



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -HIGH FEED

DREAM DRILLS - HIGH FEED

- 1.5 to 2 Times Faster Feeding Speed than 2-Flute Drill
For Carbon Steels, Alloy Steels(up to HRc35) and Cast Iron
- 1,5 bis 2 mal höhere Vorschubgeschwindigkeit als Bohrer mit 2 Schneiden,
für Kohlenstoffstähle, legierte Stähle (bis HRc35) und Grauguss

SELECTION GUIDE



SERIES

DGR493

DGR495

DRILLING DEPTH

3XD

5XD

LENGTH

SHORT

LONG

SIZE MIN

D5.0

D5.0

SIZE MAX

D20.0

D20.0

PAGE

A101

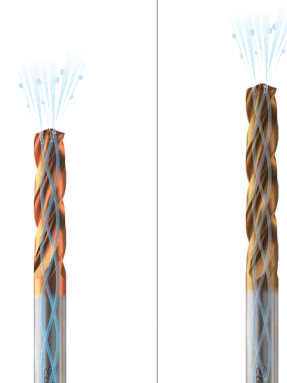
A103

SURFACE TREATMENT

H-Coating

SOLID CARBIDE DREAM DRILLS HIGH FEED

1.5 to 2 Times Faster Feeding Speed than 2-Flute Drill
for Carbon Steels, Alloy Steels(up to HRC35) and Cast Iron



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A105

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		Cutting Alloys, PB>1%		110				
	27	Copper and Copper Alloys (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		Ni or Co Based	Annealed	250	25			
	34			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		



CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

SHORT

● **DREAM DRILLS HIGH FEED mit KÜHLKANAL**

KURZ

● **Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série courte**

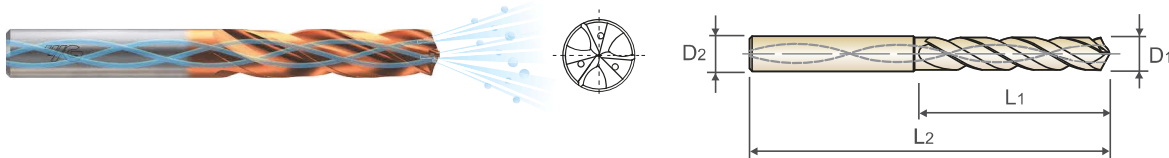
COURTE

● **PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)**

CORTA

- ▶ Drilling for Carbon Steels, Alloy Steels (-HRc35) and Cast Iron
- ▶ Higher productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Self centering and chip breaking by R-thinning and coolant holes

- ▶ Bohren von Kohlenstoff-Stählen, legierten Stählen (-HRc35) und Gusseisen
- ▶ Höhere Produktivität durch den 1,5 bis 2-fach höheren Vorschub gegenüber herkömmlichen zweischneidigen Bohrern
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

H Coating

p.A105

3 x D

Recommended ToolHolder

Plain Shank

HYDRAULIC CHUCK

SHRINK FIT HOLDER

ER COLLET CHUCK

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				L1	L2
H-Coating	D1	D2	L1	L2	
DGR493098	9.8	10	47	89	
DGR493099	9.9	10	47	89	
DGR493100	10.0	10	47	89	
DGR493101	10.1	12	55	102	
DGR493102	10.2	12	55	102	
DGR493103	10.3	12	55	102	
DGR493104	10.4	12	55	102	
DGR493105	10.5	12	55	102	
DGR493106	10.6	12	55	102	
DGR493107	10.7	12	55	102	
DGR493108	10.8	12	55	102	
DGR493109	10.9	12	55	102	
DGR493110	11.0	12	55	102	
DGR493111	11.1	12	55	102	
DGR493112	11.2	12	55	102	
DGR493113	11.3	12	55	102	
DGR493114	11.4	12	55	102	
DGR493115	11.5	12	55	102	
DGR493116	11.6	12	55	102	
DGR493117	11.7	12	55	102	

