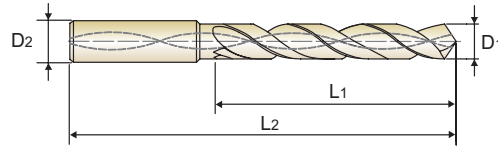


CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES *EXTRA LONG*

🇩🇪 VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL *ÜBERLANG*
🇫🇷 Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série extra-longue *EXTRA-LONGUE*
🇮🇹 PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione) *EXTRA LUNGA*

- ▶ Optimized thinning for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
- ▶ Wider and deeper flute gullets for maximum chip removal
- ▶ Special geometry and smooth coating reduces built up edge and improves finishes

- ▶ Optimierte Ausspitzung für Aluminum & Aluminiumlegierungen zur Vermeidung von Verstopfungen durch das Aufschweißen der Späne
- ▶ Breitere und tiefere Spannuten für maximale Spanabfuhr
- ▶ Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



DIN 6537
CARBIDE
30°
h6
m7
118°
20 bar

P.141

8 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5434030	3.0	6	34	72
D5434031	3.1	6	34	72
D5434032	3.2	6	34	72
D5434033	3.3	6	34	72
D5434034	3.4	6	34	72
D5434035	3.5	6	34	72
D5434036	3.6	6	34	72
D5434037	3.7	6	34	72
D5434038	3.8	6	43	81
D5434039	3.9	6	43	81
D5434040	4.0	6	43	81
D5434041	4.1	6	43	81
D5434042	4.2	6	43	81
D5434043	4.3	6	43	81
D5434044	4.4	6	43	81
D5434045	4.5	6	43	81
D5434046	4.6	6	43	81
D5434047	4.7	6	43	81
D5434048	4.8	6	57	95
D5434049	4.9	6	57	95
D5434050	5.0	6	57	95
D5434051	5.1	6	57	95
D5434052	5.2	6	57	95
D5434053	5.3	6	57	95

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5434054	5.4	6	57	95
D5434055	5.5	6	57	95
D5434056	5.6	6	57	95
D5434057	5.7	6	57	95
D5434058	5.8	6	57	95
D5434059	5.9	6	57	95
D5434060	6.0	6	57	95
D5434061	6.1	8	76	114
D5434062	6.2	8	76	114
D5434063	6.3	8	76	114
D5434064	6.4	8	76	114
D5434065	6.5	8	76	114
D5434066	6.6	8	76	114
D5434067	6.7	8	76	114
D5434068	6.8	8	76	114
D5434069	6.9	8	76	114
D5434070	7.0	8	76	114
D5434071	7.1	8	76	114
D5434072	7.2	8	76	114
D5434073	7.3	8	76	114
D5434074	7.4	8	76	114
D5434075	7.5	8	76	114
D5434076	7.6	8	76	114
D5434077	7.7	8	76	114

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended																				

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	



CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

EXTRA LONG

● **VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL**

ÜBERLANG

● **Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série extra-longue**

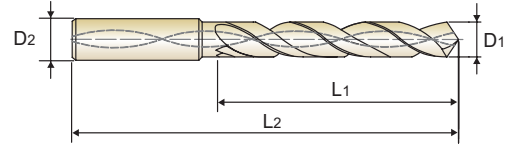
EXTRA-LONGUE

● **PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (con fori di refrigerazione)**

EXTRA LUNGA

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P.141

8 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5434078	7.8	8	76	114
D5434079	7.9	8	76	114
D5434080	8.0	8	76	114
D5434081	8.1	10	95	142
D5434082	8.2	10	95	142
D5434083	8.3	10	95	142
D5434084	8.4	10	95	142
D5434085	8.5	10	95	142
D5434086	8.6	10	95	142
D5434087	8.7	10	95	142
D5434088	8.8	10	95	142
D5434089	8.9	10	95	142
D5434090	9.0	10	95	142
D5434091	9.1	10	95	142
D5434092	9.2	10	95	142
D5434093	9.3	10	95	142
D5434094	9.4	10	95	142
D5434095	9.5	10	95	142
D5434096	9.6	10	95	142
D5434097	9.7	10	95	142
D5434098	9.8	10	95	142
D5434099	9.9	10	95	142
D5434100	10.0	10	95	142
D5434101	10.1	12	114	162

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5434102	10.2	12	114	162
D5434103	10.3	12	114	162
D5434104	10.4	12	114	162
D5434105	10.5	12	114	162
D5434106	10.6	12	114	162
D5434107	10.7	12	114	162
D5434108	10.8	12	114	162
D5434109	10.9	12	114	162
D5434110	11.0	12	114	162
D5434111	11.1	12	114	162
D5434112	11.2	12	114	162
D5434113	11.3	12	114	162
D5434114	11.4	12	114	162
D5434115	11.5	12	114	162
D5434116	11.6	12	114	162
D5434117	11.7	12	114	162
D5434118	11.8	12	114	162
D5434119	11.9	12	114	162
D5434120	12.0	12	114	162
D5434125	12.5	14	133	178
D5434130	13.0	14	133	178
D5434135	13.5	14	133	178
D5434140	14.0	14	133	178

- ▶ DLC coating is available on your request.
- ▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25			21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended																					
ISO	N									S						H					
	Aluminum-wrought alloy			Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎																	



RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDPARAMETER

D5432, D5433, D5434 SERIES

with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)															
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0					
P	1	Non-alloy steel																		
	2																			
	3																			
	4																			
	5																			
	6	Low alloy steel																		
	7																			
	8																			
	9																			
	10		High alloyed steel, and tool steel																	
	11																			
M	12	Stainless steel																		
	13																			
	14																			
K	15	Grey cast iron																		
	16																			
	17	Nodular cast iron																		
	18																			
	19																			
20	Malleable cast iron																			
N	21	Aluminum-wrought alloy	200	RPM	21220	15920	12730	10610	7960	6370	5310	4550	3980	3540	3180					
			FEED	0.12-0.18	0.14-0.22	0.15-0.23	0.17-0.25	0.21-0.28	0.24-0.30	0.24-0.30	0.25-0.35	0.25-0.35	0.28-0.38	0.30-0.40						
	22		160	RPM	16980	12730	10190	8490	6370	5090	4240	3640	3180	2830	2550					
				FEED	0.12-0.18	0.14-0.22	0.15-0.23	0.17-0.25	0.21-0.28	0.24-0.30	0.24-0.30	0.25-0.35	0.25-0.35	0.28-0.38	0.30-0.40					
	23	Aluminum-cast, alloyed	150	RPM	15920	11940	9550	7960	5970	4770	3980	3410	2980	2650	2390					
					FEED	0.15-0.21	0.17-0.25	0.19-0.27	0.21-0.28	0.24-0.31	0.29-0.45	0.33-0.55	0.35-0.60	0.35-0.60	0.39-0.73	0.39-0.85				
	24			140	RPM	14850	11140	8910	7430	5570	4460	3710	3180	2790	2480	2230				
						FEED	0.15-0.21	0.17-0.25	0.19-0.27	0.21-0.28	0.24-0.31	0.29-0.45	0.33-0.55	0.35-0.60	0.35-0.60	0.39-0.73	0.39-0.85			
	25																			
	26	Copper and Copper Alloys (Bronze / Brass)																		
27																				
28																				
29	Non Metallic Materials																			
30																				
S	31	Heat Resistant Super Alloys																		
	32																			
	33																			
	34																			
	35																			
	36	Titanium Alloys																		
	37																			
H	38	Hardened steel																		
	39																			
	40	Chilled Cast Iron																		
	41	Hardened Cast Iron																		

SELECTION GUIDE



SERIES

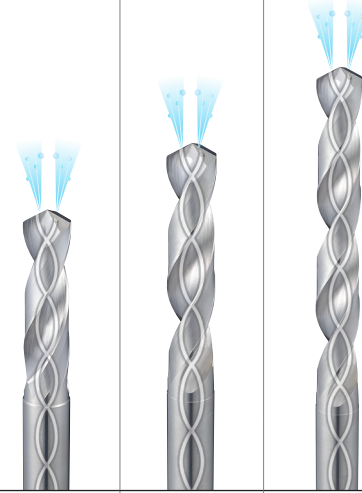
	D5432	D5433	D5434
DRILLING DEPTH	3XD	5XD	8XD
LENGTH	SHORT	LONG	EXTRA LONG
SIZE MIN	D3.0	D3.0	D3.0
SIZE MAX	D20.0	D20.0	D14.0
PAGE	133	136	139

SURFACE TREATMENT

Bright

SOLID CARBIDE DREAM DRILLS ALU

For Aluminum and Aluminum Alloys



Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.141

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc			
P	1	Non-alloy steel	About 0.15% C Annealed	125				
	2		About 0.45% C Annealed	190	13			
	3		About 0.45% C Quenched & Tempered	250	25			
	4		About 0.75% C Annealed	270	28			
	5		About 0.75% C Quenched & Tempered	300	32			
	6	Low alloy steel	Annealed	180	10			
	7		Quenched & Tempered	275	29			
	8		Quenched & Tempered	300	32			
	9		Quenched & Tempered	350	38			
	10		High alloyed steel, and tool steel	Annealed	200	15		
	11	Quenched & Tempered		325	35			
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15			
	13		Martensitic Quenched & Tempered	240	23			
	14		Austenitic	180	10			
K	15	Grey cast iron	Pearlitic / ferritic	180	10			
	16		Pearlitic (Martensitic)	260	26			
	17	Nodular cast iron	Ferritic	160	3			
	18		Pearlitic	250	25			
	19		Ferritic	130				
20	Malleable cast iron	Pearlitic	230	21				
N	21	Aluminum-wrought alloy	Not Curable	60		◎	◎	◎
	22		Curable Hardened	100		◎	◎	◎
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		◎	◎	◎
	24		≤ 12% Si, Curable Hardened	90		◎	◎	◎
	25		> 12% Si, Not Curable	130				
	26		Copper and Copper Alloys	Cutting Alloys, PB>1%	110			
	27	(Bronze / Brass)	CuZn, CuSnZn (Brass)	90				
	28		CuSn, lead-free copper and electrolytic copper	100				
	29		Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				
	30		Rubber, Wood, etc.					
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15			
	32		Cured	280	30			
	33		Annealed	250	25			
	34		Ni or Co Based Cured	350	38			
	35		Cast	320	34			
	36	Titanium Alloys	Pure Titanium	400 Rm				
	37		Alpha + Beta Alloys Hardened	1050 Rm				
H	38	Hardened steel	Hardened	550	55			
	39		Hardened	630	60			
	40	Chilled Cast Iron	Cast	400	42			
41	Hardened Cast Iron	Hardened	550	55				