

HSS



Being the best through innovation



WORM PATTERN DRILLS

- 钻深孔


Drilling Deep Holes

SELECTION GUIDE

DH100, DH50-蜗式钻头
DH100-为了在普通钢上深孔

项目	型号	规格	尺寸		页
			最小	最大	
ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
DH100 DL505		HSS-E, 深孔用直柄麻花钻头 HSS-E, STRAIGHT SHANK DRILLS for DEEP HOLES, FORM C 细长 JOBBER	D2.0	D13.0	152
DH100 DL504		HSS-E, 深孔用直柄麻花钻头 HSS-E, STRAIGHT SHANK DRILLS for DEEP HOLES, FORM C 长 LONG	D2.0	D13.0	154
DH100 DL600		HSS-E, 深孔用直柄麻花钻头 HSS-E, STRAIGHT SHANK DRILLS for DEEP HOLES, FORM C 超长 EXTRA LONG	D2.0	D13.0	155
DH100 DL608		HSS-E, 莫氏锥柄深孔用麻花钻头 HSS-E, TAPER SHANK DRILLS for DEEP HOLES, FORM C 长 LONG	D13.0	D30.0	156
DH100 DL609		HSS-E, 莫氏锥柄深孔用麻花钻头 HSS-E, TAPER SHANK DRILLS for DEEP HOLES, FORM C 超长 EXTRA LONG	D13.0	D31.0	157
DH100 DL610		HSS-E, 莫氏锥柄深孔用麻花钻头 HSS-E, TAPER SHANK DRILLS for DEEP HOLES, FORM C 超长 EXTRA LONG	D13.0	D30.0	158
DH100 DL126		HSS-E, 深孔用直柄麻花钻头 HSS-E, STRAIGHT SHANK DRILLS for DEEP HOLES, FORM C 超长 EXTRA LONG	D2.0	D13.0	159

DH50-为了在铝上加工深孔

DH50 DL507		HSS-E, 铝加工深孔用直柄麻花钻头 HSS-E, STRAIGHT SHANK DRILLS for ALUMINUM DEEP HOLES, FORM C 超长 EXTRA LONG	D2.0	D13.0	161
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS			163

HSS-E WORM PATTERN DRILLS

DH100, DH50-WORM PATTERN DRILLS

DH100-For Deep hole drilling in general steels

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

DH50-For Deep hole drilling in aluminum

◎	◎				○	◎			○		
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WORM PATTERN DRILLS

DL505 SERIES

HSS-E, 深孔用直柄麻花钻头

细长

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

JOBBER

- ▶ 表面处理 : 氧化发黑处理
- ▶ 应用 : 适用于非合金钢, 合金钢, 灰铸铁, 可锻铸铁, 特殊铝和镁合金的深孔钻削。

- ▶ Surface treatment : Steam Tempered(Black Oxide Finish)
- ▶ Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL505020	2.0	24	49	DL505047	4.7	47	80
DL505021	2.1	24	49	DL505048	4.8	52	86
DL505022	2.2	27	53	DL505049	4.9	52	86
DL505023	2.3	27	53	DL505050	5.0	52	86
DL505024	2.4	30	57	DL505051	5.1	52	86
DL505025	2.5	30	57	DL505052	5.2	52	86
DL505026	2.6	30	57	DL505053	5.3	52	86
DL505027	2.7	33	61	DL505054	5.4	57	93
DL505028	2.8	33	61	DL505055	5.5	57	93
DL505029	2.9	33	61	DL505056	5.6	57	93
DL505030	3.0	33	61	DL505057	5.7	57	93
DL505031	3.1	36	65	DL505058	5.8	57	93
DL505032	3.2	36	65	DL505059	5.9	57	93
DL505033	3.3	36	65	DL505060	6.0	57	93
DL505034	3.4	39	70	DL505061	6.1	63	101
DL505035	3.5	39	70	DL505062	6.2	63	101
DL505036	3.6	39	70	DL505063	6.3	63	101
DL505037	3.7	39	70	DL505064	6.4	63	101
DL505038	3.8	43	75	DL505065	6.5	63	101
DL505039	3.9	43	75	DL505066	6.6	63	101
DL505040	4.0	43	75	DL505067	6.7	63	101
DL505041	4.1	43	75	DL505068	6.8	69	109
DL505042	4.2	43	75	DL505069	6.9	69	109
DL505043	4.3	47	80	DL505070	7.0	69	109
DL505044	4.4	47	80	DL505071	7.1	69	109
DL505045	4.5	47	80	DL505072	7.2	69	109
DL505046	4.6	47	80	DL505073	7.3	69	109

