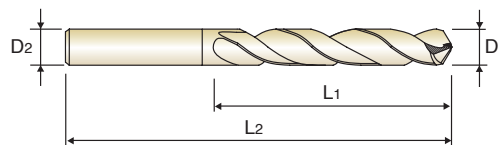




## CARBIDE, DREAM DRILLS - CFRP VOLLHARTMETALL DREAM SPIRALBOHRER - CFK

- ▶ Special Point Type improve hole quality for Composite Material  
-> Minimized Burr and Delamination at Entry / Exit Hole.
- ▶ Outstanding Performance
- ▶ Long Tool Life and Increased product by Diamond Coating.

- ▶ Spezielle Spitzengeometrie zur Verbesserung der Bohrungsqualität bei Composite-Materialien  
-> Minimiert die Grat-Bildung beim Bohrungs Ein- und Austritt
- ▶ Überzeugende Schnittdaten
- ▶ Lange Standzeiten und erhöhte Produktivität durch Diamant-Beschichtung



Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
DIAMOND COATED	D1	D2	L1	L2
DI473025	2.5	6	24	66
DI473030	3.0	6	28	66
DI473040	4.0	6	36	74
DI473050	5.0	6	44	82
DI473060	6.0	6	44	82
DI473080	8.0	8	53	91
DI473090	9.0	10	61	103
DI473100	10.0	10	61	103
DI473110	11.0	12	71	118
DI473120	12.0	12	71	118

### CUTTING CONDITIONS

Speed (m/min)	RPM	Feed (mm/rev)
100 ~ 150	12,700 ~ 19,000	0.03 ~ 0.07
	10,600 ~ 15,900	
	8,000 ~ 11,900	
	6,370 ~ 9,500	
	5,300 ~ 8,000	
	4,000 ~ 6,000	
	3,500 ~ 5,300	
	3,200 ~ 4,700	
	2,900 ~ 4,300	
	2,700 ~ 3,900	

◎ : 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~								
												◎