



DI473 SERIES

CARBIDE, DREAM DRILLS - CFRP

LONG

● VOLLHARTMETALL DREAM SPIRALBOHRER - CFK

LANG

● Forets DREAM DRILLS carbure - CFRP

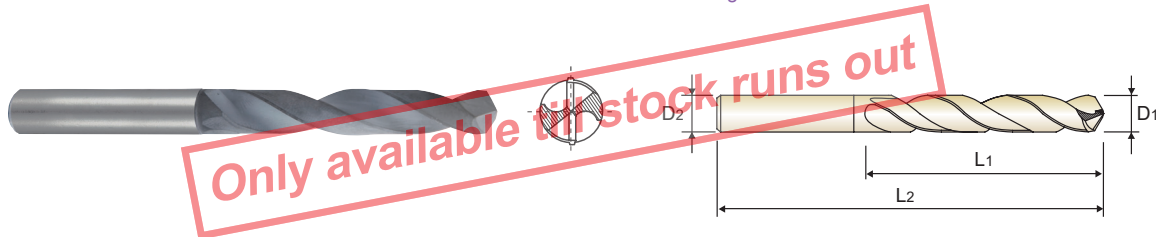
LONGUE

● PUNTE ELICOIDALI IN MD, DREAM DRILLS - CFRP

LUNGA

- ▶ Special point type to improve hole quality for Composite Materials
- ▶ Minimized burr and delamination at entry / exit hole
- ▶ Outstanding performance
- ▶ Long tool life and increased product by Diamond Coating

- ▶ Spezielle Spitzengeometrie zur Verbesserung der Qualität der Bohrung in Compsite-Materialien
- ▶ Minimierung des Grates und der Delamination am Bohrungseintritt und -austritt
- ▶ Überzeugende Performance
- ▶ Lange Standzeiten und erhöhte Produktivität durch die Diamant-Beschichtung



DIN 6537 CARBIDE 30° h6 m7 118° P.146

5 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
Diamond-Coating	D1	D2	L1	L2
▲ DI473025	2.5	6	24	66
▲ DI473030	3.0	6	28	66
▲ DI473040	4.0	6	36	74
▲ DI473050	5.0	6	44	82
▲ DI473060	6.0	6	44	82
▲ DI473080	8.0	8	53	91
▲ DI473090	9.0	10	61	103
▲ DI473100	10.0	10	61	103
▲ DI473110	11.0	12	71	118
▲ DI473120	12.0	12	71	118



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Dream Drill CFRP is only available till stock runs out!

▲ : Only available till stock runs out

◎ : Excellent ○ : Good

ISO	P										M				K								
Material Description	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						
Material Description	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	139	3	40	41
HRc											15	30	25	38	34			55	60	70		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**  
**EMPFOHLENE SCHNEIDPARAMETER**

**DI473 SERIES DREAM DRILLS - CFRP**

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	20.0
P	1	Non-alloy steel									
	2										
	3										
	4										
	5										
	6	Low alloy steel									
	7										
	8										
	9										
	10										
		11	High alloyed steel, and tool steel								
M	12	Stainless steel									
	13										
	14										
K	15	Grey cast iron									
	16	Nodular cast iron									
	17										
	18										
	19	Malleable cast iron									
20											
N	21	Aluminum-wrought alloy									
	22	Aluminum-cast, alloyed									
	23										
	24										
	25										
	26	Copper and Copper Alloys (Bronze / Brass)									
	27										
	28										
29	Non Metallic Materials	120	RPM FEED	12730 0.03-0.07	9550 0.03-0.07	7640 0.03-0.07	6370 0.03-0.07	4770 0.03-0.07	3820 0.03-0.07	3180 0.03-0.07	
S	31	Heat Resistant Super Alloys									
	32										
	33										
	34	Titanium Alloys									
	35										
H	36										
	37										
	38	Hardened steel									
	39	Chilled Cast Iron									
40											
41	Hardened Cast Iron										

SELECTION GUIDE



SERIES **DI473**

DRILLING DEPTH **5XD**

LENGTH **LONG**

SIZE MIN **D2.5**

SIZE MAX **D12.0**

PAGE **145**

SURFACE TREATMENT **Diamond Coating**

**SOLID CARBIDE  
DREAM DRILLS  
CFRP**

For Composite Materials including CFRP and GFRP

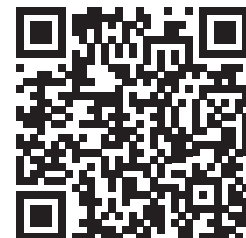


Please visit [globalyg1.com/mat](http://globalyg1.com/mat) for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.146

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc	
<b>P</b>	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	
<b>M</b>	12	Stainless steel	Ferritic / Martensitic Annealed	200	15	
	13		Martensitic Quenched & Tempered	240	23	
	14	Austenitic	180	10		
<b>K</b>	15	Grey cast iron	Pearlitic / ferritic	180	10	
	16	Nodular cast iron	Pearlitic (Martensitic)	260	26	
	17		Ferritic	160	3	
	18	Malleable cast iron	Pearlitic	250	25	
	19		Ferritic	130		
20		Pearlitic	230	21		
<b>N</b>	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		CuZn, CuSnZn (Brass)	90		
	28	(Bronze / Brass)	CuSn, lead-free copper and electrolytic copper	100		
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic			◎
	30		Rubber, Wood, etc.			
<b>S</b>	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		
<b>H</b>	38	Hardened steel	Hardened	550	55	
	39		Hardened	630	60	
	40	Chilled Cast Iron	Cast	400	42	
	41	Hardened Cast Iron	Hardened	550	55	



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