



SOLID CARBIDE DREAM DRILLS - INOX with COOLANT HOLES

- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating achieves, the better surface finish of material to be cut and the longer tool life.



DREAM DRILLS INOX | 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
NEW DH452015	1.5	3	16	55	DH452048	4.8	6	44	82
NEW DH452016	1.6	3	16	55	DH452049	4.9	6	44	82
NEW DH452017	1.7	3	16	55	DH452050	5.0	6	44	82
NEW DH452018	1.8	3	16	55	DH452051	5.1	6	44	82
NEW DH452019	1.9	3	16	55	DH452052	5.2	6	44	82
NEW DH452020	2.0	4	21	57	DH452053	5.3	6	44	82
NEW DH452021	2.1	4	21	57	DH452054	5.4	6	44	82
NEW DH452022	2.2	4	21	57	DH452055	5.5	6	44	82
NEW DH452023	2.3	4	21	57	DH452056	5.6	6	44	82
NEW DH452024	2.4	4	21	57	DH452057	5.7	6	44	82
NEW DH452025	2.5	4	21	57	DH452058	5.8	6	44	82
NEW DH452026	2.6	4	21	57	DH452059	5.9	6	44	82
NEW DH452027	2.7	4	21	57	DH452060	6.0	6	44	82
NEW DH452028	2.8	4	21	57	DH452061	6.1	8	53	91
NEW DH452029	2.9	4	21	57	DH452062	6.2	8	53	91
DH452030	3.0	6	28	66	DH452063	6.3	8	53	91
DH452031	3.1	6	28	66	DH452064	6.4	8	53	91
DH452032	3.2	6	28	66	DH452065	6.5	8	53	91
DH452033	3.3	6	28	66	DH452066	6.6	8	53	91
DH452034	3.4	6	28	66	DH452067	6.7	8	53	91
DH452035	3.5	6	28	66	DH452068	6.8	8	53	91
DH452036	3.6	6	28	66	DH452069	6.9	8	53	91
DH452037	3.7	6	28	66	DH452070	7.0	8	53	91
DH452038	3.8	6	36	74	DH452071	7.1	8	53	91
DH452039	3.9	6	36	74	DH452072	7.2	8	53	91
DH452040	4.0	6	36	74	DH452073	7.3	8	53	91
DH452041	4.1	6	36	74	DH452074	7.4	8	53	91
DH452042	4.2	6	36	74	DH452075	7.5	8	53	91
DH452043	4.3	6	36	74	DH452076	7.6	8	53	91
DH452044	4.4	6	36	74	DH452077	7.7	8	53	91
DH452045	4.5	6	36	74	DH452078	7.8	8	53	91
DH452046	4.6	6	36	74	DH452079	7.9	8	53	91
DH452047	4.7	6	36	74	DH452080	8.0	8	53	91



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TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452081	8.1	10	61	103	DH452109	10.9	12	71	118
DH452082	8.2	10	61	103	DH452110	11.0	12	71	118
DH452083	8.3	10	61	103	DH452111	11.1	12	71	118
DH452084	8.4	10	61	103	DH452112	11.2	12	71	118
DH452085	8.5	10	61	103	DH452113	11.3	12	71	118
DH452086	8.6	10	61	103	DH452114	11.4	12	71	118
DH452087	8.7	10	61	103	DH452115	11.5	12	71	118
DH452088	8.8	10	61	103	DH452116	11.6	12	71	118
DH452089	8.9	10	61	103	DH452117	11.7	12	71	118
DH452090	9.0	10	61	103	DH452118	11.8	12	71	118
DH452091	9.1	10	61	103	DH452119	11.9	12	71	118
DH452092	9.2	10	61	103	DH452120	12.0	12	71	118
DH452093	9.3	10	61	103	DH452125	12.5	14	77	124
DH452094	9.4	10	61	103	DH452130	13.0	14	77	124
DH452095	9.5	10	61	103	DH452135	13.5	14	77	124
DH452096	9.6	10	61	103	DH452140	14.0	14	77	124
DH452097	9.7	10	61	103	DH452145	14.5	16	83	133
DH452098	9.8	10	61	103	DH452150	15.0	16	83	133
DH452099	9.9	10	61	103	DH452155	15.5	16	83	133
DH452100	10.0	10	61	103	DH452160	16.0	16	83	133
DH452101	10.1	12	71	118	DH452165	16.5	18	93	143
DH452102	10.2	12	71	118	DH452170	17.0	18	93	143
DH452103	10.3	12	71	118	DH452175	17.5	18	93	143
DH452104	10.4	12	71	118	DH452180	18.0	18	93	143
DH452105	10.5	12	71	118	DH452185	18.5	20	101	153
DH452106	10.6	12	71	118	DH452190	19.0	20	101	153
DH452107	10.7	12	71	118	DH452195	19.5	20	101	153
DH452108	10.8	12	71	118	DH452200	20.0	20	101	153

► 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
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~					
◎	◎	○				○	◎	○	○