▶ TiN(DN505), TiCN(DX505), TiAlN(DT505)可根据客户需求进行加工。
TiN(DN505), TiCN(DX505) and TiAlN(DT505) 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~							
◎	◎				○	○			○		

WORM PATTERN DRILLS

DL505 SERIES

HSS-E, 深孔用直柄麻花钻头 细长 HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES JOBBER

- ▶ 表面处理：氧化发黑处理
- ▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削。

- ▶ Surface treatment : Steam Tempered(Black Oxide Finish)
- ▶ Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



DIN 338
HSS-E
38°
h8
130°
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▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL505074	7.4	69	109	DL505094	9.4	81	125
DL505075	7.5	69	109	DL505095	9.5	81	125
DL505076	7.6	75	117	DL505096	9.6	87	133
DL505077	7.7	75	117	DL505097	9.7	87	133
DL505078	7.8	75	117	DL505098	9.8	87	133
DL505079	7.9	75	117	DL505099	9.9	87	133
DL505080	8.0	75	117	DL505100	10.0	87	133
DL505081	8.1	75	117	DL505101	10.1	87	133
DL505082	8.2	75	117	DL505102	10.2	87	133
DL505083	8.3	75	117	DL505105	10.5	87	133
DL505084	8.4	75	117	DL505108	10.8	94	142
DL505085	8.5	75	117	DL505110	11.0	94	142
DL505086	8.6	81	125	DL505112	11.2	94	142
DL505087	8.7	81	125	DL505115	11.5	94	142
DL505088	8.8	81	125	DL505118	11.8	94	142
DL505089	8.9	81	125	DL505120	12.0	101	151
DL505090	9.0	81	125	DL505122	12.2	101	151
DL505091	9.1	81	125	DL505125	12.5	101	151
DL505092	9.2	81	125	DL505128	12.8	101	151
DL505093	9.3	81	125	DL505130	13.0	101	151

▶ TiN(DN505), TiCN(DX505), TiAlN(DT505) 可根据客户需求进行加工。
TiN(DN505), TiCN(DX505) and TiAlN(DT505) 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~							
◎	◎				○	○			○		

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

WORM PATTERN DRILLS

DL504 SERIES

HSS-E, 深孔用直柄麻花钻头

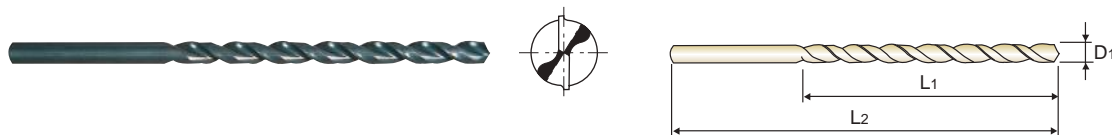
HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

