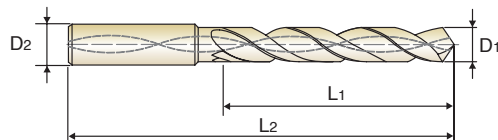




CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES *EXTRA LONG*
VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL *ÜBERLANG*

- ▶ Good chip treatment due to flute geometry & chip space
- ▶ Better finish & built-up edge preventive

- ▶ Bessere Entspannung durch eine angepasste Spannutt-Geometrie & großem Span-Volumen
- ▶ Verbesserte Schliffgüte & Schneidkanten-Präparation



8 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2		D1	D2	L1	L2
D5434030	3.0	6	34	72	D5434057	5.7	6	57	95
D5434031	3.1	6	34	72	D5434058	5.8	6	57	95
D5434032	3.2	6	34	72	D5434059	5.9	6	57	95
D5434033	3.3	6	34	72	D5434060	6.0	6	57	95
D5434034	3.4	6	34	72	D5434061	6.1	8	76	114
D5434035	3.5	6	34	72	D5434062	6.2	8	76	114
D5434036	3.6	6	34	72	D5434063	6.3	8	76	114
D5434037	3.7	6	34	72	D5434064	6.4	8	76	114
D5434038	3.8	6	43	81	D5434065	6.5	8	76	114
D5434039	3.9	6	43	81	D5434066	6.6	8	76	114
D5434040	4.0	6	43	81	D5434067	6.7	8	76	114
D5434041	4.1	6	43	81	D5434068	6.8	8	76	114
D5434042	4.2	6	43	81	D5434069	6.9	8	76	114
D5434043	4.3	6	43	81	D5434070	7.0	8	76	114
D5434044	4.4	6	43	81	D5434071	7.1	8	76	114
D5434045	4.5	6	43	81	D5434072	7.2	8	76	114
D5434046	4.6	6	43	81	D5434073	7.3	8	76	114
D5434047	4.7	6	43	81	D5434074	7.4	8	76	114
D5434048	4.8	6	57	95	D5434075	7.5	8	76	114
D5434049	4.9	6	57	95	D5434076	7.6	8	76	114
D5434050	5.0	6	57	95	D5434077	7.7	8	76	114
D5434051	5.1	6	57	95	D5434078	7.8	8	76	114
D5434052	5.2	6	57	95	D5434079	7.9	8	76	114
D5434053	5.3	6	57	95	D5434080	8.0	8	76	114
D5434054	5.4	6	57	95	D5434081	8.1	10	95	142
D5434055	5.5	6	57	95	D5434082	8.2	10	95	142
D5434056	5.6	6	57	95	D5434083	8.3	10	95	142

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

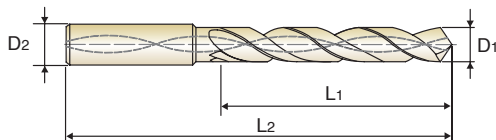
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
						◎						

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DIN 6537
MG
h6
m7
118°
P.94

8 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2		D1	D2	L1	L2
D5434084	8.4	10	95	142	D5434105	10.5	12	114	162
D5434085	8.5	10	95	142	D5434106	10.6	12	114	162
D5434086	8.6	10	95	142	D5434107	10.7	12	114	162
D5434087	8.7	10	95	142	D5434108	10.8	12	114	162
D5434088	8.8	10	95	142	D5434109	10.9	12	114	162
D5434089	8.9	10	95	142	D5434110	11.0	12	114	162
D5434090	9.0	10	95	142	D5434111	11.1	12	114	162
D5434091	9.1	10	95	142	D5434112	11.2	12	114	162
D5434092	9.2	10	95	142	D5434113	11.3	12	114	162
D5434093	9.3	10	95	142	D5434114	11.4	12	114	162
D5434094	9.4	10	95	142	D5434115	11.5	12	114	162
D5434095	9.5	10	95	142	D5434116	11.6	12	114	162
D5434096	9.6	10	95	142	D5434117	11.7	12	114	162
D5434097	9.7	10	95	142	D5434118	11.8	12	114	162
D5434098	9.8	10	95	142	D5434119	11.9	12	114	162
D5434099	9.9	10	95	142	D5434120	12.0	12	114	162
D5434100	10.0	10	95	142	D5434125	12.5	14	133	178
D5434101	10.1	12	114	162	D5434130	13.0	14	133	178
D5434102	10.2	12	114	162	D5434135	13.5	14	133	178
D5434103	10.3	12	114	162	D5434140	14.0	14	133	178
D5434104	10.4	12	114	162					

- ▶ DLC coating is available on your request.
- ▶ 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	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
						◎						

**DREAM DRILLS
-ALU****RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN****CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES
VOLLHARTMETALL DREAM BOHRER - ALU mit KÜHLKANAL****D5432, D5433, D5434 SERIES**

WORK MATERIAL	Aluminium Alloy Casting Aluminium Die Casting			Wrought Aluminium Alloy		
	DIAMETER	RPM(MIN ⁻¹)	Speed(m/min)	Feed(mm/rev)	RPM(MIN ⁻¹)	Speed(m/min)
Ø3.0 ~ Ø6.0	8,000~15,000	80~150	0.2~0.5	8,000~15,000	80~150	0.15~0.3
~ Ø10.0	6,000~10,500	100~200	0.3~1.0	6,000~10,500	100~200	0.2~0.4
~ Ø14.0	4,500~5,800	150~250	0.3~1.0	4,500~5,800	150~250	0.2~0.4
~ Ø20.0	3,200~4,600	150~200	0.3~1.0	3,200~4,600	150~200	0.2~0.4