DREAM DRILLS - GENERAL

PLAIN SHANK **DH424** SERIES
FLAT SHANK **DH444** SERIES

CARBIDE, DREAM DRILLS

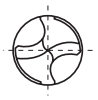
LONG
LANG
LONGUE
LUNGA

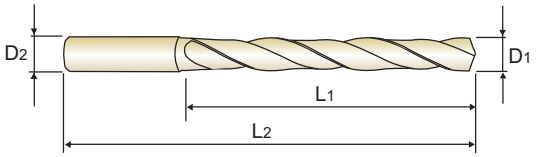
VOLLHARTMETALL DREAM SPIRALBOHRER
Forets DREAM DRILLS carbure, série longue
PUNTE ELICOIDALI IN MD - DREAM DRILLS

- 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° | TiAlN | p.A96

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	D1	D2	L1	L2
DH424010	-	1.0	3	8	55
DH424011	-	1.1	3	12	55
DH424012	-	1.2	3	12	55
DH424013	-	1.3	3	12	55
DH424014	-	1.4	3	12	55
DH424015	-	1.5	3	16	55
DH424016	-	1.6	3	16	55
DH424017	-	1.7	3	16	55
DH424018	-	1.8	3	16	55
DH424019	-	1.9	3	16	55
DH424020	-	2.0	4	21	57
DH424021	-	2.1	4	21	57
DH424022	-	2.2	4	21	57
DH424023	-	2.3	4	21	57
DH424024	-	2.4	4	21	57
DH424025	-	2.5	4	21	57
DH424026	-	2.6	4	21	57
DH424027	-	2.7	4	21	57
DH424028	-	2.8	4	21	57
DH424029	-	2.9	4	21	57
DH424030	DH444030	3.0	6	28	66
DH424031	DH444031	3.1	6	28	66
DH424032	DH444032	3.2	6	28	66
DH424033	DH444033	3.3	6	28	66

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D1	D2	L1	L2
DH424034	DH444034	3.4	6	28	66
DH424035	DH444035	3.5	6	28	66
DH424036	DH444036	3.6	6	28	66
DH424037	DH444037	3.7	6	28	66
DH424038	DH444038	3.8	6	36	74
DH424039	DH444039	3.9	6	36	74
DH424040	DH444040	4.0	6	36	74
DH424041	DH444041	4.1	6	36	74
DH424042	DH444042	4.2	6	36	74
DH424043	DH444043	4.3	6	36	74
DH424044	DH444044	4.4	6	36	74
DH424045	DH444045	4.5	6	36	74
DH424046	DH444046	4.6	6	36	74
DH424047	DH444047	4.7	6	36	74
DH424048	DH444048	4.8	6	44	82
DH424049	DH444049	4.9	6	44	82
DH424050	DH444050	5.0	6	44	82
DH424051	DH444051	5.1	6	44	82
DH424052	DH444052	5.2	6	44	82
DH424053	DH444053	5.3	6	44	82
DH424054	DH444054	5.4	6	44	82
DH424055	DH444055	5.5	6	44	82
DH424056	DH444056	5.6	6	44	82
DH424057	DH444057	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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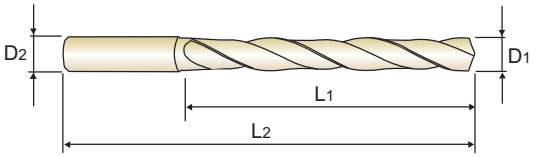

