

YG GENERAL CARBIDE DRILLS

D5405 SERIES

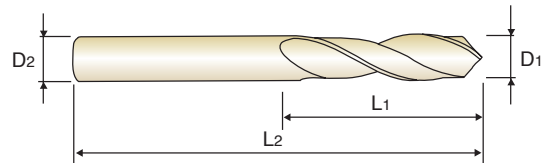
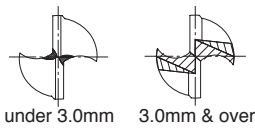
CARBIDE DRILLS
VOLLHARTMETALL-SPIRALBOHRER

STUB

EXTRA KURZ

► **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

► **Verwendung** : Zum wirtschaftlichen Bohren von Stahl allgemein, Stahlguß, Hart-und Temperguß, Nichteisen Leichtmetallen, abrasiven Kunststoffen.



DIN 6539
MG
N 30°
h6
h7
118°
P.120

D₁=D₂

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D ₁	L ₁	L ₂		D ₁	L ₁	L ₂
D5405010	1.0	6	26	D5405035	3.5	20	52
D5405011	1.1	7	28	D5405036	3.6	20	52
D5405012	1.2	8	30	D5405037	3.7	20	52
D5405013	1.3	8	30	D5405038	3.8	20	52
D5405014	1.4	9	32	D5405039	3.9	22	55
D5405015	1.5	9	32	D5405040	4.0	22	55
D5405016	1.6	10	34	D5405041	4.1	22	55
D5405017	1.7	10	34	D5405042	4.2	22	55
D5405018	1.8	11	36	D5405043	4.3	24	58
D5405019	1.9	11	36	D5405044	4.4	24	58
D5405020	2.0	12	38	D5405045	4.5	24	58
D5405021	2.1	12	38	D5405046	4.6	24	58
D5405022	2.2	13	40	D5405047	4.7	24	58
D5405023	2.3	13	40	D5405048	4.8	26	62
D5405024	2.4	14	43	D5405049	4.9	26	62
D5405025	2.5	14	43	D5405050	5.0	26	62
D5405026	2.6	14	43	D5405051	5.1	26	62
D5405027	2.7	16	46	D5405052	5.2	26	62
D5405028	2.8	16	46	D5405053	5.3	26	62
D5405029	2.9	16	46	D5405054	5.4	28	66
D5405030	3.0	16	46	D5405055	5.5	28	66
D5405031	3.1	18	49	D5405056	5.6	28	66
D5405032	3.2	18	49	D5405057	5.7	28	66
D5405033	3.3	18	49	D5405058	5.8	28	66
D5405034	3.4	20	52	D5405059	5.9	28	66

► TiN(D6405), TiCN(DG405) and TiAlN(DH405) 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	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎				○	○	○	○	◎			



GENERAL CARBIDE DRILLS

D5405 SERIES

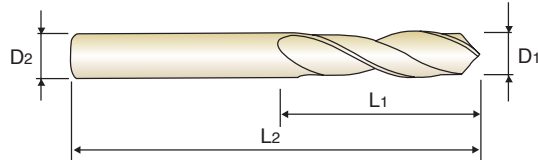
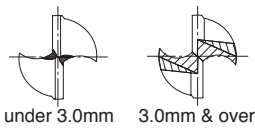
CARBIDE DRILLS VOLLHARTMETALL-SPIRALBOHRER

STUB

EXTRA KURZ

► **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

► **Verwendung** : Zum wirtschaftlichen Bohren von Stahl allgemein, Stahlguß, Hart-und Temperguß, Nichteisen Leichtmetallen, abrasiven Kunststoffen.



