

CARBIDE



Being the best through innovation



DREAM DRILLS -INOX

- 带油孔

像硬度在HRc35以下的不锈钢，镍合金和钛等硬质材料

WITH COOLANT HOLES

Tough Materials like Stainless Steels, Nickel Alloys and Titanium up to HRc35.

SELECTION GUIDE

整体硬质合金梦幻钻头-不锈钢(带油孔)

像硬度在HRc35以下的不锈钢，镍合金和钛等硬质材料

项目	型号	规格	尺寸		页	
			最小	最大		
ITEM	MODEL	DESCRIPTION	SIZE		PAGE	
			MIN	MAX		
3XD DH451		不锈钢用油孔硬质合金钻头 CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	短 SHORT	D3.0	D20.0	76
5XD DH452		不锈钢用油孔硬质合金钻头 CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	长 LONG	D1.5	D20.0	79
8XD DH453		不锈钢用油孔硬质合金钻头 CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	超长 EXTRA LONG	D3.0	D14.0	82
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS				84

SOLID CARBIDE DREAM DRILLS-INOX

SOLID CARBIDE DREAM DRILLS - INOX (with Coolant Holes)

Tough Materials like Stainless Steels, Nickel Alloys and Titanium up to HRc35.

◎ : 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~							
◎	◎	○				○	◎	○	○		
◎	◎	○				○	◎	○	○		
◎	◎	○				○	◎	○	○		

不锈钢用油孔硬质合金钻头

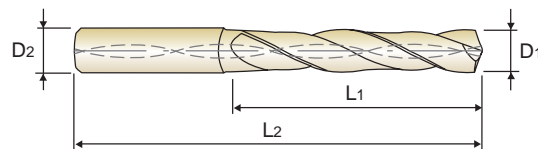
短

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

- ▶ 应用：沟槽的特殊几何形状使其适合加工不锈钢
- ▶ 更好的表面处理方式使其具有优秀的排屑性能
- ▶ 横刃修成R型使产品有较强的自定心能力和螺旋切削性
- ▶ 使用TiAlN涂层使被加工材料得到良好的表面粗糙度并且延长了钻头的使用寿命

- ▶ The tool has the special flute shape and geometry for suitable machining of stainless steels.
- ▶ Excellent chip evacuation due to better surface treatment.
- ▶ Point R-thinning makes superior centering and chip curling.
- ▶ Applied TiAlN coating achieves, the better surface finish of materials to be cut and the longer tool life.



DIN 6537 MG h6 m7 140° P.84

3 × D

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH451030	3.0	6	20	62	DH451050	5.0	6	28	66
DH451031	3.1	6	20	62	DH451051	5.1	6	28	66
DH451032	3.2	6	20	62	DH451052	5.2	6	28	66
DH451033	3.3	6	20	62	DH451053	5.3	6	28	66
DH451034	3.4	6	20	62	DH451054	5.4	6	28	66
DH451035	3.5	6	20	62	DH451055	5.5	6	28	66
DH451036	3.6	6	20	62	DH451056	5.6	6	28	66
DH451037	3.7	6	20	62	DH451057	5.7	6	28	66
DH451038	3.8	6	24	66	DH451058	5.8	6	28	66
DH451039	3.9	6	24	66	DH451059	5.9	6	28	66
DH451040	4.0	6	24	66	DH451060	6.0	6	28	66
DH451041	4.1	6	24	66	DH451061	6.1	8	34	79
DH451042	4.2	6	24	66	DH451062	6.2	8	34	79
DH451043	4.3	6	24	66	DH451063	6.3	8	34	79
DH451044	4.4	6	24	66	DH451064	6.4	8	34	79
DH451045	4.5	6	24	66	DH451065	6.5	8	34	79
DH451046	4.6	6	24	66	DH451066	6.6	8	34	79
DH451047	4.7	6	24	66	DH451067	6.7	8	34	79
DH451048	4.8	6	28	66	DH451068	6.8	8	34	79
DH451049	4.9	6	28	66	DH451069	6.9	8	34	79

▶ 其他的刀柄类型可以按照你的要求 / Other shank types are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	低碳钢 Mild Steels	铜 Copper	青铜 Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		