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | TiAlN

p.A96

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
DH424058	DH444058	5.8	6	44	82
DH424059	DH444059	5.9	6	44	82
DH424060	DH444060	6.0	6	44	82
DH424061	DH444061	6.1	8	53	91
DH424062	DH444062	6.2	8	53	91
DH424063	DH444063	6.3	8	53	91
DH424064	DH444064	6.4	8	53	91
DH424065	DH444065	6.5	8	53	91
DH424066	DH444066	6.6	8	53	91
DH424067	DH444067	6.7	8	53	91
DH424068	DH444068	6.8	8	53	91
DH424069	DH444069	6.9	8	53	91
DH424070	DH444070	7.0	8	53	91
DH424071	DH444071	7.1	8	53	91
DH424072	DH444072	7.2	8	53	91
DH424073	DH444073	7.3	8	53	91
DH424074	DH444074	7.4	8	53	91
DH424075	DH444075	7.5	8	53	91
DH424076	DH444076	7.6	8	53	91
DH424077	DH444077	7.7	8	53	91
DH424078	DH444078	7.8	8	53	91
DH424079	DH444079	7.9	8	53	91
DH424080	DH444080	8.0	8	53	91
DH424081	DH444081	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
DH424082	DH444082	8.2	10	61	103
DH424083	DH444083	8.3	10	61	103
DH424084	DH444084	8.4	10	61	103
DH424085	DH444085	8.5	10	61	103
DH424086	DH444086	8.6	10	61	103
DH424087	DH444087	8.7	10	61	103
DH424088	DH444088	8.8	10	61	103
DH424089	DH444089	8.9	10	61	103
DH424090	DH444090	9.0	10	61	103
DH424091	DH444091	9.1	10	61	103
DH424092	DH444092	9.2	10	61	103
DH424093	DH444093	9.3	10	61	103
DH424094	DH444094	9.4	10	61	103
DH424095	DH444095	9.5	10	61	103
DH424096	DH444096	9.6	10	61	103
DH424097	DH444097	9.7	10	61	103
DH424098	DH444098	9.8	10	61	103
DH424099	DH444099	9.9	10	61	103
DH424100	DH444100	10.0	10	61	103
DH424101	DH444101	10.1	12	71	118
DH424102	DH444102	10.2	12	71	118
DH424103	DH444103	10.3	12	71	118
DH424104	DH444104	10.4	12	71	118
DH424105	DH444105	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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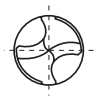

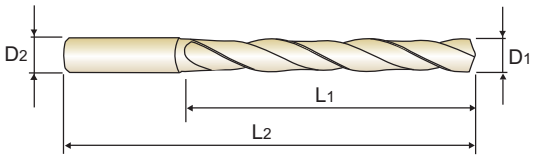

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | TiAlN

p.A96

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	D1	D2	L1	L2
DH424106	DH444106	10.6	12	71	118
DH424107	DH444107	10.7	12	71	118
DH424108	DH444108	10.8	12	71	118
DH424109	DH444109	10.9	12	71	118
DH424110	DH444110	11.0	12	71	118
DH424111	DH444111	11.1	12	71	118
DH424112	DH444112	11.2	12	71	118
DH424113	DH444113	11.3	12	71	118
DH424114	DH444114	11.4	12	71	118
DH424115	DH444115	11.5	12	71	118
DH424116	DH444116	11.6	12	71	118
DH424117	DH444117	11.7	12	71	118
DH424118	DH444118	11.8	12	71	118
DH424119	DH444119	11.9	12	71	118
DH424120	DH444120	12.0	12	71	118
DH424125	DH444125	12.5	14	77	124
DH424130	DH444130	13.0	14	77	124
DH424135	DH444135	13.5	14	77	124
DH424140	DH444140	14.0	14	77	124
DH424145	DH444145	14.5	16	83	133
DH424150	DH444150	15.0	16	83	133
DH424155	DH444155	15.5	16	83	133
DH424160	DH444160	16.0	16	83	133
DH424165	DH444165	16.5	18	93	143

EDP No. (TiAlN)		Drill Diameter	Shank Diameter	Flute Length	Overall Length
Plain	Flat	D1	D2	L1	L2
DH424170	DH444170	17.0	18	93	143
DH424175	DH444175	17.5	18	93	143
DH424180	DH444180	18.0	18	93	143
DH424185	DH444185	18.5	20	101	153
DH424190	DH444190	19.0	20	101	153
DH424195	DH444195	19.5	20	101	153
DH424200	DH444200	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																		○			