

TiAIN-COATED SOLID CARBIDE DREAM DRILLS
MQL with Coolant Holes

DH510 | DH515 | DH520 | DHM10 | DHM15 | DHM20 SERIES

WORK MATERIAL	P						K						
	CARBON STEELS						CAST IRON			DUCTILE CAST IRON			
STRENGTH	~ 1060 N/mm ²						250 ~ 350 N/mm ²			400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)	230 ~ 290 ft/min						230 ~ 290 ft/min			220 ~ 240 ft/min			
DIAMETER	RPM	FEED	IPR	RPM	FEED	IPR	RPM	FEED	IPR	RPM	FEED	IPR	
	Metric(mm) Decimal												
3	.1181	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047
4	.1575	6400	0.08~0.16	.0031	.0063	6400	0.08~0.16	.0031	.0063	5600	0.08~0.16	.0031	.0063
5	.1969	5800	0.10~0.20	.0039	.0079	5800	0.10~0.20	.0039	.0079	4500	0.10~0.20	.0039	.0079
6	.2362	4800	0.12~0.24	.0047	.0094	4800	0.12~0.24	.0047	.0094	3800	0.12~0.24	.0047	.0094
8	.3150	3600	0.16~0.28	.0063	.0110	3600	0.16~0.28	.0063	.0110	2800	0.16~0.28	.0063	.0110
10	.3937	2900	0.20~0.35	.0079	.0138	2900	0.20~0.35	.0079	.0138	2300	0.20~0.35	.0079	.0138
12	.4724	2400	0.24~0.42	.0094	.0165	2400	0.24~0.42	.0094	.0165	1900	0.24~0.42	.0094	.0165
14	.5512	2050	0.28~0.46	.0110	.0181	2050	0.28~0.46	.0110	.0181	1600	0.28~0.46	.0110	.0181

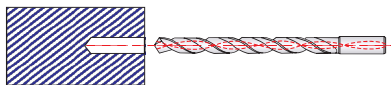
RPM = rev./min.
FEED = mm/rev.
IPR = inch/rev.

DHM25 | DHM30 SERIES

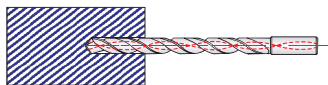
WORK MATERIAL	P						K						
	CARBON STEELS						CAST IRON			DUCTILE CAST IRON			
STRENGTH	~ 1060 N/mm ²						250 ~ 350 N/mm ²			400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)	230 ~ 290 ft/min						230 ~ 290 ft/min			220 ~ 240 ft/min			
DIAMETER	RPM	FEED	IPR	RPM	FEED	IPR	RPM	FEED	IPR	RPM	FEED	IPR	
	Metric(mm) Decimal												
3	.1181	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047
4	.1575	5500	0.08~0.16	.0031	.0063	5500	0.08~0.16	.0031	.0063	4700	0.08~0.16	.0031	.0063
5	.1969	4900	0.10~0.20	.0039	.0079	4900	0.10~0.20	.0039	.0079	3800	0.10~0.20	.0039	.0079
6	.2362	4200	0.12~0.24	.0047	.0094	4200	0.12~0.24	.0047	.0094	3200	0.12~0.24	.0047	.0094
8	.3150	3000	0.16~0.28	.0063	.0110	3000	0.16~0.28	.0063	.0110	2400	0.16~0.28	.0063	.0110
10	.3937	2500	0.20~0.35	.0079	.0138	2500	0.20~0.35	.0079	.0138	1900	0.20~0.35	.0079	.0138

RPM = rev./min.
FEED = mm/rev.
IPR = inch/rev.

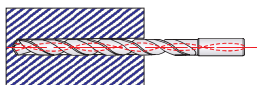
► Coolant Pressure : 900 PSI



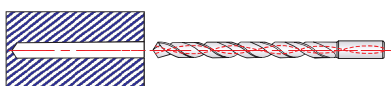
1. Use a YG 3xD Drill to produce a guide hole no larger than .004 over the required drill size. Drill the pilot hole 2xD deep hole.