长

LONG

- ▶ 表面处理：氧化发黑处理
- ▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削。

- ▶ Surface treatment : Steam Tempered(Black Oxide Finish)
- ▶ Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL504020	2.0	56	85	DL504052	5.2	87	132
DL504021	2.1	56	85	DL504055	5.5	91	139
DL504022	2.2	59	90	DL504058	5.8	91	139
DL504023	2.3	59	90	DL504060	6.0	91	139
DL504024	2.4	62	95	DL504062	6.2	97	148
DL504025	2.5	62	95	DL504065	6.5	97	148
DL504026	2.6	62	95	DL504068	6.8	102	156
DL504027	2.7	66	100	DL504070	7.0	102	156
DL504028	2.8	66	100	DL504072	7.2	102	156
DL504029	2.9	66	100	DL504075	7.5	102	156
DL504030	3.0	66	100	DL504078	7.8	109	165
DL504031	3.1	69	106	DL504080	8.0	109	165
DL504032	3.2	69	106	DL504082	8.2	109	165
DL504033	3.3	69	106	DL504085	8.5	109	165
DL504034	3.4	73	112	DL504090	9.0	115	175
DL504035	3.5	73	112	DL504095	9.5	115	175
DL504036	3.6	73	112	DL504098	9.8	121	184
DL504037	3.7	73	112	DL504100	10.0	121	184
DL504038	3.8	78	119	DL504105	10.5	121	184
DL504039	3.9	78	119	DL504110	11.0	128	195
DL504040	4.0	78	119	DL504115	11.5	128	195
DL504042	4.2	78	119	DL504120	12.0	134	205
DL504045	4.5	82	126	DL504125	12.5	134	205
DL504048	4.8	87	132	DL504130	13.0	134	205
DL504050	5.0	87	132				

▶ TiN(DN504),TiCN(DX504),TiAlN(DT504)可根据客户需求进行加工。
TiN(DN504), TiCN(DX504) and TiAlN(DT504) 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~							
◎	◎				○	○			○		

WORM PATTERN DRILLS

DL600 SERIES

HSS-E, 深孔用直柄麻花钻头 超长 HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削

▶ Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



DIN 1869/1
HSS-E
38°
h8
130°
P.163

▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL600020	2.0	85	125	DL600070	7.0	155	225
DL600922	2.25	90	135	DL600972	7.25	155	225
DL600025	2.5	95	140	DL600075	7.5	155	225
DL600927	2.75	100	150	DL600977	7.75	165	240
DL600030	3.0	100	150	DL600080	8.0	165	240
DL600932	3.25	105	155	DL600982	8.25	165	240
DL600035	3.5	115	165	DL600085	8.5	165	240
DL600937	3.75	115	165	DL600987	8.75	175	250
DL600040	4.0	120	175	DL600090	9.0	175	250
DL600942	4.25	120	175	DL600992	9.25	175	250
DL600045	4.5	125	185	DL600095	9.5	175	250
DL600947	4.75	125	185	DL600997	9.75	185	265
DL600050	5.0	135	195	DL600100	10.0	185	265
DL600952	5.25	135	195	DL600105	10.5	185	265
DL600055	5.5	140	205	DL600110	11.0	195	280
DL600957	5.75	140	205	DL600115	11.5	195	280
DL600060	6.0	140	205	DL600120	12.0	205	295
DL600962	6.25	150	215	DL600125	12.5	205	295
DL600065	6.5	150	215	DL600130	13.0	205	295
DL600967	6.75	155	225				

▶ TiN (DN600), TiCN (DX600), TiAlN (DT600) 可根据客户需求进行加工。
TiN(DN600), TiCN(DX600) and TiAlN(DT600) 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~							
◎	◎				○	○			○		

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



WORM PATTERN DRILLS

DL608 SERIES

HSS-E, 莫氏锥柄深孔用麻花钻头

长

HSS-E, MORSE TAPER SHANK TWIST DRILLS for DEEP HOLES

LONG

▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削。

▶ Application: Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



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▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	莫氏锥度号 No. of Morse Taper	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	莫氏锥度号 No. of Morse Taper
DL608130	13.0	134	215	1	DL608195	19.5	177	275	2
DL608135	13.5	142	223	1	DL608200	20.0	177	275	2
DL608140	14.0	142	223	1	DL608210	21.0	184	282	2
DL608145	14.5	147	245	2	DL608220	22.0	191	289	2
DL608150	15.0	147	245	2	DL608230	23.0	198	296	2
DL608155	15.5	153	251	2	DL608240	24.0	206	327	3
DL608160	16.0	153	251	2	DL608250	25.0	206	327	3
DL608165	16.5	159	257	2	DL608260	26.0	214	335	3
DL608170	17.0	159	257	2	DL608270	27.0	222	343	3
DL608175	17.5	165	263	2	DL608280	28.0	222	343	3
DL608180	18.0	165	263	2	DL608290	29.0	230	351	3
DL608185	18.5	171	269	2	DL608300	30.0	230	351	3
DL608190	19.0	171	269	2					

