



**DREAM DRILLS
-GENERAL**

DH408 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES **LONG LANG**
VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL **LANG**



5 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2	TiAIN	D1	D2	L1	L2
DH408010	1.0	3	8	55	DH408036	3.6	6	28	66
DH408011	1.1	3	12	55	DH408037	3.7	6	28	66
DH408012	1.2	3	12	55	DH408038	3.8	6	36	74
DH408013	1.3	3	12	55	DH408039	3.9	6	36	74
DH408014	1.4	3	12	55	DH408040	4.0	6	36	74
DH408015	1.5	3	16	55	DH408041	4.1	6	36	74
DH408016	1.6	3	16	55	DH408042	4.2	6	36	74
DH408017	1.7	3	16	55	DH408043	4.3	6	36	74
DH408018	1.8	3	16	55	DH408044	4.4	6	36	74
DH408019	1.9	3	16	55	DH408045	4.5	6	36	74
DH408020	2.0	4	21	57	DH408046	4.6	6	36	74
DH408021	2.1	4	21	57	DH408047	4.7	6	36	74
DH408022	2.2	4	21	57	DH408048	4.8	6	44	82
DH408023	2.3	4	21	57	DH408049	4.9	6	44	82
DH408024	2.4	4	21	57	DH408050	5.0	6	44	82
DH408025	2.5	4	21	57	DH408051	5.1	6	44	82
DH408026	2.6	4	21	57	DH408052	5.2	6	44	82
DH408027	2.7	4	21	57	DH408053	5.3	6	44	82
DH408028	2.8	4	21	57	DH408054	5.4	6	44	82
DH408029	2.9	4	21	57	DH408055	5.5	6	44	82
DH408030	3.0	6	28	66	DH408056	5.6	6	44	82
DH408031	3.1	6	28	66	DH408057	5.7	6	44	82
DH408032	3.2	6	28	66	DH408058	5.8	6	44	82
DH408033	3.3	6	28	66	DH408059	5.9	6	44	82
DH408034	3.4	6	28	66	DH408060	6.0	6	44	82
DH408035	3.5	6	28	66	DH408061	6.1	8	53	91

► 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~								
○	◎	◎			○		○					



CARBIDE, DREAM DRILLS with COOLANT HOLES **LONG**
VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL **LANG**



5 × D

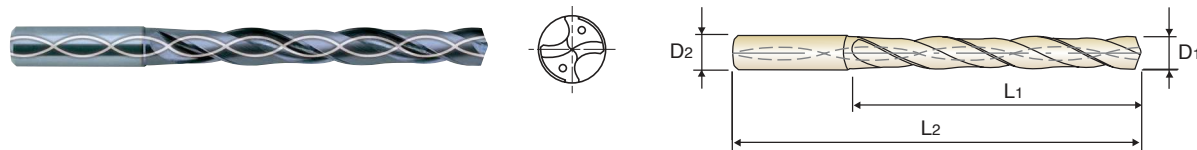
Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH408062	6.2	8	53	91	DH408088	8.8	10	61	103
DH408063	6.3	8	53	91	DH408089	8.9	10	61	103
DH408064	6.4	8	53	91	DH408090	9.0	10	61	103
DH408065	6.5	8	53	91	DH408091	9.1	10	61	103
DH408066	6.6	8	53	91	DH408092	9.2	10	61	103
DH408067	6.7	8	53	91	DH408093	9.3	10	61	103
DH408068	6.8	8	53	91	DH408094	9.4	10	61	103
DH408069	6.9	8	53	91	DH408095	9.5	10	61	103
DH408070	7.0	8	53	91	DH408096	9.6	10	61	103
DH408071	7.1	8	53	91	DH408097	9.7	10	61	103
DH408072	7.2	8	53	91	DH408098	9.8	10	61	103
DH408073	7.3	8	53	91	DH408099	9.9	10	61	103
DH408074	7.4	8	53	91	DH408100	10.0	10	61	103
DH408075	7.5	8	53	91	DH408101	10.1	12	71	118
DH408076	7.6	8	53	91	DH408102	10.2	12	71	118
DH408077	7.7	8	53	91	DH408103	10.3	12	71	118
DH408078	7.8	8	53	91	DH408104	10.4	12	71	118
DH408079	7.9	8	53	91	DH408105	10.5	12	71	118
DH408080	8.0	8	53	91	DH408106	10.6	12	71	118
DH408081	8.1	10	61	103	DH408107	10.7	12	71	118
DH408082	8.2	10	61	103	DH408108	10.8	12	71	118
DH408083	8.3	10	61	103	DH408109	10.9	12	71	118
DH408084	8.4	10	61	103	DH408110	11.0	12	71	118
DH408085	8.5	10	61	103	DH408111	11.1	12	71	118
DH408086	8.6	10	61	103	DH408112	11.2	12	71	118
DH408087	8.7	10	61	103	DH408113	11.3	12	71	118

► 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~								
○	◎	◎			○		○					

CARBIDE, DREAM DRILLS with COOLANT HOLES **LONG LANG**
VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL

5 × D

					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH408114	11.4	12	71	118	DH408150	15.0	16	83	133
DH408115	11.5	12	71	118	DH408155	15.5	16	83	133
DH408116	11.6	12	71	118	DH408160	16.0	16	83	133
DH408117	11.7	12	71	118	DH408165	16.5	18	93	143
DH408118	11.8	12	71	118	DH408170	17.0	18	93	143
DH408119	11.9	12	71	118	DH408175	17.5	18	93	143
DH408120	12.0	12	71	118	DH408180	18.0	18	93	143
DH408125	12.5	14	77	124	DH408185	18.5	20	101	153
DH408130	13.0	14	77	124	DH408190	19.0	20	101	153
DH408135	13.5	14	77	124	DH408195	19.5	20	101	153
DH408140	14.0	14	77	124	DH408200	20.0	20	101	153
DH408145	14.5	16	83	133					

▶ Other shank types are available on your request.

