

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes

DH510 | DH515 | DH520 | DHM10 | DHM15 | DHM20 SERIES

WORK MATERIAL		P				K							
		CARBON STEELS				CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm ²				250 ~ 350 N/mm ²				400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min				230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		RPM	FEED	IPR		RPM	FEED	IPR		RPM	FEED	IPR	
Metric(mm)	Decimal												
3	.1181	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047
4	.1575	6400	0.08~0.16	.0031	.0063	6400	0.08~0.16	.0031	.0063	5600	0.08~0.16	.0031	.0063
5	.1969	5800	0.10~0.20	.0039	.0079	5800	0.10~0.20	.0039	.0079	4500	0.10~0.20	.0039	.0079
6	.2362	4800	0.12~0.24	.0047	.0094	4800	0.12~0.24	.0047	.0094	3800	0.12~0.24	.0047	.0094
8	.3150	3600	0.16~0.28	.0063	.0110	3600	0.16~0.28	.0063	.0110	2800	0.16~0.28	.0063	.0110
10	.3937	2900	0.20~0.35	.0079	.0138	2900	0.20~0.35	.0079	.0138	2300	0.20~0.35	.0079	.0138
12	.4724	2400	0.24~0.42	.0094	.0165	2400	0.24~0.42	.0094	.0165	1900	0.24~0.42	.0094	.0165
14	.5512	2050	0.28~0.46	.0110	.0181	2050	0.28~0.46	.0110	.0181	1600	0.28~0.46	.0110	.0181

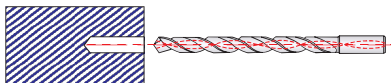
RPM = rev./min.
FEED = mm/rev.
IPR = inch/rev.

DHM25 | DHM30 SERIES

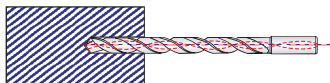
WORK MATERIAL		P				K							
		CARBON STEELS				CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm ²				250 ~ 350 N/mm ²				400 ~ 500 N/mm ²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min				230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		RPM	FEED	IPR		RPM	FEED	IPR		RPM	FEED	IPR	
Metric(mm)	Decimal												
3	.1181	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047
4	.1575	5500	0.08~0.16	.0031	.0063	5500	0.08~0.16	.0031	.0063	4700	0.08~0.16	.0031	.0063
5	.1969	4900	0.10~0.20	.0039	.0079	4900	0.10~0.20	.0039	.0079	3800	0.10~0.20	.0039	.0079
6	.2362	4200	0.12~0.24	.0047	.0094	4200	0.12~0.24	.0047	.0094	3200	0.12~0.24	.0047	.0094
8	.3150	3000	0.16~0.28	.0063	.0110	3000	0.16~0.28	.0063	.0110	2400	0.16~0.28	.0063	.0110
10	.3937	2500	0.20~0.35	.0079	.0138	2500	0.20~0.35	.0079	.0138	1900	0.20~0.35	.0079	.0138

RPM = rev./min.
FEED = mm/rev.
IPR = inch/rev.)

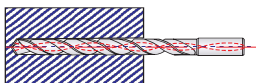
► Coolant Pressure : 900 PSI



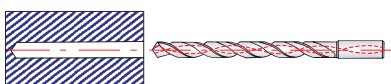
1. Use a YG 3xD Drill to produce a guide hole no larger than .004 over the required drill size. Drill the pilot hole 2xD deep hole.