◎ : 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~							
◎	◎				○	○			○		

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

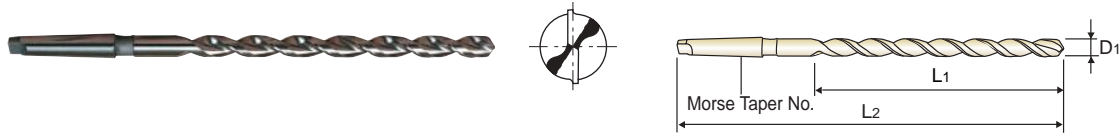
WORM PATTERN DRILLS

DL609 SERIES

HSS-E, 莫氏锥柄深孔用麻花钻头 超长 HSS-E, MORSE TAPER SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

▶ 应用：设计用于深孔加工或深定位孔加工，适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削。

▶ Application : Designed for drilling deep holes or deeply located holes.
 Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



DIN 1870/1
HSS-E
38°
1~3
h8
130°
P.163

▶ DH100 worm pattern drills

单位(Unit) : mm

型号	刃径	刃长	全长	莫氏锥度号	型号	刃径	刃长	全长	莫氏锥度号
EDP No.	Drill Diameter	Flute Length	Overall Length	No. of Morse Taper	EDP No.	Drill Diameter	Flute Length	Overall Length	No. of Morse Taper
	D1	L1	L2			D1	L1	L2	
DL609130	13.0	205	310	1	DL609220	22.0	270	405	2
DL609135	13.5	220	325	1	DL609225	22.5	270	405	2
DL609140	14.0	220	325	1	DL609230	23.0	270	405	2
DL609145	14.5	220	340	2	DL609235	23.5	270	425	3
DL609150	15.0	220	340	2	DL609240	24.0	290	440	3
DL609155	15.5	230	355	2	DL609245	24.5	290	440	3
DL609160	16.0	230	355	2	DL609250	25.0	290	440	3
DL609165	16.5	230	355	2	DL609255	25.5	290	440	3
DL609170	17.0	230	355	2	DL609260	26.0	290	440	3
DL609175	17.5	245	370	2	DL609265	26.5	290	440	3
DL609180	18.0	245	370	2	DL609270	27.0	305	460	3
DL609185	18.5	245	370	2	DL609275	27.5	305	460	3
DL609190	19.0	245	370	2	DL609280	28.0	305	460	3
DL609195	19.5	260	385	2	DL609285	28.5	305	460	3
DL609200	20.0	260	385	2	DL609290	29.0	305	460	3
DL609205	20.5	260	385	2	DL609295	29.5	305	460	3
DL609210	21.0	260	385	2	DL609300	30.0	305	460	3
DL609215	21.5	270	405	2	DL609310	31.0	320	480	3

◎ : 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

WORM PATTERN DRILLS

DL610 SERIES

HSS-E, 莫氏锥柄深孔用麻花钻头

超长

HSS-E, MORSE TAPER SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

▶ 应用：设计用于深孔加工或深定位孔加工，适用于非合金钢，合金钢，灰铸铁，可锻铸铁，特殊铝和镁合金的深孔钻削。

▶ Application: Designed for drilling deep holes or deeply located holes.
Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



