

SELECTION GUIDE



SERIES	DTX404	DTX423
DRILLING DEPTH	3XD	3XD
LENGTH	STUB	SHORT
SIZE MIN	D3.0	D3.0
SIZE MAX	D20.0	D20.0
PAGE	A78	A80
SURFACE TREATMENT	RCH-Coating	

SOLID CARBIDE
DREAM DRILL X

Multi-Purpose Solid Carbide Drilling up to HRC50



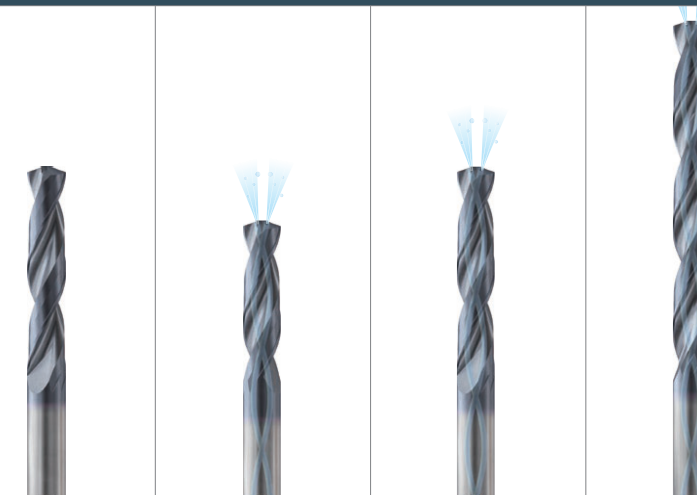
Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A92

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
P	1	Non-alloy steel	About 0.15% C Annealed	125	
	2		About 0.45% C Annealed	190	13
	3		About 0.45% C Quenched & Tempered	250	25
	4		About 0.75% C Annealed	270	28
	5	About 0.75% C Quenched & Tempered	300	32	
	6	Low alloy steel	Annealed	180	10
	7		Quenched & Tempered	275	29
	8		Quenched & Tempered	300	32
	9		Quenched & Tempered	350	38
	10		High alloyed steel, and tool steel	Annealed	200
	11	Quenched & Tempered	325	35	
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15
	13		Martensitic Quenched & Tempered	240	23
	14	Austenitic	180	10	
K	15	Grey cast iron	Pearlitic / ferritic	180	10
	16		Pearlitic (Martensitic)	260	26
	17	Nodular cast iron	Ferritic	160	3
	18		Pearlitic	250	25
	19	Malleable cast iron	Ferritic	130	
	20		Pearlitic	230	21
N	21	Aluminum-wrought alloy	Not Curable	60	
	22		Curable Hardened	100	
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75	
	24		≤ 12% Si, Curable Hardened	90	
	25		> 12% Si, Not Curable	130	
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110	
	27		CuZn, CuSnZn (Brass)	90	
	28		CuSn, lead-free copper and electrolytic copper	100	
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic		
	30		Rubber, Wood, etc.		
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15
	32		Cured	280	30
	33		Annealed	250	25
	34		Cured	350	38
	35	Cast	320	34	
	36	Titanium Alloys	Pure Titanium	400 Rm	
	37		Alpha + Beta Alloys Hardened	1050 Rm	
H	38	Hardened steel	Hardened	550	55
	39		Hardened	630	60
	40	Chilled Cast Iron	Cast	400	42
	41	Hardened Cast Iron	Hardened	550	55

DTX424	DTX406	DTX408	DTX421
5XD	3XD	5XD	8XD
LONG	SHORT	LONG	EXTRA LONG
D1.0	D3.0	D1.0	D3.0
D20.0	D20.0	D20.0	D14.0
A82	A85	A87	A90
RCH-Coating			



◎	◎	◎	◎	1
◎	◎	◎	◎	2
◎	◎	◎	◎	3
◎	◎	◎	◎	4
○	○	○	○	5
◎	◎	◎	◎	6 P
◎	◎	◎	◎	7
○	○	○	○	8
○	○	○	○	9
◎	◎	◎	◎	10
○	○	○	○	11
○	○	○	○	12
○	○	○	○	13 M
○	○	○	○	14
◎	◎	◎	◎	15
○	○	○	○	16
◎	◎	◎	◎	17 K
○	○	○	○	18
◎	◎	◎	◎	19
○	○	○	○	20
				21
				22
				23
				24
				25 N
				26
				27
				28
				29
				30
				31
				32
				33
				34 S
				35
				36
				37
○	○	○	○	38
				39
				40
				41 H