2. Enter the guide hole at 50 SFM surface and .010 feed rate / per rev.



3. Before hitting the bottom of the guide hole, Increase SFM and feed rate for normal drilling.

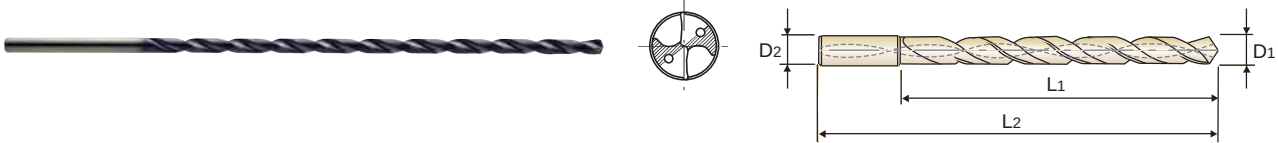


4. After drilling, to withdraw drill, reduce SFM to 50 @ 10 inches per minute.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (10XD, 15XD, 20XD)

DHM10 SERIES
DHM15 SERIES
DHM20 SERIES

- ▶ 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 TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



10 × D
(DHM10)

15 × D
(DHM15)

20 × D
(DHM20)

10 × D

Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM10030	3.0	.1181	6	40	80
DHM10033	3.3	.1299	6	47	87
DHM10035	3.5	.1378	6	47	87
DHM10040	4.0	.1575	6	53	93
DHM10042	4.2	.1654	6	60	100
DHM10045	4.5	.1772	6	60	100
DHM10050	5.0	.1969	6	66	106
DHM10055	5.5	.2165	6	73	113
DHM10060	6.0	.2362	6	79	119
DHM10065	6.5	.2559	8	86	126
DHM10068	6.8	.2677	8	92	132
DHM10070	7.0	.2756	8	92	132
DHM10075	7.5	.2953	8	99	139
DHM10080	8.0	.3150	8	105	145
DHM10085	8.5	.3346	10	112	156
DHM10090	9.0	.3543	10	118	162
DHM10095	9.5	.3740	10	126	170
DHM10100	10.0	.3937	10	132	176
DHM10105	10.5	.4134	12	139	188
DHM10110	11.0	.4330	12	145	194
DHM10115	11.5	.4527	12	152	201
DHM10120	12.0	.4724	12	158	207
DHM10125	12.5	.4921	14	165	214
DHM10130	13.0	.5118	14	171	220
DHM10135	13.5	.5314	14	178	227
DHM10140	14.0	.5512	14	184	233

15 × D

Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM15030	3.0	.1181	6	55	95
DHM15035	3.5	.1378	6	64	104
DHM15040	4.0	.1575	6	73	113
DHM15045	4.5	.1772	6	82	122
DHM15050	5.0	.1969	6	91	131
DHM15055	5.5	.2165	6	100	140
DHM15060	6.0	.2362	6	109	149
DHM15070	7.0	.2756	8	127	167
DHM15080	8.0	.3150	8	145	185
DHM15090	9.0	.3543	10	163	207
DHM15100	10.0	.3937	10	182	226
DHM15110	11.0	.4330	12	200	249
DHM15120	12.0	.4724	12	218	267

20 × D

Unit : mm

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Decimal			
TiAIN	D1		D2	L1	L2
DHM20030	3.0	.1181	6	70	110
DHM20035	3.5	.1378	6	82	122
DHM20040	4.0	.1575	6	93	133
DHM20045	4.5	.1772	6	105	145
DHM20050	5.0	.1969	6	116	156
DHM20055	5.5	.2165	6	128	168
DHM20060	6.0	.2362	6	139	179
DHM20070	7.0	.2756	8	162	202
DHM20080	8.0	.3150	8	185	225
DHM20090	9.0	.3543	10	208	252
DHM20100	10.0	.3937	10	232	276
DHM20110	11.0	.4330	12	255	304
DHM20120	12.0	.4724	12	278	327

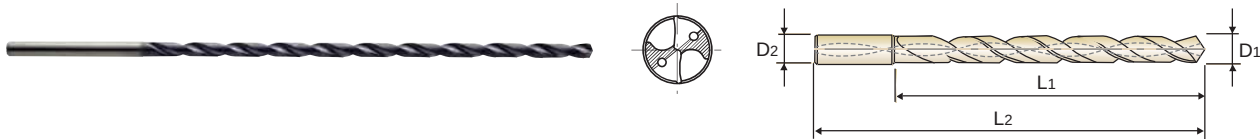
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (15XD)

