

YU-DD15



Registered
ISO 9001:2008 / ISO 14001:2004



SOLID CARBIDE **DREAM DRILLS**

- CARBIDE DREAM DRILLS - GENERAL
(with/without COOLANT HOLES)
- CARBIDE DREAM DRILLS - INOX
(with COOLANT HOLES)
- CARBIDE DREAM DRILLS - ALU
(with COOLANT HOLES)
- CARBIDE DREAM DRILLS - MQL(10 × D ~ 30 × D)
(with COOLANT HOLES)
- CARBIDE DREAM DRILLS
for HIGH HARDENED STEELS(HRc50~70)



BEST VALUE IN THE WORLD OF CUTTING TOOLS

YG-1 CO., LTD.

CBN Ball End Mill



V7 Mill



X5070 End Mill



D-Power End Mill



Multi-1 Drill



Dream Drill



Tank-Power End Mill



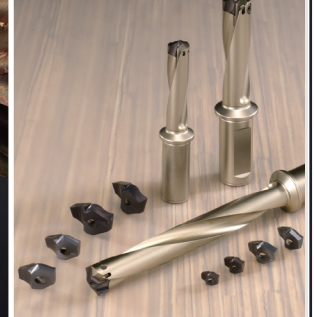
HSS End Mill



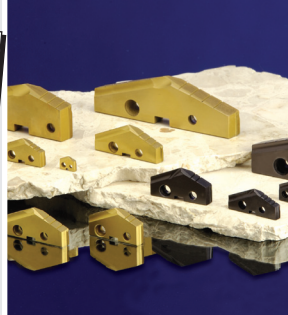
X-mill



-Dream Drill



Spade Drill Inserts



Combo Tap

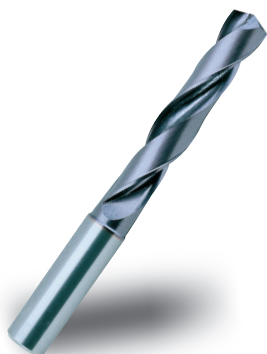


Features of SOLID CARBIDE DREAM DRILLS

SOLID CARBIDE DREAM DRILLS

with / without COOLANT HOLES (3XD, 5XD, 8XD)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling



DH414, DH722, DH404, DH423, DH424
(without coolant holes)

P. 6~15

DH416, DH711, DH418, DH712, DH406
DH408, DH421 (with coolant holes)

P. 16~26

SOLID CARBIDE DREAM DRILLS **INOX**

with COOLANT HOLES (3XD, 5XD, 8XD)

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life



DH463, DH714, DH464, DH451,
DH715, DH452, DH453

P. 28~37

SOLID CARBIDE DREAM DRILLS **ALU**

with COOLANT HOLES (5XD)

- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes



DGE466, DGE718, DGE433

P. 40~43

SOLID CARBIDE DREAM DRILLS MQL TYPE

with COOLANT HOLES (10XD, 15XD, 20XD, 25XD, 30XD)

- Non step drilling up to 10(15~30) times of drill diameter
- Available for processing MQL(Minimum Quantity Lubrication)
- Excellent positioning – Bush is not necessary
- Special design – Good chip removal
- Powerful drilling



DH510, DH515, DH520

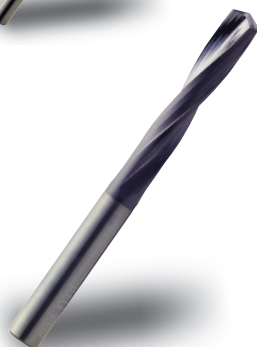
P. 46~47

DHM10, DHM15, DHM20, DHM25, DHM30

P. 48~49

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS (HRc50~70)

- 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



DH501, DH500

P. 52~54

SOLID CARBIDE DREAM DRILLS APPLICATION TABLE

○ : Excellent
○ : Good

Item	Length	Unit	Size		Page	Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels
			Min.	Max.		~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~					

SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

NEW DH414	STUB (3xD)	inch	1/8	5/8	p.6	○	○	○			○		○		
NEW DH722	LONG (5xD)		13/64	1/2	p.7	○	○	○			○		○		
NEW DH404	STUB (3xD)	metric	3.0	20.0	p.8	○	○	○			○		○		
NEW DH423	STUB (3xD)		3.0	20.0	p.10	○	○	○			○		○		
NEW DH424	LONG (5xD)		1.0	20.0	p.13	○	○	○			○		○		

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH416 DH711	STUB (3xD)	inch	1/8	5/8	p.16	○	○	○			○		○		
DH418 DH712	LONG (5xD)		13/64	1/2	p.17	○	○	○			○		○		
DH406	STUB (3xD)	metric	3.0	20.0	p.18	○	○	○			○		○		
DH408	LONG (5xD)		1.0	20.0	p.20	○	○	○			○		○		
DH421	EXTRA LONG (8xD)		3.0	14.0	p.23	○	○	○			○		○		

SOLID CARBIDE DREAM DRILLS-INOX (with COOLANT HOLES)

DH463 DH714	STUB (3xD)	inch	1/8	5/8	p.28	○	○	○				○	○	○	○
DH464 DH715	LONG (5xD)		13/64	1/2	p.29	○	○	○				○	○	○	○
DH451	STUB (3xD)	metric	3.0	20.0	p.30	○	○	○				○	○	○	○
DH452	LONG (5xD)		1.0	20.0	p.33	○	○	○				○	○	○	○
DH453	EXTRA LONG (8xD)		3.0	14.0	p.36	○	○	○				○	○	○	○

SOLID CARBIDE DREAM DRILLS-ALU (with COOLANT HOLES)

DGE466 DGE718	LONG (5xD)	inch	13/64	1/2	p.40							○			
DGE433	LONG (5xD)	metric	3.0	20.0	p.41							○			

SOLID CARBIDE DREAM DRILLS-MQL TYPE (with COOLANT HOLES)

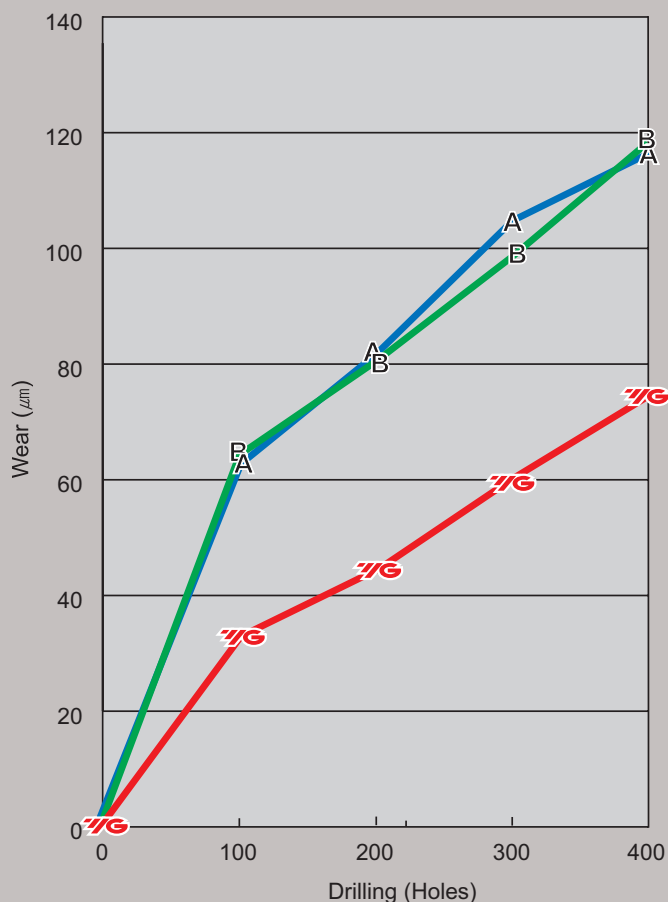
NEW DH510 DHM10	EXTRA LONG (10xD)	metric	3.0	14.0	p.46 p.48	○	○	○			○				○
NEW DH515 DHM15	EXTRA LONG (15xD)		3.0	12.0	p.47 p.48	○	○	○			○				○
NEW DH520 DHM20	EXTRA LONG (20xD)		3.0	12.0	p.47 p.48	○	○	○			○				○
NEW DHM25	EXTRA LONG (25xD)		3.0	10.0	p.49	○	○	○			○				○
NEW DHM30	EXTRA LONG (30xD)		3.0	8.0	p.49	○	○	○			○				○

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEEL

DH501	-	inch	1/8	3/4	p.52				○	○					
DH500	-	metric	1.0	14.0	p.54				○	○					

SOLID CARBIDE DREAM DRILLS - **Test Report**

with COOLANT HOLES



 YG-1
 Competitor A
 Competitor B

Cutting Condition

Tools : DH408015 (Dream Drill with Coolant Holes)

Size : Ø 1.5 x Ø 3 x 15 x 55

Work Material : • JIS:SKD61 (HRC30)

• DIN:X40GrMoV51

• WR:1.2344

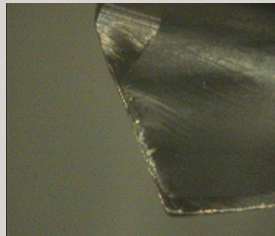
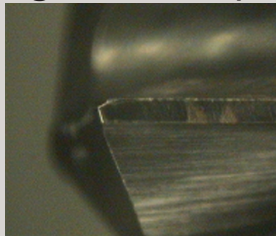
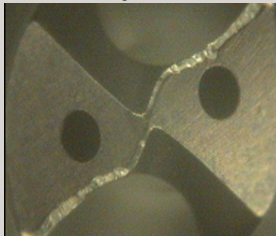
R.P.M : 14856 rev./min.

Feed : .0019 inch/rev.

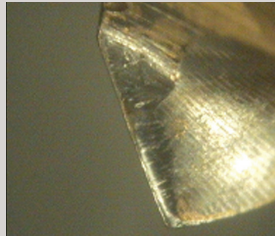
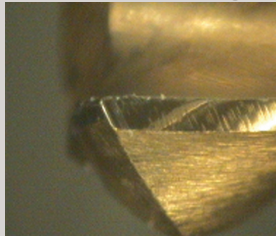
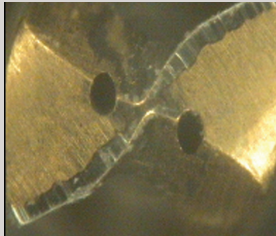
Drilling Depth : 29"

Coolant : Wet Cut

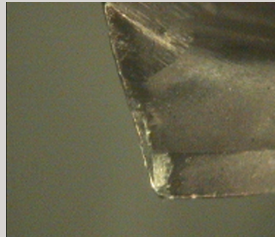
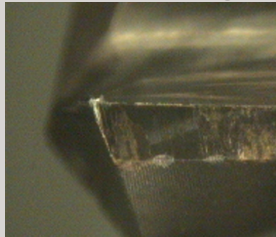
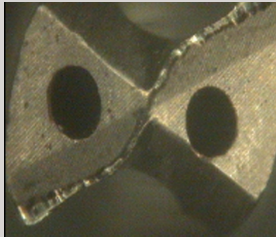
YG-1 (Total Drilling 400 Holes)



COMPETITOR A (Total Drilling 400 Holes)



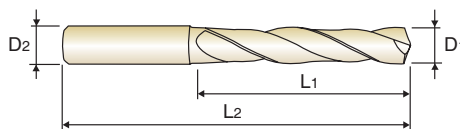
COMPETITOR B (Total Drilling 400 Holes)





SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering - center drilling is not required
 Excellent positioning - bushing is not necessary
 Special Design - reaming is not required
 - good chip removal
 - powerful drilling
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



P.25

DREAM DRILLS

D₁=D₂

3 × D

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length	EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal				Fractional	Decimal		
TiAIN	D1 = D2		L1	L2	TiAIN	D1 = D2		L1	L2
0081ATF	1/8	.1250	45/64	1-59/64	0221ATF	11/32	.3438	2-3/16	3-7/8
0091ATF	9/64	.1406	25/32	2-3/64	0231ATF	23/64	.3594	2-9/32	4
0101ATF	5/32	.1562	7/8	2-3/16	2211ATF	U	.3680	2-9/32	4
0111ATF	11/64	.1719	15/16	2-9/32	0241ATF	3/8	.3750	2-3/8	4-1/8
0121ATF	3/16	.1875	1	2-7/16	0251ATF	25/64	.3906	2-3/8	4-1/8
0131ATF	13/64	.2031	1	2-7/16	0261ATF	13/32	.4062	2-5/8	4-13/32
0141ATF	7/32	.2188	1-1/8	2-5/8	0271ATF	27/64	.4219	2-11/16	4-1/2
0151ATF	15/64	.2344	1-1/8	2-5/8	0281ATF	7/16	.4375	2-13/16	4-5/8
0161ATF	1/4	.2500	1-5/8	3-3/16	0291ATF	29/64	.4531	2-7/8	4-3/4
2061ATF	F	.2570	1-11/16	3-17/64	0301ATF	15/32	.4688	2-7/8	4-3/4
0171ATF	17/64	.2656	1-11/16	3-17/64	0311ATF	31/64	.4844	3	5-5/16
2091ATF	I	.2720	1-11/16	3-17/64	0321ATF	1/2	.5000	3-1/16	5-3/8
0181ATF	9/32	.2812	1-3/4	3-7/16	0331ATF	33/64	.5156	3-11/32	5-11/16
0191ATF	19/64	.2969	1-7/8	3-9/16	0341ATF	17/32	.5312	3-11/32	5-11/16
0201ATF	5/16	.3125	1-7/8	3-9/16	0361ATF	9/16	.5625	3-1/2	5-15/16
0211ATF	21/64	.3281	2-1/16	3-3/4	0371ATF	37/64	.5781	3-37/64	6
2171ATF	Q	.3320	2-1/16	3-3/4	0401ATF	5/8	.6250	3-25/3	6-19/64

► Other shank types are available on your request

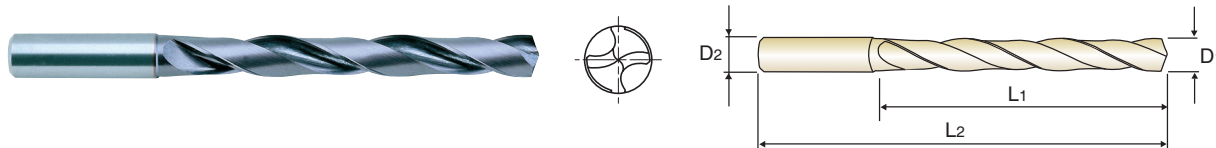
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 - center drilling is not required
 Excellent positioning - bushing is not necessary
 Special Design - reaming is not required
 - good chip removal
 - powerful drilling
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



P.25

DREAM DRILLS | 5×D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal					Fractional	Decimal			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH722013	13/64	.2031	1/4	1-3/4	3-15/16	DH722022	11/32	.3438	3/8	2-27/32	5
DH722014	7/32	.2188	1/4	1-57/64	3-15/16	DH722023	23/64	.3594	3/8	3	5-23/64
DH722015	15/64	.2344	1/4	1-57/64	3-15/16	DH722221	U	.3680	3/8	3	5-23/64
DH722016	1/4	.2500	1/4	2-3/64	4-19/64	DH722024	3/8	.3750	3/8	3-5/32	5-23/64
DH722017	F	.2570	5/16	2-13/64	4-19/64	DH722025	25/64	.3906	7/16	3-5/32	5-23/64
DH722018	17/64	.2656	5/16	2-13/64	4-19/64	DH722026	13/32	.4062	7/16	3-5/16	5-7/8
DH722019	I	.2720	5/16	2-13/64	4-19/64	DH722027	27/64	.4219	7/16	3-15/32	5-7/8
DH722020	9/32	.2812	5/16	2-23/64	4-41/64	DH722028	7/16	.4375	7/16	3-5/8	6-7/32
DH722021	19/64	.2969	5/16	2-33/64	4-41/64	DH722029	29/64	.4531	1/2	3-25/32	6-7/32
DH722022	5/16	.3125	5/16	2-33/64	4-41/64	DH722030	15/32	.4688	1/2	3-25/32	6-7/32
DH722023	21/64	.3281	3/8	2-43/64	5	DH722031	31/64	.4844	1/2	3-15/16	6-37/64
DH722024	Q	.3320	3/8	2-43/64	5	DH722032	1/2	.5000	1/2	4-3/32	6-37/64

► Other shank types are available on your request

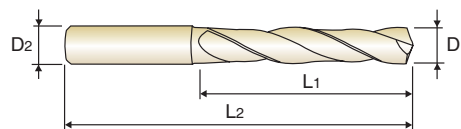
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling



DIN
6539

MG

h6

h7

140°



P.26

DREAM DRILLS

D₁=D₂

3 × D

Unit : mm

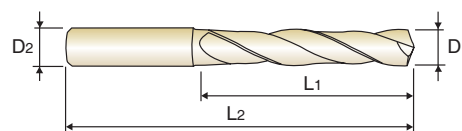
EDP No.	Diameter		Flute Length	Overall Length	EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch				Metric	Inch		
TA1N	D1 = D2		L1	L2	TA1N	D1 = D2		L1	L2
DH404030	3.0	.1181	16	46	DH404061	6.1	.2402	31	70
DH404031	3.1	.1220	18	49	DH404062	6.2	.2441	31	70
DH404032	3.2	.1260	18	49	DH404063	6.3	.2480	31	70
DH404033	3.3	.1299	18	49	DH404064	6.4	.2520	31	70
DH404034	3.4	.1339	20	52	DH404065	6.5	.2559	31	70
DH404035	3.5	.1378	20	52	DH404066	6.6	.2598	31	70
DH404036	3.6	.1417	20	52	DH404067	6.7	.2638	31	70
DH404037	3.7	.1457	20	52	DH404068	6.8	.2677	34	74
DH404038	3.8	.1496	22	55	DH404069	6.9	.2717	34	74
DH404039	3.9	.1535	22	55	DH404070	7.0	.2756	34	74
DH404040	4.0	.1575	22	55	DH404071	7.1	.2795	34	74
DH404041	4.1	.1614	22	55	DH404072	7.2	.2835	34	74
DH404042	4.2	.1654	22	55	DH404073	7.3	.2874	34	74
DH404043	4.3	.1693	24	58	DH404074	7.4	.2913	34	74
DH404044	4.4	.1732	24	58	DH404075	7.5	.2953	34	74
DH404045	4.5	.1772	24	58	DH404076	7.6	.2992	37	79
DH404046	4.6	.1811	24	58	DH404077	7.7	.3031	37	79
DH404047	4.7	.1850	24	58	DH404078	7.8	.3071	37	79
DH404048	4.8	.1890	26	62	DH404079	7.9	.3110	37	79
DH404049	4.9	.1929	26	62	DH404080	8.0	.3150	37	79
DH404050	5.0	.1969	26	62	DH404081	8.1	.3189	37	79
DH404051	5.1	.2008	26	62	DH404082	8.2	.3228	37	79
DH404052	5.2	.2047	26	62	DH404083	8.3	.3268	37	79
DH404053	5.3	.2087	26	62	DH404084	8.4	.3307	37	79
DH404054	5.4	.2126	28	66	DH404085	8.5	.3346	37	79
DH404055	5.5	.2165	28	66	DH404086	8.6	.3386	40	84
DH404056	5.6	.2205	28	66	DH404087	8.7	.3425	40	84
DH404057	5.7	.2244	28	66	DH404088	8.8	.3465	40	84
DH404058	5.8	.2283	28	66	DH404089	8.9	.3504	40	84
DH404059	5.9	.2323	28	66	DH404090	9.0	.3543	40	84
DH404060	6.0	.2362	28	66	DH404091	9.1	.3583	40	84

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS

D₁=D₂

3 × D

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length	EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch				Metric	Inch		
TiAIN	D1 = D2		L1	L2	TiAIN	D1 = D2		L1	L2
DH404092	9.2	.3622	40	84	DH404135	13.5	.5314	54	107
DH404093	9.3	.3661	40	84	DH404140	14.0	.5512	54	107
DH404094	9.4	.3701	40	84	DH404145	14.5	.5708	56	111
DH404095	9.5	.3740	40	84	DH404150	15.0	.5905	56	111
DH404096	9.6	.3780	43	89	DH404155	15.5	.6102	58	115
DH404097	9.7	.3819	43	89	DH404160	16.0	.6299	58	115
DH404098	9.8	.3858	43	89	DH404165	16.5	.6495	60	119
DH404099	9.9	.3898	43	89	DH404170	17.0	.6692	60	119
DH404100	10.0	.3937	43	89	DH404175	17.5	.6889	62	123
DH404102	10.2	.4016	43	89	DH404180	18.0	.7087	62	123
DH404105	10.5	.4134	43	89	DH404185	18.5	.7283	64	127
DH404110	11.0	.4331	47	95	DH404190	19.0	.7480	64	127
DH404115	11.5	.4528	47	95	DH404195	19.5	.7676	66	131
DH404120	12.0	.4724	51	102	DH404200	20.0	.7874	66	131
DH404130	13.0	.5118	51	102					

► Other shank types are available on your request

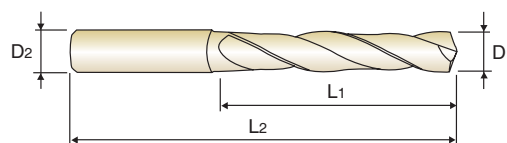
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 3×D