CARBIDE
HSS
i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS X
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
DREAM DRILLS -MQL
DREAM DRILLS for HIGH HARDENED STEELS
GENERAL CARBIDE DRILLS
MULTI-1 DRILLS
HPD DRILLS
GOLD-P DRILLS
SUPER-GP DRILLS
STRAIGHT SHANK DRILLS
TAPER SHANK DRILLS
NC-SPOTTING DRILLS
CENTER DRILLS
SPADE DRILLS
REAMERS
COUNTER SINKS
COUNTER BORES

CARBIDE
HSS
i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS X
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
DREAM DRILLS -MQL
DREAM DRILLS for HIGH HARDENED STEELS
GENERAL CARBIDE DRILLS
MULTI-1 DRILLS
HPD DRILLS
GOLD-P DRILLS
SUPER-GP DRILLS
STRAIGHT SHANK DRILLS
TAPER SHANK DRILLS
NC-SPOTTING DRILLS
CENTER DRILLS
SPADE DRILLS
REAMERS
COUNTER SINKS
COUNTER BORES



DTX404 SERIES

CARBIDE, DREAM DRILL X (3XD)

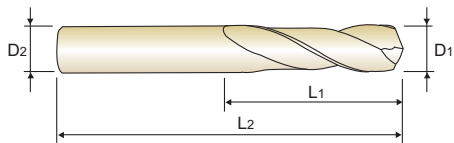
STUB

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6539 CARBIDE 30° h6 h7 140° RCH Coating p.A92

D₁=D₂
3 × D

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404030	3.0	16	46
DTX404031	3.1	18	49
DTX404032	3.2	18	49
DTX404033	3.3	18	49
DTX404034	3.4	20	52
DTX404035	3.5	20	52
DTX404036	3.6	20	52
DTX404037	3.7	20	52
DTX404038	3.8	22	55
DTX404039	3.9	22	55
DTX404040	4.0	22	55
DTX404041	4.1	22	55
DTX404042	4.2	22	55
DTX404043	4.3	24	58
DTX404044	4.4	24	58
DTX404045	4.5	24	58
DTX404046	4.6	24	58
DTX404047	4.7	24	58
DTX404048	4.8	26	62
DTX404049	4.9	26	62
DTX404050	5.0	26	62
DTX404051	5.1	26	62
DTX404052	5.2	26	62
DTX404053	5.3	26	62
DTX404054	5.4	28	66
DTX404055	5.5	28	66
DTX404056	5.6	28	66
DTX404057	5.7	28	66

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404058	5.8	28	66
DTX404059	5.9	28	66
DTX404060	6.0	28	66
DTX404061	6.1	31	70
DTX404062	6.2	31	70
DTX404063	6.3	31	70
DTX404064	6.4	31	70
DTX404065	6.5	31	70
DTX404066	6.6	31	70
DTX404067	6.7	31	70
DTX404068	6.8	34	74
DTX404069	6.9	34	74
DTX404070	7.0	34	74
DTX404071	7.1	34	74
DTX404072	7.2	34	74
DTX404073	7.3	34	74
DTX404074	7.4	34	74
DTX404075	7.5	34	74
DTX404076	7.6	37	79
DTX404077	7.7	37	79
DTX404078	7.8	37	79
DTX404079	7.9	37	79
DTX404080	8.0	37	79
DTX404081	8.1	37	79
DTX404082	8.2	37	79
DTX404083	8.3	37	79
DTX404084	8.4	37	79
DTX404085	8.5	37	79

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																							
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HRC	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230					
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



DTX404 SERIES

CARBIDE, DREAM DRILL X (3XD)

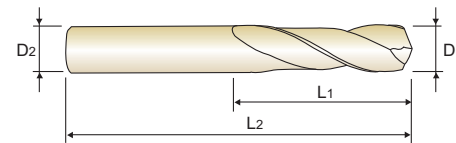
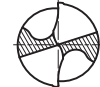
STUB

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6539 CARBIDE 30° h6 h7 140° RCH Coating p.A92

