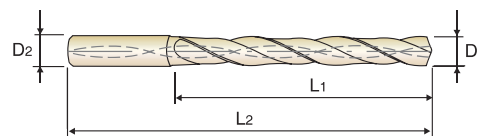




* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
 Excellent positioning - bushing is not necessary
 Special Design - reaming is not required
 - good chip removal
 - powerful drilling
- ▶ Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



DREAM DRILLS | 5x D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	
	Fractional	Decimal					Fractional	Decimal				
TAIN	D1		D2	L1	L2	TAIN	D1		D2	L1	L2	
* 0131CTF	13/64	.2031	15/64	1-3/4	3-15/16	DH712022	11/32	.3438	3/8	2-27/32	5	*
* DH712013	13/64	.2031	1/4	1-3/4	3-15/16	DH712023	23/64	.3594	3/8	3	5-23/64	*
* 0141CTF	7/32	.2188	15/64	1-57/64	3-15/16	0231CTF	23/64	.3594	25/64	3	5-23/64	*
* DH712014	7/32	.2188	1/4	1-57/64	3-15/16	DH712221	U	.3680	3/8	3	5-23/64	*
* 0151CTF	15/64	.2344	15/64	1-57/64	3-15/16	2211CTF	U	.3680	25/64	3	5-23/64	*
* DH712015	15/64	.2344	1/4	1-57/64	3-15/16	DH712024	3/8	.3750	3/8	3-5/32	5-23/64	*
* DH712016	1/4	.2500	1/4	2-3/64	4-19/64	0241CTF	3/8	.3750	25/64	3-5/32	5-23/64	*
* 0161CTF	1/4	.2500	17/64	2-3/64	4-19/64	0251CTF	25/64	.3906	25/64	3-5/32	5-23/64	*
* 2061CTF	F	.2570	17/64	2-13/64	4-19/64	DH712025	25/64	.3906	7/16	3-5/32	5-23/64	*
* DH712206	F	.2570	5/16	2-13/64	4-19/64	0261CTF	13/32	.4062	27/64	3-5/16	5-7/8	*
* 0171CTF	17/64	.2656	17/64	2-13/64	4-19/64	DH712026	13/32	.4062	7/16	3-5/16	5-7/8	*
* DH712017	17/64	.2656	5/16	2-13/64	4-19/64	0271CTF	27/64	.4219	27/64	3-15/32	5-7/8	*
* 2091CTF	I	.2720	.2720	2-13/64	4-19/64	DH712027	27/64	.4219	7/16	3-15/32	5-7/8	*
* DH712209	I	.2720	5/16	2-13/64	4-19/64	DH712028	7/16	.4375	7/16	3-5/8	6-7/32	*
* 0181CTF	9/32	.2812	5/16	2-23/64	4-41/64	0281CTF	7/16	.4375	15/32	3-5/8	6-7/32	*
* 0191CTF	19/64	.2969	5/16	2-33/64	4-41/64	0291CTF	29/64	.4531	15/32	3-25/32	6-7/32	*
* 0201CTF	5/16	.3125	5/16	2-33/64	4-41/64	DH712029	29/64	.4531	1/2	3-25/32	6-7/32	*
* 0211CTF	21/64	.3281	11/32	2-43/64	5	0301CTF	15/32	.4688	15/32	3-25/32	6-7/32	*
* DH712021	21/64	.3281	3/8	2-43/64	5	DH712030	15/32	.4688	1/2	3-25/32	6-7/32	*
* 2171CTF	Q	.3320	11/32	2-43/64	5	0311CTF	31/64	.4844	1/2	3-15/16	6-37/64	*
* DH712217	Q	.3320	3/8	2-43/64	5	0321CTF	1/2	.5000	1/2	4-3/32	6-37/64	*
* 0221CTF	11/32	.3438	11/32	2-27/32	5							

▶ Other shank types are available on your request

◎ : Excellent ○ : Good

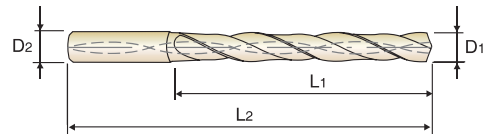
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
○	◎	◎			○		○				