不锈钢用油孔硬质合金钻头 短
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES SHORT

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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
DH451070	7.0	8	34	79	DH451090	9.0	10	47	89
DH451071	7.1	8	41	79	DH451091	9.1	10	47	89
DH451072	7.2	8	41	79	DH451092	9.2	10	47	89
DH451073	7.3	8	41	79	DH451093	9.3	10	47	89
DH451074	7.4	8	41	79	DH451094	9.4	10	47	89
DH451075	7.5	8	41	79	DH451095	9.5	10	47	89
DH451076	7.6	8	41	79	DH451096	9.6	10	47	89
DH451077	7.7	8	41	79	DH451097	9.7	10	47	89
DH451078	7.8	8	41	79	DH451098	9.8	10	47	89
DH451079	7.9	8	41	79	DH451099	9.9	10	47	89
DH451080	8.0	8	41	79	DH451100	10.0	10	47	89
DH451081	8.1	10	47	89	DH451101	10.1	12	55	102
DH451082	8.2	10	47	89	DH451102	10.2	12	55	102
DH451083	8.3	10	47	89	DH451103	10.3	12	55	102
DH451084	8.4	10	47	89	DH451104	10.4	12	55	102
DH451085	8.5	10	47	89	DH451105	10.5	12	55	102
DH451086	8.6	10	47	89	DH451106	10.6	12	55	102
DH451087	8.7	10	47	89	DH451107	10.7	12	55	102
DH451088	8.8	10	47	89	DH451108	10.8	12	55	102
DH451089	8.9	10	47	89	DH451109	10.9	12	55	102

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-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

不锈钢用油孔硬质合金钻头

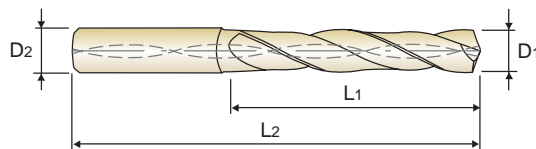
短

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TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH451110	11.0	12	55	102	DH451140	14.0	14	60	107
DH451111	11.1	12	55	102	DH451145	14.5	16	65	115
DH451112	11.2	12	55	102	DH451150	15.0	16	65	115
DH451113	11.3	12	55	102	DH451155	15.5	16	65	115
DH451114	11.4	12	55	102	DH451160	16.0	16	65	115
DH451115	11.5	12	55	102	DH451165	16.5	18	73	123
DH451116	11.6	12	55	102	DH451170	17.0	18	73	123
DH451117	11.7	12	55	102	DH451175	17.5	18	73	123
DH451118	11.8	12	55	102	DH451180	18.0	18	73	123
DH451119	11.9	12	55	102	DH451185	18.5	20	79	131
DH451120	12.0	12	55	102	DH451190	19.0	20	79	131
DH451125	12.5	14	60	107	DH451195	19.5	20	79	131
DH451130	13.0	14	60	107	DH451200	20.0	20	79	131
DH451135	13.5	14	60	107					

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-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				○	◎	○	○		

不锈钢用油孔硬质合金钻头 长
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES LONG

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DIN 6537 MG h6 m7 140° P.84

5 × D

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
DH452015	1.5	3	16	55	DH452037	3.7	6	28	66
DH452016	1.6	3	16	55	DH452038	3.8	6	36	74
DH452017	1.7	3	16	55	DH452039	3.9	6	36	74
DH452018	1.8	3	16	55	DH452040	4.0	6	36	74
DH452019	1.9	3	16	55	DH452041	4.1	6	36	74
DH452020	2.0	4	21	57	DH452042	4.2	6	36	74
DH452021	2.1	4	21	57	DH452043	4.3	6	36	74
DH452022	2.2	4	21	57	DH452044	4.4	6	36	74
DH452023	2.3	4	21	57	DH452045	4.5	6	36	74
DH452024	2.4	4	21	57	DH452046	4.6	6	36	74
DH452025	2.5	4	21	57	DH452047	4.7	6	36	74
DH452026	2.6	4	21	57	DH452048	4.8	6	44	82
DH452027	2.7	4	21	57	DH452049	4.9	6	44	82
DH452028	2.8	4	21	57	DH452050	5.0	6	44	82
DH452029	2.9	4	21	57	DH452051	5.1	6	44	82
DH452030	3.0	6	28	66	DH452052	5.2	6	44	82
DH452031	3.1	6	28	66	DH452053	5.3	6	44	82
DH452032	3.2	6	28	66	DH452054	5.4	6	44	82
DH452033	3.3	6	28	66	DH452055	5.5	6	44	82
DH452034	3.4	6	28	66	DH452056	5.6	6	44	82
DH452035	3.5	6	28	66	DH452057	5.7	6	44	82
DH452036	3.6	6	28	66	DH452058	5.8	6	44	82