D₁=D₂
3 × D

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404086	8.6	40	84
DTX404087	8.7	40	84
DTX404088	8.8	40	84
DTX404089	8.9	40	84
DTX404090	9.0	40	84
DTX404091	9.1	40	84
DTX404092	9.2	40	84
DTX404093	9.3	40	84
DTX404094	9.4	40	84
DTX404095	9.5	40	84
DTX404096	9.6	43	89
DTX404097	9.7	43	89
DTX404098	9.8	43	89
DTX404099	9.9	43	89
DTX404100	10.0	43	89
DTX404102	10.2	43	89
DTX404105	10.5	43	89
DTX404110	11.0	47	95
DTX404115	11.5	47	95
DTX404120	12.0	51	102
DTX404130	13.0	51	102
DTX404135	13.5	54	107
DTX404140	14.0	54	107
DTX404145	14.5	56	111
DTX404150	15.0	56	111
DTX404155	15.5	58	115
DTX404160	16.0	58	115
DTX404165	16.5	60	119

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404170	17.0	60	119
DTX404175	17.5	62	123
DTX404180	18.0	62	123
DTX404185	18.5	64	127
DTX404190	19.0	64	127
DTX404195	19.5	66	131
DTX404200	20.0	66	131

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																							
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HRC	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230					
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILL X (3XD)

SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

KURZ
COURTE
CORTA

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

- Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° Coating p.A92

3 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423030	3.0	6	20	62
DTX423031	3.1	6	20	62
DTX423032	3.2	6	20	62
DTX423033	3.3	6	20	62
DTX423034	3.4	6	20	62
DTX423035	3.5	6	20	62
DTX423036	3.6	6	20	62
DTX423037	3.7	6	20	62
DTX423038	3.8	6	24	66
DTX423039	3.9	6	24	66
DTX423040	4.0	6	24	66
DTX423041	4.1	6	24	66
DTX423042	4.2	6	24	66
DTX423043	4.3	6	24	66
DTX423044	4.4	6	24	66
DTX423045	4.5	6	24	66
DTX423046	4.6	6	24	66
DTX423047	4.7	6	24	66
DTX423048	4.8	6	28	66
DTX423049	4.9	6	28	66
DTX423050	5.0	6	28	66
DTX423051	5.1	6	28	66
DTX423052	5.2	6	28	66
DTX423053	5.3	6	28	66
DTX423054	5.4	6	28	66
DTX423055	5.5	6	28	66
DTX423056	5.6	6	28	66
DTX423057	5.7	6	28	66
DTX423058	5.8	6	28	66
DTX423059	5.9	6	28	66

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K			S				H																								
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46
HRC	13	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

CARBIDE, DREAM DRILL X (3XD)

SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

KURZ
COURTE
CORTA

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

- Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° Coating p.A92

3 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423090	9.0	10	47	89
DTX423091	9.1	10	47	89
DTX423092	9.2	10	47	89
DTX423093	9.3	10	47	89
DTX423094	9.4	10	47	89
DTX423095	9.5	10	47	89
DTX423096	9.6	10	47	89
DTX423097	9.7	10	47	89
DTX423098	9.8	10	47	89
DTX423099	9.9	10	47	89
DTX423100	10.0	10	47	89
DTX423101	10.1	12	55	102
DTX423102	10.2	12	55	102
DTX423103	10.3	12	55	102
DTX423104	10.4	12	55	102
DTX423105	10.5	12	55	102
DTX423106	10.6	12	55	102
DTX423107	10.7	12	55	102
DTX423108	10.8	12	55	102
DTX423109	10.9	12	55	102
DTX423110	11.0	12	55	102
DTX423111	11.1	12	55	102
DTX423112	11.2	12	55	102
DTX423113	11.3	12	55	102
DTX423114	11.4	12	55	102
DTX423115	11.5	12	55	102
DTX423116	11.6	12	55	102
DTX423117	11.7	12	55	102
DTX423118	11.8	12	55	102
DTX423119	11.9	12	55	102

◎ : Excellent ○ : Good

ISO Material Description	P										M				K			S				H																								
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46
HRC	13	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

CARBIDE, DREAM DRILL X (5XD)

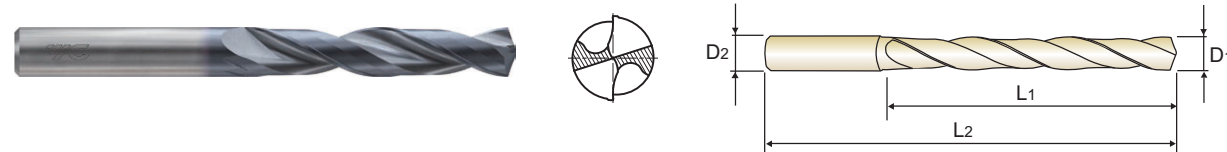
LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