Unit : mm

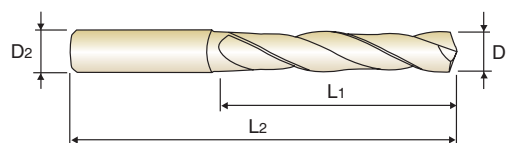
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH423030	3.0		.1181	6	20	62	DH423055	5.5		.2165	6	28	66
DH423031	3.1		.1220	6	20	62	DH423014F	5.556	7/32	.2188	6	28	66
DH423008F	3.175	1/8	.1250	6	20	62	DH423056	5.6		.2205	6	28	66
DH423032	3.2		.1260	6	20	62	DH423057	5.7		.2244	6	28	66
DH423033	3.3		.1299	6	20	62	DH423058	5.8		.2283	6	28	66
DH423034	3.4		.1339	6	20	62	DH423059	5.9		.2323	6	28	66
DH423035	3.5		.1378	6	20	62	DH423015F	5.953	15/64	.2344	6	28	66
DH423009F	3.572	9/64	.1406	6	20	62	DH423060	6.0		.2362	6	28	66
DH423036	3.6		.1417	6	20	62	DH423061	6.1		.2402	8	34	79
DH423037	3.7		.1457	6	20	62	DH423062	6.2		.2441	8	34	79
DH423038	3.8		.1496	6	24	66	DH423063	6.3		.2480	8	34	79
DH423039	3.9		.1535	6	24	66	DH423016F	6.350	1/4	.2500	8	34	79
DH423010F	3.969	5/32	.1563	6	24	66	DH423064	6.4		.2520	8	34	79
DH423040	4.0		.1575	6	24	66	DH423065	6.5		.2559	8	34	79
DH423041	4.1		.1614	6	24	66	DH423066	6.6		.2598	8	34	79
DH423042	4.2		.1654	6	24	66	DH423067	6.7		.2638	8	34	79
DH423043	4.3		.1693	6	24	66	DH423017F	6.747	17/64	.2656	8	34	79
DH423011F	4.366	11/64	.1719	6	24	66	DH423068	6.8		.2677	8	34	79
DH423044	4.4		.1732	6	24	66	DH423069	6.9		.2717	8	34	79
DH423045	4.5		.1772	6	24	66	DH423070	7.0		.2756	8	34	79
DH423046	4.6		.1811	6	24	66	DH423071	7.1		.2795	8	41	79
DH423047	4.7		.1850	6	24	66	DH423018F	7.144	9/32	.2812	8	41	79
DH423012F	4.763	3/16	.1875	6	24	66	DH423072	7.2		.2835	8	41	79
DH423048	4.8		.1890	6	28	66	DH423073	7.3		.2874	8	41	79
DH423049	4.9		.1929	6	28	66	DH423074	7.4		.2913	8	41	79
DH423050	5.0		.1969	6	28	66	DH423075	7.5		.2953	8	41	79
DH423051	5.1		.2008	6	28	66	DH423019F	7.541	19/64	.2969	8	41	79
DH423013F	5.159	13/64	.2031	6	28	66	DH423076	7.6		.2992	8	41	79
DH423052	5.2		.2047	6	28	66	DH423077	7.7		.3031	8	41	79
DH423053	5.3		.2087	6	28	66	DH423078	7.8		.3071	8	41	79
DH423054	5.4		.2126	6	28	66	DH423079	7.9		.3110	8	41	79

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 3×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH423020F	7.938	5/16	.3125	8	41	79	DH423104	10.4		.4094	12	55	102
DH423080	8.0		.3150	8	41	79	DH423105	10.5		.4134	12	55	102
DH423081	8.1		.3189	10	47	89	DH423106	10.6		.4173	12	55	102
DH423082	8.2		.3228	10	47	89	DH423107	10.7		.4213	12	55	102
DH423083	8.3		.3268	10	47	89	DH423027F	10.716	27/64	.4219	12	55	102
DH423021F	8.334	21/64	.3281	10	47	89	DH423108	10.8		.4252	12	55	102
DH423084	8.4		.3307	10	47	89	DH423109	10.9		.4291	12	55	102
DH423085	8.5		.3346	10	47	89	DH423110	11.0		.4331	12	55	102
DH423086	8.6		.3386	10	47	89	DH423111	11.1		.4370	12	55	102
DH423087	8.7		.3425	10	47	89	DH423028F	11.113	7/16	.4375	12	55	102
DH423022F	8.731	11/32	.3438	10	47	89	DH423112	11.2		.4409	12	55	102
DH423088	8.8		.3465	10	47	89	DH423113	11.3		.4449	12	55	102
DH423089	8.9		.3504	10	47	89	DH423114	11.4		.4488	12	55	102
DH423090	9.0		.3543	10	47	89	DH423115	11.5		.4528	12	55	102
DH423091	9.1		.3583	10	47	89	DH423029F	11.509	29/64	.4531	12	55	102
DH423023F	9.128	23/64	.3594	10	47	89	DH423116	11.6		.4567	12	55	102
DH423092	9.2		.3622	10	47	89	DH423117	11.7		.4606	12	55	102
DH423093	9.3		.3661	10	47	89	DH423118	11.8		.4646	12	55	102
DH423094	9.4		.3701	10	47	89	DH423119	11.9		.4685	12	55	102
DH423095	9.5		.3740	10	47	89	DH423030F	11.906	15/32	.4688	12	55	102
DH423024F	9.525	3/8	.3750	10	47	89	DH423120	12.0		.4724	12	55	102
DH423096	9.6		.3780	10	47	89	DH423123	12.3		.4843	14	60	107
DH423097	9.7		.3819	10	47	89	DH423031F	12.303	31/64	.4844	14	60	107
DH423098	9.8		.3858	10	47	89	DH423125	12.5		.4921	14	60	107
DH423099	9.9		.3898	10	47	89	DH423032F	12.7	1/2	.5000	14	60	107
DH423025F	9.922	25/64	.3906	10	47	89	DH423128	12.8		.5039	14	60	107
DH423100	10.0		.3937	10	47	89	DH423130	13.0		.5118	14	60	107
DH423101	10.1		.3976	12	55	102	DH423135	13.5		.5315	14	60	107
DH423102	10.2		.4016	12	55	102	DH423138	13.8		.5433	14	60	107
DH423103	10.3		.4055	12	55	102	DH423140	14.0		.5512	14	60	107
DH423026F	10.319	13/32	.4062	12	55	102	DH423036F	14.288	9/16	.5625	16	65	115

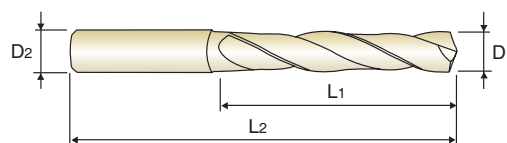
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NEW

SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 3×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH423145	14.5		.5708	16	65	115	DH423044F	17.463	11/16	.6875	18	73	123
DH423148	14.8		.5827	16	65	115	DH423175	17.5		.6889	18	73	123
DH423150	15.0		.5905	16	65	115	DH423178	17.8		.7008	18	73	123
DH423155	15.5		.6102	16	65	115	DH423180	18.0		.7087	18	73	123
DH423158	15.8		.6220	16	65	115	DH423185	18.5		.7283	20	79	131
DH423040F	15.875	5/8	.6250	16	65	115	DH423190	19.0		.7480	20	79	131
DH423160	16.0		.6299	16	65	115	DH423048F	19.05	3/4	.7500	20	79	131
DH423165	16.5		.6495	18	73	123	DH423195	19.5		.7676	20	79	131
DH423168	16.8		.6614	18	73	123	DH423198	19.8		.7795	20	79	131
DH423170	17.0		.6692	18	73	123	DH423200	20.0		.7874	20	79	131

► Other shank types are available on your request

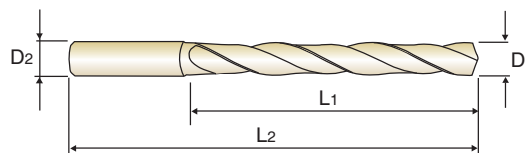
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
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 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5×D

Unit : mm

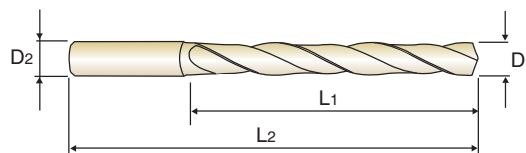
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH424010	1.0		.0394	3	8	55	DH424009F	3.572	9/64	.1406	6	28	66
DH424011	1.1		.0433	3	12	55	DH424036	3.6		.1417	6	28	66
DH424012	1.2		.0472	3	12	55	DH424037	3.7		.1457	6	28	66
DH424013	1.3		.0512	3	12	55	DH424038	3.8		.1496	6	36	74
DH424014	1.4		.0551	3	12	55	DH424039	3.9		.1535	6	36	74
DH424015	1.5		.0591	3	16	55	DH424010F	3.969	5/32	.1563	6	36	74
DH424004F	1.588	1/16	.0625	3	16	55	DH424040	4.0		.1575	6	36	74
DH424016	1.6		.0630	3	16	55	DH424041	4.1		.1614	6	36	74
DH424017	1.7		.0669	3	16	55	DH424042	4.2		.1654	6	36	74
DH424018	1.8		.0709	3	16	55	DH424043	4.3		.1693	6	36	74
DH424019	1.9		.0748	3	16	55	DH424011F	4.366	11/64	.1719	6	36	74
DH424005F	1.984	5/64	.0781	3	16	55	DH424044	4.4		.1732	6	36	74
DH424020	2.0		.0787	4	21	57	DH424045	4.5		.1772	6	36	74
DH424021	2.1		.0827	4	21	57	DH424046	4.6		.1811	6	36	74
DH424022	2.2		.0866	4	21	57	DH424047	4.7		.1850	6	36	74
DH424023	2.3		.0906	4	21	57	DH424012F	4.763	3/16	.1875	6	36	74
DH424006F	2.381	3/32	.0938	4	21	57	DH424048	4.8		.1890	6	44	82
DH424024	2.4		.0945	4	21	57	DH424049	4.9		.1929	6	44	82
DH424025	2.5		.0984	4	21	57	DH424050	5.0		.1969	6	44	82
DH424026	2.6		.1024	4	21	57	DH424051	5.1		.2008	6	44	82
DH424027	2.7		.1063	4	21	57	DH424013F	5.159	13/64	.2031	6	44	82
DH424007F	2.778	7/64	.1094	4	21	57	DH424052	5.2		.2047	6	44	82
DH424028	2.8		.1102	4	21	57	DH424053	5.3		.2087	6	44	82
DH424029	2.9		.1142	4	21	57	DH424054	5.4		.2126	6	44	82
DH424030	3.0		.1181	6	28	66	DH424055	5.5		.2165	6	44	82
DH424031	3.1		.1220	6	28	66	DH424014F	5.556	7/32	.2188	6	44	82
DH424008F	3.175	1/8	.1250	6	28	66	DH424056	5.6		.2205	6	44	82
DH424032	3.2		.1260	6	28	66	DH424057	5.7		.2244	6	44	82
DH424033	3.3		.1299	6	28	66	DH424058	5.8		.2283	6	44	82
DH424034	3.4		.1339	6	28	66	DH424059	5.9		.2323	6	44	82
DH424035	3.5		.1378	6	28	66	DH424015F	5.953	15/64	.2344	6	44	82

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5 × D

Unit : mm

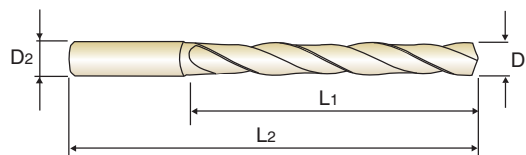
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH424060	6.0		.2362	6	44	82	DH424085	8.5		.3346	10	61	103
DH424061	6.1		.2402	8	53	91	DH424086	8.6		.3386	10	61	103
DH424062	6.2		.2441	8	53	91	DH424087	8.7		.3425	10	61	103
DH424063	6.3		.2480	8	53	91	DH424022F	8.731	11/32	.3438	10	61	103
DH424016F	6.35	1/4	.2500	8	53	91	DH424088	8.8		.3465	10	61	103
DH424064	6.4		.2520	8	53	91	DH424089	8.9		.3504	10	61	103
DH424065	6.5		.2559	8	53	91	DH424090	9.0		.3543	10	61	103
DH424066	6.6		.2598	8	53	91	DH424091	9.1		.3583	10	61	103
DH424067	6.7		.2638	8	53	91	DH424023F	9.128	23/64	.3594	10	61	103
DH424017F	6.747	17/64	.2656	8	53	91	DH424092	9.2		.3622	10	61	103
DH424068	6.8		.2677	8	53	91	DH424093	9.3		.3661	10	61	103
DH424069	6.9		.2717	8	53	91	DH424094	9.4		.3701	10	61	103
DH424070	7.0		.2756	8	53	91	DH424095	9.5		.3740	10	61	103
DH424071	7.1		.2795	8	53	91	DH424024F	9.525	3/8	.3750	10	61	103
DH424018F	7.144	9/32	.2812	8	53	91	DH424096	9.6		.3780	10	61	103
DH424072	7.2		.2835	8	53	91	DH424097	9.7		.3819	10	61	103
DH424073	7.3		.2874	8	53	91	DH424098	9.8		.3858	10	61	103
DH424074	7.4		.2913	8	53	91	DH424099	9.9		.3898	10	61	103
DH424075	7.5		.2953	8	53	91	DH424025F	9.922	25/64	.3906	10	61	103
DH424019F	7.541	19/64	.2969	8	53	91	DH424100	10.0		.3937	10	61	103
DH424076	7.6		.2992	8	53	91	DH424101	10.1		.3976	12	71	118
DH424077	7.7		.3031	8	53	91	DH424102	10.2		.4016	12	71	118
DH424078	7.8		.3071	8	53	91	DH424103	10.3		.4055	12	71	118
DH424079	7.9		.3110	8	53	91	DH424026F	10.319	13/32	.4062	12	71	118
DH424020F	7.938	5/16	.3125	8	53	91	DH424104	10.4		.4094	12	71	118
DH424080	8.0		.3150	8	53	91	DH424105	10.5		.4134	12	71	118
DH424081	8.1		.3189	10	61	103	DH424106	10.6		.4173	12	71	118
DH424082	8.2		.3228	10	61	103	DH424107	10.7		.4213	12	71	118
DH424083	8.3		.3268	10	61	103	DH424027F	10.716	27/64	.4219	12	71	118
DH424021F	8.334	21/64	.3281	10	61	103	DH424108	10.8		.4252	12	71	118
DH424084	8.4		.3307	10	61	103	DH424109	10.9		.4291	12	71	118

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

- Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics
- Advantage : Self centering - Center drilling is not required
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 - Good chip removal
 - Powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH424110	11.0		.4331	12	71	118	DH424140	14.0		.5512	14	77	124
DH424111	11.1		.4370	12	71	118	DH424036F	14.288	9/16	.5625	16	83	133
DH424028F	11.113	7/16	.4375	12	71	118	DH424145	14.5		.5708	16	83	133
DH424112	11.2		.4409	12	71	118	DH424148	14.8		.5827	16	83	133
DH424113	11.3		.4449	12	71	118	DH424150	15.0		.5905	16	83	133
DH424114	11.4		.4488	12	71	118	DH424155	15.5		.6102	16	83	133
DH424115	11.5		.4528	12	71	118	DH424158	15.8		.6220	16	83	133
DH424029F	11.509	29/64	.4531	12	71	118	DH424040F	15.875	5/8	.6250	16	83	133
DH424116	11.6		.4567	12	71	118	DH424160	16.0		.6299	16	83	133
DH424117	11.7		.4606	12	71	118	DH424165	16.5		.6495	18	93	143
DH424118	11.8		.4646	12	71	118	DH424168	16.8		.6614	18	93	143
DH424119	11.9		.4685	12	71	118	DH424170	17.0		.6692	18	93	143
DH424030F	11.906	15/32	.4688	12	71	118	DH424175	17.5		.6889	18	93	143
DH424120	12.0		.4724	12	71	118	DH424178	17.8		.7008	18	93	143
DH424123	12.3		.4843	14	77	124	DH424180	18.0		.7087	18	93	143
DH424031F	12.303	31/64	.4844	14	77	124	DH424185	18.5		.7283	20	101	153
DH424125	12.5		.4921	14	77	124	DH424190	19.0		.7480	20	101	153
DH424032F	12.7	1/2	.5000	14	77	124	DH424048F	19.05	3/4	.7500	20	101	153
DH424128	12.8		.5039	14	77	124	DH424195	19.5		.7676	20	101	153
DH424130	13.0		.5118	14	77	124	DH424198	19.8		.7795	20	101	153
DH424135	13.5		.5315	14	77	124	DH424200	20.0		.7874	20	101	153
DH424138	13.8		.5433	14	77	124							

► Other shank types are available on your request

◎ : Excellent ○ : Good

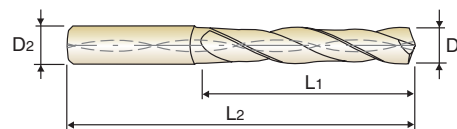
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



P.25

DREAM DRILLS | 3×D

Unit : Inch

Unit : Inch												
EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2	
* DH711008	1/8	.1250	3/16	1.102	2.992	DH711221	U	.3680	3/8	1.87	4.174	*
0081BTF	1/8	.1250	15/64	1.102	2.992	2211BTF	U	.3680	25/64	1.870	4.174	
* DH711011	11/64	.1719	3/16	1.417	3.386	DH711024	3/8	.3750	3/8	1.969	4.174	*
0111BTF	11/64	.1719	15/64	1.417	3.386	0241BTF	3/8	.3750	25/64	1.969	4.174	
* DH711012	3/16	.1875	3/16	1.575	3.543	0251BTF	25/64	.3906	25/64	1.969	4.174	
0121BTF	3/16	.1875	15/64	1.575	3.543	DH711025	25/64	.3906	7/16	1.969	4.174	*
0131BTF	13/64	.2031	15/64	1.082	3.228	0261BTF	13/32	.4062	27/64	2.067	4.567	
* DH711013	13/64	.2031	1/4	1.082	3.228	DH711026	13/32	.4062	7/16	2.067	4.567	*
0141BTF	7/32	.2188	15/64	1.181	3.228	0271BTF	27/64	.4219	27/64	2.165	4.567	
* DH711014	7/32	.2188	1/4	1.181	3.228	DH711027	27/64	.4219	7/16	2.165	4.567	*
0151BTF	15/64	.2344	15/64	1.181	3.228	DH711028	7/16	.4375	7/16	2.264	4.803	*
* DH711015	15/64	.2344	1/4	1.181	3.228	0281BTF	7/16	.4375	15/32	2.264	4.803	*
* DH711016	1/4	.2500	1/4	1.279	3.465	0291BTF	29/64	.4531	15/32	2.264	4.803	*
0161BTF	1/4	.2500	17/64	1.279	3.465	DH711029	29/64	.4531	1/2	2.264	4.803	*
2061BTF	F	.2570	17/64	1.279	3.465	0301BTF	15/32	.4688	15/32	2.362	4.803	
* DH711206	F	.2570	5/16	1.279	3.465	DH711030	15/32	.4688	1/2	2.362	4.803	*
0171BTF	17/64	.2656	17/64	1.378	3.465	0311BTF	31/64	.4844	1/2	2.461	5.039	
* DH711017	17/64	.2656	5/16	1.378	3.465	0321BTF	1/2	.5000	1/2	2.559	5.039	*
2091BTF	I	.2720	.2720	1.378	3.465	0331BTF	33/64	.5156	35/64	2.657	5.276	
* DH711209	I	.2720	5/16	1.378	3.465	DH711033	33/64	.5156	9/16	2.657	5.276	*
0181BTF	9/32	.2812	5/16	1.476	3.701	0341BTF	17/32	.5312	35/64	2.756	5.276	
0191BTF	19/64	.2969	5/16	1.476	3.701	DH711034	17/32	.5312	9/16	2.756	5.276	*
0201BTF	5/16	.3125	5/16	1.575	3.701	0351BTF	35/64	.5469	35/64	2.756	5.276	
0211BTF	21/64	.3281	11/32	1.673	3.937	DH711035	35/64	.5469	9/16	2.756	5.276	*
* DH711021	21/64	.3281	3/8	1.673	3.937	DH711036	9/16	.5625	9/16	2.854	5.512	*
2171BTF	Q	.3320	11/32	1.673	3.937	0361BTF	9/16	.5625	37/64	2.854	5.512	
* DH711217	Q	.3320	3/8	1.673	3.937	0371BTF	37/64	.5781	37/64	2.953	5.512	*
0221BTF	11/32	.3438	11/32	1.772	3.937	DH711037	37/64	.5781	5/8	2.953	5.512	*
* DH711022	11/32	.3438	3/8	1.772	3.937	0381BTF	19/32	.5937	5/8	3.051	5.709	*
* DH711023	23/64	.3594	3/8	1.87	4.174	0391BTF	39/64	.6094	5/8	3.051	5.709	*
0231BTF	23/64	.3594	25/64	1.870	4.174	0401BTF	5/8	.6250	5/8	3.150	5.709	

► Other shank types are available on your request

◎ : Excellent ○ : Good

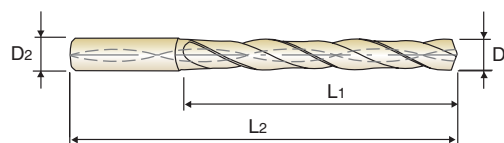
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