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~								
○	◎	◎			○		○					

◎ : Excellent ○ : Good

**CARBIDE, DREAM DRILLS, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER, TiAIN-BESCHICHTET****DH404, DH423, DH424 SERIES**

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
STRENGTH	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40	
DRILLING SPEED	Ø1.0 ~ Ø2.9 : 40 ~ 80 m/min Ø3.0 ~ : 100 ~ 120 m/min		Ø1.0 ~ Ø2.9 : 35 ~ 70 m/min Ø3.0 ~ : 85 ~ 105 m/min		Ø1.0 ~ Ø2.9 : 60 ~ 130 m/min Ø3.0 ~ : 180 ~ 200 m/min		Ø1.0 ~ Ø2.9 : 40 ~ 90 m/min Ø3.0 ~ : 110 ~ 130 m/min	
DIAMETER	N	S	N	S	N	S	N	S
1.0	13000	0.04	11250	0.04	21300	0.04	14200	0.04
2.0	13000	0.06	11250	0.06	21300	0.06	14200	0.06
3.0	13000	0.13	11000	0.13	21000	0.13	14000	0.13
4.0	9500	0.14	8400	0.14	16000	0.14	10500	0.14
5.0	7600	0.15	6700	0.15	13000	0.15	8300	0.15
6.0	6400	0.17	5600	0.17	11000	0.17	6900	0.17
7.0	5500	0.19	4800	0.19	9100	0.19	5900	0.19
8.0	4800	0.21	4200	0.21	8000	0.21	5200	0.21
9.0	4200	0.23	3700	0.23	7100	0.23	4600	0.23
10.0	3800	0.25	3350	0.25	6400	0.25	4150	0.25
12.0	3200	0.27	2800	0.27	5300	0.27	3450	0.27
14.0	2750	0.29	2400	0.29	4550	0.29	3000	0.29
16.0	2400	0.31	2100	0.31	4000	0.31	2600	0.31
18.0	2100	0.33	1850	0.33	3550	0.33	2300	0.33
20.0	1900	0.35	1650	0.35	3200	0.35	2100	0.35

► Recommend to reduce the feed rate as following

Feed 100% : DH404(3×D), DH423(3×D)**Feed 85%** : DH424(5×D)

N = R.P.M

S = Feed per Revolution (mm/rev.)

**CARBIDE, DREAM DRILLS with COOLANT HOLES DIN6537, TiAIN COATED
VOLLHARTMETALL DREAM BOHRER mit KÜHLKANAL DIN6537, TiAIN-BESCHICHTET****DH406, DH408, DH421 SERIES**

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
STRENGTH	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40	
DRILLING SPEED	Ø1.0 ~ Ø2.9 : 50 ~ 100 m/min Ø3.0 ~ : 130 ~ 150 m/min		Ø1.0 ~ Ø2.9 : 40 ~ 90 m/min Ø3.0 ~ : 115 ~ 135 m/min		Ø1.0 ~ Ø2.9 : 80 ~ 160 m/min Ø3.0 ~ : 230 ~ 250 m/min		Ø1.0 ~ Ø2.9 : 50 ~ 100 m/min Ø3.0 ~ : 140 ~ 160 m/min	
DIAMETER	N	S	N	S	N	S	N	S
1.0	16250	0.05	14800	0.05	26600	0.05	17300	0.05
2.0	16250	0.07	14800	0.07	26600	0.07	17300	0.07
3.0	16000	0.16	14500	0.16	26000	0.16	17000	0.16
4.0	12000	0.17	11000	0.17	20000	0.17	13000	0.17
5.0	9550	0.18	8600	0.18	16000	0.18	10000	0.18
6.0	8000	0.20	7200	0.20	13000	0.20	8500	0.20
7.0	6800	0.22	6100	0.22	11500	0.22	7300	0.22
8.0	6000	0.24	5400	0.24	9900	0.24	6400	0.24
9.0	5300	0.27	4800	0.27	8800	0.27	5700	0.27
10.0	4800	0.30	4300	0.30	8000	0.30	5100	0.30
12.0	4000	0.33	3600	0.33	6600	0.33	4250	0.33
14.0	3400	0.36	3050	0.36	5700	0.36	3650	0.36
16.0	3000	0.39	2700	0.39	5000	0.39	3200	0.39
18.0	2650	0.42	2400	0.42	4400	0.42	2850	0.42
20.0	2400	0.45	2150	0.45	4000	0.45	2550	0.45

► Recommend to reduce the feed rate as following

Feed 100% : DH406(3×D)**Feed 85%** : DH408(5×D)**Feed 70%** : DH421(8×D)

N = R.P.M

S = Feed per Revolution (mm/rev.)