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-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

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CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



不锈钢用油孔硬质合金钻头

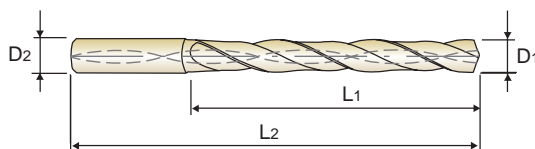
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

长

LONG

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DIN 6537 MG h6 m7 140° P.84

5 × D

单位(Unit) : mm

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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
DH452059	5.9	6	44	82	DH452081	8.1	10	61	103
DH452060	6.0	6	44	82	DH452082	8.2	10	61	103
DH452061	6.1	8	53	91	DH452083	8.3	10	61	103
DH452062	6.2	8	53	91	DH452084	8.4	10	61	103
DH452063	6.3	8	53	91	DH452085	8.5	10	61	103
DH452064	6.4	8	53	91	DH452086	8.6	10	61	103
DH452065	6.5	8	53	91	DH452087	8.7	10	61	103
DH452066	6.6	8	53	91	DH452088	8.8	10	61	103
DH452067	6.7	8	53	91	DH452089	8.9	10	61	103
DH452068	6.8	8	53	91	DH452090	9.0	10	61	103
DH452069	6.9	8	53	91	DH452091	9.1	10	61	103
DH452070	7.0	8	53	91	DH452092	9.2	10	61	103
DH452071	7.1	8	53	91	DH452093	9.3	10	61	103
DH452072	7.2	8	53	91	DH452094	9.4	10	61	103
DH452073	7.3	8	53	91	DH452095	9.5	10	61	103
DH452074	7.4	8	53	91	DH452096	9.6	10	61	103
DH452075	7.5	8	53	91	DH452097	9.7	10	61	103
DH452076	7.6	8	53	91	DH452098	9.8	10	61	103
DH452077	7.7	8	53	91	DH452099	9.9	10	61	103
DH452078	7.8	8	53	91	DH452100	10.0	10	61	103
DH452079	7.9	8	53	91	DH452101	10.1	12	71	118
DH452080	8.0	8	53	91	DH452102	10.2	12	71	118

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◎	◎	○				○	◎	○	○		

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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
DH452103	10.3	12	71	118	DH452120	12.0	12	71	118
DH452104	10.4	12	71	118	DH452125	12.5	14	77	124
DH452105	10.5	12	71	118	DH452130	13.0	14	77	124
DH452106	10.6	12	71	118	DH452135	13.5	14	77	124
DH452107	10.7	12	71	118	DH452140	14.0	14	77	124
DH452108	10.8	12	71	118	DH452145	14.5	16	83	133
DH452109	10.9	12	71	118	DH452150	15.0	16	83	133
DH452110	11.0	12	71	118	DH452155	15.5	16	83	133
DH452111	11.1	12	71	118	DH452160	16.0	16	83	133
DH452112	11.2	12	71	118	DH452165	16.5	18	93	143
DH452113	11.3	12	71	118	DH452170	17.0	18	93	143
DH452114	11.4	12	71	118	DH452175	17.5	18	93	143
DH452115	11.5	12	71	118	DH452180	18.0	18	93	143
DH452116	11.6	12	71	118	DH452185	18.5	20	101	153
DH452117	11.7	12	71	118	DH452190	19.0	20	101	153
DH452118	11.8	12	71	118	DH452195	19.5	20	101	153
DH452119	11.9	12	71	118	DH452200	20.0	20	101	153

▶ 其他的刀柄类型可以按照你的要求。 / Other shank types are available on your request.