* NEW SIZE

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
 Excellent positioning - bushing is not necessary
 Special Design - reaming is not required
 - good chip removal
 - powerful drilling



DIN 6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	
	Metric	Fractional	Decimal					Metric	Fractional	Decimal				
TAIN	D1			D2	L1	L2	TAIN	D1			D2	L1	L2	
DH408010	1.0		.0394	3	8	55	DH408009F	3.572	9/64	.1406	6	28	66	*
DH408011	1.1		.0433	3	12	55	DH408036	3.6		.1417	6	28	66	
DH408012	1.2		.0472	3	12	55	DH408037	3.7		.1457	6	28	66	
DH408013	1.3		.0512	3	12	55	DH408038	3.8		.1496	6	36	74	
DH408014	1.4		.0551	3	12	55	DH408039	3.9		.1535	6	36	74	
DH408015	1.5		.0591	3	16	55	DH408010F	3.969	5/32	.1563	6	36	74	*
* DH408004F	1.588	1/16	.0625	3	16	55	DH408040	4.0		.1575	6	36	74	
DH408016	1.6		.0630	3	16	55	DH408041	4.1		.1614	6	36	74	
DH408017	1.7		.0669	3	16	55	DH408042	4.2		.1654	6	36	74	
DH408018	1.8		.0709	3	16	55	DH408043	4.3		.1693	6	36	74	
DH408019	1.9		.0748	3	16	55	DH408011F	4.366	11/64	.1719	6	36	74	*
* DH408005F	1.984	5/64	.0781	3	16	55	DH408044	4.4		.1732	6	36	74	
DH408020	2.0		.0787	4	21	57	DH408045	4.5		.1772	6	36	74	
DH408021	2.1		.0827	4	21	57	DH408046	4.6		.1811	6	36	74	
DH408022	2.2		.0866	4	21	57	DH408047	4.7		.1850	6	36	74	
DH408023	2.3		.0906	4	21	57	DH408012F	4.763	3/16	.1875	6	36	74	*
* DH408006F	2.381	3/32	.0938	4	21	57	DH408048	4.8		.1890	6	44	82	
DH408024	2.4		.0945	4	21	57	DH408049	4.9		.1929	6	44	82	
DH408025	2.5		.0984	4	21	57	DH408050	5.0		.1969	6	44	82	
DH408026	2.6		.1024	4	21	57	DH408051	5.1		.2008	6	44	82	
DH408027	2.7		.1063	4	21	57	DH408013F	5.159	13/64	.2031	6	44	82	*
* DH408007F	2.778	7/64	.1094	4	21	57	DH408052	5.2		.2047	6	44	82	
DH408028	2.8		.1102	4	21	57	DH408053	5.3		.2087	6	44	82	
DH408029	2.9		.1142	4	21	57	DH408054	5.4		.2126	6	44	82	
DH408030	3.0		.1181	6	28	66	DH408055	5.5		.2165	6	44	82	
DH408031	3.1		.1220	6	28	66	DH408014F	5.556	7/32	.2188	6	44	82	*
* DH408008F	3.175	1/8	.1250	6	28	66	DH408056	5.6		.2205	6	44	82	
DH408032	3.2		.1260	6	28	66	DH408057	5.7		.2244	6	44	82	
DH408033	3.3		.1299	6	28	66	DH408058	5.8		.2283	6	44	82	
DH408034	3.4		.1339	6	28	66	DH408059	5.9		.2323	6	44	82	
DH408035	3.5		.1378	6	28	66	DH408015F	5.953	15/64	.2344	6	44	82	*

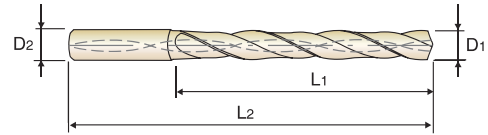
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*** NEW SIZE**

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
 Excellent positioning - bushing is not necessary
 Special Design - reaming is not required
 - good chip removal
 - powerful drilling