LANG
LONGUE
LUNGA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



5 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424010	1.0	3	8	55
DTX424011	1.1	3	12	55
DTX424012	1.2	3	12	55
DTX424013	1.3	3	12	55
DTX424014	1.4	3	12	55
DTX424015	1.5	3	16	55
DTX424016	1.6	3	16	55
DTX424017	1.7	3	16	55
DTX424018	1.8	3	16	55
DTX424019	1.9	3	16	55
DTX424020	2.0	4	21	57
DTX424021	2.1	4	21	57
DTX424022	2.2	4	21	57
DTX424023	2.3	4	21	57
DTX424024	2.4	4	21	57
DTX424025	2.5	4	21	57
DTX424026	2.6	4	21	57
DTX424027	2.7	4	21	57
DTX424028	2.8	4	21	57
DTX424029	2.9	4	21	57
DTX424030	3.0	6	28	66
DTX424031	3.1	6	28	66
DTX424032	3.2	6	28	66
DTX424033	3.3	6	28	66
DTX424034	3.4	6	28	66
DTX424035	3.5	6	28	66
DTX424036	3.6	6	28	66
DTX424037	3.7	6	28	66

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K			S				H																							
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45
HRC	13	25	28	32	35	38	40	42	45	48	50	52	55	58	60	62	65	68	70	72	75	78	80	82	85	88	90	92	95	98	100	105	110	115	120	125	130	135	140	145	150				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230																									
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				

CARBIDE, DREAM DRILL X (5XD)

LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

LANG
LONGUE
LUNGA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



5 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424066	6.6	8	53	91
DTX424067	6.7	8	53	91
DTX424068	6.8	8	53	91
DTX424069	6.9	8	53	91
DTX424070	7.0	8	53	91
DTX424071	7.1	8	53	91
DTX424072	7.2	8	53	91
DTX424073	7.3	8	53	91
DTX424074	7.4	8	53	91
DTX424075	7.5	8	53	91
DTX424076	7.6	8	53	91
DTX424077	7.7	8	53	91
DTX424078	7.8	8	53	91
DTX424079	7.9	8	53	91
DTX424080	8.0	8	53	91
DTX424081	8.1	10	61	103
DTX424082	8.2	10	61	103
DTX424083	8.3	10	61	103
DTX424084	8.4	10	61	103
DTX424085	8.5	10	61	103
DTX424086	8.6	10	61	103
DTX424087	8.7	10	61	103
DTX424088	8.8	10	61	103
DTX424089	8.9	10	61	103
DTX424090	9.0	10	61	103
DTX424091	9.1	10	61	103
DTX424092	9.2	10	61	103
DTX424093	9.3	10	61	103

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K			S				H																							
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45
HRC	13	25	28	32	35	38	40	42	45	48	50	52	55	58	60	62	65	68	70	72	75	78	80	82	85	88	90	92	95	98	100	105	110	115	120	125	130	135	140	145	150				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230																									
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				

CARBIDE, DREAM DRILL X (5XD)

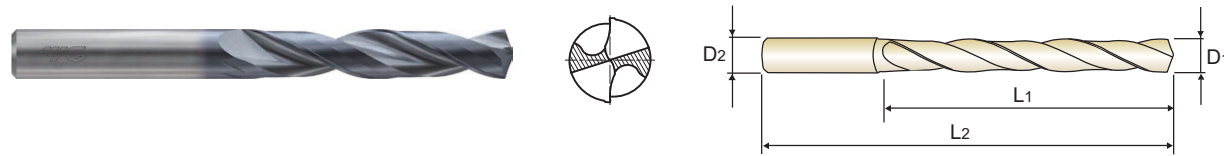
LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER X
- Forets DREAM DRILLS X carbure, série extra-courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS X

LANG
LONGUE
LUNGA

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

- Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° RCH Coating p.A92 5 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424130	13.0	14	77	124
DTX424135	13.5	14	77	124
DTX424140	14.0	14	77	124
DTX424145	14.5	16	83	133
DTX424150	15.0	16	83	133
DTX424155	15.5	16	83	133
DTX424160	16.0	16	83	133
DTX424165	16.5	18	93	143

