

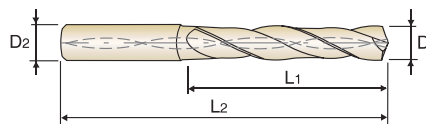


**\* NEW SIZE**

## 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**



## DREAM DRILLS INOX | 3 × 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
* DH714008	1/8	.1250	3/16	1.102	2.992	DH714221	U	.3680	3/8	1.87	4.174
DH463008	1/8	.1250	15/64	1.102	2.992	DH463221	U	.3680	25/64	1.870	4.174
* DH714011	11/64	.1719	3/16	1.417	3.386	DH714024	3/8	.3750	3/8	1.969	4.174
DH463011	11/64	.1719	15/64	1.417	3.386	DH463024	3/8	.3750	25/64	1.969	4.174
* DH714012	3/16	.1875	3/16	1.575	3.543	DH463025	25/64	.3906	25/64	1.969	4.174
DH463012	3/16	.1875	15/64	1.575	3.543	DH714025	25/64	.3906	7/16	1.969	4.174
DH463013	13/64	.2031	15/64	1.082	3.228	DH463026	13/32	.4062	27/64	2.067	4.567
* DH714013	13/64	.2031	1/4	1.082	3.228	DH714026	13/32	.4062	7/16	2.067	4.567
DH463014	7/32	.2188	15/64	1.181	3.228	DH463027	27/64	.4219	27/64	2.165	4.567
* DH714014	7/32	.2188	1/4	1.181	3.228	DH714027	27/64	.4219	7/16	2.165	4.567
DH463015	15/64	.2344	15/64	1.181	3.228	DH714028	7/16	.4375	7/16	2.264	4.803
* DH714015	15/64	.2344	1/4	1.181	3.228	DH463028	7/16	.4375	15/32	2.264	4.803
* DH714016	1/4	.2500	1/4	1.279	3.465	DH463029	29/64	.4531	15/32	2.264	4.803
DH463016	1/4	.2500	17/64	1.279	3.465	DH714029	29/64	.4531	1/2	2.264	4.803
DH463206	F	.2570	17/64	1.279	3.465	DH463030	15/32	.4688	15/32	2.362	4.803
* DH714206	F	.2570	5/16	1.279	3.465	DH714030	15/32	.4688	1/2	2.362	4.803
DH463017	17/64	.2656	17/64	1.378	3.465	DH463031	31/64	.4844	1/2	2.461	5.039
* DH714017	17/64	.2656	5/16	1.378	3.465	DH463032	1/2	.5000	1/2	2.559	5.039
DH463209	I	.2720	.2720	1.378	3.465	DH463033	33/64	.5156	35/64	2.657	5.276
* DH714209	I	.2720	5/16	1.378	3.465	DH714033	33/64	.5156	9/16	2.657	5.276
DH463018	9/32	.2812	5/16	1.476	3.701	DH463034	17/32	.5312	35/64	2.756	5.276
DH463019	19/64	.2969	5/16	1.476	3.701	DH714034	17/32	.5312	9/16	2.756	5.276
DH463020	5/16	.3125	5/16	1.575	3.701	DH463035	35/64	.5469	35/64	2.756	5.276
DH463021	21/64	.3281	11/32	1.673	3.937	DH714035	35/64	.5469	9/16	2.756	5.276
* DH714021	21/64	.3281	3/8	1.673	3.937	DH714036	9/16	.5625	9/16	2.854	5.512
DH463217	Q	.3320	11/32	1.673	3.937	DH463036	9/16	.5625	37/64	2.854	5.512
* DH714217	Q	.3320	3/8	1.673	3.937	DH463037	37/64	.5781	37/64	2.953	5.512
DH463022	11/32	.3438	11/32	1.772	3.937	DH714037	37/64	.5781	5/8	2.953	5.512
* DH714022	11/32	.3438	3/8	1.772	3.937	DH463038	19/32	.5937	5/8	3.051	5.709
* DH714023	23/64	.3594	3/8	1.87	4.174	DH463039	39/64	.6094	5/8	3.051	5.709
DH463023	23/64	.3594	25/64	1.870	4.174	DH463040	5/8	.6250	5/8	3.150	5.709