DIN 1870/2
HSS-E
38°
1~3
h8
130°
P.163

▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	莫氏锥度号 No. of Morse Taper	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	莫氏锥度号 No. of Morse Taper
DL610130	13.0	260	395	1	DL610220	22.0	345	515	2
DL610135	13.5	275	410	1	DL610225	22.5	345	515	2
DL610140	14.0	275	410	1	DL610230	23.0	345	515	2
DL610145	14.5	275	425	2	DL610235	23.5	345	535	3
DL610150	15.0	275	425	2	DL610240	24.0	365	555	3
DL610155	15.5	295	445	2	DL610245	24.5	365	555	3
DL610160	16.0	295	445	2	DL610250	25.0	365	555	3
DL610165	16.5	295	445	2	DL610255	25.5	365	555	3
DL610170	17.0	295	445	2	DL610260	26.0	365	555	3
DL610175	17.5	310	465	2	DL610265	26.5	365	555	3
DL610180	18.0	310	465	2	DL610270	27.0	385	580	3
DL610185	18.5	310	465	2	DL610275	27.5	385	580	3
DL610190	19.0	310	465	2	DL610280	28.0	385	580	3
DL610195	19.5	325	490	2	DL610285	28.5	385	580	3
DL610200	20.0	325	490	2	DL610290	29.0	385	580	3
DL610205	20.5	325	490	2	DL610295	29.5	385	580	3
DL610210	21.0	325	490	2	DL610300	30.0	385	580	3
DL610215	21.5	345	515	2					

◎ : 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~							
◎	◎				○	○			○		

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

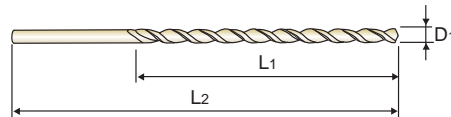
HSS-E, 深孔用直柄麻花钻头

超长

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，和镁合金的深孔钻削

▶ Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron or magnesium alloys.



P.163

▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
	D1	L1	L2		D1	L1	L2
DL126220	2.0	75	100	DL126420	2.0	150	200
DL126225	2.5	75	100	DL126425	2.5	150	200
DL126230	3.0	75	100	DL126430	3.0	150	200
DL126235	3.5	75	100	DL126435	3.5	150	200
DL126240	4.0	75	100	DL126440	4.0	150	200
DL126245	4.5	75	100	DL126445	4.5	150	200
DL126250	5.0	75	100	DL126450	5.0	150	200
DL126255	5.5	75	100	DL126455	5.5	150	200
DL126320	2.0	100	150	DL126460	6.0	150	200
DL126325	2.5	100	150	DL126465	6.5	150	200
DL126330	3.0	100	150	DL126470	7.0	150	200
DL126335	3.5	100	150	DL126475	7.5	150	200
DL126340	4.0	100	150	DL126480	8.0	150	200
DL126345	4.5	100	150	DL126485	8.5	150	200
DL126350	5.0	100	150	DL126490	9.0	150	200
DL126355	5.5	100	150	DL126495	9.5	150	200
DL126360	6.0	100	150	DL126700	10.0	150	200
DL126365	6.5	100	150	DL126705	10.5	150	200
DL126370	7.0	100	150	DL126710	11.0	150	200
DL126375	7.5	100	150	DL126715	11.5	150	200
DL126380	8.0	100	150	DL126720	12.0	150	200
DL126385	8.5	100	150				
DL126390	9.0	100	150				

◎ : 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~							
◎	◎				○				○		

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

WORM PATTERN DRILLS

DL126 SERIES

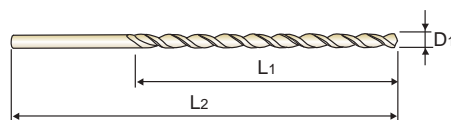
HSS-E, 深孔用直柄麻花钻头

超长

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

▶ 应用：适用于非合金钢，合金钢，灰铸铁，可锻铸铁，和镁合金的深孔钻削

▶ Application: Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron or magnesium alloys.



