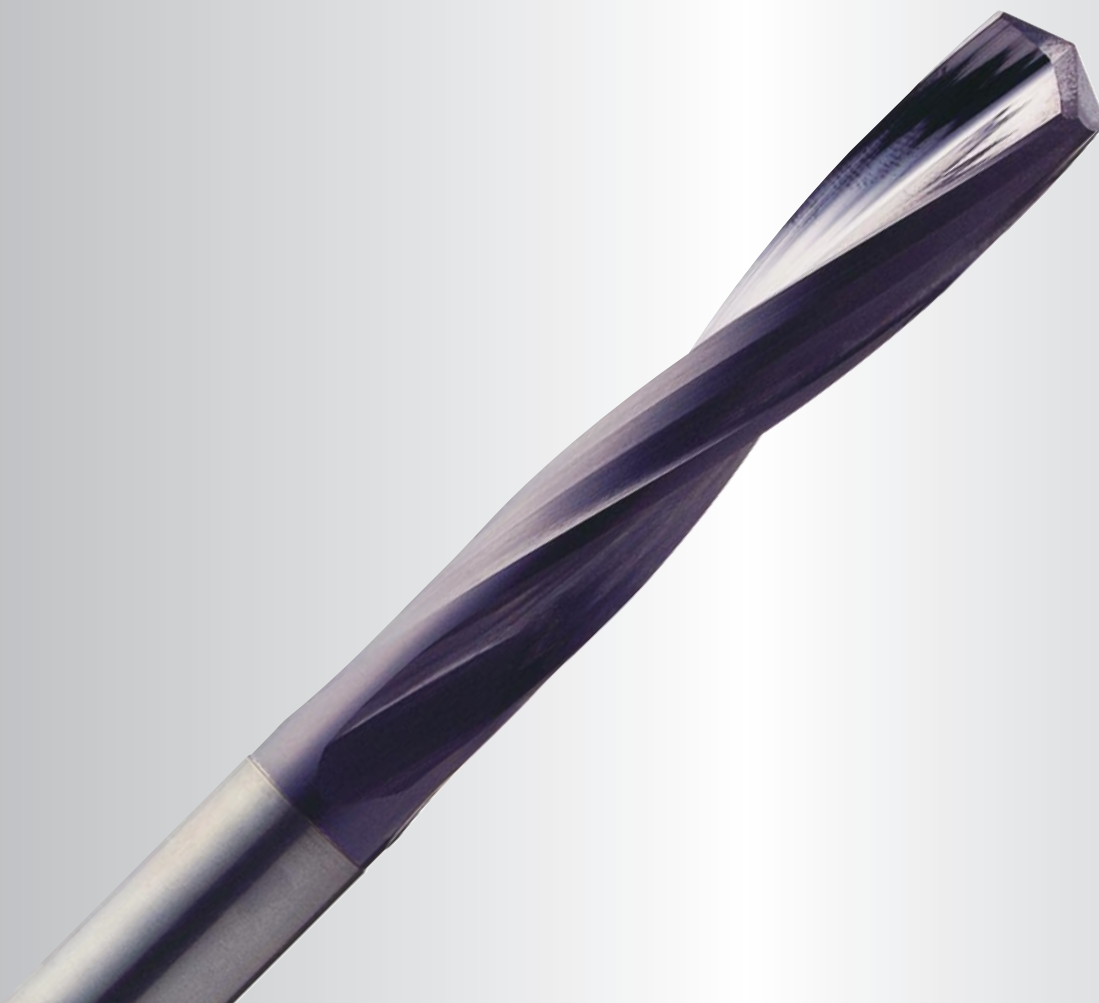


CARBIDE



Being the best through innovation



DREAM DRILLS

- For HIGH HARDENED STEELS

- HRc50 ~ HRc70的高硬度钢

HIGH HARDENED STEELS, HRc50~HRc70

SELECTION GUIDE

高硬度钢用的整体硬质合金梦幻钻头 HRC70的高硬度钢

项目	型号	规格	尺寸		页
			最小	最大	
ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
DH500		高硬度钢 (HRC50-HRC70) 用硬质合金钻头 CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS	D2.6	D14.0	94
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS			95

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

High Hardened Steels, HRc50~HRc70

◎ : 优(Excellent)
○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
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~							
			◎	◎							



DREAM DRILLS
for HIGH HARDENED STEELS

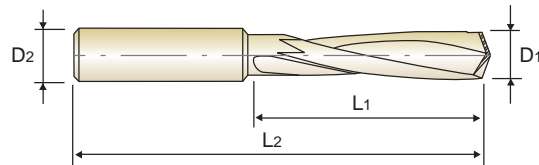
DH500 SERIES

高硬度钢 (HRc50~HRc70) 用硬质合金钻头

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRC50~HRC70)

- ▶ 应用：适用于高硬度钢【淬火钢，回火钢 (HRc70以下)】
- ▶ 优点：特殊的设计
特别的横刃修磨使切削负担最小化
更好的排屑性能
强有力的钻削力

- ▶ **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- ▶ **Advantage** : Special Design
Minimum of cutting load through special thinning
Good chip removal
Powerful Drilling