P.25

DREAM DRILLS | 5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2	
* 0131CTF	13/64	.2031	15/64	1-3/4	3-15/16	DH712022	11/32	.3438	3/8	2-27/32	5	*
* DH712013	13/64	.2031	1/4	1-3/4	3-15/16	DH712023	23/64	.3594	3/8	3	5-23/64	*
* 0141CTF	7/32	.2188	15/64	1-57/64	3-15/16	0231CTF	23/64	.3594	25/64	3	5-23/64	
* DH712014	7/32	.2188	1/4	1-57/64	3-15/16	DH712221	U	.3680	3/8	3	5-23/64	*
* 0151CTF	15/64	.2344	15/64	1-57/64	3-15/16	2211CTF	U	.3680	25/64	3	5-23/64	
* DH712015	15/64	.2344	1/4	1-57/64	3-15/16	DH712024	3/8	.3750	3/8	3-5/32	5-23/64	*
* DH712016	1/4	.2500	1/4	2-3/64	4-19/64	0241CTF	3/8	.3750	25/64	3-5/32	5-23/64	
* 0161CTF	1/4	.2500	17/64	2-3/64	4-19/64	0251CTF	25/64	.3906	25/64	3-5/32	5-23/64	
* 2061CTF	F	.2570	17/64	2-13/64	4-19/64	DH712025	25/64	.3906	7/16	3-5/32	5-23/64	*
* DH712206	F	.2570	5/16	2-13/64	4-19/64	0261CTF	13/32	.4062	27/64	3-5/16	5-7/8	
* 0171CTF	17/64	.2656	17/64	2-13/64	4-19/64	DH712026	13/32	.4062	7/16	3-5/16	5-7/8	*
* DH712017	17/64	.2656	5/16	2-13/64	4-19/64	0271CTF	27/64	.4219	27/64	3-15/32	5-7/8	
* 2091CTF	I	.2720	.2720	2-13/64	4-19/64	DH712027	27/64	.4219	7/16	3-15/32	5-7/8	*
* DH712209	I	.2720	5/16	2-13/64	4-19/64	DH712028	7/16	.4375	7/16	3-5/8	6-7/32	*
* 0181CTF	9/32	.2812	5/16	2-23/64	4-41/64	0281CTF	7/16	.4375	15/32	3-5/8	6-7/32	
* 0191CTF	19/64	.2969	5/16	2-33/64	4-41/64	0291CTF	29/64	.4531	15/32	3-25/32	6-7/32	
* 0201CTF	5/16	.3125	5/16	2-33/64	4-41/64	DH712029	29/64	.4531	1/2	3-25/32	6-7/32	*
* 0211CTF	21/64	.3281	11/32	2-43/64	5	0301CTF	15/32	.4688	15/32	3-25/32	6-7/32	
* DH712021	21/64	.3281	3/8	2-43/64	5	DH712030	15/32	.4688	1/2	3-25/32	6-7/32	*
* 2171CTF	Q	.3320	11/32	2-43/64	5	0311CTF	31/64	.4844	1/2	3-15/16	6-37/64	
* DH712217	Q	.3320	3/8	2-43/64	5	0321CTF	1/2	.5000	1/2	4-3/32	6-37/64	
* 0221CTF	11/32	.3438	11/32	2-27/32	5							

► Other shank types are available on your request

◎ : Excellent ○ : Good

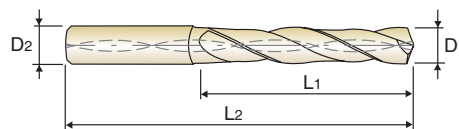
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
Excellent positioning
Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 3×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH406030	3.0		.1181	6	20	62	DH406015F	5.953	15/64	.2344	6	28	66
DH406031	3.1		.1220	6	20	62	DH406060	6.0		.2362	6	28	66
* DH406008F	3.175	1/8	.1250	6	20	62	DH406061	6.1		.2402	8	34	79
DH406032	3.2		.1260	6	20	62	DH406062	6.2		.2441	8	34	79
DH406033	3.3		.1299	6	20	62	DH406063	6.3		.2480	8	34	79
DH406034	3.4		.1339	6	20	62	DH406016F	6.35	1/4	.2500	8	34	79
DH406035	3.5		.1378	6	20	62	DH406064	6.4		.2520	8	34	79
* DH406009F	3.572	9/64	.1406	6	20	62	DH406065	6.5		.2559	8	34	79
DH406036	3.6		.1417	6	20	62	DH406066	6.6		.2598	8	34	79
DH406037	3.7		.1457	6	20	62	DH406067	6.7		.2638	8	34	79
DH406038	3.8		.1496	6	24	66	DH406017F	6.747	17/64	.2656	8	34	79
DH406039	3.9		.1535	6	24	66	DH406068	6.8		.2677	8	34	79
* DH406010F	3.969	5/32	.1563	6	24	66	DH406069	6.9		.2717	8	34	79
DH406040	4.0		.1575	6	24	66	DH406070	7.0		.2756	8	34	79
DH406041	4.1		.1614	6	24	66	DH406071	7.1		.2795	8	41	79
DH406042	4.2		.1654	6	24	66	DH406018F	7.144	9/32	.2812	8	41	79
DH406043	4.3		.1693	6	24	66	DH406072	7.2		.2835	8	41	79
* DH406011F	4.366	11/64	.1719	6	24	66	DH406073	7.3		.2874	8	41	79
DH406044	4.4		.1732	6	24	66	DH406074	7.4		.2913	8	41	79
DH406045	4.5		.1772	6	24	66	DH406075	7.5		.2953	8	41	79
DH406046	4.6		.1811	6	24	66	DH406019F	7.541	19/64	.2969	8	41	79
DH406047	4.7		.1850	6	24	66	DH406076	7.6		.2992	8	41	79
* DH406012F	4.763	3/16	.1875	6	24	66	DH406077	7.7		.3031	8	41	79
DH406048	4.8		.1890	6	28	66	DH406078	7.8		.3071	8	41	79
DH406049	4.9		.1929	6	28	66	DH406079	7.9		.3110	8	41	79
DH406050	5.0		.1969	6	28	66	DH406020F	7.938	5/16	.3125	8	41	79
DH406051	5.1		.2008	6	28	66	DH406080	8.0		.3150	8	41	79
* DH406013F	5.159	13/64	.2031	6	28	66	DH406081	8.1		.3189	10	47	89
DH406052	5.2		.2047	6	28	66	DH406082	8.2		.3228	10	47	89
DH406053	5.3		.2087	6	28	66	DH406083	8.3		.3268	10	47	89
DH406054	5.4		.2126	6	28	66	DH406021F	8.334	21/64	.3281	10	47	89
DH406055	5.5		.2165	6	28	66	DH406084	8.4		.3307	10	47	89
* DH406014F	5.556	7/32	.2188	6	28	66	DH406085	8.5		.3346	10	47	89
DH406056	5.6		.2205	6	28	66	DH406086	8.6		.3386	10	47	89
DH406057	5.7		.2244	6	28	66	DH406087	8.7		.3425	10	47	89
DH406058	5.8		.2283	6	28	66	DH406022F	8.731	11/32	.3438	10	47	89
DH406059	5.9		.2323	6	28	66	DH406088	8.8		.3465	10	47	89

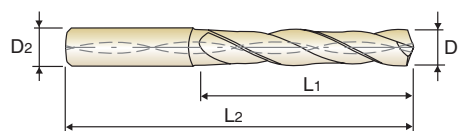
► NEXT PAGE



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 3×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH406089	8.9		.3504	10	47	89	DH406114	11.4		.4488	12	55	102
DH406090	9.0		.3543	10	47	89	DH406115	11.5		.4527	12	55	102
DH406091	9.1		.3583	10	47	89	DH406029F	11.509	29/64	.4531	12	55	102
* DH406023F	9.128	23/64	.3594	10	47	89	DH406116	11.6		.4566	12	55	102
DH406092	9.2		.3622	10	47	89	DH406117	11.7		.4606	12	55	102
DH406093	9.3		.3661	10	47	89	DH406118	11.8		.4645	12	55	102
DH406094	9.4		.3701	10	47	89	DH406119	11.9		.4685	12	55	102
DH406095	9.5		.3740	10	47	89	DH406030F	11.906	15/32	.4688	12	55	102
* DH406024F	9.525	3/8	.3750	10	47	89	DH406120	12.0		.4724	12	55	102
DH406096	9.6		.3780	10	47	89	DH406031F	12.303	31/64	.4844	14	60	107
DH406097	9.7		.3819	10	47	89	DH406125	12.5		.4921	14	60	107
DH406098	9.8		.3858	10	47	89	DH406032F	12.7	1/2	.5000	14	60	107
DH406099	9.9		.3898	10	47	89	DH406130	13.0		.5118	14	60	107
* DH406025F	9.922	25/64	.3906	10	47	89	DH406135	13.5		.5314	14	60	107
DH406100	10.0		.3937	10	47	89	DH406140	14.0		.5512	14	60	107
DH406101	10.1		.3976	12	55	102	DH406036F	14.288	9/16	.5625	16	65	115
DH406102	10.2		.4016	12	55	102	DH406145	14.5		.5708	16	65	115
DH406103	10.3		.4055	12	55	102	DH406150	15.0		.5905	16	65	115
* DH406026F	10.319	13/32	.4062	12	55	102	DH406155	15.5		.6102	16	65	115
DH406104	10.4		.4094	12	55	102	DH406040F	15.875	5/8	.6250	16	65	115
DH406105	10.5		.4134	12	55	102	DH406160	16.0		.6299	16	65	115
DH406106	10.6		.4173	12	55	102	DH406165	16.5		.6495	18	73	123
DH406107	10.7		.4212	12	55	102	DH406170	17.0		.6692	18	73	123
* DH406027F	10.716	27/64	.4219	12	55	102	DH406044F	17.463	11/16	.6875	18	73	123
DH406108	10.8		.4252	12	55	102	DH406175	17.5		.6889	18	73	123
DH406109	10.9		.4291	12	55	102	DH406180	18.0		.7087	18	73	123
DH406110	11.0		.4330	12	55	102	DH406185	18.5		.7283	20	79	131
DH406111	11.1		.4370	12	55	102	DH406190	19.0		.7480	20	79	131
* DH406028F	11.113	7/16	.4375	12	55	102	DH406048F	19.05	3/4	.7500	20	79	131
DH406112	11.2		.4409	12	55	102	DH406195	19.5		.7676	20	79	131
DH406113	11.3		.4448	12	55	102	DH406200	20.0		.7874	20	79	131

► Other shank types are available on your request

◎ : Excellent ○ : Good

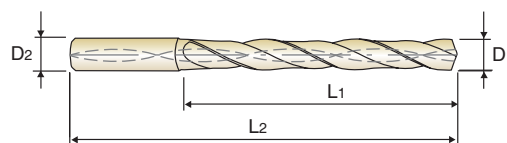
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
Excellent positioning
Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH408010	1.0		.0394	3	8	55	DH408009F	3.572	9/64	.1406	6	28	66
DH408011	1.1		.0433	3	12	55	DH408036	3.6		.1417	6	28	66
DH408012	1.2		.0472	3	12	55	DH408037	3.7		.1457	6	28	66
DH408013	1.3		.0512	3	12	55	DH408038	3.8		.1496	6	36	74
DH408014	1.4		.0551	3	12	55	DH408039	3.9		.1535	6	36	74
DH408015	1.5		.0591	3	16	55	DH408010F	3.969	5/32	.1563	6	36	74
* DH408004F	1.588	1/16	.0625	3	16	55	DH408040	4.0		.1575	6	36	74
DH408016	1.6		.0630	3	16	55	DH408041	4.1		.1614	6	36	74
DH408017	1.7		.0669	3	16	55	DH408042	4.2		.1654	6	36	74
DH408018	1.8		.0709	3	16	55	DH408043	4.3		.1693	6	36	74
DH408019	1.9		.0748	3	16	55	DH408011F	4.366	11/64	.1719	6	36	74
* DH408005F	1.984	5/64	.0781	3	16	55	DH408044	4.4		.1732	6	36	74
DH408020	2.0		.0787	4	21	57	DH408045	4.5		.1772	6	36	74
DH408021	2.1		.0827	4	21	57	DH408046	4.6		.1811	6	36	74
DH408022	2.2		.0866	4	21	57	DH408047	4.7		.1850	6	36	74
DH408023	2.3		.0906	4	21	57	DH408012F	4.763	3/16	.1875	6	36	74
* DH408006F	2.381	3/32	.0938	4	21	57	DH408048	4.8		.1890	6	44	82
DH408024	2.4		.0945	4	21	57	DH408049	4.9		.1929	6	44	82
DH408025	2.5		.0984	4	21	57	DH408050	5.0		.1969	6	44	82
DH408026	2.6		.1024	4	21	57	DH408051	5.1		.2008	6	44	82
DH408027	2.7		.1063	4	21	57	DH408013F	5.159	13/64	.2031	6	44	82
* DH408007F	2.778	7/64	.1094	4	21	57	DH408052	5.2		.2047	6	44	82
DH408028	2.8		.1102	4	21	57	DH408053	5.3		.2087	6	44	82
DH408029	2.9		.1142	4	21	57	DH408054	5.4		.2126	6	44	82
DH408030	3.0		.1181	6	28	66	DH408055	5.5		.2165	6	44	82
DH408031	3.1		.1220	6	28	66	DH408014F	5.556	7/32	.2188	6	44	82
* DH408008F	3.175	1/8	.1250	6	28	66	DH408056	5.6		.2205	6	44	82
DH408032	3.2		.1260	6	28	66	DH408057	5.7		.2244	6	44	82
DH408033	3.3		.1299	6	28	66	DH408058	5.8		.2283	6	44	82
DH408034	3.4		.1339	6	28	66	DH408059	5.9		.2323	6	44	82
DH408035	3.5		.1378	6	28	66	DH408015F	5.953	15/64	.2344	6	44	82

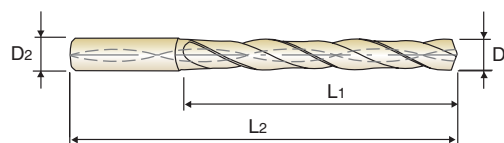
► NEXT PAGE



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5 × D

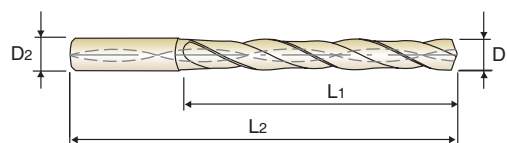
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH408060	6.0		.2362	6	44	82	DH408085	8.5		.3346	10	61	103
DH408061	6.1		.2402	8	53	91	DH408086	8.6		.3386	10	61	103
DH408062	6.2		.2441	8	53	91	DH408087	8.7		.3425	10	61	103
DH408063	6.3		.2480	8	53	91	DH408022F	8.731	11/32	.3438	10	61	103
* DH408016F	6.35	1/4	.2500	8	53	91	DH408088	8.8		.3465	10	61	103
DH408064	6.4		.2520	8	53	91	DH408089	8.9		.3504	10	61	103
DH408065	6.5		.2559	8	53	91	DH408090	9.0		.3543	10	61	103
DH408066	6.6		.2598	8	53	91	DH408091	9.1		.3583	10	61	103
DH408067	6.7		.2638	8	53	91	DH408023F	9.128	23/64	.3594	10	61	103
* DH408017F	6.747	17/64	.2656	8	53	91	DH408092	9.2		.3622	10	61	103
DH408068	6.8		.2677	8	53	91	DH408093	9.3		.3661	10	61	103
DH408069	6.9		.2717	8	53	91	DH408094	9.4		.3701	10	61	103
DH408070	7.0		.2756	8	53	91	DH408095	9.5		.3740	10	61	103
DH408071	7.1		.2795	8	53	91	DH408024F	9.525	3/8	.3750	10	61	103
* DH408018F	7.144	9/32	.2812	8	53	91	DH408096	9.6		.3780	10	61	103
DH408072	7.2		.2835	8	53	91	DH408097	9.7		.3819	10	61	103
DH408073	7.3		.2874	8	53	91	DH408098	9.8		.3858	10	61	103
DH408074	7.4		.2913	8	53	91	DH408099	9.9		.3898	10	61	103
DH408075	7.5		.2953	8	53	91	DH408025F	9.922	25/64	.3906	10	61	103
* DH408019F	7.541	19/64	.2969	8	53	91	DH408100	10.0		.3937	10	61	103
DH408076	7.6		.2992	8	53	91	DH408101	10.1		.3976	12	71	118
DH408077	7.7		.3031	8	53	91	DH408102	10.2		.4016	12	71	118
DH408078	7.8		.3071	8	53	91	DH408103	10.3		.4055	12	71	118
DH408079	7.9		.3110	8	53	91	DH408026F	10.319	13/32	.4062	12	71	118
* DH408020F	7.938	5/16	.3125	8	53	91	DH408104	10.4		.4094	12	71	118
DH408080	8.0		.3150	8	53	91	DH408105	10.5		.4134	12	71	118
DH408081	8.1		.3189	10	61	103	DH408106	10.6		.4173	12	71	118
DH408082	8.2		.3228	10	61	103	DH408107	10.7		.4212	12	71	118
DH408083	8.3		.3268	10	61	103	DH408027F	10.716	27/64	.4219	12	71	118
* DH408021F	8.334	21/64	.3281	10	61	103	DH408108	10.8		.4252	12	71	118
DH408084	8.4		.3307	10	61	103	DH408109	10.9		.4291	12	71	118

► NEXT PAGE

* **NEW SIZE****SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)**

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling

DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH408110	11.0		.4330	12	71	118	DH408135	13.5		.5314	14	77	124
DH408111	11.1		.4370	12	71	118	DH408140	14.0		.5512	14	77	124
* DH408028F	11.113	7/16	.4375	12	71	118	DH408036F	14.288	9/16	.5625	16	83	133
DH408112	11.2		.4409	12	71	118	DH408145	14.5		.5708	16	83	133
DH408113	11.3		.4448	12	71	118	DH408150	15.0		.5905	16	83	133
DH408114	11.4		.4488	12	71	118	DH408155	15.5		.6102	16	83	133
DH408115	11.5		.4527	12	71	118	DH408040F	15.875	5/8	.6250	16	83	133
* DH408029F	11.509	29/64	.4531	12	71	118	DH408160	16.0		.6299	16	83	133
DH408116	11.6		.4566	12	71	118	DH408165	16.5		.6495	18	93	143
DH408117	11.7		.4606	12	71	118	DH408170	17.0		.6692	18	93	143
DH408118	11.8		.4645	12	71	118	DH408175	17.5		.6889	18	93	143
DH408119	11.9		.4685	12	71	118	DH408180	18.0		.7087	18	93	143
* DH408030F	11.906	15/32	.4688	12	71	118	DH408185	18.5		.7283	20	101	153
DH408120	12.0		.4724	12	71	118	DH408190	19.0		.7480	20	101	153
* DH408031F	12.303	31/64	.4844	14	77	124	DH408048F	19.05	3/4	.7500	20	101	153
DH408125	12.5		.4921	14	77	124	DH408195	19.5		.7676	20	101	153
* DH408032F	12.7	1/2	.5000	14	77	124	DH408200	20.0		.7874	20	101	153
DH408130	13.0		.5118	14	77	124							

► Other shank types are available on your request

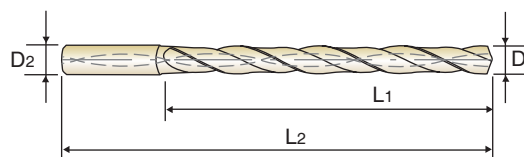
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
Excellent positioning
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- center drilling is not required
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 - reaming is not required
 - good chip removal
 - powerful drilling



DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 8×D

Unit : mm

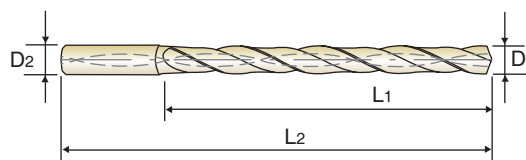
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH421030	3.0		.1181	6	34	72	DH421014F	5.556	7/32	.2188	6	57	95
DH421031	3.1		.1220	6	34	72	DH421056	5.6		.2205	6	57	95
DH421008F	3.175	1/8	.1250	6	34	72	DH421057	5.7		.2244	6	57	95
DH421032	3.2		.1260	6	34	72	DH421058	5.8		.2283	6	57	95
DH421033	3.3		.1299	6	34	72	DH421059	5.9		.2323	6	57	95
DH421034	3.4		.1339	6	34	72	DH421015F	5.953	15/64	.2344	6	57	95
DH421229G	3.450	#29	.1360	6	34	72	DH421060	6.0		.2362	6	57	95
DH421035	3.5		.1378	6	34	72	DH421061	6.1		.2402	8	76	114
DH421009F	3.572	9/64	.1406	6	34	72	DH421062	6.2		.2441	8	76	114
DH421036	3.6		.1417	6	34	72	DH421063	6.3		.2480	8	76	114
DH421037	3.7		.1457	6	34	72	DH421016F	6.350	1/4	.2500	8	76	114
DH421038	3.8		.1496	6	43	81	DH421064	6.4		.2520	8	76	114
DH421039	3.9		.1535	6	43	81	DH421065	6.5		.2559	8	76	114
DH421010F	3.969	5/32	.1563	6	43	81	DH421106L	6.53	F	.2570	8	76	114
DH421040	4.0		.1575	6	43	81	DH421066	6.6		.2598	8	76	114
DH421221G	4.040	#21	.1590	6	43	81	DH421067	6.7		.2638	8	76	114
DH421041	4.1		.1614	6	43	81	DH421017F	6.747	17/64	.2656	8	76	114
DH421042	4.2		.1654	6	43	81	DH421068	6.8		.2677	8	76	114
DH421043	4.3		.1693	6	43	81	DH421069	6.9		.2717	8	76	114
DH421011F	4.366	11/64	.1719	6	43	81	DH421070	7.0		.2756	8	76	114
DH421044	4.4		.1732	6	43	81	DH421071	7.1		.2795	8	76	114
DH421045	4.5		.1772	6	43	81	DH421018F	7.144	9/32	.2813	8	76	114
DH421046	4.6		.1811	6	43	81	DH421072	7.2		.2835	8	76	114
DH421047	4.7		.1850	6	43	81	DH421073	7.3		.2874	8	76	114
DH421012F	4.763	3/16	.1875	6	57	95	DH421074	7.4		.2913	8	76	114
DH421048	4.8		.1890	6	57	95	DH421075	7.5		.2953	8	76	114
DH421049	4.9		.1929	6	57	95	DH421019F	7.541	19/64	.2969	8	76	114
DH421050	5.0		.1969	6	57	95	DH421076	7.6		.2992	8	76	114
DH421051	5.1		.2008	6	57	95	DH421077	7.7		.3031	8	76	114
DH421013F	5.159	13/64	.2031	6	57	95	DH421078	7.8		.3071	8	76	114
DH421052	5.2		.2047	6	57	95	DH421079	7.9		.3110	8	76	114
DH421053	5.3		.2087	6	57	95	DH421020F	7.938	5/16	.3125	8	76	114
DH421054	5.4		.2126	6	57	95	DH421080	8.0		.3150	8	76	114
DH421055	5.5		.2165	6	57	95	DH421081	8.1		.3189	10	95	142