▶ DH100 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL126540	4.0	200	250	DL126655	5.5	200	300
DL126545	4.5	200	250	DL126660	6.0	200	300
DL126550	5.0	200	250	DL126665	6.5	200	300
DL126555	5.5	200	250	DL126670	7.0	200	300
DL126560	6.0	200	250	DL126675	7.5	200	300
DL126565	6.5	200	250	DL126680	8.0	200	300
DL126570	7.0	200	250	DL126685	8.5	200	300
DL126575	7.5	200	250	DL126690	9.0	200	300
DL126580	8.0	200	250	DL126695	9.5	200	300
DL126585	8.5	200	250	DL126900	10.0	200	300
DL126590	9.0	200	250	DL126905	10.5	200	300
DL126595	9.5	200	250	DL126910	11.0	200	300
DL126800	10.0	200	250	DL126915	11.5	200	300
DL126805	10.5	200	250	DL126920	12.0	200	300
DL126810	11.0	200	250	DL126925	12.5	200	300
DL126815	11.5	200	250	DL126930	13.0	200	300
DL126820	12.0	200	250				
DL126825	12.5	200	250				
DL126830	13.0	200	250				

◎ : 优(Excellent) ○ : 良(Good)

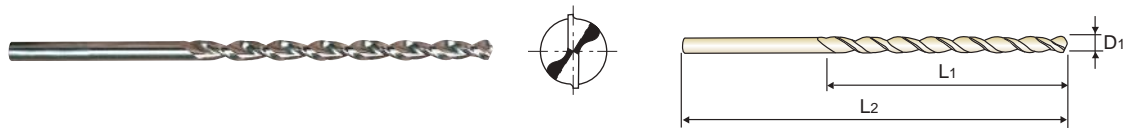
碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	低碳钢 Mild Steels	铜 Copper	青铜 Bronze
-HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎				○				○		

WORM PATTERN DRILLS

DL507 SERIES

HSS-E, 铝加工深孔用直柄麻花钻头 超长 HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES EXTRA LONG

▶ 应用：适用于铝，铝合金，含硅铝合金，锌，精炼铜，木材及其它软质合成材料的加工
 ▶ Application : Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials.



HSS-E
W 38°
h8
118°
P.163

▶ DH50 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL507120	2.0	40	75	DL507430	3.0	100	200
DL507121	2.1	40	75	DL507433	3.3	100	200
DL507220	2.0	50	100	DL507435	3.5	100	200
DL507221	2.1	50	100	DL507440	4.0	100	200
DL507225	2.5	50	100	DL507442	4.2	100	200
DL507227	2.7	50	100	DL507445	4.5	100	200
DL507230	3.0	50	100	DL507450	5.0	100	200
DL507233	3.3	50	100	DL507453	5.3	100	200
DL507235	3.5	50	100	DL507455	5.5	100	200
DL507320	2.0	75	150	DL507460	6.0	100	200
DL507321	2.1	75	150	DL507465	6.5	100	200
DL507325	2.5	75	150	DL507468	6.8	100	200
DL507327	2.7	75	150	DL507470	7.0	100	200
DL507330	3.0	75	150	DL507475	7.5	100	200
DL507333	3.3	75	150	DL507480	8.0	100	200
DL507335	3.5	75	150	DL507485	8.5	100	200
DL507340	4.0	75	150	DL507488	8.8	100	200
DL507342	4.2	75	150	DL507490	9.0	100	200
DL507345	4.5	75	150	DL507495	9.5	100	200
DL507350	5.0	75	150	DL507700	10.0	100	200
DL507353	5.3	75	150	DL507540	4.0	150	250
DL507355	5.5	75	150	DL507542	4.2	150	250
DL507360	6.0	75	150	DL507545	4.5	150	250
				DL507550	5.0	150	250
				DL507553	5.3	150	250

◎ : 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

WORM PATTERN DRILLS

DL507 SERIES

HSS-E, 铝加工深孔用直柄麻花钻头

超长

HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES EXTRA LONG

▶ 应用：适用于铝，铝合金，含硅铝合金，锌，精炼铜，木材及其它软质合成材料的加工

▶ Application: Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials.