▶ 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~							
◎	◎	○				○	◎	○	○		

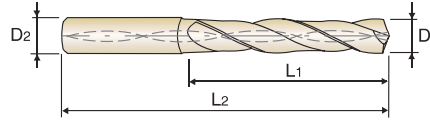


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**▶ FOR STAINLESS STEEL**



DIN 6537

MG

h6

m7

140°



P.38

## DREAM DRILLS INOX | 3 × 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
DH451030	3.0		.1181	6	20	62	DH451054	5.4		.2126	6	28	66
DH451031	3.1		.1220	6	20	62	DH451055	5.5		.2165	6	28	66
* DH451008F	3.175	1/8	.1250	6	20	62	DH451014F	5.556	7/32	.2188	6	28	66
DH451032	3.2		.1260	6	20	62	DH451056	5.6		.2205	6	28	66
DH451033	3.3		.1299	6	20	62	DH451057	5.7		.2244	6	28	66
DH451034	3.4		.1339	6	20	62	DH451058	5.8		.2283	6	28	66
DH451035	3.5		.1378	6	20	62	DH451059	5.9		.2323	6	28	66
* DH451009F	3.572	9/64	.1406	6	20	62	DH451015F	5.953	15/64	.2344	6	28	66
DH451036	3.6		.1417	6	20	62	DH451060	6.0		.2362	6	28	66
DH451037	3.7		.1457	6	20	62	DH451061	6.1		.2402	8	34	79
DH451038	3.8		.1496	6	24	66	DH451062	6.2		.2441	8	34	79
DH451039	3.9		.1535	6	24	66	DH451063	6.3		.2480	8	34	79
* DH451010F	3.969	5/32	.1563	6	24	66	DH451016F	6.35	1/4	.2500	8	34	79
DH451040	4.0		.1575	6	24	66	DH451064	6.4		.2520	8	34	79
DH451041	4.1		.1614	6	24	66	DH451065	6.5		.2559	8	34	79
DH451042	4.2		.1654	6	24	66	DH451066	6.6		.2598	8	34	79
DH451043	4.3		.1693	6	24	66	DH451067	6.7		.2638	8	34	79
* DH451011F	4.366	11/64	.1719	6	24	66	DH451017F	6.747	17/64	.2656	8	34	79
DH451044	4.4		.1732	6	24	66	DH451068	6.8		.2677	8	34	79
DH451045	4.5		.1772	6	24	66	DH451069	6.9		.2717	8	34	79
DH451046	4.6		.1811	6	24	66	DH451070	7.0		.2756	8	34	79
DH451047	4.7		.1850	6	24	66	DH451071	7.1		.2795	8	41	79
* DH451012F	4.763	3/16	.1875	6	24	66	DH451018F	7.144	9/32	.2812	8	41	79
DH451048	4.8		.1890	6	28	66	DH451072	7.2		.2835	8	41	79
DH451049	4.9		.1929	6	28	66	DH451073	7.3		.2874	8	41	79
DH451050	5.0		.1969	6	28	66	DH451074	7.4		.2913	8	41	79
DH451051	5.1		.2008	6	28	66	DH451075	7.5		.2953	8	41	79
* DH451013F	5.159	13/64	.2031	6	28	66	DH451019F	7.541	19/64	.2969	8	41	79
DH451052	5.2		.2047	6	28	66	DH451076	7.6		.2992	8	41	79
DH451053	5.3		.2087	6	28	66	DH451077	7.7		.3031	8	41	79

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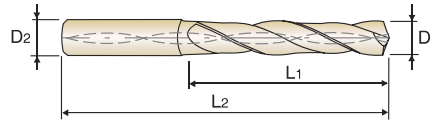