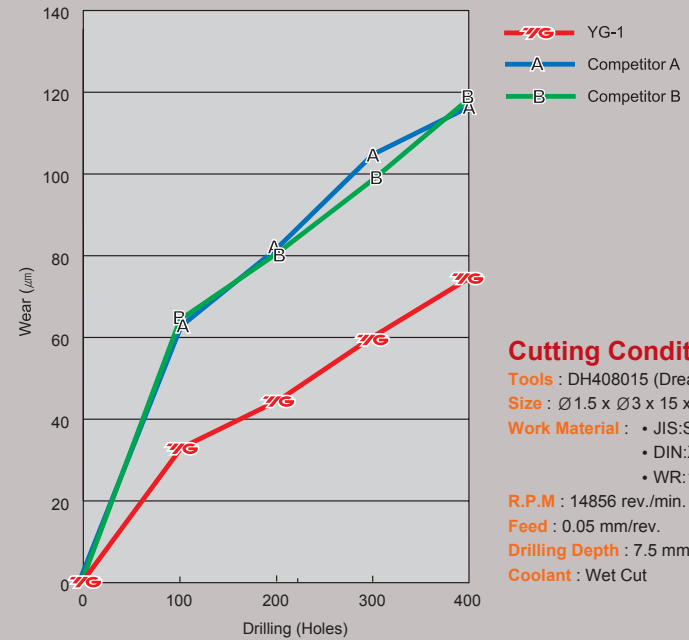
SOLID CARBIDE DREAM DRILLS - INOX with COOLANT HOLES, TiAIN COATED

DH451, DH452, DH453 Series Unit : mm

WORK MATERIAL	STAINLESS STEELS		STAINLESS STEELS		ALUMINUM		ALUMINUM		TITANIUM Ti Alloy		CARBON STEELS ALLOY STEELS		NON FRERROUS	
	< 800 N/mm ²		> 800 N/mm ²		< 10% Si		> 10% Si							
	N	S	N	S	N	S	N	S	N	S	N	S	N	S
1.5	9000	0.03	5400	0.02	43000	0.05	32000	0.04	7500	0.01	18000	0.03	25500	0.03
2.5	7000	0.04	4200	0.03	25500	0.08	19500	0.06	4500	0.02	10800	0.05	15500	0.05
3.0	7400	0.04	4700	0.02	23000	0.12	18500	0.10	5300	0.03	13000	0.04	16000	0.08
4.0	5600	0.05	3600	0.03	17500	0.18	13900	0.15	4000	0.04	10000	0.05	11900	0.10
5.0	4400	0.05	2800	0.03	14000	0.20	11000	0.18	3200	0.05	8000	0.05	9500	0.12
6.0	3700	0.06	2400	0.04	11700	0.25	9300	0.25	2650	0.06	6600	0.06	8000	0.15
8.0	2800	0.08	1800	0.06	8800	0.30	7000	0.30	2000	0.07	5000	0.08	6000	0.18
10.0	2200	0.10	1400	0.08	7000	0.40	5600	0.35	1600	0.08	4000	0.10	4800	0.22
12.0	1900	0.12	1200	0.10	5800	0.50	4600	0.40	1300	0.10	3300	0.12	4000	0.26
14.0	1600	0.15	1000	0.12	5000	0.60	4000	0.50	1100	0.12	2800	0.15	3400	0.30
16.0	1400	0.20	900	0.15	4380	0.80	3500	0.60	1000	0.14	2500	0.20	3000	0.40
18.0	1250	0.22	800	0.17	3900	1.00	3100	0.70	900	0.16	2200	0.22	2650	0.45
20.0	1120	0.24	720	0.19	3500	1.20	2800	0.80	800	0.18	2000	0.24	2400	0.50

► Recommend to reduce the feed rate as following.
 DH451(3xD), DH452(5xD) : Feed 100%
 DH453(8xD) : Feed 85%

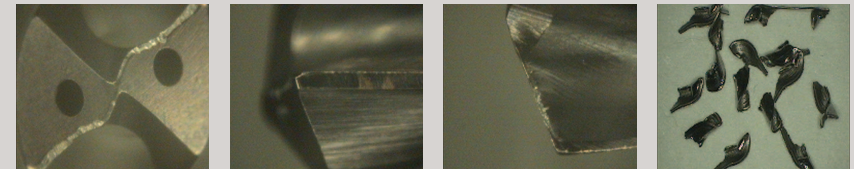
N = R.P.M
 S = Feed per Revolution (mm/rev.)



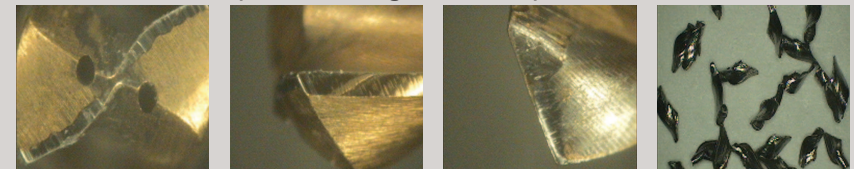
Cutting Condition

Tools : DH408015 (Dream Drill with Coolant Holes)
Size : Ø1.5 x Ø3 x 15 x 55
Work Material : • JIS:SKD61 (HRC30)
 • DIN:X40GrMoV51
 • WR:1.2344
R.P.M : 14856 rev./min.
Feed : 0.05 mm/rev.
Drilling Depth : 7.5 mm
Coolant : Wet Cut

YG-1 (Total Drilling 400 Holes)



COMPETITOR A (Total Drilling 400 Holes)



COMPETITOR B (Total Drilling 400 Holes)