DIN 6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TAIIN	D1			D2	L1	L2	TAIIN	D1			D2	L1	L2
DH408060	6.0		.2362	6	44	82	DH408085	8.5		.3346	10	61	103
DH408061	6.1		.2402	8	53	91	DH408086	8.6		.3386	10	61	103
DH408062	6.2		.2441	8	53	91	DH408087	8.7		.3425	10	61	103
DH408063	6.3		.2480	8	53	91	DH408022F	8.731	11/32	.3438	10	61	103
* DH408016F	6.35	1/4	.2500	8	53	91	DH408088	8.8		.3465	10	61	103
DH408064	6.4		.2520	8	53	91	DH408089	8.9		.3504	10	61	103
DH408065	6.5		.2559	8	53	91	DH408090	9.0		.3543	10	61	103
DH408066	6.6		.2598	8	53	91	DH408091	9.1		.3583	10	61	103
DH408067	6.7		.2638	8	53	91	DH408023F	9.128	23/64	.3594	10	61	103
* DH408017F	6.747	17/64	.2656	8	53	91	DH408092	9.2		.3622	10	61	103
DH408068	6.8		.2677	8	53	91	DH408093	9.3		.3661	10	61	103
DH408069	6.9		.2717	8	53	91	DH408094	9.4		.3701	10	61	103
DH408070	7.0		.2756	8	53	91	DH408095	9.5		.3740	10	61	103
DH408071	7.1		.2795	8	53	91	DH408024F	9.525	3/8	.3750	10	61	103
* DH408018F	7.144	9/32	.2812	8	53	91	DH408096	9.6		.3780	10	61	103
DH408072	7.2		.2835	8	53	91	DH408097	9.7		.3819	10	61	103
DH408073	7.3		.2874	8	53	91	DH408098	9.8		.3858	10	61	103
DH408074	7.4		.2913	8	53	91	DH408099	9.9		.3898	10	61	103
DH408075	7.5		.2953	8	53	91	DH408025F	9.922	25/64	.3906	10	61	103
* DH408019F	7.541	19/64	.2969	8	53	91	DH408100	10.0		.3937	10	61	103
DH408076	7.6		.2992	8	53	91	DH408101	10.1		.3976	12	71	118
DH408077	7.7		.3031	8	53	91	DH408102	10.2		.4016	12	71	118
DH408078	7.8		.3071	8	53	91	DH408103	10.3		.4055	12	71	118
DH408079	7.9		.3110	8	53	91	DH408026F	10.319	13/32	.4062	12	71	118
* DH408020F	7.938	5/16	.3125	8	53	91	DH408104	10.4		.4094	12	71	118
DH408080	8.0		.3150	8	53	91	DH408105	10.5		.4134	12	71	118
DH408081	8.1		.3189	10	61	103	DH408106	10.6		.4173	12	71	118
DH408082	8.2		.3228	10	61	103	DH408107	10.7		.4212	12	71	118
DH408083	8.3		.3268	10	61	103	DH408027F	10.716	27/64	.4219	12	71	118
* DH408021F	8.334	21/64	.3281	10	61	103	DH408108	10.8		.4252	12	71	118
DH408084	8.4		.3307	10	61	103	DH408109	10.9		.4291	12	71	118

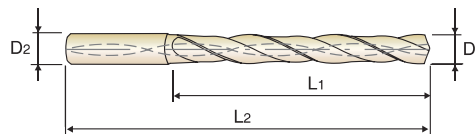
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*** NEW SIZE**

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

- ▶ Application : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic
- ▶ Advantage : Self centering - center drilling is not required
- Excellent positioning - bushing is not necessary
- Special Design - reaming is not required
- good chip removal
- powerful drilling



