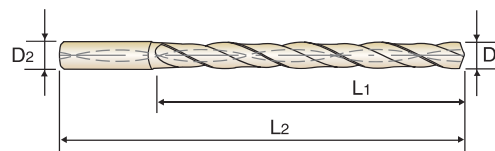




SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES

- ▶ 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:m7, Shank Tolerance ØD2: h6

▶ FOR STAINLESS STEEL



DIN 6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 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			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH453030	3.0		.1181	6	34	72	DH453058	5.8		.2283	6	57	95
DH453031	3.1		.1220	6	34	72	DH453059	5.9		.2323	6	57	95
DH453008F	3.175	1/8	.1250	6	34	72	DH453015F	5.953	15/64	.2344	6	57	95
DH453032	3.2		.1260	6	34	72	DH453060	6.0		.2362	6	57	95
DH453033	3.3		.1299	6	34	72	DH453061	6.1		.2402	8	76	114
DH453034	3.4		.1339	6	34	72	DH453062	6.2		.2441	8	76	114
DH453229G	3.454	#29	.1360	6	34	72	DH453063	6.3		.2480	8	76	114
DH453035	3.5		.1378	6	34	72	DH453016F	6.35	1/4	.2500	8	76	114
DH453009F	3.572	9/64	.1406	6	34	72	DH453064	6.4		.2520	8	76	114
DH453036	3.6		.1417	6	34	72	DH453065	6.5		.2559	8	76	114
DH453037	3.7		.1457	6	34	72	DH453106L	6.527	F	.2570	8	76	114
DH453038	3.8		.1496	6	43	81	DH453066	6.6		.2598	8	76	114
DH453039	3.9		.1535	6	43	81	DH453067	6.7		.2638	8	76	114
DH453010F	3.969	5/32	.1563	6	43	81	DH453017F	6.747	17/64	.2656	8	76	114
DH453040	4.0		.1575	6	43	81	DH453068	6.8		.2677	8	76	114
DH453221G	4.038	#21	.1590	6	43	81	DH453069	6.9		.2717	8	76	114
DH453041	4.1		.1614	6	43	81	DH453070	7.0		.2756	8	76	114
DH453042	4.2		.1654	6	43	81	DH453071	7.1		.2795	8	76	114
DH453043	4.3		.1693	6	43	81	DH453018F	7.144	9/32	.2813	8	76	114
DH453011F	4.366	11/64	.1719	6	43	81	DH453072	7.2		.2835	8	76	114
DH453044	4.4		.1732	6	43	81	DH453073	7.3		.2874	8	76	114
DH453045	4.5		.1772	6	43	81	DH453074	7.4		.2913	8	76	114
DH453046	4.6		.1811	6	43	81	DH453075	7.5		.2953	8	76	114
DH453047	4.7		.1850	6	43	81	DH453019F	7.541	19/64	.2969	8	76	114
DH453012F	4.763	3/16	.1875	6	57	95	DH453076	7.6		.2992	8	76	114
DH453048	4.8		.1890	6	57	95	DH453077	7.7		.3031	8	76	114
DH453049	4.9		.1929	6	57	95	DH453078	7.8		.3071	8	76	114
DH453050	5.0		.1969	6	57	95	DH453079	7.9		.3110	8	76	114
DH453051	5.1		.2008	6	57	95	DH453020F	7.938	5/16	.3125	8	76	114
DH453013F	5.159	13/64	.2031	6	57	95	DH453080	8.0		.3150	8	76	114
DH453052	5.2		.2047	6	57	95	DH453081	8.1		.3189	10	95	142
DH453053	5.3		.2087	6	57	95	DH453082	8.2		.3228	10	95	142
DH453054	5.4		.2126	6	57	95	DH453083	8.3		.3268	10	95	142
DH453055	5.5		.2165	6	57	95	DH453021F	8.334	21/64	.3281	10	95	142
DH453014F	5.556	7/32	.2188	6	57	95	DH453084	8.4		.3307	10	95	142
DH453056	5.6		.2205	6	57	95	DH453117L	8.432	Q	.3320	10	95	142
DH453057	5.7		.2244	6	57	95	DH453085	8.5		.3346	10	95	142

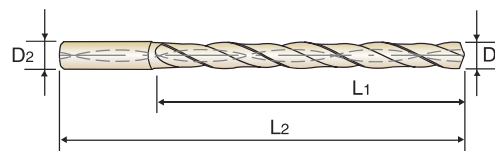
▶ NEXT PAGE



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▶ FOR STAINLESS STEEL



DIN 6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 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			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH453086	8.6		.3386	10	95	142	DH453106	10.6		.4173	12	114	162
DH453087	8.7		.3425	10	95	142	DH453107	10.7		.4212	12	114	162
DH453022F	8.731	11/32	.3438	10	95	142	DH453027F	10.716	27/64	.4219	12	114	162
DH453088	8.8		.3465	10	95	142	DH453108	10.8		.4252	12	114	162
DH453089	8.9		.3504	10	95	142	DH453109	10.9		.4291	12	114	162
DH453090	9.0		.3543	10	95	142	DH453110	11.0		.4330	12	114	162
DH453091	9.1		.3583	10	95	142	DH453111	11.1		.4370	12	114	162
DH453023F	9.128	23/64	.3594	10	95	142	DH453028F	11.113	7/16	.4375	12	114	162
DH453092	9.2		.3622	10	95	142	DH453112	11.2		.4409	12	114	162
DH453093	9.3		.3661	10	95	142	DH453113	11.3		.4448	12	114	162
DH453121L	9.347	U	.3680	10	95	142	DH453114	11.4		.4488	12	114	162
DH453094	9.4		.3701	10	95	142	DH453115	11.5		.4527	12	114	162
DH453095	9.5		.3740	10	95	142	DH453116	11.6		.4566	12	114	162
DH453024F	9.525	3/8	.3750	10	95	142	DH453117	11.7		.4606	12	114	162
DH453096	9.6		.3780	10	95	142	DH453118	11.8		.4645	12	114	162
DH453097	9.7		.3819	10	95	142	DH453119	11.9		.4685	12	114	162
DH453098	9.8		.3858	10	95	142	DH453030F	11.906	15/32	.4688	12	114	162
DH453099	9.9		.3898	10	95	142	DH453120	12.0		.4724	12	114	162
DH453025F	9.922	25/64	.3906	10	95	142	DH453031F	12.303	31/64	.4844	14	133	178
DH453100	10.0		.3937	10	95	142	DH453125	12.5		.4921	14	133	178
DH453101	10.1		.3976	12	114	162	DH453032F	12.7	1/2	.5000	14	133	178
DH453102	10.2		.4016	12	114	162	DH453130	13.0		.5118	14	133	178
DH453103	10.3		.4055	12	114	162	DH453033F	13.097	33/64	.5156	14	133	178
DH453026F	10.319	13/32	.4063	12	114	162	DH453135	13.5		.5314	14	133	178
DH453104	10.4		.4094	12	114	162	DH453140	14.0		.5512	14	133	178
DH453105	10.5		.4134	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 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.)