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- Advantage : Self centering
 Excellent positioning
 Special Design
- center drilling is not required
 - bushing is not necessary
 - reaming is not required
 - good chip removal
 - powerful drilling



DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH421082	8.2		.3228	10	95	142	DH421026F	10.319	13/32	.4063	12	114	162
DH421083	8.3		.3268	10	95	142	DH421104	10.4		.4094	12	114	162
DH421021F	8.334	21/64	.3281	10	95	142	DH421105	10.5		.4134	12	114	162
DH421084	8.4		.3307	10	95	142	DH421106	10.6		.4173	12	114	162
DH421117L	8.430	Q	.3320	10	95	142	DH421107	10.7		.4212	12	114	162
DH421085	8.5		.3346	10	95	142	DH421027F	10.716	27/64	.4219	12	114	162
DH421086	8.6		.3386	10	95	142	DH421108	10.8		.4252	12	114	162
DH421087	8.7		.3425	10	95	142	DH421109	10.9		.4291	12	114	162
DH421022F	8.731	11/32	.3438	10	95	142	DH421110	11.0		.4330	12	114	162
DH421088	8.8		.3465	10	95	142	DH421111	11.1		.4370	12	114	162
DH421089	8.9		.3504	10	95	142	DH421028F	11.113	7/16	.4375	12	114	162
DH421090	9.0		.3543	10	95	142	DH421112	11.2		.4409	12	114	162
DH421091	9.1		.3583	10	95	142	DH421113	11.3		.4448	12	114	162
DH421023F	9.128	23/64	.3594	10	95	142	DH421114	11.4		.4488	12	114	162
DH421092	9.2		.3622	10	95	142	DH421115	11.5		.4527	12	114	162
DH421093	9.3		.3661	10	95	142	DH421116	11.6		.4566	12	114	162
DH421121L	9.350	U	.3680	10	95	142	DH421117	11.7		.4606	12	114	162
DH421094	9.4		.3701	10	95	142	DH421118	11.8		.4645	12	114	162
DH421095	9.5		.3740	10	95	142	DH421119	11.9		.4685	12	114	162
DH421024F	9.525	3/8	.3750	10	95	142	DH421030F	11.906	15/32	.4688	12	114	162
DH421096	9.6		.3780	10	95	142	DH421120	12.0		.4724	12	114	162
DH421097	9.7		.3819	10	95	142	DH421031F	12.303	31/64	.4844	14	133	178
DH421098	9.8		.3858	10	95	142	DH421125	12.5		.4921	14	133	178
DH421099	9.9		.3898	10	95	142	DH421032F	12.700	1/2	.5000	14	133	178
DH421025F	9.922	25/64	.3906	10	95	142	DH421130	13.0		.5118	14	133	178
DH421100	10.0		.3937	10	95	142	DH421033F	13.097	33/64	.5156	14	133	178
DH421101	10.1		.3976	12	114	162	DH421135	13.5		.5314	14	133	178
DH421102	10.2		.4016	12	114	162	DH421140	14.0		.5512	14	133	178
DH421103	10.3		.4055	12	114	162							

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



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

DH414, DH722 Series

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRc24		> HRc24		< HRc30		HRc30 - 42	
DRILLING SPEED(SFM)				400 ~ 650 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min		210 ~ 350 ft/min	
DIAMETER				N	IPR	N	IPR	N	IPR	N	IPR
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	13120	.006	8750	.005	7880	.005	7000	.005
3/16	5/16	4.763	7.938	8200	.008	5470	.006	4920	.006	4370	.006
5/16	3/8	7.938	9.525	5970	.011	3980	.009	3560	.009	3190	.009
3/8	1/2	9.525	12.700	4690	.014	3120	.011	2810	.011	2500	.011
1/2	9/16	12.700	14.288	3860	.016	2570	.012	2310	.012	2060	.012
9/16	13/16	14.288	20.638	2980	.018	1990	.014	1790	.014	1590	.014

► Recommend to reduce the feed rate as following

DH414(3xD) : Feed 100%

DH722(5xD) : Feed 85%

N = R.P.M

IPR = feed rate(inch/rev.)

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH416, DH418, DH711, DH712 Series

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRc24		> HRc24		< HB240, GG25		< HB300, GG40	
DRILLING SPEED(SFM)				480 ~ 730 ft/min		310 ~ 490 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min	
DIAMETER				N	IPR	N	IPR	N	IPR	N	IPR
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	14870	.006	9620	.006	8750	.006	7880	.005
3/16	5/16	4.763	7.938	8200	.008	6010	.008	5470	.008	4920	.006
5/16	3/8	7.938	9.525	6760	.011	4370	.011	3980	.011	3580	.009
3/8	1/2	9.525	12.700	5310	.014	3440	.014	3120	.014	2810	.011
1/2	9/16	12.700	14.288	4370	.016	2830	.016	2570	.016	2310	.012
9/16	13/16	14.288	20.638	3380	.018	2190	.018	1990	.018	1790	.014

► Recommend to reduce the feed rate as following

DH416/DH711(3xD) : Feed 100%

DH418/DH712(5xD) : Feed 85%

N = R.P.M

IPR= feed rate (Inch/rev.)



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

DH404, DH423, DH424 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED(SFM)		130 ~ 400 ft/min			115 ~ 340 ft/min			220 ~ 650 ft/min			150 ~ 430 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	13000	0.04	.002	11250	0.04	.002	21300	0.04	.002	14200	0.04	.002
2.0	.0787	13000	0.06	.002	11250	0.06	.002	21300	0.06	.002	14200	0.06	.002
3.0	.1181	13000	0.13	.005	11000	0.13	.005	21000	0.13	.005	14000	0.13	.005
4.0	.1575	9500	0.14	.006	8400	0.14	.006	16000	0.14	.006	10500	0.14	.006
5.0	.1969	7600	0.15	.006	6700	0.15	.006	13000	0.15	.006	8300	0.15	.006
6.0	.2362	6400	0.17	.007	5600	0.17	.007	11000	0.17	.007	6900	0.17	.007
7.0	.2756	5500	0.19	.007	4800	0.19	.007	9100	0.19	.007	5900	0.19	.007
8.0	.3150	4800	0.21	.008	4200	0.21	.008	8000	0.21	.008	5200	0.21	.008
9.0	.3543	4200	0.23	.009	3700	0.23	.009	7100	0.23	.009	4600	0.23	.009
10.0	.3937	3800	0.25	.010	3350	0.25	.010	6400	0.25	.010	4150	0.25	.010
12.0	.4724	3200	0.27	.011	2800	0.27	.011	5300	0.27	.011	3450	0.27	.011
14.0	.5512	2750	0.29	.011	2400	0.29	.011	4550	0.29	.011	3000	0.29	.011
16.0	.6299	2400	0.31	.012	2100	0.31	.012	4000	0.31	.012	2600	0.31	.012
18.0	.7087	2100	0.33	.013	1850	0.33	.013	3550	0.33	.013	2300	0.33	.013
20.0	.7874	1900	0.35	.014	1650	0.35	.014	3200	0.35	.014	2100	0.35	.014

► Recommend to reduce the feed rate as following

DH404(3xD), DH423(3xD) : Feed 100%

DH424(5xD) : Feed 85%

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH406, DH408, DH421 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED		160 ~ 490 ft/min			150 ~ 440 ft/min			270 ~ 820 ft/min			170 ~ 530 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	16250	0.05	.002	14800	0.05	.002	26600	0.05	.002	17300	0.05	.002
2.0	.0787	16250	0.07	.003	14800	0.07	.003	26600	0.07	.003	17300	0.07	.003
3.0	.1181	16000	0.16	.006	14500	0.16	.006	26000	0.16	.006	17000	0.16	.006
4.0	.1575	12000	0.17	.007	11000	0.17	.007	20000	0.17	.007	13000	0.17	.007
5.0	.1969	9550	0.18	.007	8600	0.18	.007	16000	0.18	.007	10000	0.18	.007
6.0	.2362	8000	0.20	.008	7200	0.20	.008	13000	0.20	.008	8500	0.20	.008
7.0	.2756	6800	0.22	.009	6100	0.22	.009	11500	0.22	.009	7300	0.22	.009
8.0	.3150	6000	0.24	.009	5400	0.24	.009	9900	0.24	.009	6400	0.24	.009
9.0	.3543	5300	0.27	.011	4800	0.27	.011	8800	0.27	.011	5700	0.27	.011
10.0	.3937	4800	0.30	.012	4300	0.30	.012	8000	0.30	.012	5100	0.30	.012
12.0	.4724	4000	0.33	.013	3600	0.33	.013	6600	0.33	.013	4250	0.33	.013
14.0	.5512	3400	0.36	.014	3050	0.36	.014	5700	0.36	.014	3650	0.36	.014
16.0	.6299	3000	0.39	.015	2700	0.39	.015	5000	0.39	.015	3200	0.39	.015
18.0	.7087	2650	0.42	.017	2400	0.42	.017	4400	0.42	.017	2850	0.42	.017
20.0	.7874	2400	0.45	.018	2150	0.45	.018	4000	0.45	.018	2550	0.45	.018

► Recommend to reduce the feed rate as following

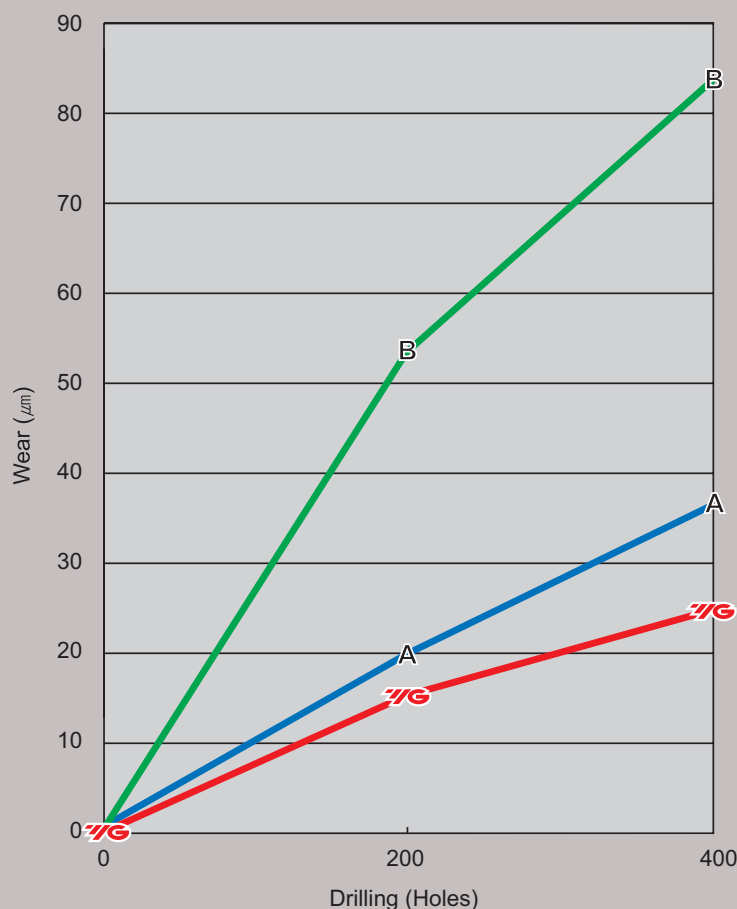
DH406(3xD) : Feed 100%, DH408(5xD) : Feed 85%

DH421(8xD) : Feed 70%

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

SOLID CARBIDE DREAM DRILLS INOX - **Test Report**

with COOLANT HOLES



 YG-1
 Competitor A
 Competitor B

Cutting Condition

Tools : DH452060(DREAM DRILL-INOX)

Size : Ø6 x Ø6 x 44 x 82

Work Material : • JIS:SUS304

• DIN:X5CrNi1810

(X4CrNi18-10)

• WR:1.4301

R.P.M : 3700 rev./min.

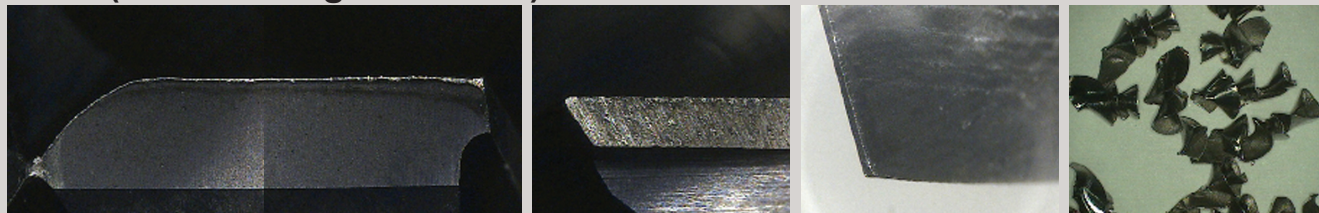
SFM : 229 ft/min.

Feed : .0028 inch/rev.

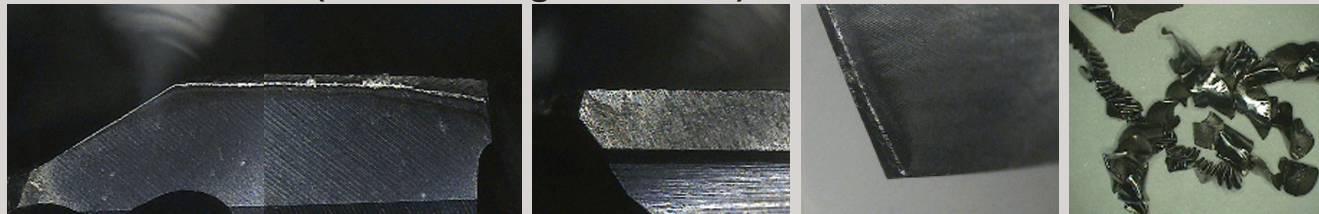
Drilling Depth : .94"

Coolant : Wet Cut

YG-1 (Total Drilling 400 Holes)



COMPETITOR A (Total Drilling 400 Holes)

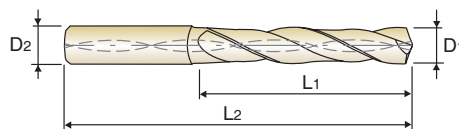


COMPETITOR B (Total Drilling 400 Holes)



*** NEW SIZE****SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES**

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005

► FOR STAINLESS STEEL

P.38

DREAM DRILLS INOX | 3 × D

Unit : Inch

Unit : Inch												
EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
TiAlN	D1		D2	L1	L2	TiAlN	D1		D2	L1	L2	
* DH714008	1/8	.1250	3/16	1.102	2.992	DH714221	U	.3680	3/8	1.87	4.174	*
DH463008	1/8	.1250	15/64	1.102	2.992	DH463221	U	.3680	25/64	1.870	4.174	*
* DH714011	11/64	.1719	3/16	1.417	3.386	DH714024	3/8	.3750	3/8	1.969	4.174	*
DH463011	11/64	.1719	15/64	1.417	3.386	DH463024	3/8	.3750	25/64	1.969	4.174	*
* DH714012	3/16	.1875	3/16	1.575	3.543	DH463025	25/64	.3906	25/64	1.969	4.174	*
DH463012	3/16	.1875	15/64	1.575	3.543	DH714025	25/64	.3906	7/16	1.969	4.174	*
DH463013	13/64	.2031	15/64	1.082	3.228	DH463026	13/32	.4062	27/64	2.067	4.567	*
* DH714013	13/64	.2031	1/4	1.082	3.228	DH714026	13/32	.4062	7/16	2.067	4.567	*
DH463014	7/32	.2188	15/64	1.181	3.228	DH463027	27/64	.4219	27/64	2.165	4.567	*
* DH714014	7/32	.2188	1/4	1.181	3.228	DH714027	27/64	.4219	7/16	2.165	4.567	*
DH463015	15/64	.2344	15/64	1.181	3.228	DH714028	7/16	.4375	7/16	2.264	4.803	*
* DH714015	15/64	.2344	1/4	1.181	3.228	DH463028	7/16	.4375	15/32	2.264	4.803	*
* DH714016	1/4	.2500	1/4	1.279	3.465	DH463029	29/64	.4531	15/32	2.264	4.803	*
DH463016	1/4	.2500	17/64	1.279	3.465	DH714029	29/64	.4531	1/2	2.264	4.803	*
DH463206	F	.2570	17/64	1.279	3.465	DH463030	15/32	.4688	15/32	2.362	4.803	*
* DH714206	F	.2570	5/16	1.279	3.465	DH714030	15/32	.4688	1/2	2.362	4.803	*
DH463017	17/64	.2656	17/64	1.378	3.465	DH463031	31/64	.4844	1/2	2.461	5.039	*
* DH714017	17/64	.2656	5/16	1.378	3.465	DH463032	1/2	.5000	1/2	2.559	5.039	*
DH463209	I	.2720	.2720	1.378	3.465	DH463033	33/64	.5156	35/64	2.657	5.276	*
* DH714209	I	.2720	5/16	1.378	3.465	DH714033	33/64	.5156	9/16	2.657	5.276	*
DH463018	9/32	.2812	5/16	1.476	3.701	DH463034	17/32	.5312	35/64	2.756	5.276	*
DH463019	19/64	.2969	5/16	1.476	3.701	DH714034	17/32	.5312	9/16	2.756	5.276	*
DH463020	5/16	.3125	5/16	1.575	3.701	DH463035	35/64	.5469	35/64	2.756	5.276	*
DH463021	21/64	.3281	11/32	1.673	3.937	DH714035	35/64	.5469	9/16	2.756	5.276	*
* DH714021	21/64	.3281	3/8	1.673	3.937	DH714036	9/16	.5625	9/16	2.854	5.512	*
DH463217	Q	.3320	11/32	1.673	3.937	DH463036	9/16	.5625	37/64	2.854	5.512	*
* DH714217	Q	.3320	3/8	1.673	3.937	DH463037	37/64	.5781	37/64	2.953	5.512	*
DH463022	11/32	.3438	11/32	1.772	3.937	DH714037	37/64	.5781	5/8	2.953	5.512	*
* DH714022	11/32	.3438	3/8	1.772	3.937	DH463038	19/32	.5937	5/8	3.051	5.709	*
* DH714023	23/64	.3594	3/8	1.87	4.174	DH463039	39/64	.6094	5/8	3.051	5.709	*
DH463023	23/64	.3594	25/64	1.870	4.174	DH463040	5/8	.6250	5/8	3.150	5.709	*

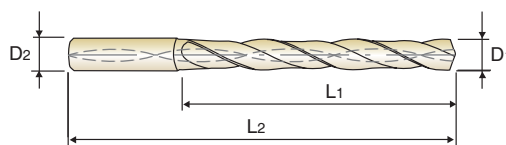
► Other shank types are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○	◎	○	○		

*** NEW SIZE****SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES**

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005

► FOR STAINLESS STEEL

P.38

DREAM DRILLS INOX | 5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
TiAlN	D1		D2	L1	L2	TiAlN	D1		D2	L1	L2	
DH464013	13/64	.2031	15/64	1-3/4	3-15/16	DH715022	11/32	.3438	3/8	2-27/32	5	*
* DH715013	13/64	.2031	1/4	1-3/4	3-15/16	DH715023	23/64	.3594	3/8	3	5-23/64	*
DH464014	7/32	.2188	15/64	1-57/64	3-15/16	DH464023	23/64	.3594	25/64	3	5-23/64	
* DH715014	7/32	.2188	1/4	1-57/64	3-15/16	DH715221	U	.3680	3/8	3	5-23/64	*
DH464015	15/64	.2344	15/64	1-57/64	3-15/16	DH464221	U	.3680	25/64	3	5-23/64	
* DH715015	15/64	.2344	1/4	1-57/64	3-15/16	DH715024	3/8	.3750	3/8	3-5/32	5-23/64	*
* DH715016	1/4	.2500	1/4	2-3/64	4-19/64	DH464024	3/8	.3750	25/64	3-5/32	5-23/64	
DH464016	1/4	.2500	17/64	2-3/64	4-19/64	DH464025	25/64	.3906	25/64	3-5/32	5-23/64	
DH464206	F	.2570	17/64	2-13/64	4-19/64	DH715025	25/64	.3906	7/16	3-5/32	5-23/64	*
* DH715206	F	.2570	5/16	2-13/64	4-19/64	DH464026	13/32	.4062	27/64	3-5/16	5-7/8	
DH464017	17/64	.2656	17/64	2-13/64	4-19/64	DH715026	13/32	.4062	7/16	3-5/16	5-7/8	*
* DH715017	17/64	.2656	5/16	2-13/64	4-19/64	DH464027	27/64	.4219	27/64	3-15/32	5-7/8	
DH464209	I	.2720	.2720	2-13/64	4-19/64	DH715027	27/64	.4219	7/16	3-15/32	5-7/8	*
* DH715209	I	.2720	5/16	2-13/64	4-19/64	DH715028	7/16	.4375	7/16	3-5/8	6-7/32	*
DH464018	9/32	.2812	5/16	2-23/64	4-41/64	DH464028	7/16	.4375	15/32	3-5/8	6-7/32	
DH464019	19/64	.2969	5/16	2-33/64	4-41/64	DH464029	29/64	.4531	15/32	3-25/32	6-7/32	
DH464020	5/16	.3125	5/16	2-33/64	4-41/64	DH715029	29/64	.4531	1/2	3-25/32	6-7/32	*
DH464021	21/64	.3281	11/32	2-43/64	5	DH464030	15/32	.4688	15/32	3-25/32	6-7/32	
* DH715021	21/64	.3281	3/8	2-43/64	5	DH715030	15/32	.4688	1/2	3-25/32	6-7/32	*
DH464217	Q	.3320	11/32	2-43/64	5	DH464031	31/64	.4844	1/2	3-15/16	6-37/64	
* DH715217	Q	.3320	3/8	2-43/64	5	DH464032	1/2	.5000	1/2	4-3/32	6-37/64	
DH464022	11/32	.3438	11/32	2-27/32	5							