EXTRA LONG
DH515 SERIES

- ▶ 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 TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



15 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515030	3.0		.1181	3	54	105
DH515031	3.1		.1220	4	63	114
DH515008F	3.175	1/8	.1250	4	63	114
DH515032	3.2		.1260	4	63	114
DH515033	3.3		.1299	4	63	114
DH515034	3.4		.1339	4	63	114
DH515035	3.5		.1378	4	63	114
DH515036	3.6		.1417	4	72	123
DH515037	3.7		.1457	4	72	123
DH515038	3.8		.1496	4	72	123
DH515039	3.9		.1535	4	72	123
DH515040	4.0		.1575	4	72	123
DH515041	4.1		.1614	5	81	134
DH515042	4.2		.1654	5	81	134
DH515043	4.3		.1693	5	81	134
DH515044	4.4		.1732	5	81	134
DH515045	4.5		.1772	5	81	134
DH515046	4.6		.1811	5	90	143
DH515047	4.7		.1850	5	90	143
DH515048	4.8		.1890	5	90	143
DH515049	4.9		.1929	5	90	143
DH515050	5.0		.1969	5	90	143
DH515051	5.1		.2008	6	99	154
DH515052	5.2		.2047	6	99	154
DH515053	5.3		.2087	6	99	154
DH515054	5.4		.2126	6	99	154

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515055	5.5		.2165	6	99	154
DH515056	5.6		.2205	6	108	163
DH515057	5.7		.2244	6	108	163
DH515058	5.8		.2283	6	108	163
DH515059	5.9		.2323	6	108	163
DH515060	6.0		.2362	6	108	163
DH515061	6.1		.2402	7	117	173
DH515062	6.2		.2441	7	117	173
DH515063	6.3		.2480	7	117	173
DH515016F	6.350	1/4	.2500	7	117	173
DH515064	6.4		.2520	7	117	173
DH515065	6.5		.2559	7	117	173
DH515206L	6.528	F	.2570	7	126	182
DH515066	6.6		.2598	7	126	182
DH515067	6.7		.2638	7	126	182
DH515017F	6.746	17/64	.2656	7	126	182
DH515068	6.8		.2677	7	126	182
DH515069	6.9		.2717	7	126	182
DH515209L	6.909	I	.2720	7	126	182
DH515070	7.0		.2756	7	126	182
DH515071	7.1		.2795	8	135	192
DH515018F	7.142	9/32	.2812	8	135	192
DH515072	7.2		.2835	8	135	192
DH515073	7.3		.2874	8	135	192
DH515074	7.4		.2913	8	135	192
DH515075	7.5		.2953	8	135	192

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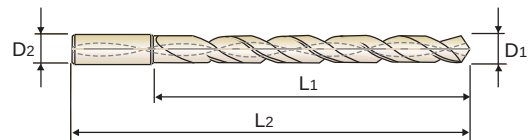
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (15XD)

EXTRA LONG
DH515 SERIES

- ▶ 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 TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



15 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515019F	7.541	19/64	.2969	8	144	201
DH515076	7.6		.2992	8	144	201
DH515077	7.7		.3031	8	144	201
DH515078	7.8		.3071	8	144	201
DH515079	7.9		.3110	8	144	201
DH515020F	7.938	5/16	.3125	8	144	201
DH515080	8.0		.3150	8	144	201
DH515081	8.1		.3189	9	153	211
DH515082	8.2		.3228	9	153	211
DH515083	8.3		.3268	9	153	211
DH515021F	8.334	21/64	.3281	9	153	211
DH515084	8.4		.3307	9	153	211
DH515217L	8.433	Q	.3320	9	153	211
DH515085	8.5		.3346	9	153	211
DH515086	8.6		.3386	9	162	220
DH515087	8.7		.3425	9	162	220
DH515022F	8.733	11/32	.3438	9	162	220
DH515088	8.8		.3465	9	162	220
DH515089	8.9		.3504	9	162	220
DH515090	9.0		.3543	9	162	220
DH515091	9.1		.3583	10	171	229
DH515023F	9.129	23/64	.3594	10	171	229
DH515092	9.2		.3622	10	171	229
DH515093	9.3		.3661	10	171	229
DH515221L	9.347	U	.3680	10	171	229
DH515094	9.4		.3701	10	171	229