DIN
6537

MG

h6

m7

140°



P.26

DREAM DRILLS | 5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TAIN	D1			D2	L1	L2	TAIN	D1			D2	L1	L2
DH408110	11.0		.4330	12	71	118	DH408135	13.5		.5314	14	77	124
DH408111	11.1		.4370	12	71	118	DH408140	14.0		.5512	14	77	124
* DH408028F	11.113	7/16	.4375	12	71	118	DH408036F	14.288	9/16	.5625	16	83	133
DH408112	11.2		.4409	12	71	118	DH408145	14.5		.5708	16	83	133
DH408113	11.3		.4448	12	71	118	DH408150	15.0		.5905	16	83	133
DH408114	11.4		.4488	12	71	118	DH408155	15.5		.6102	16	83	133
DH408115	11.5		.4527	12	71	118	DH408040F	15.875	5/8	.6250	16	83	133
* DH408029F	11.509	29/64	.4531	12	71	118	DH408160	16.0		.6299	16	83	133
DH408116	11.6		.4566	12	71	118	DH408165	16.5		.6495	18	93	143
DH408117	11.7		.4606	12	71	118	DH408170	17.0		.6692	18	93	143
DH408118	11.8		.4645	12	71	118	DH408175	17.5		.6889	18	93	143
DH408119	11.9		.4685	12	71	118	DH408180	18.0		.7087	18	93	143
* DH408030F	11.906	15/32	.4688	12	71	118	DH408185	18.5		.7283	20	101	153
DH408120	12.0		.4724	12	71	118	DH408190	19.0		.7480	20	101	153
* DH408031F	12.303	31/64	.4844	14	77	124	DH408048F	19.05	3/4	.7500	20	101	153
DH408125	12.5		.4921	14	77	124	DH408195	19.5		.7676	20	101	153
* DH408032F	12.7	1/2	.5000	14	77	124	DH408200	20.0		.7874	20	101	153
DH408130	13.0		.5118	14	77	124							

▶ Other shank types are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○		○				



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

DH414, DH722 Series

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRC24		> HRC24		< HRC30		HRC30 - 42	
DRILLING SPEED(SFM)				400 ~ 650 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min		210 ~ 350 ft/min	
DIAMETER				N		IPR		N		IPR	
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	13120	.006	8750	.005	7880	.005	7000	.005
3/16	5/16	4.763	7.938	8200	.008	5470	.006	4920	.006	4370	.006
5/16	3/8	7.938	9.525	5970	.011	3980	.009	3560	.009	3190	.009
3/8	1/2	9.525	12.700	4690	.014	3120	.011	2810	.011	2500	.011
1/2	9/16	12.700	14.288	3860	.016	2570	.012	2310	.012	2060	.012
9/16	13/16	14.288	20.638	2980	.018	1990	.014	1790	.014	1590	.014

- ▶ Recommend to reduce the feed rate as following
 DH414(3xD) : Feed 100%
 DH722(5xD) : Feed 85%

N = R.P.M
 IPR = feed rate(inch/rev.)

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH416, DH418, DH711, DH712 Series

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRC24		> HRC24		< HB240, GG25		< HB300, GG40	
DRILLING SPEED(SFM)				480 ~ 730 ft/min		310 ~ 490 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min	
DIAMETER				N		IPR		N		IPR	
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	14870	.006	9620	.006	8750	.006	7880	.005
3/16	5/16	4.763	7.938	8200	.008	6010	.008	5470	.008	4920	.006
5/16	3/8	7.938	9.525	6760	.011	4370	.011	3980	.011	3580	.009
3/8	1/2	9.525	12.700	5310	.014	3440	.014	3120	.014	2810	.011
1/2	9/16	12.700	14.288	4370	.016	2830	.016	2570	.016	2310	.012
9/16	13/16	14.288	20.638	3380	.018	2190	.018	1990	.018	1790	.014

- ▶ Recommend to reduce the feed rate as following
 DH416/DH711(3xD) : Feed 100%
 DH418/DH712(5xD) : Feed 85%

N = R.P.M
 IPR= feed rate (Inch/rev.)