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

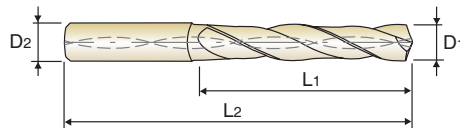


*** NEW SIZE**

SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life
- Tolerance : Dia. Tolerance ØD1:m7, Shank Tolerance ØD2: h6

► **FOR STAINLESS STEEL**



DIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 3 × D

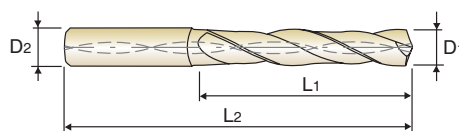
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH451030	3.0		.1181	6	20	62	DH451054	5.4		.2126	6	28	66
DH451031	3.1		.1220	6	20	62	DH451055	5.5		.2165	6	28	66
* DH451008F	3.175	1/8	.1250	6	20	62	DH451014F	5.556	7/32	.2188	6	28	66
DH451032	3.2		.1260	6	20	62	DH451056	5.6		.2205	6	28	66
DH451033	3.3		.1299	6	20	62	DH451057	5.7		.2244	6	28	66
DH451034	3.4		.1339	6	20	62	DH451058	5.8		.2283	6	28	66
DH451035	3.5		.1378	6	20	62	DH451059	5.9		.2323	6	28	66
* DH451009F	3.572	9/64	.1406	6	20	62	DH451015F	5.953	15/64	.2344	6	28	66
DH451036	3.6		.1417	6	20	62	DH451060	6.0		.2362	6	28	66
DH451037	3.7		.1457	6	20	62	DH451061	6.1		.2402	8	34	79
DH451038	3.8		.1496	6	24	66	DH451062	6.2		.2441	8	34	79
DH451039	3.9		.1535	6	24	66	DH451063	6.3		.2480	8	34	79
* DH451010F	3.969	5/32	.1563	6	24	66	DH451016F	6.35	1/4	.2500	8	34	79
DH451040	4.0		.1575	6	24	66	DH451064	6.4		.2520	8	34	79
DH451041	4.1		.1614	6	24	66	DH451065	6.5		.2559	8	34	79
DH451042	4.2		.1654	6	24	66	DH451066	6.6		.2598	8	34	79
DH451043	4.3		.1693	6	24	66	DH451067	6.7		.2638	8	34	79
* DH451011F	4.366	11/64	.1719	6	24	66	DH451017F	6.747	17/64	.2656	8	34	79
DH451044	4.4		.1732	6	24	66	DH451068	6.8		.2677	8	34	79
DH451045	4.5		.1772	6	24	66	DH451069	6.9		.2717	8	34	79
DH451046	4.6		.1811	6	24	66	DH451070	7.0		.2756	8	34	79
DH451047	4.7		.1850	6	24	66	DH451071	7.1		.2795	8	41	79
* DH451012F	4.763	3/16	.1875	6	24	66	DH451018F	7.144	9/32	.2812	8	41	79
DH451048	4.8		.1890	6	28	66	DH451072	7.2		.2835	8	41	79
DH451049	4.9		.1929	6	28	66	DH451073	7.3		.2874	8	41	79
DH451050	5.0		.1969	6	28	66	DH451074	7.4		.2913	8	41	79
DH451051	5.1		.2008	6	28	66	DH451075	7.5		.2953	8	41	79
* DH451013F	5.159	13/64	.2031	6	28	66	DH451019F	7.541	19/64	.2969	8	41	79
DH451052	5.2		.2047	6	28	66	DH451076	7.6		.2992	8	41	79
DH451053	5.3		.2087	6	28	66	DH451077	7.7		.3031	8	41	79

► NEXT PAGE

*** NEW SIZE****SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES**

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- ▶ Tolerance : Dia. Tolerance ØD1:m7, Shank Tolerance ØD2: h6

▶ FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 3 × D

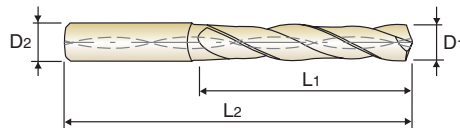
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH451078	7.8		.3071	8	41	79	DH451102	10.2		.4016	12	55	102
DH451079	7.9		.3110	8	41	79	DH451103	10.3		.4055	12	55	102
* DH451020F	7.938	5/16	.3125	8	41	79	DH451026F	10.319	13/32	.4062	12	55	102
DH451080	8.0		.3150	8	41	79	DH451104	10.4		.4094	12	55	102
DH451081	8.1		.3189	10	47	89	DH451105	10.5		.4134	12	55	102
DH451082	8.2		.3228	10	47	89	DH451106	10.6		.4173	12	55	102
DH451083	8.3		.3268	10	47	89	DH451107	10.7		.4212	12	55	102
* DH451021F	8.334	21/64	.3281	10	47	89	DH451027F	10.716	27/64	.4219	12	55	102
DH451084	8.4		.3307	10	47	89	DH451108	10.8		.4252	12	55	102
DH451085	8.5		.3346	10	47	89	DH451109	10.9		.4291	12	55	102
DH451086	8.6		.3386	10	47	89	DH451110	11.0		.4330	12	55	102
DH451087	8.7		.3425	10	47	89	DH451111	11.1		.4370	12	55	102
* DH451022F	8.731	11/32	.3438	10	47	89	DH451028F	11.113	7/16	.4375	12	55	102
DH451088	8.8		.3465	10	47	89	DH451112	11.2		.4409	12	55	102
DH451089	8.9		.3504	10	47	89	DH451113	11.3		.4448	12	55	102
DH451090	9.0		.3543	10	47	89	DH451114	11.4		.4488	12	55	102
DH451091	9.1		.3583	10	47	89	DH451115	11.5		.4527	12	55	102
* DH451023F	9.128	23/64	.3594	10	47	89	DH451029F	11.509	29/64	.4531	12	55	102
DH451092	9.2		.3622	10	47	89	DH451116	11.6		.4566	12	55	102
DH451093	9.3		.3661	10	47	89	DH451117	11.7		.4606	12	55	102
DH451094	9.4		.3701	10	47	89	DH451118	11.8		.4645	12	55	102
DH451095	9.5		.3740	10	47	89	DH451119	11.9		.4685	12	55	102
* DH451024F	9.525	3/8	.3750	10	47	89	DH451030F	11.906	15/32	.4688	12	55	102
DH451096	9.6		.3780	10	47	89	DH451120	12.0		.4724	12	55	102
DH451097	9.7		.3819	10	47	89	DH451031F	12.303	31/64	.4844	14	60	107
DH451098	9.8		.3858	10	47	89	DH451125	12.5		.4921	14	60	107
DH451099	9.9		.3898	10	47	89	DH451032F	12.7	1/2	.5000	14	60	107
* DH451025F	9.922	25/64	.3906	10	47	89	DH451130	13.0		.5118	14	60	107
DH451100	10.0		.3937	10	47	89	DH451135	13.5		.5314	14	60	107
DH451101	10.1		.3976	12	55	102	DH451140	14.0		.5512	14	60	107

▶ NEXT PAGE

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► FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
* DH451036F	14.288	9/16	.5625	16	65	115	DH451044F	17.463	11/16	.6875	18	73	123
DH451145	14.5		.5708	16	65	115	DH451175	17.5		.6889	18	73	123
DH451150	15.0		.5905	16	65	115	DH451180	18.0		.7087	18	73	123
DH451155	15.5		.6102	16	65	115	DH451185	18.5		.7283	20	79	131
* DH451040F	15.875	5/8	.6250	16	65	115	DH451190	19.0		.7480	20	79	131
DH451160	16.0		.6299	16	65	115	DH451048F	19.05	3/4	.7500	20	79	131
DH451165	16.5		.6495	18	73	123	DH451195	19.5		.7676	20	79	131
DH451170	17.0		.6692	18	73	123	DH451200	20.0		.7874	20	79	131

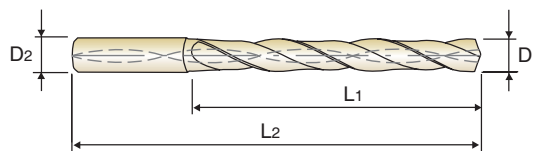
► Other shank types are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		

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► FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × D

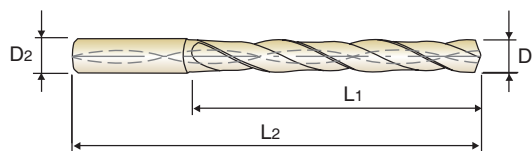
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH452010	1.0		.0394	3	8	55	DH452009F	3.572	9/64	.1406	6	28	66
DH452011	1.1		.0433	3	12	55	DH452036	3.6		.1417	6	28	66
DH452012	1.2		.0472	3	12	55	DH452037	3.7		.1457	6	28	66
DH452013	1.3		.0512	3	12	55	DH452038	3.8		.1496	6	36	74
DH452014	1.4		.0551	3	12	55	DH452039	3.9		.1535	6	36	74
DH452015	1.5		.0591	3	16	55	DH452010F	3.969	5/32	.1563	6	36	74
* DH452004F	1.588	1/16	.0625	3	16	55	DH452040	4.0		.1575	6	36	74
DH452016	1.6		.0630	3	16	55	DH452041	4.1		.1614	6	36	74
DH452017	1.7		.0669	3	16	55	DH452042	4.2		.1654	6	36	74
DH452018	1.8		.0709	3	16	55	DH452043	4.3		.1693	6	36	74
DH452019	1.9		.0748	3	16	55	DH452011F	4.366	11/64	.1719	6	36	74
* DH452005F	1.984	5/64	.0781	3	16	55	DH452044	4.4		.1732	6	36	74
DH452020	2.0		.0787	4	21	57	DH452045	4.5		.1772	6	36	74
DH452021	2.1		.0827	4	21	57	DH452046	4.6		.1811	6	36	74
DH452022	2.2		.0866	4	21	57	DH452047	4.7		.1850	6	36	74
DH452023	2.3		.0906	4	21	57	DH452012F	4.763	3/16	.1875	6	36	74
* DH452006F	2.381	3/32	.0938	4	21	57	DH452048	4.8		.1890	6	44	82
DH452024	2.4		.0945	4	21	57	DH452049	4.9		.1929	6	44	82
DH452025	2.5		.0984	4	21	57	DH452050	5.0		.1969	6	44	82
DH452026	2.6		.1024	4	21	57	DH452051	5.1		.2008	6	44	82
DH452027	2.7		.1063	4	21	57	DH452013F	5.159	13/64	.2031	6	44	82
* DH452007F	2.778	7/64	.1094	4	21	57	DH452052	5.2		.2047	6	44	82
DH452028	2.8		.1102	4	21	57	DH452053	5.3		.2087	6	44	82
DH452029	2.9		.1142	4	21	57	DH452054	5.4		.2126	6	44	82
DH452030	3.0		.1181	6	28	66	DH452055	5.5		.2165	6	44	82
DH452031	3.1		.1220	6	28	66	DH452014F	5.556	7/32	.2188	6	44	82
* DH452008F	3.175	1/8	.1250	6	28	66	DH452056	5.6		.2205	6	44	82
DH452032	3.2		.1260	6	28	66	DH452057	5.7		.2244	6	44	82
DH452033	3.3		.1299	6	28	66	DH452058	5.8		.2283	6	44	82
DH452034	3.4		.1339	6	28	66	DH452059	5.9		.2323	6	44	82
DH452035	3.5		.1378	6	28	66	DH452015F	5.953	15/64	.2344	6	44	82

► NEXT PAGE

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► FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × D

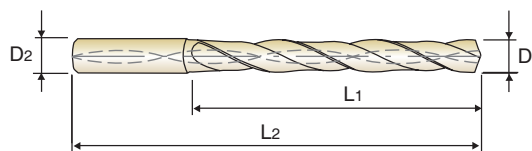
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH452060	6.0		.2362	6	44	82	DH452085	8.5		.3346	10	61	103
DH452061	6.1		.2402	8	53	91	DH452086	8.6		.3386	10	61	103
DH452062	6.2		.2441	8	53	91	DH452087	8.7		.3425	10	61	103
DH452063	6.3		.2480	8	53	91	DH452022F	8.731	11/32	.3438	10	61	103
* DH452016F	6.35	1/4	.2500	8	53	91	DH452088	8.8		.3465	10	61	103
DH452064	6.4		.2520	8	53	91	DH452089	8.9		.3504	10	61	103
DH452065	6.5		.2559	8	53	91	DH452090	9.0		.3543	10	61	103
DH452066	6.6		.2598	8	53	91	DH452091	9.1		.3583	10	61	103
DH452067	6.7		.2638	8	53	91	DH452023F	9.128	23/64	.3594	10	61	103
* DH452017F	6.747	17/64	.2656	8	53	91	DH452092	9.2		.3622	10	61	103
DH452068	6.8		.2677	8	53	91	DH452093	9.3		.3661	10	61	103
DH452069	6.9		.2717	8	53	91	DH452094	9.4		.3701	10	61	103
DH452070	7.0		.2756	8	53	91	DH452095	9.5		.3740	10	61	103
DH452071	7.1		.2795	8	53	91	DH452024F	9.525	3/8	.3750	10	61	103
* DH452018F	7.144	9/32	.2812	8	53	91	DH452096	9.6		.3780	10	61	103
DH452072	7.2		.2835	8	53	91	DH452097	9.7		.3819	10	61	103
DH452073	7.3		.2874	8	53	91	DH452098	9.8		.3858	10	61	103
DH452074	7.4		.2913	8	53	91	DH452099	9.9		.3898	10	61	103
DH452075	7.5		.2953	8	53	91	DH452025F	9.922	25/64	.3906	10	61	103
* DH452019F	7.541	19/64	.2969	8	53	91	DH452100	10.0		.3937	10	61	103
DH452076	7.6		.2992	8	53	91	DH452101	10.1		.3976	12	71	118
DH452077	7.7		.3031	8	53	91	DH452102	10.2		.4016	12	71	118
DH452078	7.8		.3071	8	53	91	DH452103	10.3		.4055	12	71	118
DH452079	7.9		.3110	8	53	91	DH452026F	10.319	13/32	.4062	12	71	118
* DH452020F	7.938	5/16	.3125	8	53	91	DH452104	10.4		.4094	12	71	118
DH452080	8.0		.3150	8	53	91	DH452105	10.5		.4134	12	71	118
DH452081	8.1		.3189	10	61	103	DH452106	10.6		.4173	12	71	118
DH452082	8.2		.3228	10	61	103	DH452107	10.7		.4212	12	71	118
DH452083	8.3		.3268	10	61	103	DH452027F	10.716	27/64	.4219	12	71	118
* DH452021F	8.334	21/64	.3281	10	61	103	DH452108	10.8		.4252	12	71	118
DH452084	8.4		.3307	10	61	103	DH452109	10.9		.4291	12	71	118

► NEXT PAGE

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► FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH452110	11.0		.4330	12	71	118	DH452135	13.5		.5314	14	77	124
DH452111	11.1		.4370	12	71	118	DH452140	14.0		.5512	14	77	124
* DH452028F	11.113	7/16	.4375	12	71	118	DH452036F	14.288	9/16	.5625	16	83	133
DH452112	11.2		.4409	12	71	118	DH452145	14.5		.5708	16	83	133
DH452113	11.3		.4448	12	71	118	DH452150	15.0		.5905	16	83	133
DH452114	11.4		.4488	12	71	118	DH452155	15.5		.6102	16	83	133
DH452115	11.5		.4527	12	71	118	DH452040F	15.875	5/8	.6250	16	83	133
* DH452029F	11.509	29/64	.4531	12	71	118	DH452160	16.0		.6299	16	83	133
DH452116	11.6		.4566	12	71	118	DH452165	16.5		.6495	18	93	143
DH452117	11.7		.4606	12	71	118	DH452170	17.0		.6692	18	93	143
DH452118	11.8		.4645	12	71	118	DH452175	17.5		.6889	18	93	143
DH452119	11.9		.4685	12	71	118	DH452180	18.0		.7087	18	93	143
* DH452030F	11.906	15/32	.4688	12	71	118	DH452185	18.5		.7283	20	101	153
DH452120	12.0		.4724	12	71	118	DH452190	19.0		.7480	20	101	153
* DH452031F	12.303	31/64	.4844	14	77	124	DH452048F	19.05	3/4	.7500	20	101	153
DH452125	12.5		.4921	14	77	124	DH452195	19.5		.7676	20	101	153
* DH452032F	12.7	1/2	.5000	14	77	124	DH452200	20.0		.7874	20	101	153
DH452130	13.0		.5118	14	77	124							

► Other shank types are available on your request

◎ : Excellent ○ : Good

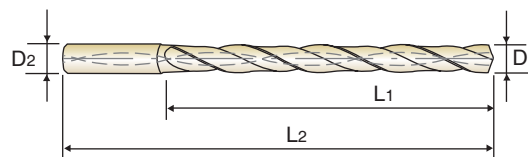
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○	◎	○	○		



SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life
- Tolerance : Dia. Tolerance ØD1:m7, Shank Tolerance ØD2: h6

► FOR STAINLESS STEEL



DIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 8 × D

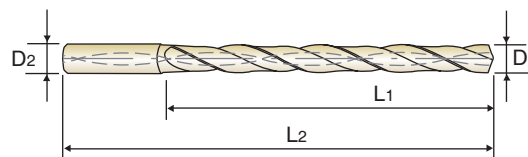
Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH453030	3.0		.1181	6	34	72	DH453058	5.8		.2283	6	57	95
DH453031	3.1		.1220	6	34	72	DH453059	5.9		.2323	6	57	95
DH453008F	3.175	1/8	.1250	6	34	72	DH453015F	5.953	15/64	.2344	6	57	95
DH453032	3.2		.1260	6	34	72	DH453060	6.0		.2362	6	57	95
DH453033	3.3		.1299	6	34	72	DH453061	6.1		.2402	8	76	114
DH453034	3.4		.1339	6	34	72	DH453062	6.2		.2441	8	76	114
DH453229G	3.454	#29	.1360	6	34	72	DH453063	6.3		.2480	8	76	114
DH453035	3.5		.1378	6	34	72	DH453016F	6.35	1/4	.2500	8	76	114
DH453009F	3.572	9/64	.1406	6	34	72	DH453064	6.4		.2520	8	76	114
DH453036	3.6		.1417	6	34	72	DH453065	6.5		.2559	8	76	114
DH453037	3.7		.1457	6	34	72	DH453106L	6.527	F	.2570	8	76	114
DH453038	3.8		.1496	6	43	81	DH453066	6.6		.2598	8	76	114
DH453039	3.9		.1535	6	43	81	DH453067	6.7		.2638	8	76	114
DH453010F	3.969	5/32	.1563	6	43	81	DH453017F	6.747	17/64	.2656	8	76	114
DH453040	4.0		.1575	6	43	81	DH453068	6.8		.2677	8	76	114
DH453221G	4.038	#21	.1590	6	43	81	DH453069	6.9		.2717	8	76	114
DH453041	4.1		.1614	6	43	81	DH453070	7.0		.2756	8	76	114
DH453042	4.2		.1654	6	43	81	DH453071	7.1		.2795	8	76	114
DH453043	4.3		.1693	6	43	81	DH453018F	7.144	9/32	.2813	8	76	114
DH453011F	4.366	11/64	.1719	6	43	81	DH453072	7.2		.2835	8	76	114
DH453044	4.4		.1732	6	43	81	DH453073	7.3		.2874	8	76	114
DH453045	4.5		.1772	6	43	81	DH453074	7.4		.2913	8	76	114
DH453046	4.6		.1811	6	43	81	DH453075	7.5		.2953	8	76	114
DH453047	4.7		.1850	6	43	81	DH453019F	7.541	19/64	.2969	8	76	114
DH453012F	4.763	3/16	.1875	6	57	95	DH453076	7.6		.2992	8	76	114
DH453048	4.8		.1890	6	57	95	DH453077	7.7		.3031	8	76	114
DH453049	4.9		.1929	6	57	95	DH453078	7.8		.3071	8	76	114
DH453050	5.0		.1969	6	57	95	DH453079	7.9		.3110	8	76	114
DH453051	5.1		.2008	6	57	95	DH453020F	7.938	5/16	.3125	8	76	114
DH453013F	5.159	13/64	.2031	6	57	95	DH453080	8.0		.3150	8	76	114
DH453052	5.2		.2047	6	57	95	DH453081	8.1		.3189	10	95	142
DH453053	5.3		.2087	6	57	95	DH453082	8.2		.3228	10	95	142
DH453054	5.4		.2126	6	57	95	DH453083	8.3		.3268	10	95	142
DH453055	5.5		.2165	6	57	95	DH453021F	8.334	21/64	.3281	10	95	142
DH453014F	5.556	7/32	.2188	6	57	95	DH453084	8.4		.3307	10	95	142
DH453056	5.6		.2205	6	57	95	DH453117L	8.432	Q	.3320	10	95	142
DH453057	5.7		.2244	6	57	95	DH453085	8.5		.3346	10	95	142

► NEXT PAGE

**SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES**

- The tool has the special flute shape and geometry for suitable machining of stainless steel
- Excellent chip evacuation due to better surface treatment
- Point R-thinning makes the superior centering and chip curl
- TiAlN coating achieves the better surface finishes and longer tool life
- Tolerance : Dia. Tolerance ØD1:m7, Shank Tolerance ØD2: h6