2. Enter the guide hole at 50 SFM surface and .010 feed rate / per rev.



3. Before hitting the bottom of the guide hole, Increase SFM and feed rate for normal drilling.

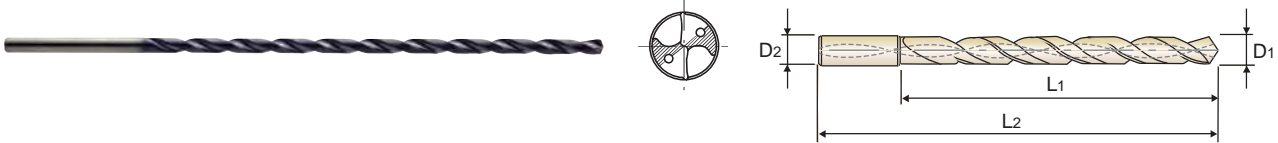


4. After drilling, to withdraw drill, reduce SFM to 50 @ 10 inches per minute.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (10XD, 15XD, 20XD)

DHM10 SERIES
DHM15 SERIES
DHM20 SERIES

- ▶ 4-Facet Point for good centering capability
- ▶ Optimized special flutes are ideal for removing chips and for productive drilling
- ▶ Enhanced chip evacuation by polished flute upgraded TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



10 × D (DHM10)	15 × D (DHM15)	20 × D (DHM20)
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10 × D Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM10030	3.0	.1181	6	40	80
DHM10033	3.3	.1299	6	47	87
DHM10035	3.5	.1378	6	47	87
DHM10040	4.0	.1575	6	53	93
DHM10042	4.2	.1654	6	60	100
DHM10045	4.5	.1772	6	60	100
DHM10050	5.0	.1969	6	66	106
DHM10055	5.5	.2165	6	73	113
DHM10060	6.0	.2362	6	79	119
DHM10065	6.5	.2559	8	86	126
DHM10068	6.8	.2677	8	92	132
DHM10070	7.0	.2756	8	92	132
DHM10075	7.5	.2953	8	99	139
DHM10080	8.0	.3150	8	105	145
DHM10085	8.5	.3346	10	112	156
DHM10090	9.0	.3543	10	118	162
DHM10095	9.5	.3740	10	126	170
DHM10100	10.0	.3937	10	132	176
DHM10105	10.5	.4134	12	139	188
DHM10110	11.0	.4330	12	145	194
DHM10115	11.5	.4527	12	152	201
DHM10120	12.0	.4724	12	158	207
DHM10125	12.5	.4921	14	165	214
DHM10130	13.0	.5118	14	171	220
DHM10135	13.5	.5314	14	178	227
DHM10140	14.0	.5512	14	184	233

15 × D Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM15030	3.0	.1181	6	55	95
DHM15035	3.5	.1378	6	64	104
DHM15040	4.0	.1575	6	73	113
DHM15045	4.5	.1772	6	82	122
DHM15050	5.0	.1969	6	91	131
DHM15055	5.5	.2165	6	100	140
DHM15060	6.0	.2362	6	109	149
DHM15070	7.0	.2756	8	127	167
DHM15080	8.0	.3150	8	145	185
DHM15090	9.0	.3543	10	163	207
DHM15100	10.0	.3937	10	182	226
DHM15110	11.0	.4330	12	200	249
DHM15120	12.0	.4724	12	218	267

20 × D Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM20030	3.0	.1181	6	70	110
DHM20035	3.5	.1378	6	82	122
DHM20040	4.0	.1575	6	93	133
DHM20045	4.5	.1772	6	105	145
DHM20050	5.0	.1969	6	116	156
DHM20055	5.5	.2165	6	128	168
DHM20060	6.0	.2362	6	139	179
DHM20070	7.0	.2756	8	162	202
DHM20080	8.0	.3150	8	185	225
DHM20090	9.0	.3543	10	208	252
DHM20100	10.0	.3937	10	232	276
DHM20110	11.0	.4330	12	255	304
DHM20120	12.0	.4724	12	278	327

◎ : Excellent ○ : Good

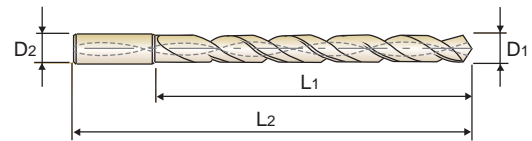
P			H		M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
-HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

TiAlN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (10XD)

EXTRA LONG

DH510 SERIES

- ▶ 4-Facet Point for good centering capability
- ▶ Optimized special flutes are ideal for removing chips and for productive drilling
- ▶ Enhanced chip evacuation by polished flute upgraded TiAlN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