DIN 6539
MG
N 30°
h6
h7
118°
P.120

$D_1=D_2$

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D5405060	6.0	28	66	D5405084	8.4	37	79
D5405061	6.1	31	70	D5405085	8.5	37	79
D5405062	6.2	31	70	D5405086	8.6	40	84
D5405063	6.3	31	70	D5405087	8.7	40	84
D5405064	6.4	31	70	D5405088	8.8	40	84
D5405065	6.5	31	70	D5405089	8.9	40	84
D5405066	6.6	31	70	D5405090	9.0	40	84
D5405067	6.7	31	70	D5405091	9.1	40	84
D5405068	6.8	34	74	D5405092	9.2	40	84
D5405069	6.9	34	74	D5405093	9.3	40	84
D5405070	7.0	34	74	D5405094	9.4	40	84
D5405071	7.1	34	74	D5405095	9.5	40	84
D5405072	7.2	34	74	D5405096	9.6	43	89
D5405073	7.3	34	74	D5405097	9.7	43	89
D5405074	7.4	34	74	D5405098	9.8	43	89
D5405075	7.5	34	74	D5405099	9.9	43	89
D5405076	7.6	37	79	D5405100	10.0	43	89
D5405077	7.7	37	79	D5405102	10.2	43	89
D5405078	7.8	37	79	D5405105	10.5	43	89
D5405079	7.9	37	79	D5405110	11.0	47	95
D5405080	8.0	37	79	D5405115	11.5	47	95
D5405081	8.1	37	79	D5405120	12.0	51	102
D5405082	8.2	37	79	D5405130	13.0	51	102
D5405083	8.3	37	79				

► TiN(D6405), TiCN(DG405) and TiAlN(DH405) 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	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎				○	○	○	○	◎			



**GENERAL
CARBIDE DRILLS**

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE DRILLS, DIN6539, DIN338
VOLLHARTMETALL SPIRALBOHRER, DIN 6539, DIN 338**

D5405, D5407 SERIES

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS		Al-Si ALLOYS, Si<10%		Al-Si ALLOYS, Si>10%		Ti, Ni ALLOY STEELS	
	STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH	
DRILLING SPEED	65 ~ 75 m/min		45 ~ 55 m/min		80 ~ 100 m/min		50 ~ 70 m/min		30 ~ 40 m/min		150 ~ 170 m/min		110 ~ 130 m/min		33 ~ 38 m/min	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S	N	S
	1.0	23000	0.03	17200	0.03	32000	0.04	23000	0.04	12000	0.04	54000	0.05	42000	0.05	11800
2.0	11500	0.04	8600	0.04	16000	0.05	11500	0.05	6000	0.03	27000	0.06	21000	0.06	5900	0.03
3.0	7800	0.05	5750	0.05	10500	0.06	7600	0.06	4000	0.04	18000	0.07	14000	0.07	3900	0.04
4.0	5800	0.06	4300	0.06	7800	0.07	5700	0.07	3000	0.05	13000	0.08	10500	0.08	2950	0.05
5.0	4700	0.07	3450	0.07	6200	0.08	4550	0.08	2400	0.06	10500	0.09	8500	0.09	2350	0.06
6.0	3900	0.08	2850	0.08	5200	0.09	3800	0.09	2000	0.07	8800	0.11	7100	0.11	1950	0.07
7.0	3350	0.09	2450	0.09	4500	0.10	3250	0.10	1700	0.08	7600	0.13	6100	0.13	1700	0.08
8.0	2900	0.10	2150	0.10	3900	0.12	2850	0.12	1500	0.09	6600	0.15	5350	0.15	1450	0.09
9.0	2600	0.11	1900	0.11	3450	0.14	2550	0.14	1350	0.10	5900	0.17	4750	0.17	1300	0.10
10.0	2350	0.12	1700	0.12	3100	0.16	2300	0.16	1200	0.11	5300	0.19	4250	0.19	1200	0.11
11.0	2150	0.13	1600	0.13	2850	0.18	2100	0.18	1100	0.12	4850	0.21	3900	0.21	1050	0.12
12.0	1950	0.14	1450	0.14	2600	0.20	1900	0.20	1000	0.13	4450	0.23	3550	0.23	980	0.13
13.0	1800	0.16	1350	0.16	2400	0.20	1750	0.20	950	0.13	4100	0.25	3300	0.25	905	0.13

N = R.P.M
S = Feed per Revolution (mm/rev.)