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424170	17.0	18	93	143
DTX424175	17.5	18	93	143
DTX424180	18.0	18	93	143
DTX424185	18.5	20	101	153
DTX424190	19.0	20	101	153
DTX424195	19.5	20	101	153
DTX424200	20.0	20	101	153

Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron			Nodular cast iron			Malleable cast iron																
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc																																									
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230																					
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILL X with COOLANT HOLES (3XD)

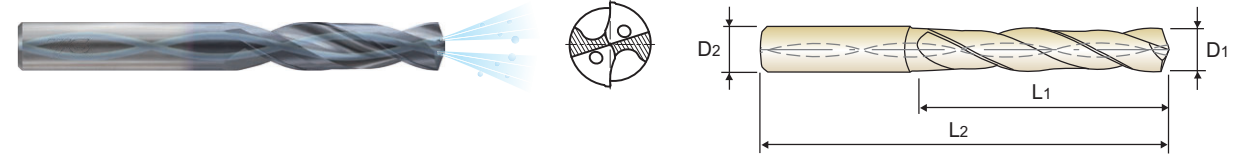
SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
- Forets DREAM DRILLS carbure, avec arrosage central, série courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

KURZ
COURTE
CORTA

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

- Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 3 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406030	3.0	6	20	62
DTX406031	3.1	6	20	62
DTX406032	3.2	6	20	62
DTX406033	3.3	6	20	62
DTX406034	3.4	6	20	62
DTX406035	3.5	6	20	62
DTX406036	3.6	6	20	62
DTX406037	3.7	6	20	62
DTX406038	3.8	6	24	66
DTX406039	3.9	6	24	66
DTX406040	4.0	6	24	66
DTX406041	4.1	6	24	66
DTX406042	4.2	6	24	66
DTX406043	4.3	6	24	66
DTX406044	4.4	6	24	66
DTX406045	4.5	6	24	66
DTX406046	4.6	6	24	66
DTX406047	4.7	6	24	66
DTX406048	4.8	6	28	66
DTX406049	4.9	6	28	66
DTX406050	5.0	6	28	66
DTX406051	5.1	6	28	66
DTX406052	5.2	6	28	66
DTX406053	5.3	6	28	66
DTX406054	5.4	6	28	66
DTX406055	5.5	6	28	66
DTX406056	5.6	6	28	66
DTX406057	5.7	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406058	5.8	6	28	66
DTX406059	5.9	6	28	66
DTX406060	6.0	6	28	66
DTX406061	6.1	8	34	79
DTX406062	6.2	8	34	79
DTX406063	6.3	8	34	79
DTX406064	6.4	8	34	79
DTX406065	6.5	8	34	79
DTX406066	6.6	8	34	79
DTX406067	6.7	8	34	79
DTX406068	6.8	8	34	79
DTX406069	6.9	8	34	79
DTX406070	7.0	8	34	79
DTX406071	7.1	8	41	79
DTX406072	7.2	8	41	79
DTX406073	7.3	8	41	79
DTX406074	7.4	8	41	79
DTX406075	7.5	8	41	79
DTX406076	7.6	8	41	79
DTX406077	7.7	8	41	79
DTX406078	7.8	8	41	79
DTX406079	7.9	8	41	79
DTX406080	8.0	8	41	79
DTX406081	8.1	10	47	89
DTX406082	8.2	10	47	89
DTX406083	8.3	10	47	89
DTX406084	8.4	10	47	89
DTX406085	8.5	10	47	89

Other shank types are available on your request.

NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron			Nodular cast iron			Malleable cast iron																
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc																																									
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230																					
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILL X with COOLANT HOLES (3XD)

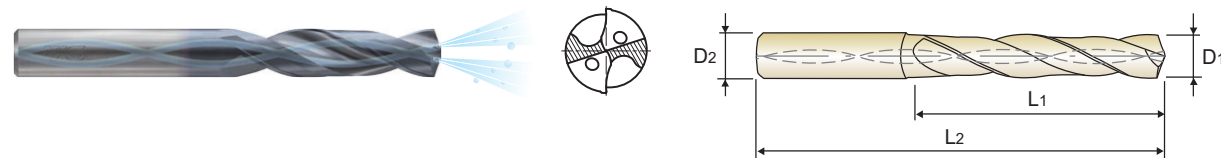
SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
- Forets DREAM DRILLS carbure, avec arrosage central, série courte
- PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

