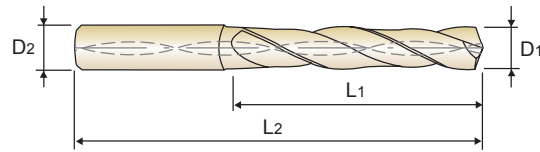




SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

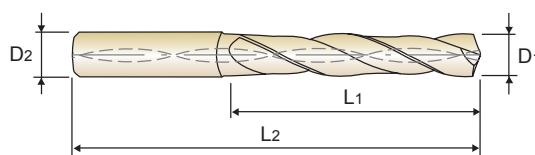
DREAM DRILLS | 3x3

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5432030	3.0	6	20	62	D5432076	7.6	8	41	79
D5432031	3.1	6	20	62	D5432077	7.7	8	41	79
D5432032	3.2	6	20	62	D5432078	7.8	8	41	79
D5432033	3.3	6	20	62	D5432079	7.9	8	41	79
D5432034	3.4	6	20	62	D5432080	8.0	8	41	79
D5432035	3.5	6	20	62	D5432081	8.1	10	47	89
D5432036	3.6	6	20	62	D5432082	8.2	10	47	89
D5432037	3.7	6	20	62	D5432083	8.3	10	47	89
D5432038	3.8	6	24	66	D5432084	8.4	10	47	89
D5432039	3.9	6	24	66	D5432085	8.5	10	47	89
D5432040	4.0	6	24	66	D5432086	8.6	10	47	89
D5432041	4.1	6	24	66	D5432087	8.7	10	47	89
D5432042	4.2	6	24	66	D5432088	8.8	10	47	89
D5432043	4.3	6	24	66	D5432089	8.9	10	47	89
D5432044	4.4	6	24	66	D5432090	9.0	10	47	89
D5432045	4.5	6	24	66	D5432091	9.1	10	47	89
D5432046	4.6	6	24	66	D5432092	9.2	10	47	89
D5432047	4.7	6	24	66	D5432093	9.3	10	47	89
D5432048	4.8	6	28	66	D5432094	9.4	10	47	89
D5432049	4.9	6	28	66	D5432095	9.5	10	47	89
D5432050	5.0	6	28	66	D5432096	9.6	10	47	89
D5432051	5.1	6	28	66	D5432097	9.7	10	47	89
D5432052	5.2	6	28	66	D5432098	9.8	10	47	89
D5432053	5.3	6	28	66	D5432099	9.9	10	47	89
D5432054	5.4	6	28	66	D5432100	10.0	10	47	89
D5432055	5.5	6	28	66	D5432101	10.1	12	55	102
D5432056	5.6	6	28	66	D5432102	10.2	12	55	102
D5432057	5.7	6	28	66	D5432103	10.3	12	55	102
D5432058	5.8	6	28	66	D5432104	10.4	12	55	102
D5432059	5.9	6	28	66	D5432105	10.5	12	55	102
D5432060	6.0	6	28	66	D5432106	10.6	12	55	102
D5432061	6.1	8	34	79	D5432107	10.7	12	55	102
D5432062	6.2	8	34	79	D5432108	10.8	12	55	102
D5432063	6.3	8	34	79	D5432109	10.9	12	55	102
D5432064	6.4	8	34	79	D5432110	11.0	12	55	102
D5432065	6.5	8	34	79	D5432111	11.1	12	55	102
D5432066	6.6	8	34	79	D5432112	11.2	12	55	102
D5432067	6.7	8	34	79	D5432113	11.3	12	55	102
D5432068	6.8	8	34	79	D5432114	11.4	12	55	102
D5432069	6.9	8	34	79	D5432115	11.5	12	55	102
D5432070	7.0	8	34	79	D5432116	11.6	12	55	102
D5432071	7.1	8	41	79	D5432117	11.7	12	55	102
D5432072	7.2	8	41	79	D5432118	11.8	12	55	102
D5432073	7.3	8	41	79	D5432119	11.9	12	55	102
D5432074	7.4	8	41	79	D5432120	12.0	12	55	102
D5432075	7.5	8	41	79	D5432125	12.5	14	60	107



SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

DREAM DRILLS | 3x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5432130	13.0	14	60	107	D5432170	17.0	18	73	123
D5432135	13.5	14	60	107	D5432175	17.5	18	73	123
D5432140	14.0	14	60	107	D5432180	18.0	18	73	123
D5432145	14.5	16	65	115	D5432185	18.5	20	79	131
D5432150	15.0	16	65	115	D5432190	19.0	20	79	131
D5432155	15.5	16	65	115	D5432195	19.5	20	79	131
D5432160	16.0	16	65	115	D5432200	20.0	20	79	131
D5432165	16.5	18	73	123					

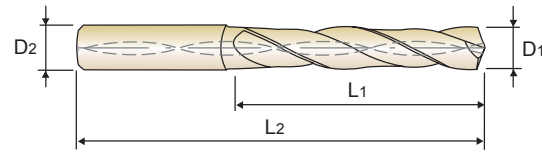
Recommended Cutting Condition

Unit : mm

	Φ3.0~Φ6.0		~Φ10.0		~Φ14.0		~Φ20.0	
	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)
Aluminium Alloy Casting	8,000~15,000	0.2~0.5	6,000~10,500	0.3~1.0	4,500~5,800	0.3~1.0	3,200~4,600	0.3~1.0
Aluminium Die Casting								
Wrought Aluminium Alloy	8,000~15,000	0.15~0.3	6,000~10,500	0.2~0.4	4,500~5,800	0.2~0.4	3,200~4,600	0.2~0.4



SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

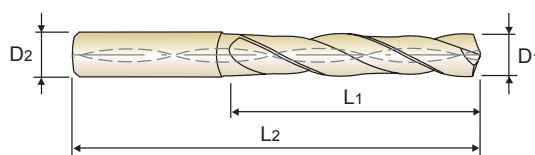
DREAM DRILLS | 5x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5433030	3.0	6	28	66	D5433076	7.6	8	53	91
D5433031	3.1	6	28	66	D5433077	7.7	8	53	91
D5433032	3.2	6	28	66	D5433078	7.8	8	53	91
D5433033	3.3	6	28	66	D5433079	7.9	8	53	91
D5433034	3.4	6	28	66	D5433080	8.0	8	53	91
D5433035	3.5	6	28	66	D5433081	8.1	10	61	103
D5433036	3.6	6	28	66	D5433082	8.2	10	61	103
D5433037	3.7	6	28	66	D5433083	8.3	10	61	103
D5433038	3.8	6	36	74	D5433084	8.4	10	61	103
D5433039	3.9	6	36	74	D5433085	8.5	10	61	103
D5433040	4.0	6	36	74	D5433086	8.6	10	61	103
D5433041	4.1	6	36	74	D5433087	8.7	10	61	103
D5433042	4.2	6	36	74	D5433088	8.8	10	61	103
D5433043	4.3	6	36	74	D5433089	8.9	10	61	103
D5433044	4.4	6	36	74	D5433090	9.0	10	61	103
D5433045	4.5	6	36	74	D5433091	9.1	10	61	103
D5433046	4.6	6	36	74	D5433092	9.2	10	61	103
D5433047	4.7	6	36	74	D5433093	9.3	10	61	103
D5433048	4.8	6	44	82	D5433094	9.4	10	61	103
D5433049	4.9	6	44	82	D5433095	9.5	10	61	103
D5433050	5.0	6	44	82	D5433096	9.6	10	61	103
D5433051	5.1	6	44	82	D5433097	9.7	10	61	103
D5433052	5.2	6	44	82	D5433098	9.8	10	61	103
D5433053	5.3	6	44	82	D5433099	9.9	10	61	103
D5433054	5.4	6	44	82	D5433100	10.0	10	61	103
D5433055	5.5	6	44	82	D5433101	10.1	12	71	118
D5433056	5.6	6	44	82	D5433102	10.2	12	71	118
D5433057	5.7	6	44	82	D5433103	10.3	12	71	118
D5433058	5.8	6	44	82	D5433104	10.4	12	71	118
D5433059	5.9	6	44	82	D5433105	10.5	12	71	118
D5433060	6.0	6	44	82	D5433106	10.6	12	71	118
D5433061	6.1	8	53	91	D5433107	10.7	12	71	118
D5433062	6.2	8	53	91	D5433108	10.8	12	71	118
D5433063	6.3	8	53	91	D5433109	10.9	12	71	118
D5433064	6.4	8	53	91	D5433110	11.0	12	71	118
D5433065	6.5	8	53	91	D5433111	11.1	12	71	118
D5433066	6.6	8	53	91	D5433112	11.2	12	71	118
D5433067	6.7	8	53	91	D5433113	11.3	12	71	118
D5433068	6.8	8	53	91	D5433114	11.4	12	71	118
D5433069	6.9	8	53	91	D5433115	11.5	12	71	118
D5433070	7.0	8	53	91	D5433116	11.6	12	71	118
D5433071	7.1	8	53	91	D5433117	11.7	12	71	118
D5433072	7.2	8	53	91	D5433118	11.8	12	71	118
D5433073	7.3	8	53	91	D5433119	11.9	12	71	118
D5433074	7.4	8	53	91	D5433120	12.0	12	71	118
D5433075	7.5	8	53	91	D5433125	12.5	14	77	124



SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

DREAM DRILLS | 5x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5433130	13.0	14	77	124	D5433170	17.0	18	93	143
D5433135	13.5	14	77	124	D5433175	17.5	18	93	143
D5433140	14.0	14	77	124	D5433180	18.0	18	93	143
D5433145	14.5	16	83	133	D5433185	18.5	20	101	153
D5433150	15.0	16	83	133	D5433190	19.0	20	101	153
D5433155	15.5	16	83	133	D5433195	19.5	20	101	153
D5433160	16.0	16	83	133	D5433200	20.0	20	101	153
D5433165	16.5	18	93	143					

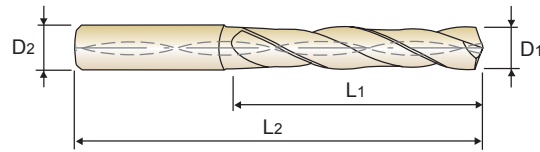
Recommended Cutting Condition

Unit : mm

	Φ3.0~Φ6.0		~Φ10.0		~Φ14.0		~Φ20.0	
	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)
Aluminium Alloy Casting	8,000~15,000	0.2~0.5	6,000~10,500	0.3~1.0	4,500~5,800	0.3~1.0	3,200~4,600	0.3~1.0
Aluminium Die Casting								
Wrought Aluminium Alloy	8,000~15,000	0.15~0.3	6,000~10,500	0.2~0.4	4,500~5,800	0.2~0.4	3,200~4,600	0.2~0.4



SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

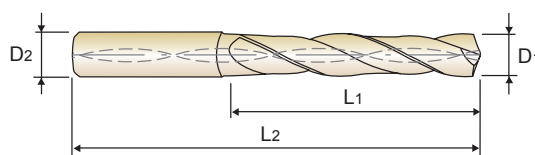
DREAM DRILLS | 8x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5434030	3.0	6	34	72	D5434070	7.0	8	76	114
D5434031	3.1	6	34	72	D5434071	7.1	8	76	114
D5434032	3.2	6	34	72	D5434072	7.2	8	76	114
D5434033	3.3	6	34	72	D5434073	7.3	8	76	114
D5434034	3.4	6	34	72	D5434074	7.4	8	76	114
D5434035	3.5	6	34	72	D5434075	7.5	8	76	114
D5434036	3.6	6	34	72	D5434076	7.6	8	76	114
D5434037	3.7	6	34	72	D5434077	7.7	8	76	114
D5434038	3.8	6	43	81	D5434078	7.8	8	76	114
D5434039	3.9	6	43	81	D5434079	7.9	8	76	114
D5434040	4.0	6	43	81	D5434080	8.0	8	76	114
D5434041	4.1	6	43	81	D5434081	8.1	10	95	142
D5434042	4.2	6	43	81	D5434082	8.2	10	95	142
D5434043	4.3	6	43	81	D5434083	8.3	10	95	142
D5434044	4.4	6	43	81	D5434084	8.4	10	95	142
D5434045	4.5	6	43	81	D5434085	8.5	10	95	142
D5434046	4.6	6	43	81	D5434086	8.6	10	95	142
D5434047	4.7	6	43	81	D5434087	8.7	10	95	142
D5434048	4.8	6	57	95	D5434088	8.8	10	95	142
D5434049	4.9	6	57	95	D5434089	8.9	10	95	142
D5434050	5.0	6	57	95	D5434090	9.0	10	95	142
D5434051	5.1	6	57	95	D5434091	9.1	10	95	142
D5434052	5.2	6	57	95	D5434092	9.2	10	95	142
D5434053	5.3	6	57	95	D5434093	9.3	10	95	142
D5434054	5.4	6	57	95	D5434094	9.4	10	95	142
D5434055	5.5	6	57	95	D5434095	9.5	10	95	142
D5434056	5.6	6	57	95	D5434096	9.6	10	95	142
D5434057	5.7	6	57	95	D5434097	9.7	10	95	142
D5434058	5.8	6	57	95	D5434098	9.8	10	95	142
D5434059	5.9	6	57	95	D5434099	9.9	10	95	142
D5434060	6.0	6	57	95	D5434100	10.0	10	95	142
D5434061	6.1	8	76	114	D5434101	10.1	12	114	162
D5434062	6.2	8	76	114	D5434102	10.2	12	114	162
D5434063	6.3	8	76	114	D5434103	10.3	12	114	162
D5434064	6.4	8	76	114	D5434104	10.4	12	114	162
D5434065	6.5	8	76	114	D5434105	10.5	12	114	162
D5434066	6.6	8	76	114	D5434106	10.6	12	114	162
D5434067	6.7	8	76	114	D5434107	10.7	12	114	162
D5434068	6.8	8	76	114	D5434108	10.8	12	114	162
D5434069	6.9	8	76	114	D5434109	10.9	12	114	162



SOLID CARBIDE DREAM DRILLS - ALU with COOLANT HOLES



DIN 6537

MG

h6

m7

140°

DREAM DRILLS | 8×D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Uncoated	D1	D2	L1	L2	Uncoated	D1	D2	L1	L2
D5434110	11.0	12	114	162	D5434118	11.8	12	114	162
D5434111	11.1	12	114	162	D5434119	11.9	12	114	162
D5434112	11.2	12	114	162	D5434120	12.0	12	114	162
D5434113	11.3	12	114	162	D5434125	12.5	14	133	178
D5434114	11.4	12	114	162	D5434130	13.0	14	133	178
D5434115	11.5	12	114	162	D5434135	13.5	14	133	178
D5434116	11.6	12	114	162	D5434140	14.0	14	133	178
D5434117	11.7	12	114	162					

Recommended Cutting Condition

Unit : mm

	Φ3.0~Φ6.0		~Φ10.0		~Φ14.0	
	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)	RPM(MIN ⁻¹)	Feed(mm/rev)
Aluminium Alloy Casting	8,000~15,000	0.2~0.5	6,000~10,500	0.3~1.0	4,500~5,800	0.3~1.0
Aluminium Die Casting						
Wrought Aluminium Alloy	8,000~15,000	0.15~0.3	6,000~10,500	0.2~0.4	4,500~5,800	0.2~0.4