DREAM DRILLS - GENERAL

PLAIN SHANK **DH408** SERIES
FLAT SHANK **DH448** SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

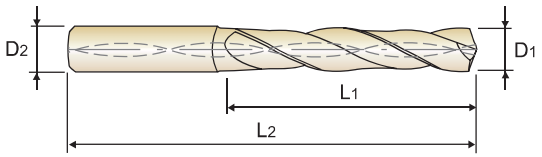
LONG
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LONGUE
LUNGA

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
Forets DREAM DRILLS carbure, avec arrosage central, série longue
PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

- Drilling for Steel, Cast Steel, Cast Iron, Malleable Cast Iron
- Self centering and chip breaking by R-thinning
- Wave shape and negative land on the cutting edge for low thrust, stable torque and long tool life
- Optimized flute shape for strength of drilling and smooth chip evacuation

- Bohren von Stahl, Stahlguss, Gusseisen, Temperguss, Nichteisenmetallen-Leichtmetallen, abrasiven Kunststoffen
- Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung
- Wellenform und Neagtivfase auf der Schneide bewirken geringen Schub, stabiles Drehmoment und lange Standzeit
- Optimierte Nutenform für Hochleistungsbohren und leichte Spanabfuhr





DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | TiAlN

p.A97

5 × D

Recommended ToolHolder

	Plain Shank	Flat Shank
◎	SHRINK FIT HOLDER	HYDRAULIC CHUCK
◎	HYDRAULIC CHUCK	SHRINK FIT HOLDER
○	ER COLLET CHUCK	END MILL HOLDER

Unit : mm

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D_1	D_2	L_1	L_2
DH408010	-	1.0	3	8	55
DH408011	-	1.1	3	12	55
DH408012	-	1.2	3	12	55
DH408013	-	1.3	3	12	55
DH408014	-	1.4	3	12	55
DH408015	-	1.5	3	16	55
DH408016	-	1.6	3	16	55
DH408017	-	1.7	3	16	55
DH408018	-	1.8	3	16	55
DH408019	-	1.9	3	16	55
DH408020	-	2.0	4	21	57
DH408021	-	2.1	4	21	57
DH408022	-	2.2	4	21	57
DH408023	-	2.3	4	21	57
DH408024	-	2.4	4	21	57
DH408025	-	2.5	4	21	57
DH408026	-	2.6	4	21	57
DH408027	-	2.7	4	21	57
DH408028	-	2.8	4	21	57
DH408029	-	2.9	4	21	57
DH408030	DH448030	3.0	6	28	66
DH408031	DH448031	3.1	6	28	66
DH408032	DH448032	3.2	6	28	66
DH408033	DH448033	3.3	6	28	66

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D_1	D_2	L_1	L_2
DH408034	DH448034	3.4	6	28	66
DH408035	DH448035	3.5	6	28	66
DH408036	DH448036	3.6	6	28	66
DH408037	DH448037	3.7	6	28	66
DH408038	DH448038	3.8	6	36	74
DH408039	DH448039	3.9	6	36	74
DH408040	DH448040	4.0	6	36	74
DH408041	DH448041	4.1	6	36	74
DH408042	DH448042	4.2	6	36	74
DH408043	DH448043	4.3	6	36	74
DH408044	DH448044	4.4	6	36	74
DH408045	DH448045	4.5	6	36	74
DH408046	DH448046	4.6	6	36	74
DH408047	DH448047	4.7	6	36	74
DH408048	DH448048	4.8	6	44	82
DH408049	DH448049	4.9	6	44	82
DH408050	DH448050	5.0	6	44	82
DH408051	DH448051	5.1	6	44	82
DH408052	DH448052	5.2	6	44	82
DH408053	DH448053	5.3	6	44	82
DH408054	DH448054	5.4	6	44	82
DH408055	DH448055	5.5	6	44	82
DH408056	DH448056	5.6	6	44	82
DH408057	DH448057	5.7	6	44	82

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

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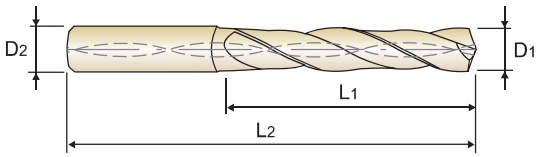
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DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | TiAlN

p.A97

5 × D

Recommended ToolHolder

Plain Shank	Flat Shank
SHRINK FIT HOLDER	HYDRAULIC CHUCK
HYDRAULIC CHUCK	SHRINK FIT HOLDER
ER COLLET CHUCK	END MILL HOLDER