▶ DH50 worm pattern drills

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2	型号 EDP No.	刃径 Drill Diameter D1	刃长 Flute Length L1	全长 Overall Length L2
DL507555	5.5	150	250	DL507650	5.0	180	300
DL507560	6.0	150	250	DL507653	5.3	180	300
DL507565	6.5	150	250	DL507655	5.5	180	300
DL507568	6.8	150	250	DL507660	6.0	180	300
DL507570	7.0	150	250	DL507665	6.5	180	300
DL507575	7.5	150	250	DL507668	6.8	180	300
DL507580	8.0	150	250	DL507670	7.0	180	300
DL507585	8.5	150	250	DL507675	7.5	180	300
DL507588	8.8	150	250	DL507680	8.0	180	300
DL507590	9.0	150	250	DL507685	8.5	180	300
DL507595	9.5	150	250	DL507688	8.8	180	300
DL507800	10.0	150	250	DL507690	9.0	180	300
DL507803	10.3	150	250	DL507695	9.5	180	300
DL507805	10.5	150	250	DL507900	10.0	180	300
DL507810	11.0	150	250	DL507903	10.3	180	300
DL507815	11.5	150	250	DL507905	10.5	180	300
DL507820	12.0	150	250	DL507910	11.0	180	300
DL507825	12.5	150	250	DL507915	11.5	180	300
DL507830	13.0	150	250	DL507920	12.0	180	300
				DL507925	12.5	180	300
				DL507930	13.0	180	300

◎ : 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~							
◎	◎				○	◎			○		

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


WORM PATTERN DRILLS

推荐的切削条件

RECOMMENDED CUTTING CONDITIONS

HSS-E, DH100 蜗式钻头, DIN1897, DIN338, DIN340, DIN1869, DIN341, DIN1870
HSS-E, DH100 TYPE WORM PATTERN DRILLS, DIN1897, DIN338, DIN340, DIN1869, DIN341, DIN1870
DL505, DL504, DL600, DL608, DL609, DL610, DL126 SERIES

单位(Unit) : mm

被加工材料	碳钢, 合金钢		工具钢, 硬化钢		软灰铸铁		硬灰铸铁	
WORK MATERIAL	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
HARDNESS	HRc15 ~ 30		HRc20 ~ 40					
STRENGTH	700 ~ 1000 N/mm ²		800 ~ 1200 N/mm ²					
DIAMETER	N	S	N	S	N	S	N	S
2.0	2630	0.03	2100	0.025	4200	0.06	1680	0.05
2.5	2100	0.04	1680	0.03	3300	0.08	1310	0.06
3.0	1680	0.05	1310	0.04	2630	0.10	1050	0.08
4.0	1310	0.06	1050	0.05	2100	0.13	840	0.10
5.0	1050	0.06	840	0.05	1680	0.13	660	0.10
6.0	840	0.08	660	0.06	1310	0.16	530	0.13
8.0	660	0.10	530	0.08	1050	0.20	420	0.17
10.0	530	0.13	420	0.10	840	0.25	330	0.21
13.0	420	0.13	330	0.10	660	0.25	260	0.21
16.0	330	0.15	260	0.13	530	0.30	210	0.25
20.0	260	0.20	210	0.15	420	0.40	170	0.30
25.0	210	0.25	170	0.20	330	0.50	130	0.50
30.0	170	0.25	130	0.20	260	0.50	110	0.50

N = R.P.M

S = Feed per Revolution (mm/rev.)