10 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Inch	Decimal			
TiAlN	D1					
DH510030	3.0		.1181	3	39	90
DH510031	3.1		.1220	4	46	97
DH510008F	3.175	1/8	.1250	4	46	97
DH510032	3.2		.1260	4	46	97
DH510033	3.3		.1299	4	46	97
DH510034	3.4		.1339	4	46	97
DH510035	3.5		.1378	4	46	97
DH510036	3.6		.1417	4	52	103
DH510037	3.7		.1457	4	52	103
DH510038	3.8		.1496	4	52	103
DH510039	3.9		.1535	4	52	103
DH510040	4.0		.1575	4	52	103
DH510041	4.1		.1614	5	59	112
DH510042	4.2		.1654	5	59	112
DH510043	4.3		.1693	5	59	112
DH510044	4.4		.1732	5	59	112
DH510045	4.5		.1772	5	59	112
DH510046	4.6		.1811	5	65	118
DH510047	4.7		.1850	5	65	118
DH510048	4.8		.1890	5	65	118
DH510049	4.9		.1929	5	65	118
DH510050	5.0		.1969	5	65	118
DH510051	5.1		.2008	6	72	127
DH510052	5.2		.2047	6	72	127
DH510053	5.3		.2087	6	72	127
DH510054	5.4		.2126	6	72	127

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Inch	Decimal			
TiAlN	D1					
DH510055	5.5		.2165	6	72	127
DH510056	5.6		.2205	6	78	133
DH510057	5.7		.2244	6	78	133
DH510058	5.8		.2283	6	78	133
DH510059	5.9		.2323	6	78	133
DH510060	6.0		.2362	6	78	133
DH510061	6.1		.2402	7	85	141
DH510062	6.2		.2441	7	85	141
DH510063	6.3		.2480	7	85	141
DH510016F	6.350	1/4	.2500	7	85	141
DH510064	6.4		.2520	7	85	141
DH510065	6.5		.2559	7	85	141
DH510206L	6.528	F	.2570	7	91	147
DH510066	6.6		.2598	7	91	147
DH510067	6.7		.2638	7	91	147
DH510017F	6.746	17/64	.2656	7	91	147
DH510068	6.8		.2677	7	91	147
DH510069	6.9		.2717	7	91	147
DH510209L	6.909	I	.2720	7	91	147
DH510070	7.0		.2756	7	91	147
DH510071	7.1		.2795	8	98	155
DH510018F	7.142	9/32	.2812	8	98	155
DH510072	7.2		.2835	8	98	155
DH510073	7.3		.2874	8	98	155
DH510074	7.4		.2913	8	98	155
DH510075	7.5		.2953	8	98	155

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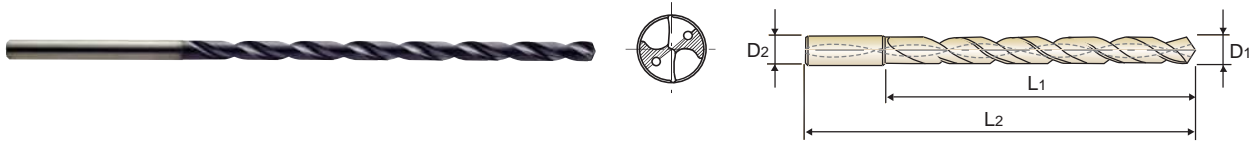
◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (10XD)

EXTRA LONG DH510 SERIES

- ▶ 4-Facet Point for good centering capability
- ▶ Optimized special flutes are ideal for removing chips and for productive drilling
- ▶ Enhanced chip evacuation by polished flute upgraded TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



10 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter D ₂	Flute Length L ₁	Overall Length L ₂
	Metric	Inch	Decimal			
TiAIN	D ₁					
DH510019F	7.541	19/64	.2969	8	104	161
DH510076	7.6		.2992	8	104	161
DH510077	7.7		.3031	8	104	161
DH510078	7.8		.3071	8	104	161
DH510079	7.9		.3110	8	104	161
DH510020F	7.938	5/16	.3125	8	104	161
DH510080	8.0		.3150	8	104	161
DH510081	8.1		.3189	9	111	169
DH510082	8.2		.3228	9	111	169
DH510083	8.3		.3268	9	111	169
DH510021F	8.334	21/64	.3281	9	111	169
DH510084	8.4		.3307	9	111	169
DH510217L	8.433	Q	.3320	9	111	169
DH510085	8.5		.3346	9	111	169
DH510086	8.6		.3386	9	117	175
DH510087	8.7		.3425	9	117	175
DH510022F	8.733	11/32	.3438	9	117	175
DH510088	8.8		.3465	9	117	175
DH510089	8.9		.3504	9	117	175
DH510090	9.0		.3543	9	117	175
DH510091	9.1		.3583	10	124	182
DH510023F	9.129	23/64	.3594	10	124	182
DH510092	9.2		.3622	10	124	182
DH510093	9.3		.3661	10	124	182
DH510221L	9.347	U	.3680	10	124	182
DH510094	9.4		.3701	10	124	182