► FOR STAINLESS STEELDIN
6537

MG

h6

m7

140°



P.38

DREAM DRILLS INOX | 8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH453086	8.6		.3386	10	95	142	DH453106	10.6		.4173	12	114	162
DH453087	8.7		.3425	10	95	142	DH453107	10.7		.4212	12	114	162
DH453022F	8.731	11/32	.3438	10	95	142	DH453027F	10.716	27/64	.4219	12	114	162
DH453088	8.8		.3465	10	95	142	DH453108	10.8		.4252	12	114	162
DH453089	8.9		.3504	10	95	142	DH453109	10.9		.4291	12	114	162
DH453090	9.0		.3543	10	95	142	DH453110	11.0		.4330	12	114	162
DH453091	9.1		.3583	10	95	142	DH453111	11.1		.4370	12	114	162
DH453023F	9.128	23/64	.3594	10	95	142	DH453028F	11.113	7/16	.4375	12	114	162
DH453092	9.2		.3622	10	95	142	DH453112	11.2		.4409	12	114	162
DH453093	9.3		.3661	10	95	142	DH453113	11.3		.4448	12	114	162
DH453121L	9.347	U	.3680	10	95	142	DH453114	11.4		.4488	12	114	162
DH453094	9.4		.3701	10	95	142	DH453115	11.5		.4527	12	114	162
DH453095	9.5		.3740	10	95	142	DH453116	11.6		.4566	12	114	162
DH453024F	9.525	3/8	.3750	10	95	142	DH453117	11.7		.4606	12	114	162
DH453096	9.6		.3780	10	95	142	DH453118	11.8		.4645	12	114	162
DH453097	9.7		.3819	10	95	142	DH453119	11.9		.4685	12	114	162
DH453098	9.8		.3858	10	95	142	DH453030F	11.906	15/32	.4688	12	114	162
DH453099	9.9		.3898	10	95	142	DH453120	12.0		.4724	12	114	162
DH453025F	9.922	25/64	.3906	10	95	142	DH453031F	12.303	31/64	.4844	14	133	178
DH453100	10.0		.3937	10	95	142	DH453125	12.5		.4921	14	133	178
DH453101	10.1		.3976	12	114	162	DH453032F	12.7	1/2	.5000	14	133	178
DH453102	10.2		.4016	12	114	162	DH453130	13.0		.5118	14	133	178
DH453103	10.3		.4055	12	114	162	DH453033F	13.097	33/64	.5156	14	133	178
DH453026F	10.319	13/32	.4063	12	114	162	DH453135	13.5		.5314	14	133	178
DH453104	10.4		.4094	12	114	162	DH453140	14.0		.5512	14	133	178
DH453105	10.5		.4134	12	114	162							

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



SOLID CARBIDE DREAM DRILLS INOX with COOLANT HOLES, TiAIN COATED

► FOR STAINLESS STEEL

DH451, DH463, DH714, DH452, DH464, DH715, DH453 Series

WORK MATERIAL			M						N					
			STAINLESS S TEELS			STAINLESS STEELS			ALUMINUM			ALUMINUM		
STRENGTH			< 800 N/mm ²			> 800 N/mm ²			< 10% Si			< 10% Si		
DRILLING SPEED(SFM)			120 ~ 230 ft/min			60 ~ 140 ft/min			490 ~ 720 ft/min			390 ~ 570 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional												
1.0	.0394		12000	0.02	.001	6200	0.02	.001	48000	0.04	.002	38000	0.03	.001
1.5	.0591		9000	0.03	.001	5400	0.02	.001	43000	0.05	.002	32000	0.04	.002
2.5	.0984		7000	0.04	.002	4200	0.03	.001	25500	0.08	.003	19500	0.06	.002
3.0	.1181	1/8	7400	0.04	.002	4700	0.02	.001	23000	0.12	.005	18500	0.10	.004
4.0	.1575	5/32	5600	0.05	.002	3600	0.03	.001	17500	0.18	.007	13900	0.15	.006
5.0	.1969	13/64	4400	0.05	.002	2800	0.03	.001	14000	0.20	.008	11000	0.18	.007
6.0	.2362	15/64	3700	0.06	.002	2400	0.04	.002	11700	0.25	.010	9300	0.25	.010
8.0	.3150	5/16	2800	0.08	.003	1800	0.06	.002	8800	0.30	.012	7000	0.30	.012
10.0	.3937	25/64	2200	0.10	.004	1400	0.08	.003	7000	0.40	.016	5600	0.35	.014
12.0	.4724	15/32	1900	0.12	.005	1200	0.10	.004	5800	0.50	.020	4600	0.40	.016
14.0	.5512	35/64	1600	0.15	.006	1000	0.12	.005	5000	0.60	.024	4000	0.50	.020
16.0	.6299	5/8	1400	0.20	.008	900	0.15	.006	4380	0.80	.031	3500	0.60	.024
18.0	.7087	45/64	1250	0.22	.009	800	0.17	.007	3900	1.00	.039	3100	0.70	.028
20.0	.7874	25/32	1120	0.24	.009	720	0.19	.007	3500	1.20	.047	2800	0.80	.031

WORK MATERIAL			S			P			N		
			TITANIUM TI ALLOY			CARBON STEELS ALLOY STEELS			NON FRERROUS		
STRENGTH											
DRILLING SPEED(SFM)			80 ~ 160 ft/min			260 ~ 410 ft/min			390 ~ 490 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional									
1.0	.0394		8100	0.01	.0004	26000	0.02	.001	38000	0.02	.001
1.5	.0591		7500	0.01	.0004	18000	0.03	.001	25500	0.03	.001
2.5	.0984		4500	0.02	.001	10800	0.05	.002	15500	0.05	.002
3.0	.1181	1/8	5300	0.03	.001	13000	0.04	.002	16000	0.08	.003
4.0	.1575	5/32	4000	0.04	.002	10000	0.05	.002	11900	0.10	.004
5.0	.1969	13/64	3200	0.05	.002	8000	0.05	.002	9500	0.12	.005
6.0	.2362	15/64	2650	0.06	.002	6600	0.06	.002	8000	0.15	.006
8.0	.3150	5/16	2000	0.07	.003	5000	0.08	.003	6000	0.18	.007
10.0	.3937	25/64	1600	0.08	.003	4000	0.10	.004	4800	0.22	.009
12.0	.4724	15/32	1300	0.10	.004	3300	0.12	.005	4000	0.26	.010
14.0	.5512	35/64	1100	0.12	.005	2800	0.15	.006	3400	0.30	.012
16.0	.6299	5/8	1000	0.14	.006	2500	0.20	.008	3000	0.40	.016
18.0	.7087	45/64	900	0.16	.006	2200	0.22	.009	2650	0.45	.018
20.0	.7874	25/32	800	0.18	.007	2000	0.24	.009	2400	0.50	.020

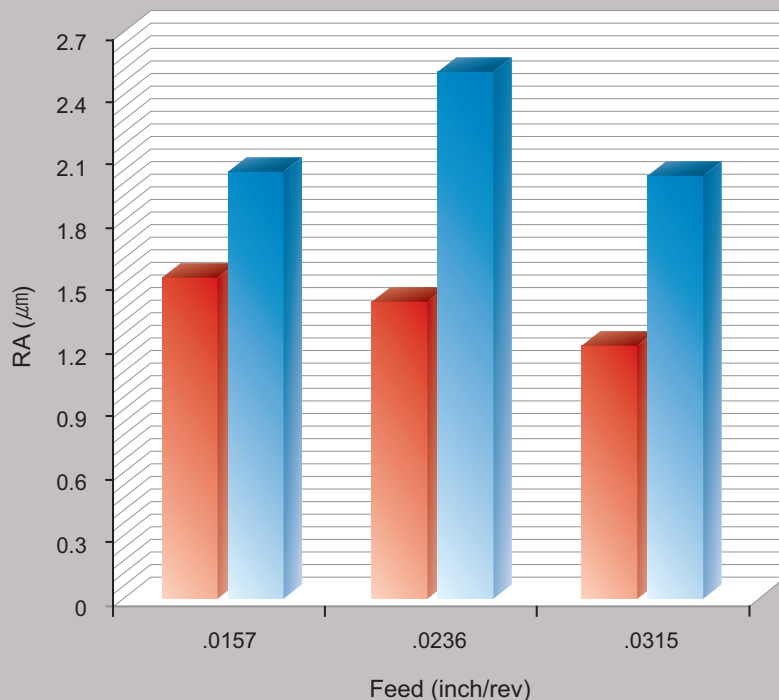
► Recommend to reduce the feed rate as following
 DH463/DH714/DH451(3xD), DH464/DH714/DH452(5xD) : Feed 100%
 DH453(8xD) : Feed 85%

N = R.P.M
 S= feed rate (mm/rev.)
 IPR= feed rate (Inch/rev.)

SOLID CARBIDE DREAM DRILLS ALU - **Test Report**

with COOLANT HOLES

● **Surface Roughness of Work Piece**

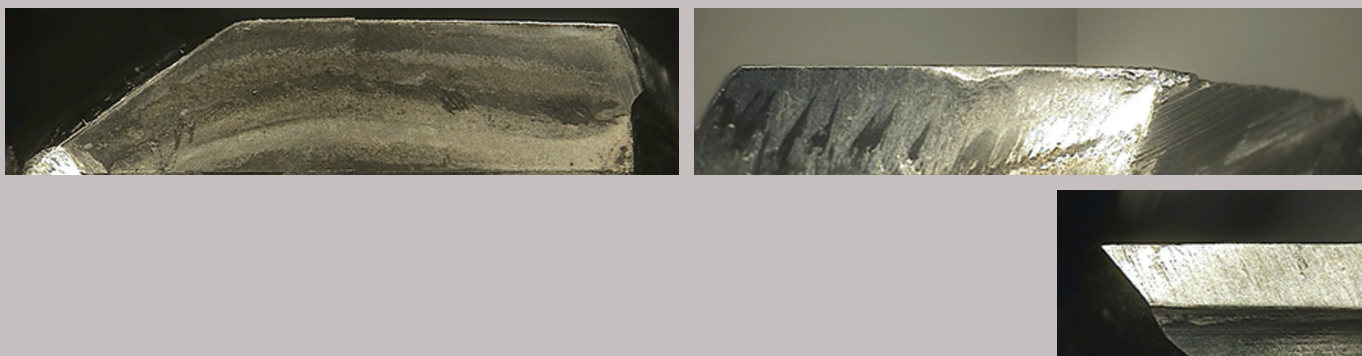


YG-1
COMPETITOR

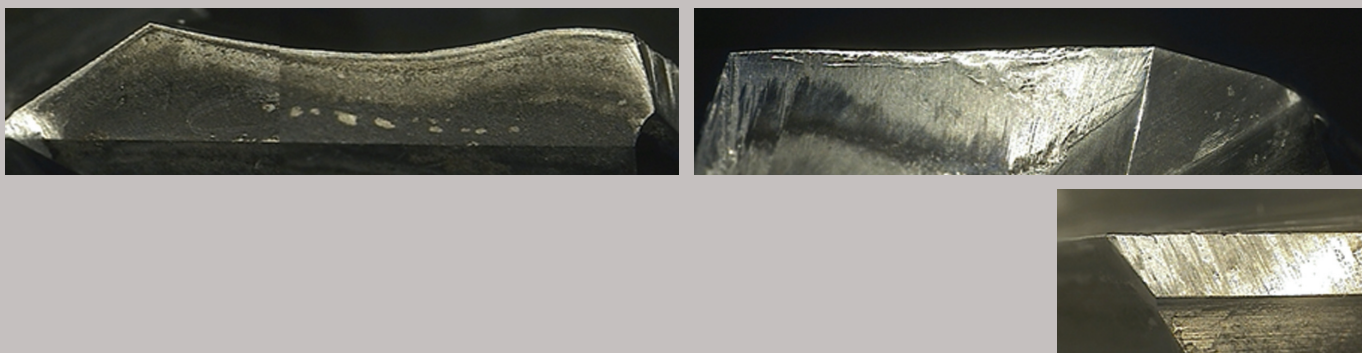
Cutting Condition

- Tools : D5433100 (DREAM DRILL - ALU)
- Size : $\varnothing 10.0 \times \varnothing 10 \times 61 \times 103$
- Work Material : • Al(6061)
 - JIS:A6061
 - DIN:AlMgSiCu
- R.P.M : 6367 rev./min.
- SFM : 656 ft/min.
- Feed : .0157 ~ .0315 inch/rev.
- Drilling Depth : 1.77"
- Coolant : Wet cut

▶ **YG-1 (Total Drilling 820 Holes)**

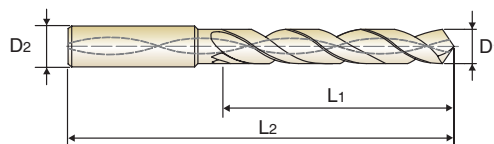


▶ **COMPETITOR (Total Drilling 820 Holes)**



*** NEW SIZE****SOLID DREAM DRILLS - ALU with COOLANT HOLES (DLC COATED)**

- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes
- Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005

► FOR ALUMINUM

MG

h6

118°



P.44

DREAM DRILLS ALU | 5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
DLC	D1		D2	L1	L2	DLC	D1		D2	L1	L2	
DGE466013	13/64	.2031	15/64	1-3/4	3-15/16	DGE718022	11/32	.3438	3/8	2-27/32	5	*
* DGE718013	13/64	.2031	1/4	1-3/4	3-15/16	DGE718023	23/64	.3594	3/8	3	5-23/64	*
DGE466014	7/32	.2188	15/64	1-57/64	3-15/16	DGE466023	23/64	.3594	25/64	3	5-23/64	
* DGE718014	7/32	.2188	1/4	1-57/64	3-15/16	DGE718221	U	.3680	3/8	3	5-23/64	*
DGE466015	15/64	.2344	15/64	1-57/64	3-15/16	DGE466221	U	.3680	25/64	3	5-23/64	
* DGE718015	15/64	.2344	1/4	1-57/64	3-15/16	DGE718024	3/8	.3750	3/8	3-5/32	5-23/64	*
* DGE718016	1/4	.2500	1/4	2-3/64	4-19/64	DGE466024	3/8	.3750	25/64	3-5/32	5-23/64	
DGE466016	1/4	.2500	17/64	2-3/64	4-19/64	DGE466025	25/64	.3906	25/64	3-5/32	5-23/64	
DGE466206	F	.2570	17/64	2-13/64	4-19/64	DGE718025	25/64	.3906	7/16	3-5/32	5-23/64	*
* DGE718206	F	.2570	5/16	2-13/64	4-19/64	DGE466026	13/32	.4062	27/64	3-5/16	5-7/8	
DGE466017	17/64	.2656	17/64	2-13/64	4-19/64	DGE718026	13/32	.4062	7/16	3-5/16	5-7/8	*
* DGE718017	17/64	.2656	5/16	2-13/64	4-19/64	DGE466027	27/64	.4219	27/64	3-15/32	5-7/8	
DGE466209	I	.2720	.272	2-13/64	4-19/64	DGE718027	27/64	.4219	7/16	3-15/32	5-7/8	*
* DGE718209	I	.2720	5/16	2-13/64	4-19/64	DGE718028	7/16	.4375	7/16	3-5/8	6-7/32	*
DGE466018	9/32	.2812	5/16	2-23/64	4-41/64	DGE466028	7/16	.4375	15/32	3-5/8	6-7/32	
DGE466019	19/64	.2969	5/16	2-33/64	4-41/64	DGE466029	29/64	.4531	15/32	3-25/32	6-7/32	
DGE466020	5/16	.3125	5/16	2-33/64	4-41/64	DGE718029	29/64	.4531	1/2	3-25/32	6-7/32	*
DGE466021	21/64	.3281	11/32	2-43/64	5	DGE466030	15/32	.4688	15/32	3-25/32	6-7/32	
* DGE718021	21/64	.3281	3/8	2-43/64	5	DGE718030	15/32	.4688	1/2	3-25/32	6-7/32	*
DGE466217	Q	.3320	11/32	2-43/64	5	DGE466031	31/64	.4844	1/2	3-15/16	6-37/64	
* DGE718217	Q	.3320	3/8	2-43/64	5	DGE466032	1/2	.5000	1/2	4-3/32	6-37/64	
DGE466022	11/32	.3438	11/32	2-27/32	5							

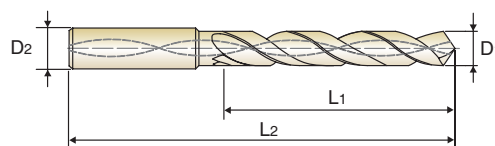
► Other shank types are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
						◎					

*** NEW SIZE****SOLID DREAM DRILLS - ALU with COOLANT HOLES (DLC COATED)**

- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes

► FOR ALUMINUMDIN
6537

MG

h6

m7

118°



P.44

DREAM DRILLS ALU | 5 × D

Unit : mm

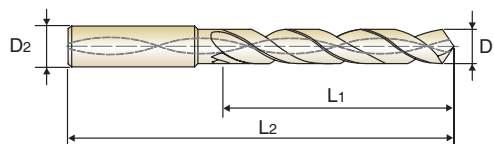
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2	DLC	D1			D2	L1	L2
DGE433030	3.0		.1181	6	28	66	DGE433054	5.4		.2126	6	44	82
DGE433031	3.1		.1220	6	28	66	DGE433055	5.5		.2165	6	44	82
* DGE433008F	3.175	1/8	.1250	6	28	66	DGE433014F	5.556	7/32	.2188	6	44	82
DGE433032	3.2		.1260	6	28	66	DGE433056	5.6		.2205	6	44	82
DGE433033	3.3		.1299	6	28	66	DGE433057	5.7		.2244	6	44	82
DGE433034	3.4		.1339	6	28	66	DGE433058	5.8		.2283	6	44	82
DGE433035	3.5		.1378	6	28	66	DGE433059	5.9		.2323	6	44	82
* DGE433009F	3.572	9/64	.1406	6	28	66	DGE433015F	5.953	15/64	.2344	6	44	82
DGE433036	3.6		.1417	6	28	66	DGE433060	6.0		.2362	6	44	82
DGE433037	3.7		.1457	6	28	66	DGE433061	6.1		.2402	8	53	91
DGE433038	3.8		.1496	6	36	74	DGE433062	6.2		.2441	8	53	91
DGE433039	3.9		.1535	6	36	74	DGE433063	6.3		.2480	8	53	91
* DGE433010F	3.969	5/32	.1563	6	36	74	DGE433016F	6.35	1/4	.2500	8	53	91
DGE433040	4.0		.1575	6	36	74	DGE433064	6.4		.2520	8	53	91
DGE433041	4.1		.1614	6	36	74	DGE433065	6.5		.2559	8	53	91
DGE433042	4.2		.1654	6	36	74	DGE433066	6.6		.2598	8	53	91
DGE433043	4.3		.1693	6	36	74	DGE433067	6.7		.2638	8	53	91
* DGE433011F	4.366	11/64	.1719	6	36	74	DGE433017F	6.747	17/64	.2656	8	53	91
DGE433044	4.4		.1732	6	36	74	DGE433068	6.8		.2677	8	53	91
DGE433045	4.5		.1772	6	36	74	DGE433069	6.9		.2717	8	53	91
DGE433046	4.6		.1811	6	36	74	DGE433070	7.0		.2756	8	53	91
DGE433047	4.7		.1850	6	36	74	DGE433071	7.1		.2795	8	53	91
* DGE433012F	4.763	3/16	.1875	6	36	74	DGE433018F	7.144	9/32	.2812	8	53	91
DGE433048	4.8		.1890	6	44	82	DGE433072	7.2		.2835	8	53	91
DGE433049	4.9		.1929	6	44	82	DGE433073	7.3		.2874	8	53	91
DGE433050	5.0		.1969	6	44	82	DGE433074	7.4		.2913	8	53	91
DGE433051	5.1		.2008	6	44	82	DGE433075	7.5		.2953	8	53	91
* DGE433013F	5.159	13/64	.2031	6	44	82	DGE433019F	7.541	19/64	.2969	8	53	91
DGE433052	5.2		.2047	6	44	82	DGE433076	7.6		.2992	8	53	91
DGE433053	5.3		.2087	6	44	82	DGE433077	7.7		.3031	8	53	91