- KURZ
- COURTE
- CORTA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 3 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406086	8.6	10	47	89
DTX406087	8.7	10	47	89
DTX406088	8.8	10	47	89
DTX406089	8.9	10	47	89
DTX406090	9.0	10	47	89
DTX406091	9.1	10	47	89
DTX406092	9.2	10	47	89
DTX406093	9.3	10	47	89
DTX406094	9.4	10	47	89
DTX406095	9.5	10	47	89
DTX406096	9.6	10	47	89
DTX406097	9.7	10	47	89
DTX406098	9.8	10	47	89
DTX406099	9.9	10	47	89
DTX406100	10.0	10	47	89
DTX406101	10.1	12	55	102
DTX406102	10.2	12	55	102
DTX406103	10.3	12	55	102
DTX406104	10.4	12	55	102
DTX406105	10.5	12	55	102
DTX406106	10.6	12	55	102
DTX406107	10.7	12	55	102
DTX406108	10.8	12	55	102
DTX406109	10.9	12	55	102
DTX406110	11.0	12	55	102
DTX406111	11.1	12	55	102
DTX406112	11.2	12	55	102
DTX406113	11.3	12	55	102

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	130	230	130	230	130	130	230	130	230	130	400 Rm	1050 Rm	550	630	400	550					
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILL X with COOLANT HOLES (5XD)

LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
- Forets DREAM DRILLS carbure, avec arrosage central, série longue
- PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

- LANG
- LONGUE
- LUNGA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 5 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408010	1.0	3	8	55
DTX408011	1.1	3	12	55
DTX408012	1.2	3	12	55
DTX408013	1.3	3	12	55
DTX408014	1.4	3	12	55
DTX408015	1.5	3	16	55
DTX408016	1.6	3	16	55
DTX408017	1.7	3	16	55
DTX408018	1.8	3	16	55
DTX408019	1.9	3	16	55
DTX408020	2.0	4	21	57
DTX408021	2.1	4	21	57
DTX408022	2.2	4	21	57
DTX408023	2.3	4	21	57
DTX408024	2.4	4	21	57
DTX408025	2.5	4	21	57
DTX408026	2.6	4	21	57
DTX408027	2.7	4	21	57
DTX408028	2.8	4	21	57
DTX408029	2.9	4	21	57
DTX408030	3.0	6	28	66
DTX408031	3.1	6	28	66
DTX408032	3.2	6	28	66
DTX408033	3.3	6	28	66
DTX408034	3.4	6	28	66
DTX408035	3.5	6	28	66
DTX408036	3.6	6	28	66
DTX408037	3.7	6	28	66

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	130	230	130	230	130	130	230	130	230	130	400 Rm	1050 Rm	550	630	400	550					
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILL X with COOLANT HOLES (5XD)

LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
- Forets DREAM DRILLS carbure, avec arrosage central, série longue
- PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

LANG
LONGUE
LUNGA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 5 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408066	6.6	8	53	91
DTX408067	6.7	8	53	91
DTX408068	6.8	8	53	91
DTX408069	6.9	8	53	91
DTX408070	7.0	8	53	91
DTX408071	7.1	8	53	91
DTX408072	7.2	8	53	91
DTX408073	7.3	8	53	91
DTX408074	7.4	8	53	91
DTX408075	7.5	8	53	91
DTX408076	7.6	8	53	91
DTX408077	7.7	8	53	91
DTX408078	7.8	8	53	91
DTX408079	7.9	8	53	91
DTX408080	8.0	8	53	91
DTX408081	8.1	10	61	103
DTX408082	8.2	10	61	103
DTX408083	8.3	10	61	103
DTX408084	8.4	10	61	103
DTX408085	8.5	10	61	103
DTX408086	8.6	10	61	103
DTX408087	8.7	10	61	103
DTX408088	8.8	10	61	103
DTX408089	8.9	10	61	103
DTX408090	9.0	10	61	103
DTX408091	9.1	10	61	103
DTX408092	9.2	10	61	103
DTX408093	9.3	10	61	103

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K			S			H																				
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	13	25	28	32	38	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

CARBIDE, DREAM DRILL X with COOLANT HOLES (5XD)

LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
- Forets DREAM DRILLS carbure, avec arrosage central, série longue
- PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

LANG
LONGUE
LUNGA

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation

- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 5 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408130	13.0	14	77	124
DTX408135	13.5	14	77	124
DTX408140	14.0	14	77	124
DTX408145	14.5	16	83	133
DTX408150	15.0	16	83	133
DTX408155	15.5	16	83	133
DTX408160	16.0	16	83	133
DTX408165	16.5	18	93	143

▶ Other shank types are available on your request.

