH715221	U	.3680	3/8	3	5-23/64
DH464015	15/64	.2344	15/64	1-57/64	3-15/16	DH464221	U	.3680	25/64	3	5-23/64
* DH715015	15/64	.2344	1/4	1-57/64	3-15/16	DH715024	3/8	.3750	3/8	3-5/32	5-23/64
* DH715016	1/4	.2500	1/4	2-3/64	4-19/64	DH464024	3/8	.3750	25/64	3-5/32	5-23/64
DH464016	1/4	.2500	17/64	2-3/64	4-19/64	DH464025	25/64	.3906	25/64	3-5/32	5-23/64
DH464206	F	.2570	17/64	2-13/64	4-19/64	DH715025	25/64	.3906	7/16	3-5/32	5-23/64
* DH715206	F	.2570	5/16	2-13/64	4-19/64	DH464026	13/32	.4062	27/64	3-5/16	5-7/8
DH464017	17/64	.2656	17/64	2-13/64	4-19/64	DH715026	13/32	.4062	7/16	3-5/16	5-7/8
* DH715017	17/64	.2656	5/16	2-13/64	4-19/64	DH464027	27/64	.4219	27/64	3-15/32	5-7/8
DH464209	I	.2720	.2720	2-13/64	4-19/64	DH715027	27/64	.4219	7/16	3-15/32	5-7/8
* DH715209	I	.2720	5/16	2-13/64	4-19/64	DH715028	7/16	.4375	7/16	3-5/8	6-7/32
DH464018	9/32	.2812	5/16	2-23/64	4-41/64	DH464028	7/16	.4375	15/32	3-5/8	6-7/32
DH464019	19/64	.2969	5/16	2-33/64	4-41/64	DH464029	29/64	.4531	15/32	3-25/32	6-7/32
DH464020	5/16	.3125	5/16	2-33/64	4-41/64	DH715029	29/64	.4531	1/2	3-25/32	6-7/32
DH464021	21/64	.3281	11/32	2-43/64	5	DH464030	15/32	.4688	15/32	3-25/32	6-7/32
* DH715021	21/64	.3281	3/8	2-43/64	5	DH715030	15/32	.4688	1/2	3-25/32	6-7/32
DH464217	Q	.3320	11/32	2-43/64	5	DH464031	31/64	.4844	1/2	3-15/16	6-37/64
* DH715217	Q	.3320	3/8	2-43/64	5	DH464032	1/2	.5000	1/2	4-3/32	6-37/64
DH464022	11/32	.3438	11/32	2-27/32	5						

▶ 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~							
◎	◎	○				○	◎	○	○		



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- ▶ Tolerance : Dia. Tolerance ØD1:m7, Shank Tolerance ØD2: h6