SOLID CARBIDE DREAM DRILLS-GENERAL (without COOLANT HOLES)

DH404, DH423, DH424 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED(SFM)		130 ~ 400 ft/min			115 ~ 340 ft/min			220 ~ 650 ft/min			150 ~ 430 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	13000	0.04	.002	11250	0.04	.002	21300	0.04	.002	14200	0.04	.002
2.0	.0787	13000	0.06	.002	11250	0.06	.002	21300	0.06	.002	14200	0.06	.002
3.0	.1181	13000	0.13	.005	11000	0.13	.005	21000	0.13	.005	14000	0.13	.005
4.0	.1575	9500	0.14	.006	8400	0.14	.006	16000	0.14	.006	10500	0.14	.006
5.0	.1969	7600	0.15	.006	6700	0.15	.006	13000	0.15	.006	8300	0.15	.006
6.0	.2362	6400	0.17	.007	5600	0.17	.007	11000	0.17	.007	6900	0.17	.007
7.0	.2756	5500	0.19	.007	4800	0.19	.007	9100	0.19	.007	5900	0.19	.007
8.0	.3150	4800	0.21	.008	4200	0.21	.008	8000	0.21	.008	5200	0.21	.008
9.0	.3543	4200	0.23	.009	3700	0.23	.009	7100	0.23	.009	4600	0.23	.009
10.0	.3937	3800	0.25	.010	3350	0.25	.010	6400	0.25	.010	4150	0.25	.010
12.0	.4724	3200	0.27	.011	2800	0.27	.011	5300	0.27	.011	3450	0.27	.011
14.0	.5512	2750	0.29	.011	2400	0.29	.011	4550	0.29	.011	3000	0.29	.011
16.0	.6299	2400	0.31	.012	2100	0.31	.012	4000	0.31	.012	2600	0.31	.012
18.0	.7087	2100	0.33	.013	1850	0.33	.013	3550	0.33	.013	2300	0.33	.013
20.0	.7874	1900	0.35	.014	1650	0.35	.014	3200	0.35	.014	2100	0.35	.014

► Recommend to reduce the feed rate as following
 DH404(3xD), DH423(3xD) : Feed 100%
 DH424(5xD) : Feed 85%

N = R.P.M
 S= feed rate (mm/rev.)
 IPR= feed rate (Inch/rev.)

SOLID CARBIDE DREAM DRILLS-GENERAL (with COOLANT HOLES)

DH406, DH408, DH421 Series

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRC 20			> HRC 20			< 240 BHN			< 300 BHN		
DRILLING SPEED		160 ~ 490 ft/min			150 ~ 440 ft/min			270 ~ 820 ft/min			170 ~ 530 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	16250	0.05	.002	14800	0.05	.002	26600	0.05	.002	17300	0.05	.002
2.0	.0787	16250	0.07	.003	14800	0.07	.003	26600	0.07	.003	17300	0.07	.003
3.0	.1181	16000	0.16	.006	14500	0.16	.006	26000	0.16	.006	17000	0.16	.006
4.0	.1575	12000	0.17	.007	11000	0.17	.007	20000	0.17	.007	13000	0.17	.007
5.0	.1969	9550	0.18	.007	8600	0.18	.007	16000	0.18	.007	10000	0.18	.007
6.0	.2362	8000	0.20	.008	7200	0.20	.008	13000	0.20	.008	8500	0.20	.008
7.0	.2756	6800	0.22	.009	6100	0.22	.009	11500	0.22	.009	7300	0.22	.009
8.0	.3150	6000	0.24	.009	5400	0.24	.009	9900	0.24	.009	6400	0.24	.009
9.0	.3543	5300	0.27	.011	4800	0.27	.011	8800	0.27	.011	5700	0.27	.011
10.0	.3937	4800	0.30	.012	4300	0.30	.012	8000	0.30	.012	5100	0.30	.012
12.0	.4724	4000	0.33	.013	3600	0.33	.013	6600	0.33	.013	4250	0.33	.013
14.0	.5512	3400	0.36	.014	3050	0.36	.014	5700	0.36	.014	3650	0.36	.014
16.0	.6299	3000	0.39	.015	2700	0.39	.015	5000	0.39	.015	3200	0.39	.015
18.0	.7087	2650	0.42	.017	2400	0.42	.017	4400	0.42	.017	2850	0.42	.017
20.0	.7874	2400	0.45	.018	2150	0.45	.018	4000	0.45	.018	2550	0.45	.018

► Recommend to reduce the feed rate as following
 DH406(3xD) : Feed 100%, DH408(5xD) : Feed 85%
 DH421(8xD) : Feed 70%

N = R.P.M
 S= feed rate (mm/rev.)
 IPR= feed rate (Inch/rev.)