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**▶ FOR STAINLESS STEEL**



DIN 6537

MG

h6

m7

140°



P.38

## DREAM DRILLS INOX | 3 × 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
DH451078	7.8		.3071	8	41	79	DH451102	10.2		.4016	12	55	102
DH451079	7.9		.3110	8	41	79	DH451103	10.3		.4055	12	55	102
* DH451020F	7.938	5/16	.3125	8	41	79	DH451026F	10.319	13/32	.4062	12	55	102
DH451080	8.0		.3150	8	41	79	DH451104	10.4		.4094	12	55	102
DH451081	8.1		.3189	10	47	89	DH451105	10.5		.4134	12	55	102
DH451082	8.2		.3228	10	47	89	DH451106	10.6		.4173	12	55	102
DH451083	8.3		.3268	10	47	89	DH451107	10.7		.4212	12	55	102
* DH451021F	8.334	21/64	.3281	10	47	89	DH451027F	10.716	27/64	.4219	12	55	102
DH451084	8.4		.3307	10	47	89	DH451108	10.8		.4252	12	55	102
DH451085	8.5		.3346	10	47	89	DH451109	10.9		.4291	12	55	102
DH451086	8.6		.3386	10	47	89	DH451110	11.0		.4330	12	55	102
DH451087	8.7		.3425	10	47	89	DH451111	11.1		.4370	12	55	102
* DH451022F	8.731	11/32	.3438	10	47	89	DH451028F	11.113	7/16	.4375	12	55	102
DH451088	8.8		.3465	10	47	89	DH451112	11.2		.4409	12	55	102
DH451089	8.9		.3504	10	47	89	DH451113	11.3		.4448	12	55	102
DH451090	9.0		.3543	10	47	89	DH451114	11.4		.4488	12	55	102
DH451091	9.1		.3583	10	47	89	DH451115	11.5		.4527	12	55	102
* DH451023F	9.128	23/64	.3594	10	47	89	DH451029F	11.509	29/64	.4531	12	55	102
DH451092	9.2		.3622	10	47	89	DH451116	11.6		.4566	12	55	102
DH451093	9.3		.3661	10	47	89	DH451117	11.7		.4606	12	55	102
DH451094	9.4		.3701	10	47	89	DH451118	11.8		.4645	12	55	102
DH451095	9.5		.3740	10	47	89	DH451119	11.9		.4685	12	55	102
* DH451024F	9.525	3/8	.3750	10	47	89	DH451030F	11.906	15/32	.4688	12	55	102
DH451096	9.6		.3780	10	47	89	DH451120	12.0		.4724	12	55	102
DH451097	9.7		.3819	10	47	89	DH451031F	12.303	31/64	.4844	14	60	107
DH451098	9.8		.3858	10	47	89	DH451125	12.5		.4921	14	60	107
DH451099	9.9		.3898	10	47	89	DH451032F	12.7	1/2	.5000	14	60	107
* DH451025F	9.922	25/64	.3906	10	47	89	DH451130	13.0		.5118	14	60	107
DH451100	10.0		.3937	10	47	89	DH451135	13.5		.5314	14	60	107
DH451101	10.1		.3976	12	55	102	DH451140	14.0		.5512	14	60	107

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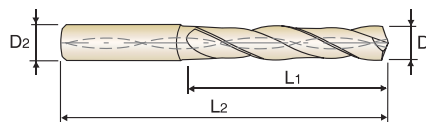


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**▶ FOR STAINLESS STEEL**



DIN 6537

MG

h6

m7

140°



P.38

## DREAM DRILLS INOX | 3 × 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
* DH451036F	14.288	9/16	.5625	16	65	115	DH451044F	17.463	11/16	.6875	18	73	123
DH451145	14.5		.5708	16	65	115	DH451175	17.5		.6889	18	73	123
DH451150	15.0		.5905	16	65	115	DH451180	18.0		.7087	18	73	123
DH451155	15.5		.6102	16	65	115	DH451185	18.5		.7283	20	79	131
* DH451040F	15.875	5/8	.6250	16	65	115	DH451190	19.0		.7480	20	79	131
DH451160	16.0		.6299	16	65	115	DH451048F	19.05	3/4	.7500	20	79	131
DH451165	16.5		.6495	18	73	123	DH451195	19.5		.7676	20	79	131
DH451170	17.0		.6692	18	73	123	DH451200	20.0		.7874	20	79	131

▶ 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 <sup>2</sup>			> 800 N/mm <sup>2</sup>			< 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.)