► Other shank types are available on your request

► NEXT PAGE

*** NEW SIZE****SOLID DREAM DRILLS - ALU with COOLANT HOLES (DLC COATED)**

- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes

► FOR ALUMINUMDIN
6537

MG

h6

m7

118°



P.44

DREAM DRILLS ALU | 5 × D

Unit : mm

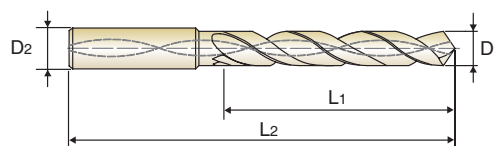
EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2	DLC	D1			D2	L1	L2
DGE433078	7.8		.3071	8	53	91	DGE433102	10.2		.4016	12	71	118
DGE433079	7.9		.3110	8	53	91	DGE433103	10.3		.4055	12	71	118
* DGE433020F	7.938	5/16	.3125	8	53	91	DGE433026F	10.319	13/32	.4062	12	71	118
DGE433080	8.0		.3150	8	53	91	DGE433104	10.4		.4094	12	71	118
DGE433081	8.1		.3189	10	61	103	DGE433105	10.5		.4134	12	71	118
DGE433082	8.2		.3228	10	61	103	DGE433106	10.6		.4173	12	71	118
DGE433083	8.3		.3268	10	61	103	DGE433107	10.7		.4212	12	71	118
* DGE433021F	8.334	21/64	.3281	10	61	103	DGE433027F	10.716	27/64	.4219	12	71	118
DGE433084	8.4		.3307	10	61	103	DGE433108	10.8		.4252	12	71	118
DGE433085	8.5		.3346	10	61	103	DGE433109	10.9		.4291	12	71	118
DGE433086	8.6		.3386	10	61	103	DGE433110	11.0		.4330	12	71	118
DGE433087	8.7		.3425	10	61	103	DGE433111	11.1		.4370	12	71	118
* DGE433022F	8.731	11/32	.3438	10	61	103	DGE433028F	11.113	7/16	.4375	12	71	118
DGE433088	8.8		.3465	10	61	103	DGE433112	11.2		.4409	12	71	118
DGE433089	8.9		.3504	10	61	103	DGE433113	11.3		.4448	12	71	118
DGE433090	9.0		.3543	10	61	103	DGE433114	11.4		.4488	12	71	118
DGE433091	9.1		.3583	10	61	103	DGE433115	11.5		.4527	12	71	118
* DGE433023F	9.128	23/64	.3594	10	61	103	DGE433029F	11.509	29/64	.4531	12	71	118
DGE433092	9.2		.3622	10	61	103	DGE433116	11.6		.4566	12	71	118
DGE433093	9.3		.3661	10	61	103	DGE433117	11.7		.4606	12	71	118
DGE433094	9.4		.3701	10	61	103	DGE433118	11.8		.4645	12	71	118
DGE433095	9.5		.3740	10	61	103	DGE433119	11.9		.4685	12	71	118
* DGE433024F	9.525	3/8	.3750	10	61	103	DGE433030F	11.906	15/32	.4688	12	71	118
DGE433096	9.6		.3780	10	61	103	DGE433120	12.0		.4724	12	71	118
DGE433097	9.7		.3819	10	61	103	DGE433031F	12.303	31/64	.4844	14	77	124
DGE433098	9.8		.3858	10	61	103	DGE433125	12.5		.4921	14	77	124
DGE433099	9.9		.3898	10	61	103	DGE433032F	12.7	1/2	.5000	14	77	124
* DGE433025F	9.922	25/64	.3906	10	61	103	DGE433130	13.0		.5118	14	77	124
DGE433100	10.0		.3937	10	61	103	DGE433135	13.5		.5314	14	77	124
DGE433101	10.1		.3976	12	71	118	DGE433140	14.0		.5512	14	77	124

► Other shank types are available on your request

► NEXT PAGE

*** NEW SIZE****SOLID DREAM DRILLS - ALU with COOLANT HOLES (DLC COATED)**

- Wider and deeper flute gullets for maximum chip removal
- Special geometry and smooth coating reduces built up edge and improves finishes

► FOR ALUMINUMDIN
6537

MG

h6

m7

118°



P.44

DREAM DRILLS ALU | 5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2	DLC	D1			D2	L1	L2
* DGE433036F	14.288	9/16	.5625	16	83	133	DGE433175	17.5		.6889	18	93	143
DGE433145	14.5		.5708	16	83	133	DGE433180	18.0		.7087	18	93	143
DGE433150	15.0		.5905	16	83	133	DGE433185	18.5		.7283	20	101	153
DGE433155	15.5		.6102	16	83	133	DGE433190	19.0		.7480	20	101	153
* DGE433040F	15.875	5/8	.6250	16	83	133	DGE433048F	19.05	3/4	.7500	20	101	153
DGE433160	16.0		.6299	16	83	133	DGE433195	19.5		.7676	20	101	153
DGE433165	16.5		.6495	18	93	143	DGE433200	20.0		.7874	20	101	153
DGE433170	17.0		.6692	18	93	143							

► 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
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
						◎					



SOLID CARBIDE DREAM DRILLS ALU with COOLANT HOLES (DLC COATED)

► FOR ALUMINUM

DGE466, DGE433, DGE718 Series

WORK MATERIAL		N							
		ALUMINUM ALLOY CASTING ALUMINUM DIE CASTING				WROUGHT ALUMINUM ALLOY			
DRILLING SPEED(SFM)		240 ~ 650 ft/min				240 ~ 650 ft/min			
DIAMETER		N		S		IPR		N	
Metric(mm)	Decimal								
3.0~6.0	.1181 ~ .2362	8,000~15,000		0.2~0.5		.008 .020		8,000~15,000	
~10.0	~.3937	6,000~10,500		0.3~1.0		.012 .039		6,000~10,500	
~14.0	~.5512	4,500~ 5,800		0.3~1.0		.012 .039		4,500~ 5,800	
~20.0	~.7874	3,200~ 4,600		0.3~1.0		.012 .039		3,200~ 4,600	

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

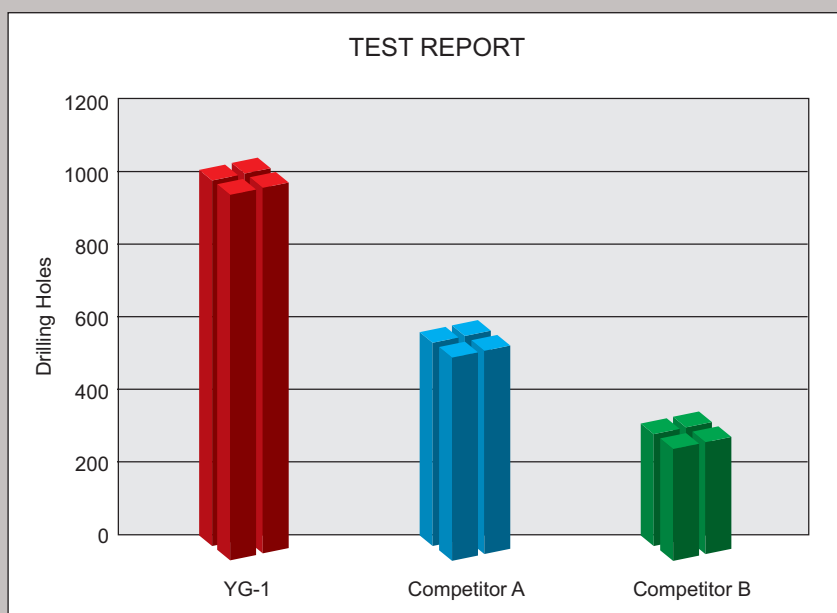
SOLID CARBIDE DREAM DRILLS MQL TYPE - **Test Report**

with COOLANT HOLES

● **FEATURES OF DREAM DRILLS MQL TYPE**

- Flute Shape and Point Shape allowing better chip evacuation in deep hole drilling
- Excellent Coating and Surface Treatment for better performance and chip evacuation

● **TEST RESULT AGAINST COMPETITOR'S DRILL**



Cutting Condition

- Tools : DH520060 (DREAM DRILL - MQL)
- Size : $\varnothing 6.0 \times \varnothing 6 \times 138 \times 193$
- Work Material :
 - JIS:S45C (HRc 25)
 - DIN:C45
 - WR:1.0503
- R.P.M : 3528 rev./min.
- SFM : 218 ft/min.
- Feed : .0075 inch/rev.
- Drilling Depth : 3.15"
- Coolant : Oil Mist (MQL Techniques)

➤ **YG-1 (After drilling 1,000 holes)**



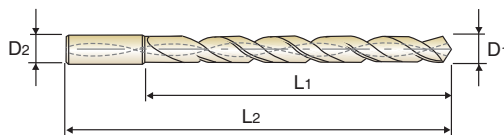
➤ **COMPETITOR A (After drilling 546 holes)**





SOLID CARBIDE DREAM DRILLS MQL TYPE

- ▶ Non step drilling up to 10 times of drill diameter
- ▶ Available for processing MQL (Minimum Quantity Lubrication)
- ▶ Excellent positioning – Bush is not necessary
- ▶ Special design – Good chip removal
- ▶ Powerful drilling



P.50

MQL TYPE | 10×D

10×D

Unit :mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch					Metric	Inch			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH510030	3.0	.1181	3	39	90	DH510080	8.0	.3150	8	104	161
DH510033	3.3	.1299	4	46	97	DH510085	8.5	.3346	9	111	169
DH510035	3.5	.1378	4	46	97	DH510090	9.0	.3543	9	117	175
DH510040	4.0	.1575	4	52	103	DH510095	9.5	.3740	10	124	182
DH510042	4.2	.1654	5	59	112	DH510100	10.0	.3937	10	130	188
DH510045	4.5	.1772	5	59	112	DH510105	10.5	.4134	11	137	201
DH510050	5.0	.1969	5	65	118	DH510110	11.0	.4330	11	143	207
DH510055	5.5	.2165	6	72	127	DH510115	11.5	.4527	12	150	215
DH510060	6.0	.2362	6	78	133	DH510120	12.0	.4724	12	156	221
DH510065	6.5	.2559	7	85	141	DH510125	12.5	.4921	13	163	229
DH510068	6.8	.2677	7	91	147	DH510130	13.0	.5118	13	169	235
DH510070	7.0	.2756	7	91	147	DH510135	13.5	.5314	14	176	243
DH510075	7.5	.2953	8	98	155	DH510140	14.0	.5512	14	182	249

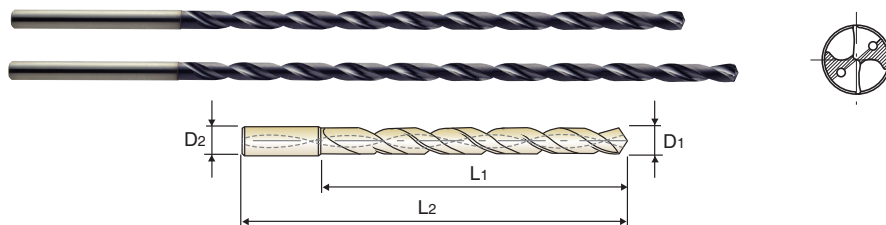
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○			○				○		



SOLID CARBIDE DREAM DRILLS MQL TYPE

- ▶ Non step drilling up to 15 times (20 times) of drill diameter
- ▶ Available for processing MQL (Minimum Quantity Lubrication)
- ▶ Excellent positioning – Bush is not necessary
- ▶ Special design – Good chip removal
- ▶ Powerful drilling



P.50

MQL TYPE | 15 × D, 20 × D

15 × D

20 × D

Unit :mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch					Metric	Inch			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH515030	3.0	.1181	3	54	105	DH520030	3.0	.1181	3	69	120
DH515035	3.5	.1378	4	63	114	DH520035	3.5	.1378	4	81	132
DH515040	4.0	.1575	4	72	123	DH520040	4.0	.1575	4	92	143
DH515045	4.5	.1772	5	81	134	DH520045	4.5	.1772	5	104	157
DH515050	5.0	.1969	5	90	143	DH520050	5.0	.1969	5	115	168
DH515055	5.5	.2165	6	99	154	DH520055	5.5	.2165	6	127	182
DH515060	6.0	.2362	6	108	163	DH520060	6.0	.2362	6	138	193
DH515070	7.0	.2756	7	126	182	DH520070	7.0	.2756	7	161	217
DH515080	8.0	.3150	8	144	201	DH520080	8.0	.3150	8	184	241
DH515090	9.0	.3543	9	162	220	DH520090	9.0	.3543	9	207	265
DH515100	10.0	.3937	10	180	238	DH520100	10.0	.3937	10	230	288
DH515110	11.0	.4330	11	198	262	DH520120	12.0	.4724	12	276	341
DH515120	12.0	.4724	12	216	281						

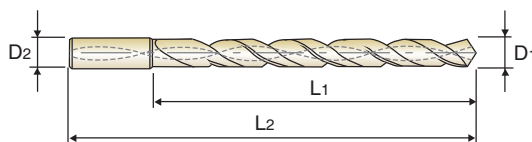
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○			○				○		



SOLID CARBIDE DREAM DRILLS MQL TYPE with COOLANT HOLES

- ▶ Non step drilling up to 10(15&20) times of drill diameter
- ▶ Available for processing MQL (Minimum Quantity Lubrication)
- ▶ Excellent positioning – Bush is not necessary
- ▶ Special design – Good chip removal
- ▶ Powerful drilling



Call for availability



P.50

MQL TYPE | 10×D, 15×D, 20×D

10×D

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAIN	D1		D2	L1	L2
DHM10030	3.0	.1181	6	40	80
DHM10033	3.3	.1299	6	47	87
DHM10035	3.5	.1378	6	47	87
DHM10040	4.0	.1575	6	53	93
DHM10042	4.2	.1654	6	60	100
DHM10045	4.5	.1772	6	60	100
DHM10050	5.0	.1969	6	66	106
DHM10055	5.5	.2165	6	73	113
DHM10060	6.0	.2362	6	79	119
DHM10065	6.5	.2559	8	86	126
DHM10068	6.8	.2677	8	92	132
DHM10070	7.0	.2756	8	92	132
DHM10075	7.5	.2953	8	99	139
DHM10080	8.0	.3150	8	105	145
DHM10085	8.5	.3346	10	112	156
DHM10090	9.0	.3543	10	118	162
DHM10095	9.5	.3740	10	126	170
DHM10100	10.0	.3937	10	132	176
DHM10105	10.5	.4134	12	139	188
DHM10110	11.0	.4330	12	145	194
DHM10115	11.5	.4527	12	152	201
DHM10120	12.0	.4724	12	158	207
DHM10125	12.5	.4921	14	165	214
DHM10130	13.0	.5118	14	171	220
DHM10135	13.5	.5314	14	178	227
DHM10140	14.0	.5512	14	184	233

15×D

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAIN	D1		D2	L1	L2
DHM15030	3.0	.1181	6	55	95
DHM15035	3.5	.1378	6	64	104
DHM15040	4.0	.1575	6	73	113
DHM15045	4.5	.1772	6	82	122
DHM15050	5.0	.1969	6	91	131
DHM15055	5.5	.2165	6	100	140
DHM15060	6.0	.2362	6	109	149
DHM15070	7.0	.2756	8	127	167
DHM15080	8.0	.3150	8	145	185
DHM15090	9.0	.3543	10	163	207
DHM15100	10.0	.3937	10	182	226
DHM15110	11.0	.4330	12	200	249
DHM15120	12.0	.4724	12	218	267

20×D

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAIN	D1		D2	L1	L2
DHM20030	3.0	.1181	6	70	110
DHM20035	3.5	.1378	6	82	122
DHM20040	4.0	.1575	6	93	133
DHM20045	4.5	.1772	6	105	145
DHM20050	5.0	.1969	6	116	156
DHM20055	5.5	.2165	6	128	168
DHM20060	6.0	.2362	6	139	179
DHM20070	7.0	.2756	8	162	202
DHM20080	8.0	.3150	8	185	225
DHM20090	9.0	.3543	10	208	252
DHM20100	10.0	.3937	10	232	276
DHM20110	11.0	.4330	12	255	304
DHM20120	12.0	.4724	12	278	327

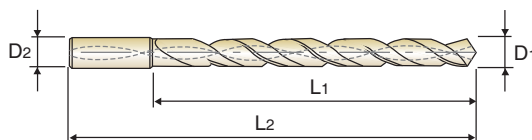
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○			○				○		



SOLID CARBIDE DREAM DRILLS MQL TYPE with COOLANT HOLES

- ▶ Non step drilling up to 25(30) times of drill diameter
- ▶ Available for processing MQL (Minimum Quantity Lubrication)
- ▶ Excellent positioning – Bush is not necessary
- ▶ Special design – Good chip removal
- ▶ Powerful drilling



Call for availability



MQL TYPE | 25 × D, 30 × D

25 × D

30 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch					Metric	Inch			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DHM25030	3.0	.1181	6	85	125	DHM30030	3.0	.1181	6	100	140
DHM25035	3.5	.1378	6	99	139	DHM30035	3.5	.1378	6	117	157
DHM25040	4.0	.1575	6	113	153	DHM30040	4.0	.1575	6	133	173
DHM25045	4.5	.1772	6	127	167	DHM30045	4.5	.1772	6	150	190
DHM25050	5.0	.1969	6	141	181	DHM30050	5.0	.1969	6	166	206
DHM25055	5.5	.2165	6	155	195	DHM30055	5.5	.2165	6	183	223
DHM25060	6.0	.2362	6	169	209	DHM30060	6.0	.2362	6	199	239
DHM25070	7.0	.2756	8	197	237	DHM30070	7.0	.2756	8	232	272
DHM25080	8.0	.3150	8	225	265	DHM30080	8.0	.3150	8	265	305
DHM25090	9.0	.3543	10	253	297						
DHM25100	10.0	.3937	10	282	326						

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○			○				○		



SOLID CARBIDE DREAM DRILLS MQL TYPE, TiAIN COATED

DH510, DH515, DH520, DHM10, DHM15, DHM20 Series

WORK MATERIAL		P					K							
		CARBON STEELS					CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm ²					250 ~ 350 N/mm ²				400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min					230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		N	S	IPR		N	S	IPR		N	S	IPR		
Metric(mm)	Decimal													
3	.1181	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047	
4	.1575	6400	0.08~0.16	.0031	.0063	6400	0.08~0.16	.0031	.0063	5600	0.08~0.16	.0031	.0063	
5	.1969	5800	0.10~0.20	.0039	.0079	5800	0.10~0.20	.0039	.0079	4500	0.10~0.20	.0039	.0079	
6	.2362	4800	0.12~0.24	.0047	.0094	4800	0.12~0.24	.0047	.0094	3800	0.12~0.24	.0047	.0094	
8	.3150	3600	0.16~0.28	.0063	.0110	3600	0.16~0.28	.0063	.0110	2800	0.16~0.28	.0063	.0110	
10	.3937	2900	0.20~0.35	.0079	.0138	2900	0.20~0.35	.0079	.0138	2300	0.20~0.35	.0079	.0138	
12	.4724	2400	0.24~0.42	.0094	.0165	2400	0.24~0.42	.0094	.0165	1900	0.24~0.42	.0094	.0165	
14	.5512	2050	0.28~0.46	.0110	.0181	2050	0.28~0.46	.0110	.0181	1600	0.28~0.46	.0110	.0181	

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

DHM25, DHM30 Series

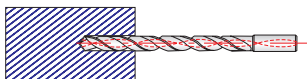
WORK MATERIAL		P				K							
		CARBON STEELS				CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm ²				250 ~ 350 N/mm ²				400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min				230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		N	S	IPR		N	S	IPR		N	S	IPR	
Metric(mm)	Decimal												
3	.1181	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047
4	.1575	5500	0.08~0.16	.0031	.0063	5500	0.08~0.16	.0031	.0063	4700	0.08~0.16	.0031	.0063
5	.1969	4900	0.10~0.20	.0039	.0079	4900	0.10~0.20	.0039	.0079	3800	0.10~0.20	.0039	.0079
6	.2362	4200	0.12~0.24	.0047	.0094	4200	0.12~0.24	.0047	.0094	3200	0.12~0.24	.0047	.0094
8	.3150	3000	0.16~0.28	.0063	.0110	3000	0.16~0.28	.0063	.0110	2400	0.16~0.28	.0063	.0110
10	.3937	2500	0.20~0.35	.0079	.0138	2500	0.20~0.35	.0079	.0138	1900	0.20~0.35	.0079	.0138

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

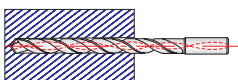
► COOLANT PRESSURE : 900 PSI



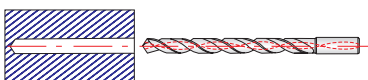
1. Use a YG 3xD Drill to produce a guide hole no larger than .004 over the required drill size. Drill the pilot hole 2xD deep hole.



2. Enter the guide hole at 50 SFM surface and .010 feed rate / per rev.



3. Before hitting the bottom of the guide hole, Increase SFM and feed rate for normal drilling.



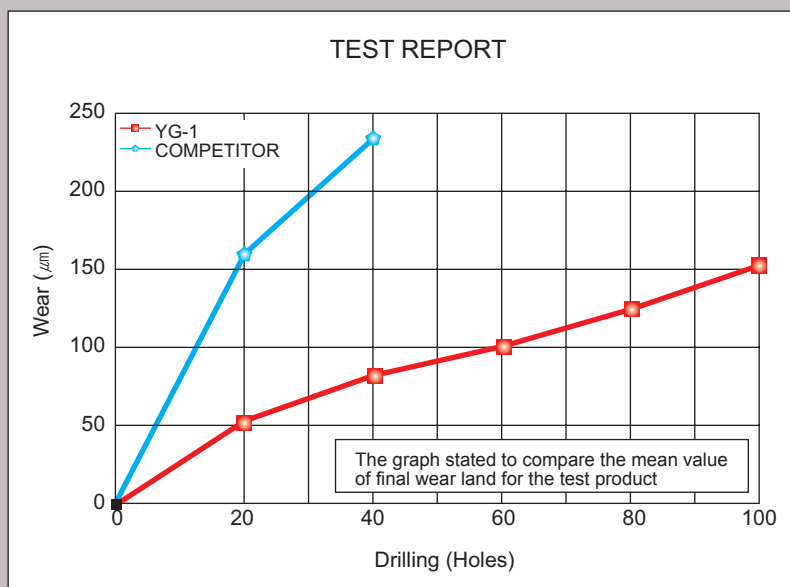
4. After drilling, to withdraw drill, reduce SFM to 50 @ 10 inches per minute.

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS (HRc50~70)

FEATURES OF DREAM DRILLS for HARDENED STEELS

- Low Helix Angle to maximize tool's rigidity.
- Special Point Thinning to improve chip evacuation.
- Excellent Coating and Surface Treatment for improved surface and better chip evacuation.

