

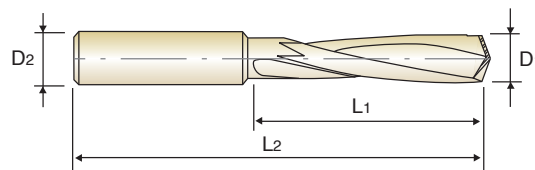
**Y/G DREAM DRILLS for HIGH HARDENED STEELS**

**DH500 SERIES**

**CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70)  
VOLLHARTMETALL DREAM SPIRALBOHRER für HOCHGEHARTETE STAHL**

- ▶ **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- ▶ **Advantage** : Special Design  
Minimum of cutting load through special thinning  
Good chip removal  
Powerful Drilling

- ▶ **Verwendung** : Hoch gehärtete Stähle (Vergütungsstähle, angelassene Stähle) bis HRc 70
- ▶ **Vorteile** : Spezielle Bohrergeometrie  
Minimaler Schneidendruck durch besondere Ausspitzung  
Gute Spanabfuhr  
Hochleistungsbohren



MG 15° h6 h7 140° P.111

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
DH500026	2.6	3	14	44	DH500070	7.0	8	45	85
DH500030	3.0	3	16	46	DH500075	7.5	8	45	85
DH500033	3.3	4	18	48	DH500080	8.0	8	50	98
DH500034	3.4	4	20	50	DH500085	8.5	10	50	98
DH500035	3.5	4	20	50	DH500086	8.6	10	57	105
DH500040	4.0	4	22	52	DH500088	8.8	10	57	105
DH500042	4.2	6	25	65	DH500090	9.0	10	57	105
DH500043	4.3	6	28	68	DH500095	9.5	10	57	105
DH500044	4.4	6	28	68	DH500100	10.0	10	63	111
DH500045	4.5	6	28	68	DH500102	10.2	12	63	111
DH500050	5.0	6	32	72	DH500103	10.3	12	63	111
DH500051	5.1	6	32	72	DH500105	10.5	12	63	111
DH500052	5.2	6	32	72	DH500108	10.8	12	71	119
DH500055	5.5	6	35	75	DH500110	11.0	12	71	119
DH500060	6.0	6	35	75	DH500115	11.5	12	71	119
DH500065	6.5	8	40	80	DH500120	12.0	12	71	119
DH500068	6.8	8	45	85	DH500140	14.0	14	77	125
DH500069	6.9	8	45	85					

◎ : 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~								
			◎	◎								

**YG DREAM DRILLS**  
for HIGH HARDENED STEELS

**RECOMMENDED CUTTING CONDITIONS**  
EMPFOHLENE SCHNEIDKONDITIONEN

**CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70), TiAlN COATED**  
**VOLLHARTMETALL DREAM BOHRER für HOCHGEHÄRTETE STÄHLE, TiAlN-BESCHICHTET**

**DH500** SERIES

WORK MATERIAL	HARDENED STEELS					
	HRc 50~55		HRc 55~60		HRc 60~70	
	14 ~ 22 m/min		10 ~ 16 m/min		8 ~ 13 m/min	
DRILLING SPEED						
DIAMETER	N	S	N	S	N	S
3.0	1900	0.04	1330	0.04	1250	0.04
4.0	1430	0.04	1000	0.04	950	0.04
5.0	1150	0.04	800	0.04	750	0.04
6.0	960	0.04	670	0.04	630	0.04
8.0	720	0.04	500	0.04	480	0.04
10.0	570	0.04	400	0.04	380	0.04
12.0	480	0.04	330	0.04	320	0.04
14.0	438	0.04	282	0.04	272	0.04

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

- HSS
- I-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- GENERAL CARBIDE DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA