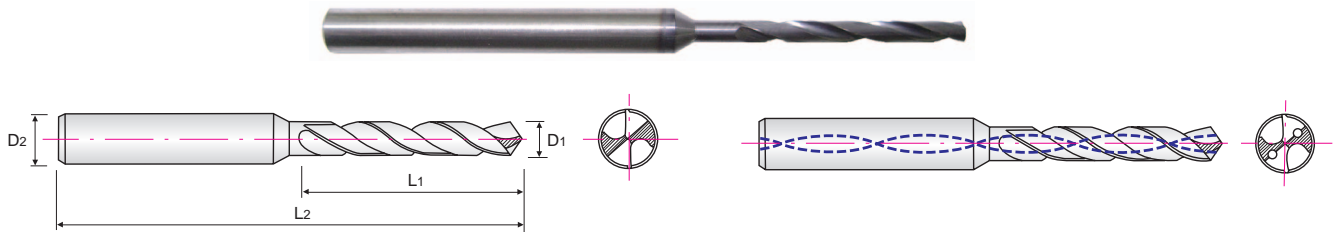


# CARBIDE DREAM DRILL



## DH424 WITHOUT COOLANT HOLES (5XD) Unit:mm

EDP NO.	DRILL DIAMETER D1	SHANK DIAMETER D2	FLUTE LENGTH L1	OVERALL LENGTH L2
DH424010	1.0	3	8	55
DH424011	1.1	3	12	55
DH424012	1.2	3	12	55
DH424013	1.3	3	12	55
DH424014	1.4	3	12	55
DH424015	1.5	3	16	55
DH424016	1.6	3	16	55
DH424017	1.7	3	16	55
DH424018	1.8	3	16	55
DH424019	1.9	3	16	55
DH424020	2.0	4	21	57
DH424021	2.1	4	21	57
DH424022	2.2	4	21	57
DH424023	2.3	4	21	57
DH424024	2.4	4	21	57
DH424025	2.5	4	21	57
DH424026	2.6	4	21	57
DH424027	2.7	4	21	57
DH424028	2.8	4	21	57
DH424029	2.9	4	21	57

## DH408 WITH COOLANT HOLES (5XD) Unit:mm

EDP NO.	DRILL DIAMETER D1	SHANK DIAMETER D2	FLUTE LENGTH L1	OVERALL LENGTH L2
DH408010	1.0	3	8	55
DH408011	1.1	3	12	55
DH408012	1.2	3	12	55
DH408013	1.3	3	12	55
DH408014	1.4	3	12	55
DH408015	1.5	3	16	55
DH408016	1.6	3	16	55
DH408017	1.7	3	16	55
DH408018	1.8	3	16	55
DH408019	1.9	3	16	55
DH408020	2.0	4	21	57
DH408021	2.1	4	21	57
DH408022	2.2	4	21	57
DH408023	2.3	4	21	57
DH408024	2.4	4	21	57
DH408025	2.5	4	21	57
DH408026	2.6	4	21	57
DH408027	2.7	4	21	57
DH408028	2.8	4	21	57
DH408029	2.9	4	21	57

## CUTTING CONDITION

### SOLID CARBIDE DREAM DRILLS WITHOUT COOLANT HOLES, TiAlN COATED

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS	
	STRENGTH < 700 N/mm <sup>2</sup>		STRENGTH < 1000 N/mm <sup>2</sup>		STRENGTH < HB240, GG25		STRENGTH < HB300, GG40		-	
DIAMETER (mm)	N	S	N	S	N	S	N	S	N	S
1.0	13000	0.04	11250	0.04	21300	0.04	14200	0.04	7160	0.03
2.0	13000	0.06	11250	0.06	21300	0.06	14200	0.06	7160	0.04

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

### SOLID CARBIDE DREAM DRILLS WITH COOLANT HOLES, TiAlN COATED

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS	
	STRENGTH < 700 N/mm <sup>2</sup>		STRENGTH < 1000 N/mm <sup>2</sup>		STRENGTH < HB240, GG25		STRENGTH < HB300, GG40		-	
DIAMETER (mm)	N	S	N	S	N	S	N	S	N	S
1.0	16250	0.05	14800	0.05	26600	0.05	17300	0.05	9550	0.03
2.0	16250	0.07	14800	0.07	26600	0.07	17300	0.07	9550	0.04

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