TEST RESULT AGAINST COMPETITOR'S DRILL



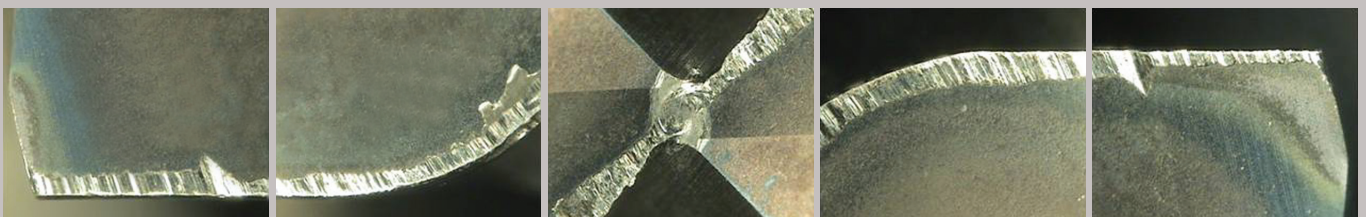
Cutting Condition

- Tools : DH500100
(DREAM DRILLS for HIGH HARDENED STEELS)
- Size : Ø10.0×Ø10×63×111
- Work Material : • JIS:SKD11 (HRc 60)
 - DIN:X155CrV-Mo12.1
 - WR:1.2379
- R.P.M : 380 rev./min.
- SFM : 39 ft/min.
- Feed : .0016 inch/rev.
- Drilling Depth : .98" (2.5D)
- Coolant : Wet Cut

YG-1 (After drilling 100 holes)



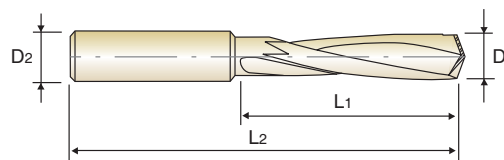
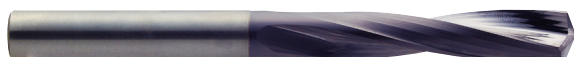
COMPETITOR (After drilling 40 holes)





SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS (HRC50~70)

- 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
- Tolerance : Dia. Tolerance $\varnothing D1$: See page 57, Shank Tolerance $\varnothing D2$: -.0001 -.0005



P.55

for HIGH HARDENED STEELS

Unit : Inch

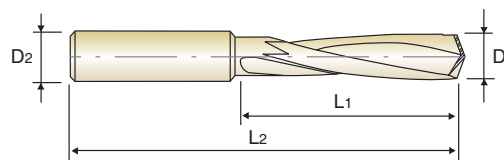
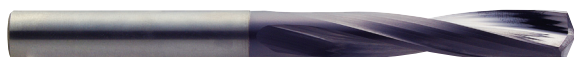
EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal					Fractional	Decimal			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH501001	1/8	.1250	1/8	21/32	2	DH501031	#1	.2280	1/4	1-13/32	3
DH501002	#30	.1285	3/16	23/32	2	DH501032	15/64	.2344	1/4	1-13/32	3
DH501003	#29	.1360	3/16	13/16	2	DH501033	B	.2380	1/4	1-19/32	3-1/8
DH501004	#28	.1405	3/16	13/16	2	DH501034	C	.2420	1/4	1-19/32	3-1/8
DH501005	9/64	.1406	3/16	13/16	2	DH501035	D	.2460	1/4	1-19/32	3-1/8
DH501006	#27	.1440	3/16	13/16	2	DH501036	1/4	.2500	1/4	1-19/32	3-1/8
DH501007	#26	.1470	3/16	13/16	2	DH501037	F	.2570	3/8	1-19/32	3-1/8
DH501008	#25	.1495	3/16	7/8	2-1/16	DH501038	G	.2610	3/8	1-19/32	3-1/8
DH501009	#24	.1520	3/16	7/8	2-1/16	DH501039	17/64	.2656	3/8	1-19/32	3-1/8
DH501010	#23	.1540	3/16	7/8	2-1/16	DH501040	I	.2720	3/8	1-25/32	3-3/8
DH501011	5/32	.1562	3/16	7/8	2-1/16	DH501041	J	.2770	3/8	1-25/32	3-3/8
DH501012	#22	.1570	3/16	7/8	2-1/16	DH501042	9/32	.2812	3/8	1-25/32	3-3/8
DH501013	#21	.1590	3/16	7/8	2-1/16	DH501043	L	.2900	3/8	1-25/32	3-3/8
DH501014	#20	.1610	3/16	1	2-1/2	DH501044	M	.2950	3/8	1-25/32	3-3/8
DH501015	#19	.1660	3/16	1	2-1/2	DH501045	19/64	.2969	3/8	1-25/32	3-3/8
DH501016	11/64	.1719	3/16	1-1/8	2-3/4	DH501046	N	.3020	3/8	1-31/32	3-7/8
DH501017	#15	.1800	3/16	1-1/8	2-3/4	DH501047	5/16	.3125	3/8	1-31/32	3-7/8
DH501018	#14	.1820	3/16	1-1/8	2-3/4	DH501048	O	.3160	3/8	1-31/32	3-7/8
DH501019	3/16	.1875	3/16	1-1/8	2-3/4	DH501049	21/64	.3281	3/8	1-31/32	3-7/8
DH501020	#10	.1935	1/4	1-9/32	2-7/8	DH501050	Q	.3320	3/8	1-31/32	3-7/8
DH501021	#9	.1960	1/4	1-9/32	2-7/8	DH501051	R	.3390	3/8	2-1/4	4-1/8
DH501022	#8	.1990	1/4	1-9/32	2-7/8	DH501052	11/32	.3438	3/8	2-1/4	4-1/8
DH501023	#7	.2010	1/4	1-9/32	2-7/8	DH501053	23/64	.3594	3/8	2-1/4	4-1/8
DH501024	13/64	.2031	1/4	1-9/32	2-7/8	DH501054	U	.3680	3/8	2-1/4	4-1/8
DH501025	#6	.2040	1/4	1-9/32	2-7/8	DH501055	3/8	.3750	3/8	2-1/4	4-1/8
DH501026	#5	.2055	1/4	1-9/32	2-7/8	DH501056	V	.3770	1/2	2-1/2	4-3/8
DH501027	#4	.2090	1/4	1-9/32	2-7/8	DH501057	25/64	.3906	1/2	2-1/2	4-3/8
DH501028	#3	.2130	1/4	1-13/32	3	DH501058	X	.3970	1/2	2-1/2	4-3/8
DH501029	7/32	.2188	1/4	1-13/32	3	DH501059	Y	.4040	1/2	2-1/2	4-3/8
DH501030	#2	.2210	1/4	1-13/32	3	DH501060	13/32	.4062	1/2	2-1/2	4-3/8

► NEXT PAGE



SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS (HRc50~70)

- 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
- Tolerance : Dia. Tolerance $\varnothing D1$: See page 57, Shank Tolerance $\varnothing D2$: -.0001 -.0005



P.55

for HIGH HARDENED STEELS

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal					Fractional	Decimal			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH501061	Z	.4130	1/2	2-1/2	4-3/8	DH501073	19/32	.5937	5/8	3-9/32	5-1/4
DH501062	27/64	.4219	1/2	2-13/16	4-5/8	DH501074	39/64	.6094	5/8	3-9/32	5-1/4
DH501063	7/16	.4375	1/2	2-13/16	4-5/8	DH501075	5/8	.6250	5/8	3-9/32	5-1/4
DH501064	29/64	.4531	1/2	2-13/16	4-5/8	DH501076	41/64	.6406	3/4	3-9/32	5-1/4
DH501065	15/32	.4688	1/2	2-13/16	4-5/8	DH501077	21/32	.6563	3/4	3-11/16	5-5/8
DH501066	31/64	.4844	1/2	2-13/16	4-5/8	DH501078	43/64	.6719	3/4	3-11/16	5-5/8
DH501067	1/2	.5000	1/2	3-1/16	5	DH501079	11/16	.6875	3/4	3-11/16	5-5/8
DH501068	33/64	.5156	5/8	3-1/16	5	DH501080	45/64	.7031	3/4	3-11/16	5-5/8
DH501069	17/32	.5312	5/8	3-1/16	5	DH501081	23/32	.7188	3/4	3-3/4	6
DH501070	35/64	.5469	5/8	3-1/16	5	DH501082	47/64	.7344	3/4	3-3/4	6
DH501071	9/16	.5625	5/8	3-1/16	5	DH501083	3/4	.7500	3/4	3-3/4	6
DH501072	37/64	.5781	5/8	3-9/32	5-1/4						

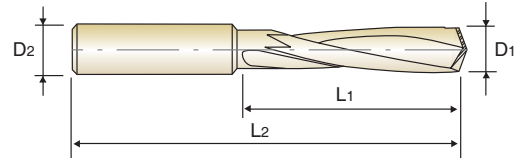
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
			◎	◎							



SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS (HRc50~70)

- 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



P.55

for HIGH HARDENED STEELS

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch					Metric	Inch			
TiAIN	D1		D2	L1	L2	TiAIN	D1		D2	L1	L2
DH500010	1.0	.0394	3	6	40	DH500051	5.1	.2008	6	32	72
DH500011	1.1	.0433	3	6	40	DH500052	5.2	.2047	6	32	72
DH500012	1.2	.0472	3	6	40	DH500053	5.3	.2087	6	32	72
DH500013	1.3	.0512	3	8	40	DH500055	5.5	.2165	6	35	75
DH500014	1.4	.0551	3	8	40	DH500060	6.0	.2362	6	35	75
DH500015	1.5	.0591	3	8	40	DH500062	6.2	.2441	8	40	80
DH500016	1.6	.0630	3	10	40	DH500065	6.5	.2559	8	40	80
DH500017	1.7	.0669	3	10	40	DH500068	6.8	.2677	8	45	85
DH500018	1.8	.0709	3	10	40	DH500069	6.9	.2717	8	45	85
DH500019	1.9	.0748	3	10	40	DH500070	7.0	.2756	8	45	85
DH500020	2.0	.0787	3	12	42	DH500075	7.5	.2953	8	45	85
DH500025	2.5	.0984	3	14	44	DH500080	8.0	.3150	8	50	98
DH500026	2.6	.1024	3	16	44	DH500085	8.5	.3346	10	50	98
DH500028	2.8	.1102	3	16	46	DH500086	8.6	.3386	10	57	105
DH500030	3.0	.1181	3	18	46	DH500088	8.8	.3465	10	57	105
DH500033	3.3	.1299	4	18	48	DH500090	9.0	.3543	10	57	105
DH500034	3.4	.1339	4	20	50	DH500093	9.3	.3661	10	57	105
DH500035	3.5	.1378	4	20	50	DH500095	9.5	.3740	10	57	105
DH500038	3.8	.1496	4	22	52	DH500100	10.0	.3937	10	63	111
DH500040	4.0	.1575	4	22	52	DH500102	10.2	.4016	12	63	111
DH500041	4.1	.1614	6	25	65	DH500103	10.3	.4055	12	63	111
DH500042	4.2	.1654	6	25	65	DH500105	10.5	.4134	12	71	111
DH500043	4.3	.1693	6	28	68	DH500108	10.8	.4252	12	71	119
DH500044	4.4	.1732	6	28	68	DH500110	11.0	.4331	12	71	119
DH500045	4.5	.1772	6	28	68	DH500115	11.5	.4528	12	71	119
DH500046	4.6	.1811	6	28	68	DH500120	12.0	.4724	12	71	119
DH500048	4.8	.1890	6	32	72	DH500121	12.1	.4764	14	77	125
DH500049	4.9	.1929	6	32	72	DH500140	14.0	.5512	14	77	125
DH500050	5.0	.1969	6	32	72						

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
			◎	◎							



SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS HRc50~HRc70, TiAlN COATED

DH501 Series

WORK MATERIAL			P								
			HARDENED STEELS								
			HRc 50~55			HRc 55~60			HRc 60~70		
DRILLING SPEED(SFM)			45 ~ 72 ft/min			32 ~ 52 ft/min			26 ~ 42 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Fractional	Metric(mm)	Decimal									
5/64	1.984	.0781	2860	0.04	.0015	2000	0.04	.0015	1900	0.04	.0015
1/8	3.175	.1250	1900	0.04	.0015	1330	0.04	.0015	1250	0.04	.0015
5/32	3.969	.1563	1430	0.04	.0015	1000	0.04	.0015	950	0.04	.0015
13/64	5.159	.2031	1150	0.04	.0015	800	0.04	.0015	750	0.04	.0015
15/64	5.953	.2344	960	0.04	.0015	670	0.04	.0015	630	0.04	.0015
5/16	7.938	.3125	720	0.04	.0015	500	0.04	.0015	480	0.04	.0015
25/64	9.922	.3906	570	0.04	.0015	400	0.04	.0015	380	0.04	.0015
15/32	11.906	.4688	480	0.04	.0015	330	0.04	.0015	320	0.04	.0015
9/16	14.288	.5625	435	0.04	.0015	280	0.04	.0015	270	0.04	.0015
41/64	16.272	.6406	380	0.04	.0015	250	0.04	.0015	240	0.04	.0015
11/16	17.463	.6875	325	0.04	.0015	235	0.04	.0015	190	0.04	.0015
47/64	18.653	.7344	310	0.04	.0015	220	0.04	.0015	180	0.04	.0015

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

DH500 Series

WORK MATERIAL		P								
		HARDENED STEELS								
		HRc 50~55			HRc 55~60			HRc 60~70		
DRILLING SPEED(SFM)		45 ~ 72 ft/min			32 ~ 52 ft/min			26 ~ 42 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Inch									
1.0	.0394	5600	0.04	.0015	4000	0.04	.0015	3700	0.04	.0015
2.0	.0787	2900	0.04	.0015	2100	0.04	.0015	1900	0.04	.0015
3.0	.1181	1900	0.04	.0015	1330	0.04	.0015	1250	0.04	.0015
4.0	.1575	1430	0.04	.0015	1000	0.04	.0015	950	0.04	.0015
5.0	.1969	1150	0.04	.0015	800	0.04	.0015	750	0.04	.0015
6.0	.2362	960	0.04	.0015	670	0.04	.0015	630	0.04	.0015
8.0	.3150	720	0.04	.0015	500	0.04	.0015	480	0.04	.0015
10.0	.3937	570	0.04	.0015	400	0.04	.0015	380	0.04	.0015
12.0	.4724	480	0.04	.0015	330	0.04	.0015	320	0.04	.0015
14.0	.5512	438	0.04	.0015	282	0.04	.0015	272	0.04	.0015

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)



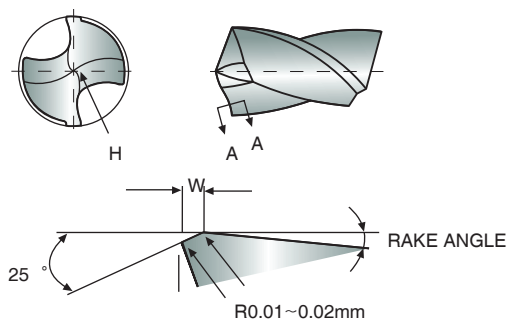
Characteristic of DREAM DRILLS

- YG-1's Dream Drill Series are suitable for high speed and accurate drilling operations by special design and high quality
- Good performance for Steels, Cast Iron, Tool steels, Alloy steels and Stainless steels
- Rapid chip evacuation and excellent chip breaking can be achieved by special designed cutting edges on point and chip breakers on leading edges
- High accuracy and stability
- Longer tool life due to TiAlN coating
- Self-centering



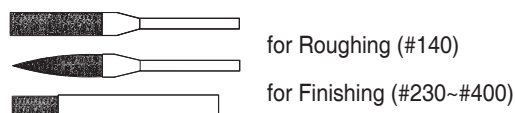
Honing Guide of DREAM DRILL

Dimension of Honing



► Section A-A

Scraper

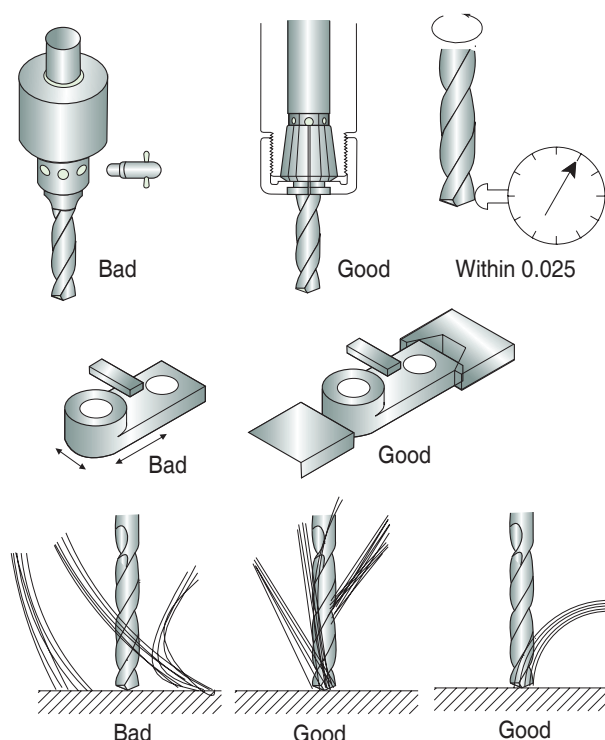


Work Material	Alloy Steels	Mild Steels	Cast Iron
W[mm]	0.15~0.2	0.1~0.15	0.03

► The dimension W of stocked products is 0.1~0.15



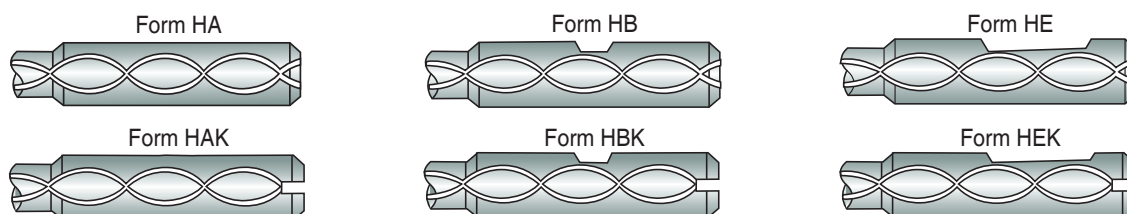
Use of DREAM DRILL



- Chucking with spring collet correctly.
- Radial run out at cutting lip must not exceed 0.025 mm.
- Tighten clamp of work piece.
- Supply coolant enough to the entrance of holes.
- In using Dream Drills with Coolant holes, high pressure coolant is needed.



Shank Type DREAM DRILLS with Coolant Holes



- ▶ Shank Type of stocked products is Form HA
- ▶ Other shank types are available on your request



Drill Diameter Tolerance Inch

up to .118	over .118 up to .236	over .236 up to .394	over .394 up to .709
+0 -.00055	+0 -.00071	+0 -.00087	+0 -.00106

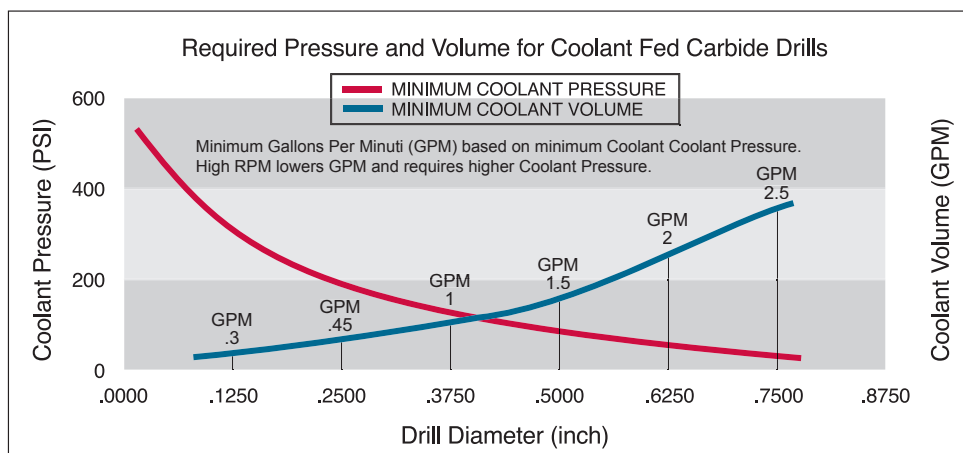
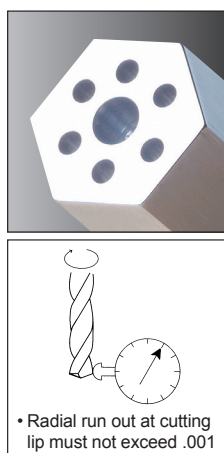


Drill Diameter Tolerance Metric

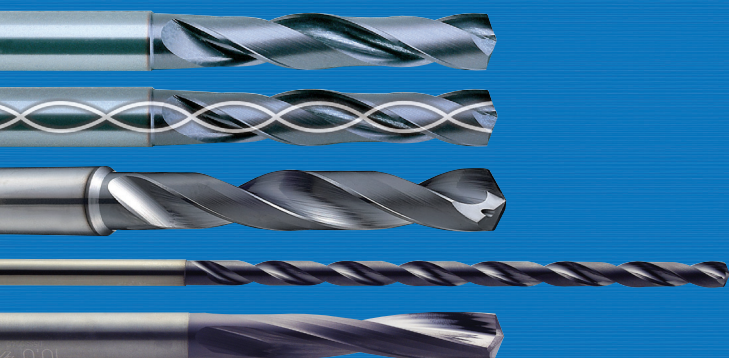
Diameter (mm)	1 - 3 from to	3 - 6 over to	6 - 10 over to	10 - 18 over to	18 - 30 over to
h6	0 -.00024	0 -.00032	0 -.00036	0 -.00044	0 -.00052
h7	0 -.0004	0 -.00048	0 -.00059	0 -.00071	0 -.00083
h8	0 -.00056	0 -.00071	0 -.00087	0 -.00107	0 -.00130
m7	+.00048 +.00007	+.00063 +.00015	+.00083 +.00023	+.00099 +.00027	+.00114 +.00031



Coolant Recommendations for Carbide Dream Drills



SOLID CARBIDE **DREAM DRILLS**



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Tool specifications are subject to change without notice.

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