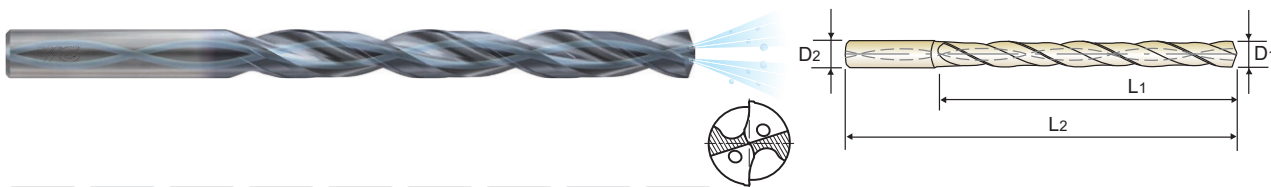
◎ : Excellent ○ : Good

ISO	P										M				K			S			H																								
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HRc	13	25	28	32	38	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎					

CARBIDE, DREAM DRILL X with COOLANT HOLES (8XD) EXTRA LONG

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
Forets DREAM DRILLS carbure, avec arrosage central, série extra-longue
PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation
- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 8 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421030	3.0	6	34	72
DTX421031	3.1	6	34	72
DTX421032	3.2	6	34	72
DTX421033	3.3	6	34	72
DTX421034	3.4	6	34	72
DTX421035	3.5	6	34	72
DTX421036	3.6	6	34	72
DTX421037	3.7	6	34	72
DTX421038	3.8	6	43	81
DTX421039	3.9	6	43	81
DTX421040	4.0	6	43	81
DTX421041	4.1	6	43	81
DTX421042	4.2	6	43	81
DTX421043	4.3	6	43	81
DTX421044	4.4	6	43	81
DTX421045	4.5	6	43	81
DTX421046	4.6	6	43	81
DTX421047	4.7	6	43	81
DTX421048	4.8	6	57	95
DTX421049	4.9	6	57	95
DTX421050	5.0	6	57	95
DTX421051	5.1	6	57	95
DTX421052	5.2	6	57	95
DTX421053	5.3	6	57	95
DTX421054	5.4	6	57	95
DTX421055	5.5	6	57	95
DTX421056	5.6	6	57	95
DTX421057	5.7	6	57	95

▶ Other shank types are available on your request. ▶ NEXT PAGE

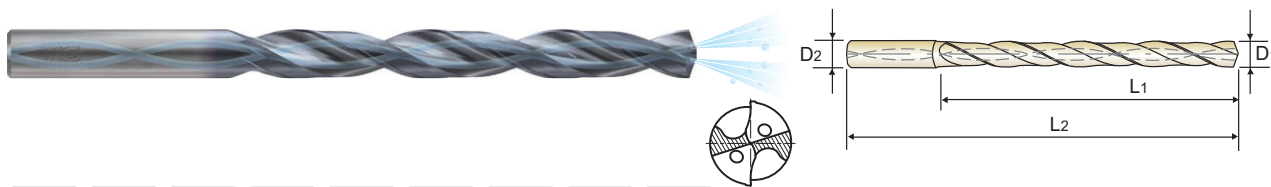
◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	13	25	28	32	10	29	32	38	15	35	15	23	10	10	10	26	3	25	21	21	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	Recommended	◎	◎	◎	○	○	◎	◎	◎	○	○	◎	◎	◎	○	○	◎	◎	◎	○	○

CARBIDE, DREAM DRILL X with COOLANT HOLES (8XD) EXTRA LONG

VOLLHARTMETALL DREAM SPIRALBOHRER mit KÜHLKANAL
Forets DREAM DRILLS carbure, avec arrosage central, série extra-longue
PUNTE ELICOIDALI IN MD - DREAM DRILLS (con fori di refrigerazione)