EDP No.	Drill Diameter			Shank Diameter D ₂	Flute Length L ₁	Overall Length L ₂
	Metric	Inch	Decimal			
TiAIN	D ₁					
DH510095	9.5		.3740	10	124	182
DH510024F	9.525	3/8	.3750	10	130	188
DH510096	9.6		.3780	10	130	188
DH510097	9.7		.3819	10	130	188
DH510098	9.8		.3858	10	130	188
DH510099	9.9		.3898	10	130	188
DH510025F	9.921	25/64	.3906	10	130	188
DH510100	10.0		.3937	10	130	188
DH510101	10.1		.3976	11	137	201
DH510102	10.2		.4016	11	137	201
DH510103	10.3		.4055	11	137	201
DH510026F	10.318	13/32	.4062	11	137	201
DH510104	10.4		.4094	11	137	201
DH510105	10.5		.4134	11	137	201
DH510106	10.6		.4173	11	143	207
DH510107	10.7		.4213	11	143	207
DH510027F	10.716	27/64	.4219	11	143	207
DH510108	10.8		.4252	11	143	207
DH510109	10.9		.4291	11	143	207
DH510110	11.0		.4331	11	143	207
DH510111	11.1		.4370	12	150	215
DH510028F	11.113	7/16	.4375	12	150	215
DH510112	11.2		.4409	12	150	215
DH510113	11.3		.4449	12	150	215
DH510114	11.4		.4488	12	150	215
DH510115	11.5		.4528	12	150	215

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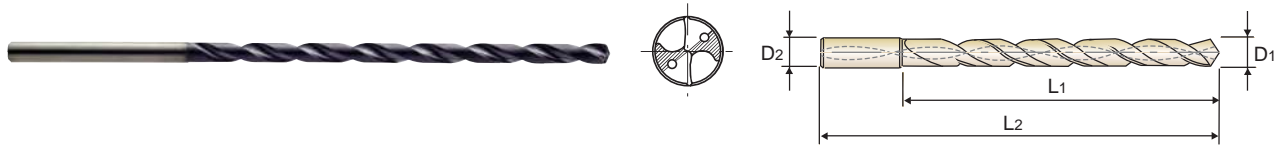
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
-HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

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EXTRA LONG
DH510 SERIES

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- ▶ Enhanced chip evacuation by polished flute upgraded TiAlN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



MG 30° h6 h7 140° 20 bar P.97

10 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length		Overall Length L2
	Metric	Inch	Decimal		L1	L2	
TiAlN	D1						
DH510029F	11.509	29/64	.4531	12	156	221	
DH510116	11.6		.4567	12	156	221	
DH510117	11.7		.4606	12	156	221	
DH510118	11.8		.4646	12	156	221	
DH510119	11.9		.4685	12	156	221	
DH510030F	11.908	15/32	.4688	12	156	221	
DH510120	12.0		.4724	12	156	221	
DH510121	12.1		.4764	13	163	229	
DH510122	12.2		.4803	13	163	229	
DH510123	12.3		.4843	13	163	229	
DH510031F	12.304	31/64	.4844	13	163	229	
DH510124	12.4		.4882	13	163	229	
DH510125	12.5		.4921	13	163	229	
DH510126	12.6		.4961	13	169	235	

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length		Overall Length L2
	Metric	Inch	Decimal		L1	L2	
TiAlN	D1						
DH510127	12.7	1/2	.5000	13	169	235	
DH510128	12.8		.5039	13	169	235	
DH510129	12.9		.5079	13	169	235	
DH510130	13.0		.5118	13	169	235	
DH510131	13.1		.5157	14	176	243	
DH510132	13.2		.5197	14	176	243	
DH510133	13.3		.5236	14	176	243	
DH510134	13.4		.5276	14	176	243	
DH510135	13.5		.5315	14	176	243	
DH510136	13.6		.5354	14	182	249	
DH510137	13.7		.5394	14	182	249	
DH510138	13.8		.5433	14	182	249	
DH510139	13.9		.5472	14	182	249	
DH510140	14.0		.5512	14	182	249	

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					