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515095	9.5		.3740	10	171	229
DH515024F	9.525	3/8	.3750	10	180	238
DH515096	9.6		.3780	10	180	238
DH515097	9.7		.3819	10	180	238
DH515098	9.8		.3858	10	180	238
DH515099	9.9		.3898	10	180	238
DH515025F	9.921	25/64	.3906	10	180	238
DH515100	10.0		.3937	10	180	238
DH515101	10.1		.3976	11	189	253
DH515102	10.2		.4016	11	189	253
DH515103	10.3		.4055	11	189	253
DH515026F	10.318	13/32	.4062	11	189	253
DH515104	10.4		.4094	11	189	253
DH515105	10.5		.4134	11	189	253
DH515106	10.6		.4173	11	198	262
DH515107	10.7		.4213	11	198	262
DH515027F	10.716	27/64	.4219	11	198	262
DH515108	10.8		.4252	11	198	262
DH515109	10.9		.4291	11	198	262
DH515110	11.0		.4331	11	198	262
DH515111	11.1		.4370	12	207	272
DH515028F	11.113	7/16	.4375	12	207	272
DH515112	11.2		.4409	12	207	272
DH515113	11.3		.4449	12	207	272
DH515114	11.4		.4488	12	207	272
DH515115	11.5		.4527	12	207	272

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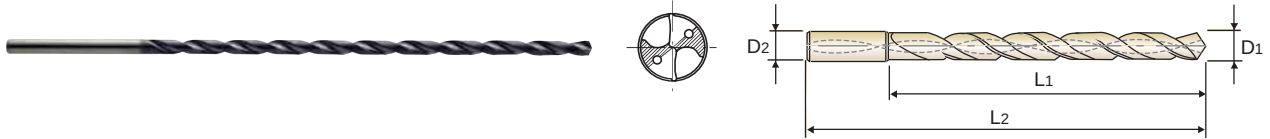
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					

TiAIN-COATED SOLID CARBIDE DREAM DRILLS MQL with Coolant Holes (15XD)

EXTRA LONG
DH515 SERIES

- ▶ 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 TiAIN nano layer full coating
- ▶ MQL system compatible (Minimum Quantity Lubrication)



15 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515029F	11.509	29/64	.4531	12	216	281
DH515116	11.6		.4567	12	216	281
DH515117	11.7		.4606	12	216	281
DH515118	11.8		.4646	12	216	281
DH515119	11.9		.4685	12	216	281
DH515030F	11.908	15/32	.4688	12	216	281
DH515120	12.0		.4724	12	216	281
DH515121	12.1		.4764	13	225	291
DH515122	12.2		.4803	13	225	291
DH515123	12.3		.4843	13	225	291
DH515031F	12.304	31/64	.4844	13	225	291
DH515124	12.4		.4882	13	225	291
DH515125	12.5		.4921	13	225	291
DH515126	12.6		.4961	13	234	300

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Inch	Decimal			
TiAIN	D1			D2	L1	L2
DH515127	12.7	1/2	.5000	13	234	300
DH515128	12.8		.5039	13	234	300
DH515129	12.9		.5079	13	234	300
DH515130	13.0		.5118	13	234	300
DH515131	13.1		.5157	14	243	310
DH515132	13.2		.5197	14	243	310
DH515133	13.3		.5236	14	243	310
DH515134	13.4		.5276	14	243	310
DH515135	13.5		.5314	14	243	310
DH515136	13.6		.5354	14	252	319
DH515137	13.7		.5394	14	252	319
DH515138	13.8		.5433	14	252	319
DH515139	13.9		.5472	14	252	319
DH515140	14.0		.5512	14	252	319

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎	○				○					