▶ FOR STAINLESS STEEL



DIN 6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × 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			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH452010	1.0		.0394	3	8	55	DH452009F	3.572	9/64	.1406	6	28	66
DH452011	1.1		.0433	3	12	55	DH452036	3.6		.1417	6	28	66
DH452012	1.2		.0472	3	12	55	DH452037	3.7		.1457	6	28	66
DH452013	1.3		.0512	3	12	55	DH452038	3.8		.1496	6	36	74
DH452014	1.4		.0551	3	12	55	DH452039	3.9		.1535	6	36	74
DH452015	1.5		.0591	3	16	55	DH452010F	3.969	5/32	.1563	6	36	74
* DH452004F	1.588	1/16	.0625	3	16	55	DH452040	4.0		.1575	6	36	74
DH452016	1.6		.0630	3	16	55	DH452041	4.1		.1614	6	36	74
DH452017	1.7		.0669	3	16	55	DH452042	4.2		.1654	6	36	74
DH452018	1.8		.0709	3	16	55	DH452043	4.3		.1693	6	36	74
DH452019	1.9		.0748	3	16	55	DH452011F	4.366	11/64	.1719	6	36	74
* DH452005F	1.984	5/64	.0781	3	16	55	DH452044	4.4		.1732	6	36	74
DH452020	2.0		.0787	4	21	57	DH452045	4.5		.1772	6	36	74
DH452021	2.1		.0827	4	21	57	DH452046	4.6		.1811	6	36	74
DH452022	2.2		.0866	4	21	57	DH452047	4.7		.1850	6	36	74
DH452023	2.3		.0906	4	21	57	DH452012F	4.763	3/16	.1875	6	36	74
* DH452006F	2.381	3/32	.0938	4	21	57	DH452048	4.8		.1890	6	44	82
DH452024	2.4		.0945	4	21	57	DH452049	4.9		.1929	6	44	82
DH452025	2.5		.0984	4	21	57	DH452050	5.0		.1969	6	44	82
DH452026	2.6		.1024	4	21	57	DH452051	5.1		.2008	6	44	82
DH452027	2.7		.1063	4	21	57	DH452013F	5.159	13/64	.2031	6	44	82
* DH452007F	2.778	7/64	.1094	4	21	57	DH452052	5.2		.2047	6	44	82
DH452028	2.8		.1102	4	21	57	DH452053	5.3		.2087	6	44	82
DH452029	2.9		.1142	4	21	57	DH452054	5.4		.2126	6	44	82
DH452030	3.0		.1181	6	28	66	DH452055	5.5		.2165	6	44	82
DH452031	3.1		.1220	6	28	66	DH452014F	5.556	7/32	.2188	6	44	82
* DH452008F	3.175	1/8	.1250	6	28	66	DH452056	5.6		.2205	6	44	82
DH452032	3.2		.1260	6	28	66	DH452057	5.7		.2244	6	44	82
DH452033	3.3		.1299	6	28	66	DH452058	5.8		.2283	6	44	82
DH452034	3.4		.1339	6	28	66	DH452059	5.9		.2323	6	44	82
DH452035	3.5		.1378	6	28	66	DH452015F	5.953	15/64	.2344	6	44	82

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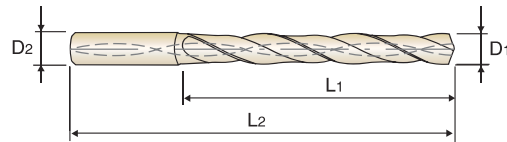


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▶ FOR STAINLESS STEEL



DIN 6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × 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			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH452060	6.0		.2362	6	44	82	DH452085	8.5		.3346	10	61	103
DH452061	6.1		.2402	8	53	91	DH452086	8.6		.3386	10	61	103
DH452062	6.2		.2441	8	53	91	DH452087	8.7		.3425	10	61	103
DH452063	6.3		.2480	8	53	91	DH452022F	8.731	11/32	.3438	10	61	103
* DH452016F	6.35	1/4	.2500	8	53	91	DH452088	8.8		.3465	10	61	103
DH452064	6.4		.2520	8	53	91	DH452089	8.9		.3504	10	61	103
DH452065	6.5		.2559	8	53	91	DH452090	9.0		.3543	10	61	103
DH452066	6.6		.2598	8	53	91	DH452091	9.1		.3583	10	61	103
DH452067	6.7		.2638	8	53	91	DH452023F	9.128	23/64	.3594	10	61	103
* DH452017F	6.747	17/64	.2656	8	53	91	DH452092	9.2		.3622	10	61	103
DH452068	6.8		.2677	8	53	91	DH452093	9.3		.3661	10	61	103
DH452069	6.9		.2717	8	53	91	DH452094	9.4		.3701	10	61	103
DH452070	7.0		.2756	8	53	91	DH452095	9.5		.3740	10	61	103
DH452071	7.1		.2795	8	53	91	DH452024F	9.525	3/8	.3750	10	61	103
* DH452018F	7.144	9/32	.2812	8	53	91	DH452096	9.6		.3780	10	61	103
DH452072	7.2		.2835	8	53	91	DH452097	9.7		.3819	10	61	103
DH452073	7.3		.2874	8	53	91	DH452098	9.8		.3858	10	61	103
DH452074	7.4		.2913	8	53	91	DH452099	9.9		.3898	10	61	103
DH452075	7.5		.2953	8	53	91	DH452025F	9.922	25/64	.3906	10	61	103
* DH452019F	7.541	19/64	.2969	8	53	91	DH452100	10.0		.3937	10	61	103
DH452076	7.6		.2992	8	53	91	DH452101	10.1		.3976	12	71	118
DH452077	7.7		.3031	8	53	91	DH452102	10.2		.4016	12	71	118
DH452078	7.8		.3071	8	53	91	DH452103	10.3		.4055	12	71	118
DH452079	7.9		.3110	8	53	91	DH452026F	10.319	13/32	.4062	12	71	118
* DH452020F	7.938	5/16	.3125	8	53	91	DH452104	10.4		.4094	12	71	118
DH452080	8.0		.3150	8	53	91	DH452105	10.5		.4134	12	71	118
DH452081	8.1		.3189	10	61	103	DH452106	10.6		.4173	12	71	118
DH452082	8.2		.3228	10	61	103	DH452107	10.7		.4212	12	71	118
DH452083	8.3		.3268	10	61	103	DH452027F	10.716	27/64	.4219	12	71	118
* DH452021F	8.334	21/64	.3281	10	61	103	DH452108	10.8		.4252	12	71	118
DH452084	8.4		.3307	10	61	103	DH452109	10.9		.4291	12	71	118