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				L1	L2
H-Coating	D1	D2	L1	L2	
DGR493118	11.8	12	55	102	
DGR493119	11.9	12	55	102	
DGR493120	12.0	12	55	102	
DGR493125	12.5	14	60	107	
DGR493130	13.0	14	60	107	
DGR493135	13.5	14	60	107	
DGR493140	14.0	14	60	107	
DGR493145	14.5	16	65	115	
DGR493150	15.0	16	65	115	
DGR493155	15.5	16	65	115	
DGR493160	16.0	16	65	115	
DGR493165	16.5	18	73	123	
DGR493170	17.0	18	73	123	
DGR493175	17.5	18	73	123	
DGR493180	18.0	18	73	123	
DGR493185	18.5	20	79	131	
DGR493190	19.0	20	79	131	
DGR493195	19.5	20	79	131	
DGR493200	20.0	20	79	131	

Unit : mm

▶ Other shank types are available on your request.

ISO	P										M				K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular 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	30	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																					

◎ : Excellent ○ : Good



CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

LONG

● DREAM DRILLS HIGH FEED mit KÜHLKANAL

KURZ

● Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série longue

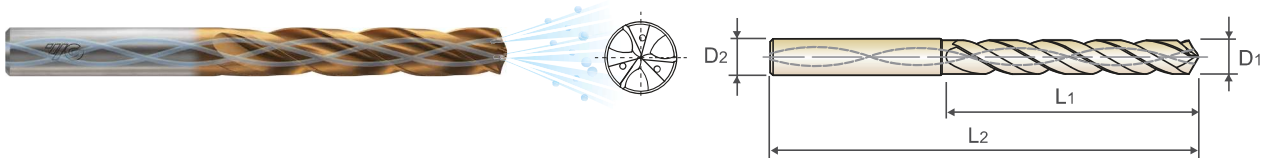
LONGUE

● PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)

LUNGA

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H Coating

p.A105

5 x D



- Plain Shank
- HYDRAULIC CHUCK
- SHRINK FIT HOLDER
- ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2
DGR495098	9.8	10	61	103
DGR495099	9.9	10	61	103
DGR495100	10.0	10	61	103
DGR495101	10.1	12	71	118
DGR495102	10.2	12	71	118
DGR495103	10.3	12	71	118
DGR495104	10.4	12	71	118
DGR495105	10.5	12	71	118
DGR495106	10.6	12	71	118
DGR495107	10.7	12	71	118
DGR495108	10.8	12	71	118
DGR495109	10.9	12	71	118
DGR495110	11.0	12	71	118
DGR495111	11.1	12	71	118
DGR495112	11.2	12	71	118
DGR495113	11.3	12	71	118
DGR495114	11.4	12	71	118
DGR495115	11.5	12	71	118
DGR495116	11.6	12	71	118
DGR495117	11.7	12	71	118

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2
DGR495118	11.8	12	71	118
DGR495119	11.9	12	71	118
DGR495120	12.0	12	71	118
DGR495125	12.5	14	77	124
DGR495130	13.0	14	77	124
DGR495135	13.5	14	77	124
DGR495140	14.0	14	77	124
DGR495145	14.5	16	83	133
DGR495150	15.0	16	83	133
DGR495155	15.5	16	83	133
DGR495160	16.0	16	83	133
DGR495165	16.5	18	93	143
DGR495170	17.0	18	93	143
DGR495175	17.5	18	93	143
DGR495180	18.0	18	93	143
DGR495185	18.5	20	101	153
DGR495190	19.0	20	101	153
DGR495195	19.5	20	101	153
DGR495200	20.0	20	101	153

▶ Other shank types are available on your request.

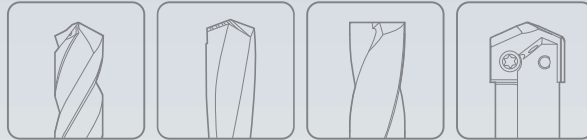
◎ : Excellent ○ : Good

ISO Material Description	P										M				K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular 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	30	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 Material Description	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																					



Global Cutting Tool Leader **YG-1**



HOLEMAKING