单位(Unit) : mm

型号	刃径	柄径	刃长	全长	型号	刃径	柄径	刃长	全长
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH500026	2.6	3	14	44	DH500070	7.0	8	45	85
DH500030	3.0	3	16	46	DH500075	7.5	8	45	85
DH500033	3.3	4	18	48	DH500080	8.0	8	50	98
DH500034	3.4	4	20	50	DH500085	8.5	10	50	98
DH500035	3.5	4	20	50	DH500086	8.6	10	57	105
DH500040	4.0	4	22	52	DH500088	8.8	10	57	105
DH500042	4.2	6	25	65	DH500090	9.0	10	57	105
DH500043	4.3	6	28	68	DH500095	9.5	10	57	105
DH500044	4.4	6	28	68	DH500100	10.0	10	63	111
DH500045	4.5	6	28	68	DH500102	10.2	12	63	111
DH500050	5.0	6	32	72	DH500103	10.3	12	63	111
DH500051	5.1	6	32	72	DH500105	10.5	12	63	111
DH500052	5.2	6	32	72	DH500108	10.8	12	71	119
DH500055	5.5	6	35	75	DH500110	11.0	12	71	119
DH500060	6.0	6	35	75	DH500115	11.5	12	71	119
DH500065	6.5	8	40	80	DH500120	12.0	12	71	119
DH500068	6.8	8	45	85	DH500140	14.0	14	77	125
DH500069	6.9	8	45	85					

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
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~							
			◎	◎							

- i-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -SOFT
- DREAM DRILLS -INOX
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- GENERAL CARBIDE DRILLS
- NC-SPOTTING DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- WORM PATTERN DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA



DREAM DRILLS for HIGH HARDENED STEELS

推荐的切削条件

RECOMMENDED CUTTING CONDITIONS

HSS

高硬度钢 (HRc50~HRc70) 用硬质合金钻头, TiAlN 涂层

CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70), TiAlN COATED

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

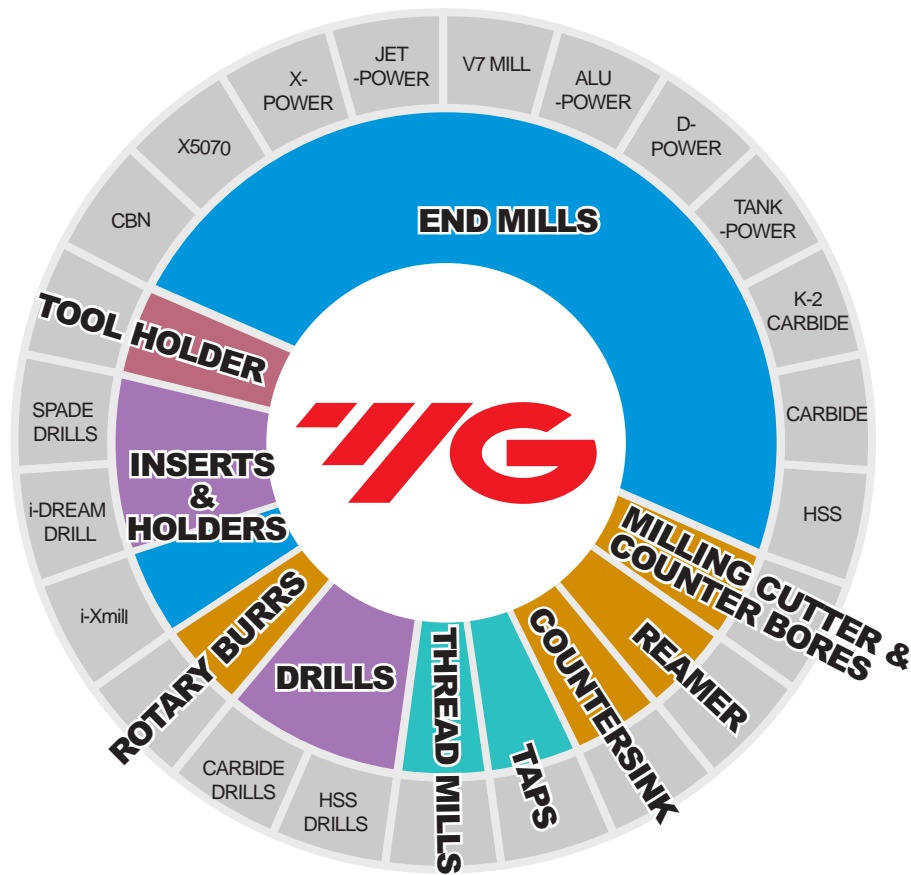
DH500 SERIES

单位(Unit) : mm

被加工材料 WORK MATERIAL	硬化钢 HARDENED STEELS					
	HRc 50~55		HRc 55~60		HRc 60~70	
DRILLING SPEED	14 ~ 22 m/min		10 ~ 16 m/min		8 ~ 13 m/min	
DIAMETER	N	S	N	S	N	S
3.0	1900	0.04	1330	0.04	1250	0.04
4.0	1430	0.04	1000	0.04	950	0.04
5.0	1150	0.04	800	0.04	750	0.04
6.0	960	0.04	670	0.04	630	0.04
8.0	720	0.04	500	0.04	480	0.04
10.0	570	0.04	400	0.04	380	0.04
12.0	480	0.04	330	0.04	320	0.04
14.0	438	0.04	282	0.04	272	0.04

N = R.P.M

S = Feed per Revolution (mm/rev.)



Challenge toward a Global Leader-

YG-1 Leads the World Market.