DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRC50 ~ HRC70)

SHORT

VOLLHARTMETALL DREAM SPIRALBOHRER FÜR HOCHGEHARTETE STAHLE — *KURZ*

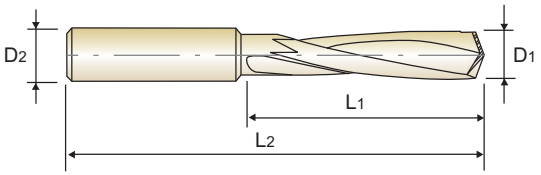
Forets DREAM DRILLS carbure pour Aciers Trempés (50 HRc ~ 70 HRc) — *COURTE*

PUNTE ELICOIDALI IN MD, DREAM DRILL - ACCIAI HRC50 - 70 — *CORTA*

- ▶Drilling for High Hardened Steels; Quenched Steels, Tempered Steels (under HRc70)
- ▶Special geometry design for Hardened Steels
- ▶Minimum of cutting load through special thinning
- ▶Performing good chip removal and powerful drilling

- ▶Bohren von hoch gehärteten Stählen, Vergütungsstähle, angelassenen Stählen bis HRc70
- ▶Spezielle Bohrergeometrie für gehärtete Stähle
- ▶Minimaler Schnedendruck durch spezielle Ausspitzung
- ▶Gute Spanabfuhr und Hochleistungsbohren





CARBIDE | 15° | h6 | h7 | 140° | TiAlN

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3 × D

Recommended ToolHolder: Plain Shank; SHRINK FIT HOLDER; HYDRAULIC CHUCK; ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH500026	2.6	3	14	44
DH500030	3.0	3	16	46
DH500033	3.3	4	18	48
DH500034	3.4	4	20	50
DH500035	3.5	4	20	50
DH500040	4.0	4	22	52
DH500042	4.2	6	25	65
DH500043	4.3	6	28	68
DH500044	4.4	6	28	68
DH500045	4.5	6	28	68
DH500050	5.0	6	32	72
DH500051	5.1	6	32	72
DH500052	5.2	6	32	72
DH500055	5.5	6	35	75
DH500060	6.0	6	35	75
DH500065	6.5	8	40	80
DH500068	6.8	8	45	85
DH500069	6.9	8	45	85

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH500070	7.0	8	45	85
DH500075	7.5	8	45	85
DH500080	8.0	8	50	98
DH500085	8.5	10	50	98
DH500086	8.6	10	57	105
DH500088	8.8	10	57	105
DH500090	9.0	10	57	105
DH500095	9.5	10	57	105
DH500100	10.0	10	63	111
DH500102	10.2	12	63	111
DH500103	10.3	12	63	111
DH500105	10.5	12	63	111
DH500108	10.8	12	71	119
DH500110	11.0	12	71	119
DH500115	11.5	12	71	119
DH500120	12.0	12	71	119
DH500140	14.0	14	77	125

Recommended cutting conditions

EMPFOHLENE SCHNEIDPARAMETER

Vc = m/min.
RPM = rev./min.
FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm) 2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0
H	38	Hardened steel	20	RPM	2550	2120	1590	1270	1060	800	640	530	450
				FEED	0.01-0.03	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06
	39.1		15	RPM	1910	1590	1190	950	800	600	480	400	340
				FEED	0.01-0.03	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06
	39.3		12	RPM	1530	1270	950	760	640	480	380	320	270
				FEED	0.01-0.03	0.01-0.03	0.01-0.04	0.01-0.04	0.01-0.05	0.01-0.05	0.01-0.05	0.01-0.06	0.01-0.06

◎ : 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	39.1	39.3	40	41
HRc											15	30	25	38	34			55	60	70	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																		◎	◎	◎		