◎ : 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~							
◎	◎	○				○	◎	○	○		

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

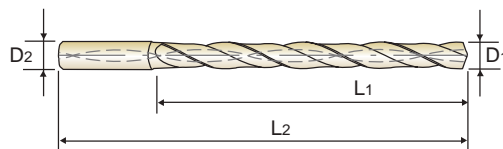
不锈钢用油孔硬质合金钻头

超长

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES EXTRA LONG

- ▶ 应用：沟槽的特殊几何形状使其适合加工不锈钢
- ▶ 更好的表面处理方式使其具有优秀的排屑性能
- ▶ 横刃修成R型使产品有较强的自定心能力和螺旋切削性
- ▶ 使用TiAlN涂层使被加工材料得到良好的表面粗糙度并且延长了钻头的使用寿命

- ▶ The tool has the special flute shape and geometry for suitable machining of stainless steels.
- ▶ Excellent chip evacuation due to better surface treatment.
- ▶ Point R-thinning makes superior centering and chip curling.
- ▶ Applied TiAlN coating achieves, the better surface finish of materials to be cut and the longer tool life.



DIN 6537
MG
h6
m7
140°
P.84

8 × D

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
DH453030	3.0	6	34	72	DH453057	5.7	6	57	95
DH453031	3.1	6	34	72	DH453058	5.8	6	57	95
DH453032	3.2	6	34	72	DH453059	5.9	6	57	95
DH453033	3.3	6	34	72	DH453060	6.0	6	57	95
DH453034	3.4	6	34	72	DH453061	6.1	8	76	114
DH453035	3.5	6	34	72	DH453062	6.2	8	76	114
DH453036	3.6	6	34	72	DH453063	6.3	8	76	114
DH453037	3.7	6	34	72	DH453064	6.4	8	76	114
DH453038	3.8	6	43	81	DH453065	6.5	8	76	114
DH453039	3.9	6	43	81	DH453066	6.6	8	76	114
DH453040	4.0	6	43	81	DH453067	6.7	8	76	114
DH453041	4.1	6	43	81	DH453068	6.8	8	76	114
DH453042	4.2	6	43	81	DH453069	6.9	8	76	114
DH453043	4.3	6	43	81	DH453070	7.0	8	76	114
DH453044	4.4	6	43	81	DH453071	7.1	8	76	114
DH453045	4.5	6	43	81	DH453072	7.2	8	76	114
DH453046	4.6	6	43	81	DH453073	7.3	8	76	114
DH453047	4.7	6	43	81	DH453074	7.4	8	76	114
DH453048	4.8	6	57	95	DH453075	7.5	8	76	114
DH453049	4.9	6	57	95	DH453076	7.6	8	76	114
DH453050	5.0	6	57	95	DH453077	7.7	8	76	114
DH453051	5.1	6	57	95	DH453078	7.8	8	76	114
DH453052	5.2	6	57	95	DH453079	7.9	8	76	114
DH453053	5.3	6	57	95	DH453080	8.0	8	76	114
DH453054	5.4	6	57	95	DH453081	8.1	10	95	142
DH453055	5.5	6	57	95	DH453082	8.2	10	95	142
DH453056	5.6	6	57	95	DH453083	8.3	10	95	142

▶ 其他的刀柄类型可以按照你的要求。 / Other shank types are available on your request.

◎ : 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~							
◎	◎	○				○	◎	○	○		



不锈钢用油孔硬质合金钻头 超长
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES **EXTRA LONG**

- ▶ 应用：沟槽的特殊几何形状使其适合加工不锈钢
- ▶ 更好的表面处理方式使其具有优秀的排屑性能
- ▶ 横刃修成R型使产品有较强的自定心能力和螺旋切削性
- ▶ 使用TiAlN涂层使被加工材料得到良好的表面粗糙度并且延长了钻头的使用寿命

- ▶ The tool has the special flute shape and geometry for suitable machining of stainless steels.
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DIN 6537
MG
h6
m7
140°
P.84