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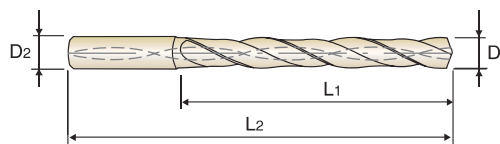


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▶ FOR STAINLESS STEEL



DIN 6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × 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			
TIAlN	D1			D2	L1	L2	TIAlN	D1			D2	L1	L2
DH452110	11.0		.4330	12	71	118	DH452135	13.5		.5314	14	77	124
DH452111	11.1		.4370	12	71	118	DH452140	14.0		.5512	14	77	124
* DH452028F	11.113	7/16	.4375	12	71	118	DH452036F	14.288	9/16	.5625	16	83	133
DH452112	11.2		.4409	12	71	118	DH452145	14.5		.5708	16	83	133
DH452113	11.3		.4448	12	71	118	DH452150	15.0		.5905	16	83	133
DH452114	11.4		.4488	12	71	118	DH452155	15.5		.6102	16	83	133
DH452115	11.5		.4527	12	71	118	DH452040F	15.875	5/8	.6250	16	83	133
* DH452029F	11.509	29/64	.4531	12	71	118	DH452160	16.0		.6299	16	83	133
DH452116	11.6		.4566	12	71	118	DH452165	16.5		.6495	18	93	143
DH452117	11.7		.4606	12	71	118	DH452170	17.0		.6692	18	93	143
DH452118	11.8		.4645	12	71	118	DH452175	17.5		.6889	18	93	143
DH452119	11.9		.4685	12	71	118	DH452180	18.0		.7087	18	93	143
* DH452030F	11.906	15/32	.4688	12	71	118	DH452185	18.5		.7283	20	101	153
DH452120	12.0		.4724	12	71	118	DH452190	19.0		.7480	20	101	153
* DH452031F	12.303	31/64	.4844	14	77	124	DH452048F	19.05	3/4	.7500	20	101	153
DH452125	12.5		.4921	14	77	124	DH452195	19.5		.7676	20	101	153
* DH452032F	12.7	1/2	.5000	14	77	124	DH452200	20.0		.7874	20	101	153
DH452130	13.0		.5118	14	77	124							

▶ 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 INOX with COOLANT HOLES, TiAIN COATED

