DREAM DRILLS - MQL TYPE

DHM15 SERIES
DHM10 SERIES
DHM20 SERIES

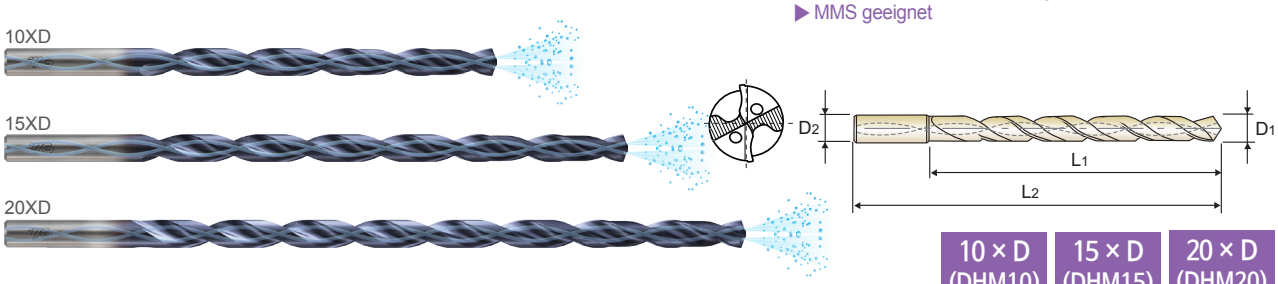
CARBIDE, DREAM DRILL MQL TYPE END MILL SHANK with COOLANT HOLE

EXTRA LONG
ÜBERLANG
EXTRA-LONGUE
EXTRA LUNGA

VOLLHARTMETALL DREAM SPIRALBOHRER MQL - TYPE MIT KÜHLKANAL
Forets DREAM DRILLS carbure Type MQL avec arrosage central, série extra-longue
PUNTE MD, DREAM DRILLS MQL GAMBO RINFORZATO (con fori di ferigerazione)

- 4-Facet Point for good centering capability
- Optimized special flutes are ideal for removing chips and for productive drilling
- Enhanced chip evacuation by polished flute upgraded TiAlN nano layer full coating
- MQL system compatible (Minimum Quantity Lubrication)

- 4-Facetten-Spitze für gute Zentrierfähigkeit
- Optimierte Spezialnuten für die ideale Spanabfuhr und zum produktiven Bohren
- Verbesserte Spanabfuhr durch hochglanzpolierte TiAlN-Nano-Vollbeschichtung
- MMS geeignet



10 × D (DHM10) | 15 × D (DHM15) | 20 × D (DHM20)

CARBIDE | 30° | h6 | h7 | 140° | DHM10 20 bar | DHM15 DHM20 45 bar | TiAlN

p.A148

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

Unit : mm

DHM10

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DHM10030	3.0	6	40	80
DHM10033	3.3	6	47	87
DHM10035	3.5	6	47	87
DHM10040	4.0	6	53	93
DHM10042	4.2	6	60	100
DHM10045	4.5	6	60	100
DHM10050	5.0	6	66	106
DHM10055	5.5	6	73	113
DHM10060	6.0	6	79	119
DHM10065	6.5	8	86	126
DHM10068	6.8	8	92	132
DHM10070	7.0	8	92	132
DHM10075	7.5	8	99	139
DHM10080	8.0	8	105	145
DHM10085	8.5	10	112	156
DHM10090	9.0	10	118	162
DHM10095	9.5	10	126	170
DHM10100	10.0	10	132	176
DHM10105	10.5	12	139	188
DHM10110	11.0	12	145	194
DHM10115	11.5	12	152	201
DHM10120	12.0	12	158	207
DHM10125	12.5	14	165	214
DHM10130	13.0	14	171	220
DHM10135	13.5	14	178	227
DHM10140	14.0	14	184	233

DHM15

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DHM15030	3.0	6	55	95
DHM15035	3.5	6	64	104
DHM15040	4.0	6	73	113
DHM15045	4.5	6	82	122
DHM15050	5.0	6	91	131
DHM15055	5.5	6	100	140
DHM15060	6.0	6	109	149
DHM15070	7.0	8	127	167
DHM15080	8.0	8	145	185
DHM15090	9.0	10	163	207
DHM15100	10.0	10	182	226
DHM15110	11.0	12	200	249
DHM15120	12.0	12	218	267

DHM20

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DHM20030	3.0	6	70	110
DHM20035	3.5	6	82	122
DHM20040	4.0	6	93	133
DHM20045	4.5	6	105	145
DHM20050	5.0	6	116	156
DHM20055	5.5	6	128	168
DHM20060	6.0	6	139	179
DHM20070	7.0	8	162	202
DHM20080	8.0	8	185	225
DHM20090	9.0	10	208	252
DHM20100	10.0	10	232	276
DHM20110	11.0	12	255	304
DHM20120	12.0	12	278	327

◎ : 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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