8 × D

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
DH453084	8.4	10	95	142	DH453105	10.5	12	114	162
DH453085	8.5	10	95	142	DH453106	10.6	12	114	162
DH453086	8.6	10	95	142	DH453107	10.7	12	114	162
DH453087	8.7	10	95	142	DH453108	10.8	12	114	162
DH453088	8.8	10	95	142	DH453109	10.9	12	114	162
DH453089	8.9	10	95	142	DH453110	11.0	12	114	162
DH453090	9.0	10	95	142	DH453111	11.1	12	114	162
DH453091	9.1	10	95	142	DH453112	11.2	12	114	162
DH453092	9.2	10	95	142	DH453113	11.3	12	114	162
DH453093	9.3	10	95	142	DH453114	11.4	12	114	162
DH453094	9.4	10	95	142	DH453115	11.5	12	114	162
DH453095	9.5	10	95	142	DH453116	11.6	12	114	162
DH453096	9.6	10	95	142	DH453117	11.7	12	114	162
DH453097	9.7	10	95	142	DH453118	11.8	12	114	162
DH453098	9.8	10	95	142	DH453119	11.9	12	114	162
DH453099	9.9	10	95	142	DH453120	12.0	12	114	162
DH453100	10.0	10	95	142	DH453125	12.5	14	133	178
DH453101	10.1	12	114	162	DH453130	13.0	14	133	178
DH453102	10.2	12	114	162	DH453135	13.5	14	133	178
DH453103	10.3	12	114	162	DH453140	14.0	14	133	178
DH453104	10.4	12	114	162					

▶ 其他的刀柄类型可以按照你的要求。 / Other shank types are available on your request.

◎ : 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~							
◎	◎	○				○	◎	○	○		

HSS

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
-INOX**

推荐的切削条件

RECOMMENDED CUTTING CONDITIONS

不锈钢用油孔硬质合金钻头, TiAIN涂层

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES, TiAIN COATED

DH451, DH452, DH453 SERIES

单位(Unit) : mm

被加工材料 WORK MATERIAL	不锈钢 STAINLESS STEELS		不锈钢 STAINLESS STEELS		铝 ALUMINUM		铝 ALUMINUM		钛, 钛合金 TITANIUM TI ALLOYS		碳钢, 合金钢 CARBON STEELS ALLOY STEELS		钛, 有色金属 TITANIUM NON FRERROUS	
	< 800 N/mm ²		> 800 N/mm ²		< 10% Si		> 10% Si							
STRENGTH														
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S
1.5	9000	0.03	5400	0.02	43000	0.05	32000	0.04	7500	0.01	18000	0.03	25500	0.03
2.5	7000	0.04	4200	0.03	25500	0.08	19500	0.06	4500	0.02	10800	0.05	15500	0.05
3.0	7400	0.04	4700	0.02	23000	0.12	18500	0.10	5300	0.03	13000	0.04	16000	0.08
4.0	5600	0.05	3600	0.03	17500	0.18	13900	0.15	4000	0.04	10000	0.05	11900	0.10
5.0	4400	0.05	2800	0.03	14000	0.20	11000	0.18	3200	0.05	8000	0.05	9500	0.12
6.0	3700	0.06	2400	0.04	11700	0.25	9300	0.25	2650	0.06	6600	0.06	8000	0.15
8.0	2800	0.08	1800	0.06	8800	0.30	7000	0.30	2000	0.07	5000	0.08	6000	0.18
10.0	2200	0.10	1400	0.08	7000	0.40	5600	0.35	1600	0.08	4000	0.10	4800	0.22
12.0	1900	0.12	1200	0.10	5800	0.50	4600	0.40	1300	0.10	3300	0.12	4000	0.26
14.0	1600	0.15	1000	0.12	5000	0.60	4000	0.50	1100	0.12	2800	0.15	3400	0.30
16.0	1400	0.20	900	0.15	4380	0.80	3500	0.60	1000	0.14	2500	0.20	3000	0.40
18.0	1250	0.22	800	0.17	3900	1.00	3100	0.70	900	0.16	2200	0.22	2650	0.45
20.0	1120	0.24	720	0.19	3500	1.20	2800	0.80	800	0.18	2000	0.24	2400	0.50

▶ 荐于按照下面减少进给速度 / Recommend to reduce the feed rate as following

N = R.P.M
S = Feed per Revolution (mm/rev.)

Feed 100% : DH451(3xD), DH452(5XD)

Feed 85% : DH453(8xD)

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