- ▶ Upgraded coating for higher Tool Life in various materials
- ▶ Soft cutting action and reduced axial forces; Easy to Recondition
- ▶ Good self-centering even at low feed rates and unstable situations
- ▶ Excellent Chip breaking and chip evacuation
- ▶ Verbesserte Beschichtung für höhere Standzeit in verschiedenen Materialien
- ▶ Weicher Schnitt und reduzierte Axialkräfte; leicht nachzuschleifen
- ▶ Sehr gute Selbstzentrierung auch bei niedrigen Vorschubgeschwindigkeiten und labilen Verhältnissen
- ▶ Hervorragender Spanbruch und Spanabfuhr



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar RCH Coating p.A93 8 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421086	8.6	10	95	142
DTX421087	8.7	10	95	142
DTX421088	8.8	10	95	142
DTX421089	8.9	10	95	142
DTX421090	9.0	10	95	142
DTX421091	9.1	10	95	142
DTX421092	9.2	10	95	142
DTX421093	9.3	10	95	142
DTX421094	9.4	10	95	142
DTX421095	9.5	10	95	142
DTX421096	9.6	10	95	142
DTX421097	9.7	10	95	142
DTX421098	9.8	10	95	142
DTX421099	9.9	10	95	142
DTX421100	10.0	10	95	142
DTX421101	10.1	12	114	162
DTX421102	10.2	12	114	162
DTX421103	10.3	12	114	162
DTX421104	10.4	12	114	162
DTX421105	10.5	12	114	162
DTX421106	10.6	12	114	162
DTX421107	10.7	12	114	162
DTX421108	10.8	12	114	162
DTX421109	10.9	12	114	162
DTX421110	11.0	12	114	162
DTX421111	11.1	12	114	162
DTX421112	11.2	12	114	162
DTX421113	11.3	12	114	162

▶ Other shank types are available on your request. ▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K			S				H																			
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	13	25	28	32	10	29	32	38	15	35	15	23	10	10	10	26	3	25	21	21	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	Recommended	◎	◎	◎	○	○	◎	◎	◎	○	○	◎	◎	◎	○	○	◎	◎	◎	○	○



RECOMMENDED CUTTING CONDITIONS
EMPFOLHENE SCHNEIDPARAMETER

DTX404, DTX423, DTX424 SERIES

without COOLANT HOLES

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

Table with columns for ISO, VDI 3323, Material Description, Vc, Parameter, and Drill Diameter (mm) for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, and Hardened steel.

Table with columns for ISO, VDI 3323, Material Description, Vc, Parameter, and Drill Diameter (mm) for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, and Hardened steel.

Recommend to reduce the feed rate as following Feed 100% : DTX404(3xD), DTX423(3xD), DTX424(5xD)
A92 phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions YG-1 CO., LTD.



RECOMMENDED CUTTING CONDITIONS
EMPFOLHENE SCHNEIDPARAMETER

DTX406, DTX408, DTX421 SERIES

with COOLANT HOLES

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

Table with columns for ISO, VDI 3323, Material Description, Vc, Parameter, and Drill Diameter (mm) for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, and Hardened steel.

Table with columns for ISO, VDI 3323, Material Description, Vc, Parameter, and Drill Diameter (mm) for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, and Hardened steel.

Recommend to reduce the feed rate as following Feed 100% : DTX406(3xD), DTX408(5xD) Feed 75% : DTX421(8xD)
YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions A93

i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS X
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
DREAM DRILLS -MQL
DREAM DRILLS for HIGH HARDENED STEELS
GENERAL CARBIDE DRILLS
MULTI-1 DRILLS
HPD DRILLS
GOLD-P DRILLS
SUPER-GP DRILLS
STRAIGHT SHANK DRILLS
TAPER SHANK DRILLS
NC-SPOTTING DRILLS
CENTER DRILLS
SPADE DRILLS
REAMERS
COUNTER SINKS
COUNTER BORES

i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS X
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
DREAM DRILLS -MQL
DREAM DRILLS for HIGH HARDENED STEELS
GENERAL CARBIDE DRILLS
MULTI-1 DRILLS
HPD DRILLS
GOLD-P DRILLS
SUPER-GP DRILLS
STRAIGHT SHANK DRILLS
TAPER SHANK DRILLS
NC-SPOTTING DRILLS
CENTER DRILLS
SPADE DRILLS
REAMERS
COUNTER SINKS
COUNTER BORES