



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -INOX

DREAM DRILLS - INOX

- For Tough Materials like Stainless Steels
- Für schwierig zerspanbare Materialien wie Edelstahl

SELECTION GUIDE



SERIES

DH451	DH452	DH453
3XD	5XD	8XD
SHORT	LONG	EXTRA LONG
D3.0	D1.0	D3.0
D20.0	D20.0	D14.0
A119	A122	A125

DRILLING DEPTH

LENGTH

SIZE MIN

SIZE MAX

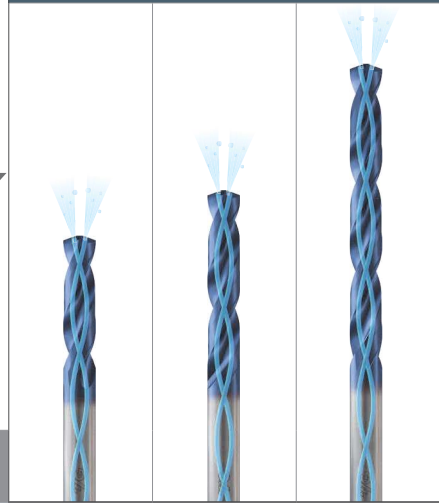
PAGE

SURFACE TREATMENT

TiAIN

SOLID CARBIDE DREAM DRILLS INOX

For Tough Materials like Stainless Steels



Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A127

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		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				



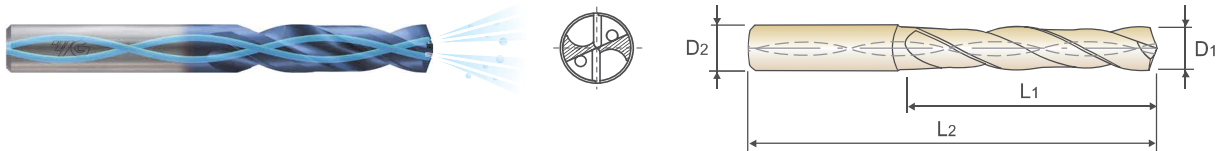
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

- **VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL**
- **Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série courte**
- **PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione)**

**KURZ
COURTE
CORTA**

- ▶ Special flute shape and geometry suitable for machining stainless steel
- ▶ Excellent chip evacuation from better surface treatment
- ▶ Point R-thinning achieves superior centering and chip curling
- ▶ TiAlN coating for better surface finishes and longer tool life
- ▶ Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- ▶ Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- ▶ TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAlN



p.A127

3 x D



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

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH451078	7.8	8	41	79
DH451079	7.9	8	41	79
DH451080	8.0	8	41	79
DH451081	8.1	10	47	89
DH451082	8.2	10	47	89
DH451083	8.3	10	47	89
DH451084	8.4	10	47	89
DH451085	8.5	10	47	89
DH451086	8.6	10	47	89
DH451087	8.7	10	47	89
DH451088	8.8	10	47	89
DH451089	8.9	10	47	89
DH451090	9.0	10	47	89
DH451091	9.1	10	47	89
DH451092	9.2	10	47	89
DH451093	9.3	10	47	89
DH451094	9.4	10	47	89
DH451095	9.5	10	47	89
DH451096	9.6	10	47	89
DH451097	9.7	10	47	89
DH451098	9.8	10	47	89
DH451099	9.9	10	47	89
DH451100	10.0	10	47	89
DH451101	10.1	12	55	102

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
DH451102	10.2	12	55	102
DH451103	10.3	12	55	102
DH451104	10.4	12	55	102
DH451105	10.5	12	55	102
DH451106	10.6	12	55	102
DH451107	10.7	12	55	102
DH451108	10.8	12	55	102
DH451109	10.9	12	55	102
DH451110	11.0	12	55	102
DH451111	11.1	12	55	102
DH451112	11.2	12	55	102
DH451113	11.3	12	55	102
DH451114	11.4	12	55	102
DH451115	11.5	12	55	102
DH451116	11.6	12	55	102
DH451117	11.7	12	55	102
DH451118	11.8	12	55	102
DH451119	11.9	12	55	102
DH451120	12.0	12	55	102
DH451125	12.5	14	60	107
DH451130	13.0	14	60	107
DH451135	13.5	14	60	107
DH451140	14.0	14	60	107
DH451145	14.5	16	65	115

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : 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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	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	40	41
HRc	15	30	25	38	34						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	◎	◎	○	○	○												○				

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LONG

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LONGUE
LUNGA

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TiAlN

p.A127

5 x D



- Plain Shank
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- ER COLLET CHUCK

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				D1	D2
TiAlN					
DH452010	1.0	3	8	55	
DH452011	1.1	3	12	55	
DH452012	1.2	3	12	55	
DH452013	1.3	3	12	55	
DH452014	1.4	3	12	55	
DH452015	1.5	3	16	55	
DH452016	1.6	3	16	55	
DH452017	1.7	3	16	55	
DH452018	1.8	3	16	55	
DH452019	1.9	3	16	55	
DH452020	2.0	4	21	57	
DH452021	2.1	4	21	57	
DH452022	2.2	4	21	57	
DH452023	2.3	4	21	57	
DH452024	2.4	4	21	57	
DH452025	2.5	4	21	57	
DH452026	2.6	4	21	57	
DH452027	2.7	4	21	57	
DH452028	2.8	4	21	57	
DH452029	2.9	4	21	57	
DH452030	3.0	6	28	66	
DH452031	3.1	6	28	66	
DH452032	3.2	6	28	66	
DH452033	3.3	6	28	66	

