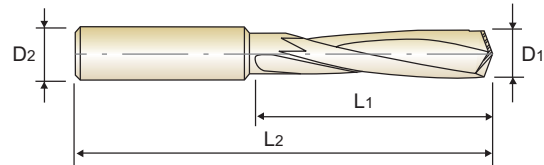


TiAIN-COATED SOLID CARBIDE DREAM DRILLS for High Hardened Steels (HRc 50 - 70)

DH500 SERIES

- ▶ Drilling for High Hardened Steels; Quenched Steels, Tempered Steels (under HRc 70)
- ▶ Special geometry design for Hardened Steels
- ▶ Minimum of cutting load through special thinning
- ▶ Performing good chip removal and powerful drilling


3 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	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

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	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

CUTTING CONDITIONS

DH500 SERIES DREAM DRILLS for HIGH HARDENED STEELS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)							
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0
H	38	Hardened steel	20	RPM	2120	1590	1270	1060	800	640	530	450
				FEED	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	1590	1190	950	800	600	480	400	340
				FEED	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	1270	950	760	640	480	380	320	270
				FEED	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	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																		◎	◎	◎		