Unit : mm

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D_1	D_2	L_1	L_2
DH408058	DH448058	5.8	6	44	82
DH408059	DH448059	5.9	6	44	82
DH408060	DH448060	6.0	6	44	82
DH408061	DH448061	6.1	8	53	91
DH408062	DH448062	6.2	8	53	91
DH408063	DH448063	6.3	8	53	91
DH408064	DH448064	6.4	8	53	91
DH408065	DH448065	6.5	8	53	91
DH408066	DH448066	6.6	8	53	91
DH408067	DH448067	6.7	8	53	91
DH408068	DH448068	6.8	8	53	91
DH408069	DH448069	6.9	8	53	91
DH408070	DH448070	7.0	8	53	91
DH408071	DH448071	7.1	8	53	91
DH408072	DH448072	7.2	8	53	91
DH408073	DH448073	7.3	8	53	91
DH408074	DH448074	7.4	8	53	91
DH408075	DH448075	7.5	8	53	91
DH408076	DH448076	7.6	8	53	91
DH408077	DH448077	7.7	8	53	91
DH408078	DH448078	7.8	8	53	91
DH408079	DH448079	7.9	8	53	91
DH408080	DH448080	8.0	8	53	91
DH408081	DH448081	8.1	10	61	103

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D_1	D_2	L_1	L_2
DH408082	DH448082	8.2	10	61	103
DH408083	DH448083	8.3	10	61	103
DH408084	DH448084	8.4	10	61	103
DH408085	DH448085	8.5	10	61	103
DH408086	DH448086	8.6	10	61	103
DH408087	DH448087	8.7	10	61	103
DH408088	DH448088	8.8	10	61	103
DH408089	DH448089	8.9	10	61	103
DH408090	DH448090	9.0	10	61	103
DH408091	DH448091	9.1	10	61	103
DH408092	DH448092	9.2	10	61	103
DH408093	DH448093	9.3	10	61	103
DH408094	DH448094	9.4	10	61	103
DH408095	DH448095	9.5	10	61	103
DH408096	DH448096	9.6	10	61	103
DH408097	DH448097	9.7	10	61	103
DH408098	DH448098	9.8	10	61	103
DH408099	DH448099	9.9	10	61	103
DH408100	DH448100	10.0	10	61	103
DH408101	DH448101	10.1	12	71	118
DH408102	DH448102	10.2	12	71	118
DH408103	DH448103	10.3	12	71	118
DH408104	DH448104	10.4	12	71	118
DH408105	DH448105	10.5	12	71	118

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

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FLAT SHANK **DH448** SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

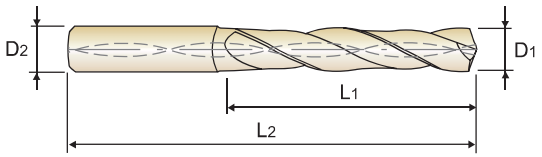
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ER COLLET CHUCK	END MILL HOLDER

Unit : mm

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D1	D2	L1	L2
DH408106	DH448106	10.6	12	71	118
DH408107	DH448107	10.7	12	71	118
DH408108	DH448108	10.8	12	71	118
DH408109	DH448109	10.9	12	71	118
DH408110	DH448110	11.0	12	71	118
DH408111	DH448111	11.1	12	71	118
DH408112	DH448112	11.2	12	71	118
DH408113	DH448113	11.3	12	71	118
DH408114	DH448114	11.4	12	71	118
DH408115	DH448115	11.5	12	71	118
DH408116	DH448116	11.6	12	71	118
DH408117	DH448117	11.7	12	71	118
DH408118	DH448118	11.8	12	71	118
DH408119	DH448119	11.9	12	71	118
DH408120	DH448120	12.0	12	71	118
DH408125	DH448125	12.5	14	77	124
DH408130	DH448130	13.0	14	77	124
DH408135	DH448135	13.5	14	77	124
DH408140	DH448140	14.0	14	77	124
DH408145	DH448145	14.5	16	83	133
DH408150	DH448150	15.0	16	83	133
DH408155	DH448155	15.5	16	83	133
DH408160	DH448160	16.0	16	83	133
DH408165	DH448165	16.5	18	93	143

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D1	D2	L1	L2
DH408170	DH448170	17.0	18	93	143
DH408175	DH448175	17.5	18	93	143
DH408180	DH448180	18.0	18	93	143
DH408185	DH448185	18.5	20	101	153
DH408190	DH448190	19.0	20	101	153
DH408195	DH448195	19.5	20	101	153
DH408200	DH448200	20.0	20	101	153

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◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			