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				L1	L2
TiAlN					
DH452034	3.4	6	28	66	
DH452035	3.5	6	28	66	
DH452036	3.6	6	28	66	
DH452037	3.7	6	28	66	
DH452038	3.8	6	36	74	
DH452039	3.9	6	36	74	
DH452040	4.0	6	36	74	
DH452041	4.1	6	36	74	
DH452042	4.2	6	36	74	
DH452043	4.3	6	36	74	
DH452044	4.4	6	36	74	
DH452045	4.5	6	36	74	
DH452046	4.6	6	36	74	
DH452047	4.7	6	36	74	
DH452048	4.8	6	44	82	
DH452049	4.9	6	44	82	
DH452050	5.0	6	44	82	
DH452051	5.1	6	44	82	
DH452052	5.2	6	44	82	
DH452053	5.3	6	44	82	
DH452054	5.4	6	44	82	
DH452055	5.5	6	44	82	
DH452056	5.6	6	44	82	
DH452057	5.7	6	44	82	

▶ 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	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

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p.A127

5 x D



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EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				D1	L2
TiAlN	D1	D2	L1	L2	
DH452106	10.6	12	71	118	
DH452107	10.7	12	71	118	
DH452108	10.8	12	71	118	
DH452109	10.9	12	71	118	
DH452110	11.0	12	71	118	
DH452111	11.1	12	71	118	
DH452112	11.2	12	71	118	
DH452113	11.3	12	71	118	
DH452114	11.4	12	71	118	
DH452115	11.5	12	71	118	
DH452116	11.6	12	71	118	
DH452117	11.7	12	71	118	
DH452118	11.8	12	71	118	
DH452119	11.9	12	71	118	
DH452120	12.0	12	71	118	
DH452125	12.5	14	77	124	
DH452130	13.0	14	77	124	
DH452135	13.5	14	77	124	
DH452140	14.0	14	77	124	
DH452145	14.5	16	83	133	
DH452150	15.0	16	83	133	
DH452155	15.5	16	83	133	
DH452160	16.0	16	83	133	
DH452165	16.5	18	93	143	

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	
				L1	L2
TiAlN	D1	D2	L1	L2	
DH452170	17.0	18	93	143	
DH452175	17.5	18	93	143	
DH452180	18.0	18	93	143	
DH452185	18.5	20	101	153	
DH452190	19.0	20	101	153	
DH452195	19.5	20	101	153	
DH452200	20.0	20	101	153	

▶ 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	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	◎	◎	○	○	○												○				



CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

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

ÜBERLANG

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

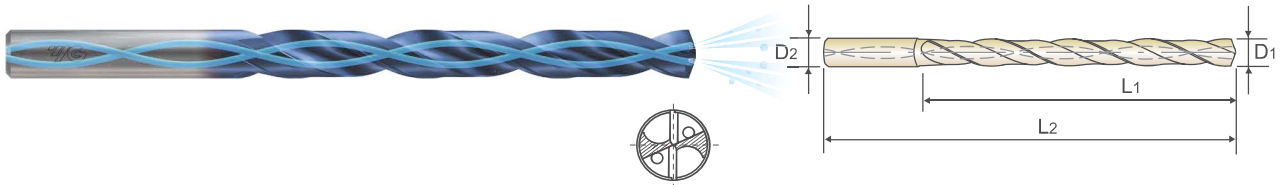
EXTRA-LONGUE

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

EXTRA LUNGA

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DIN 6537

CARBIDE

30°

h6

m7

140°

20 bar

TiAlN

p.A127

8 x D



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

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length		Overall Length
			L1	L2	
TiAlN	D1	D2	L1	L2	
DH453078	7.8	8	76	114	
DH453079	7.9	8	76	114	
DH453080	8.0	8	76	114	
DH453081	8.1	10	95	142	
DH453082	8.2	10	95	142	
DH453083	8.3	10	95	142	
DH453084	8.4	10	95	142	
DH453085	8.5	10	95	142	
DH453086	8.6	10	95	142	
DH453087	8.7	10	95	142	
DH453088	8.8	10	95	142	
DH453089	8.9	10	95	142	
DH453090	9.0	10	95	142	
DH453091	9.1	10	95	142	
DH453092	9.2	10	95	142	
DH453093	9.3	10	95	142	
DH453094	9.4	10	95	142	
DH453095	9.5	10	95	142	
DH453096	9.6	10	95	142	
DH453097	9.7	10	95	142	
DH453098	9.8	10	95	142	
DH453099	9.9	10	95	142	
DH453100	10.0	10	95	142	
DH453101	10.1	12	114	162	

EDP No.	Drill Diameter	Shank Diameter	Flute Length		Overall Length
			L1	L2	
TiAlN	D1	D2	L1	L2	
DH453102	10.2	12	114	162	
DH453103	10.3	12	114	162	
DH453104	10.4	12	114	162	
DH453105	10.5	12	114	162	
DH453106	10.6	12	114	162	
DH453107	10.7	12	114	162	
DH453108	10.8	12	114	162	
DH453109	10.9	12	114	162	
DH453110	11.0	12	114	162	
DH453111	11.1	12	114	162	
DH453112	11.2	12	114	162	
DH453113	11.3	12	114	162	
DH453114	11.4	12	114	162	
DH453115	11.5	12	114	162	
DH453116	11.6	12	114	162	
DH453117	11.7	12	114	162	
DH453118	11.8	12	114	162	
DH453119	11.9	12	114	162	
DH453120	12.0	12	114	162	
DH453125	12.5	14	133	178	
DH453130	13.0	14	133	178	
DH453135	13.5	14	133	178	
DH453140	14.0	14	133	178	

▶ 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	30	20	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	◎	◎	○	○	○												○				