► FOR STAINLESS STEEL

DH451, DH463, DH714, DH452, DH464, DH715, DH453 Series

WORK MATERIAL			M						N					
			STAINLESS S TEELS			STAINLESS STEELS			ALUMINUM			ALUMINUM		
STRENGTH			< 800 N/mm ²			> 800 N/mm ²			< 10% Si			< 10% Si		
DRILLING SPEED(SFM)			120 ~ 230 ft/min			60 ~ 140 ft/min			490 ~ 720 ft/min			390 ~ 570 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional												
1.0	.0394		12000	0.02	.001	6200	0.02	.001	48000	0.04	.002	38000	0.03	.001
1.5	.0591		9000	0.03	.001	5400	0.02	.001	43000	0.05	.002	32000	0.04	.002
2.5	.0984		7000	0.04	.002	4200	0.03	.001	25500	0.08	.003	19500	0.06	.002
3.0	.1181	1/8	7400	0.04	.002	4700	0.02	.001	23000	0.12	.005	18500	0.10	.004
4.0	.1575	5/32	5600	0.05	.002	3600	0.03	.001	17500	0.18	.007	13900	0.15	.006
5.0	.1969	13/64	4400	0.05	.002	2800	0.03	.001	14000	0.20	.008	11000	0.18	.007
6.0	.2362	15/64	3700	0.06	.002	2400	0.04	.002	11700	0.25	.010	9300	0.25	.010
8.0	.3150	5/16	2800	0.08	.003	1800	0.06	.002	8800	0.30	.012	7000	0.30	.012
10.0	.3937	25/64	2200	0.10	.004	1400	0.08	.003	7000	0.40	.016	5600	0.35	.014
12.0	.4724	15/32	1900	0.12	.005	1200	0.10	.004	5800	0.50	.020	4600	0.40	.016
14.0	.5512	35/64	1600	0.15	.006	1000	0.12	.005	5000	0.60	.024	4000	0.50	.020
16.0	.6299	5/8	1400	0.20	.008	900	0.15	.006	4380	0.80	.031	3500	0.60	.024
18.0	.7087	45/64	1250	0.22	.009	800	0.17	.007	3900	1.00	.039	3100	0.70	.028
20.0	.7874	25/32	1120	0.24	.009	720	0.19	.007	3500	1.20	.047	2800	0.80	.031

WORK MATERIAL			S			P			N		
			TITANIUM TI ALLOY			CARBON STEELS ALLOY STEELS			NON FRERROUS		
STRENGTH											
DRILLING SPEED(SFM)			80 ~ 160 ft/min			260 ~ 410 ft/min			390 ~ 490 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional									
1.0	.0394		8100	0.01	.0004	26000	0.02	.001	38000	0.02	.001
1.5	.0591		7500	0.01	.0004	18000	0.03	.001	25500	0.03	.001
2.5	.0984		4500	0.02	.001	10800	0.05	.002	15500	0.05	.002
3.0	.1181	1/8	5300	0.03	.001	13000	0.04	.002	16000	0.08	.003
4.0	.1575	5/32	4000	0.04	.002	10000	0.05	.002	11900	0.10	.004
5.0	.1969	13/64	3200	0.05	.002	8000	0.05	.002	9500	0.12	.005
6.0	.2362	15/64	2650	0.06	.002	6600	0.06	.002	8000	0.15	.006
8.0	.3150	5/16	2000	0.07	.003	5000	0.08	.003	6000	0.18	.007
10.0	.3937	25/64	1600	0.08	.003	4000	0.10	.004	4800	0.22	.009
12.0	.4724	15/32	1300	0.10	.004	3300	0.12	.005	4000	0.26	.010
14.0	.5512	35/64	1100	0.12	.005	2800	0.15	.006	3400	0.30	.012
16.0	.6299	5/8	1000	0.14	.006	2500	0.20	.008	3000	0.40	.016
18.0	.7087	45/64	900	0.16	.006	2200	0.22	.009	2650	0.45	.018
20.0	.7874	25/32	800	0.18	.007	2000	0.24	.009	2400	0.50	.020

- Recommend to reduce the feed rate as following
 DH463/DH714/DH451(3xD), DH464/DH714/DH452(5xD) : Feed 100%
 DH453(8xD) : Feed 85%

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