HSS-E, DH50 蜗式钻头
HSS-E, DH50 TYPE WORM PATTERN DRILLS
DL507 SERIES

单位(Unit) : mm

被加工材料	碳钢, 合金钢		软灰铸铁		铝合金	
WORK MATERIAL	CARBON STEELS ALLOY STEELS		SOFT GREY CAST IRON		ALUMINUM ALLOY	
HARDNESS	HRc15 ~ 30					
STRENGTH	700 ~ 1000 N/mm ²					
DIAMETER	N	S	N	S	N	S
2.0	2630	0.03	4200	0.06	8700	0.04
2.5	2100	0.04	3300	0.08	6950	0.05
3.0	1680	0.05	2630	0.10	5800	0.06
4.0	1310	0.06	2100	0.13	4300	0.08
5.0	1050	0.06	1680	0.13	3500	0.10
6.0	840	0.08	1310	0.16	2900	0.12
8.0	660	0.10	1050	0.20	2200	0.16
10.0	530	0.13	840	0.25	1750	0.20
13.0	420	0.13	660	0.25	1350	0.26

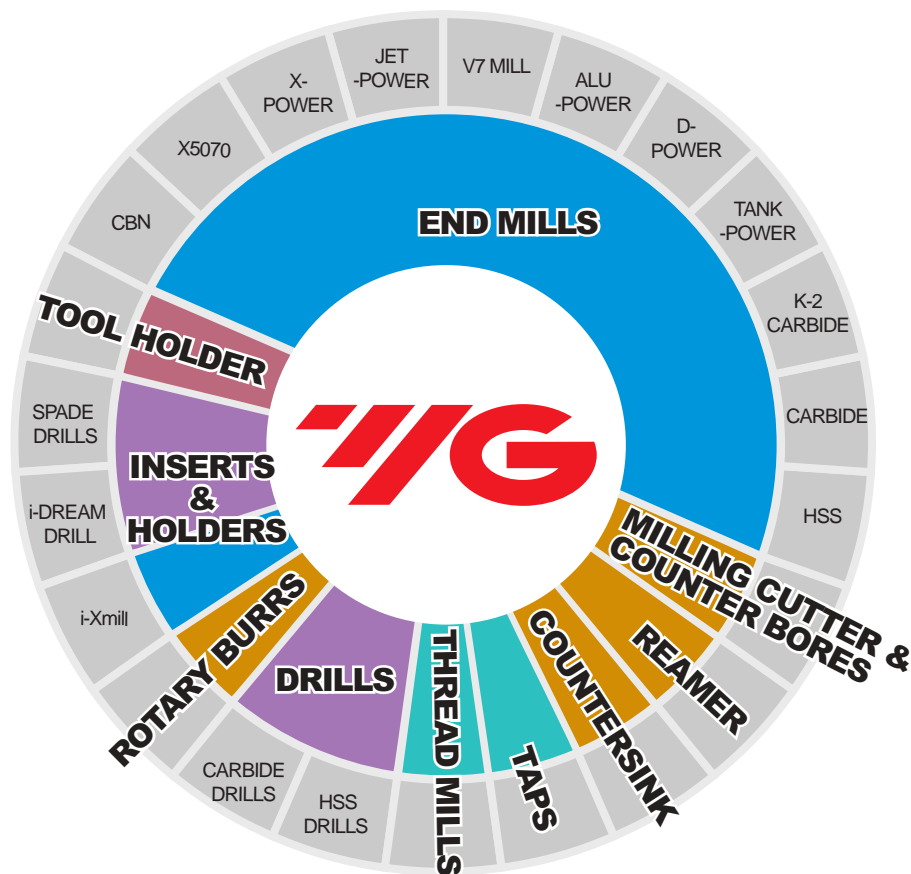
N = R.P.M

S = Feed per Revolution (mm/rev.)

I-DREAM
DRILLSDREAM
DRILLS
-GENERALDREAM
DRILLS
-SOFTDREAM
DRILLS
-INOXDREAM
DRILLS
-MQL TYPEDREAM
DRILLS
for HARDENED
STEELSGENERAL
CARBIDE
DRILLSNC-SPOTTING
DRILLSMULTI-1
DRILLS

HPD DRILLS

GOLD-P
DRILLSWORM
PATTERN
DRILLSSTRAIGHT
SHANK
DRILLSTAPER
SHANK
DRILLSNC-SPOTTING
DRILLSCENTER
DRILLSSPADE
DRILLSTECHNICAL
DATA



Challenge toward a Global Leader-

YG-1 Leads the World Market.