



Leading Through Innovation



Global Cutting Tool Leader **YG-1**



HOLEMAKING



SOLID CARBIDE

DREAM DRILLS -ALU

DREAM DRILLS -ALU

- For Aluminum and Aluminum Alloys

- Für Aluminium und Aluminiumlegierungen

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

SHORT

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

KURZ
COURTE
CORTA

- ▶ 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 Bright p.A139 3 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter		Flute Length L1	Overall Length L2	EDP No.	Drill Diameter		Flute Length L1	Overall Length L2
	D1	D2				D1	D2		
D5432078	7.8	8	41	79	D5432102	10.2	12	55	102
D5432079	7.9	8	41	79	D5432103	10.3	12	55	102
D5432080	8.0	8	41	79	D5432104	10.4	12	55	102
D5432081	8.1	10	47	89	D5432105	10.5	12	55	102
D5432082	8.2	10	47	89	D5432106	10.6	12	55	102
D5432083	8.3	10	47	89	D5432107	10.7	12	55	102
D5432084	8.4	10	47	89	D5432108	10.8	12	55	102
D5432085	8.5	10	47	89	D5432109	10.9	12	55	102
D5432086	8.6	10	47	89	D5432110	11.0	12	55	102
D5432087	8.7	10	47	89	D5432111	11.1	12	55	102
D5432088	8.8	10	47	89	D5432112	11.2	12	55	102
D5432089	8.9	10	47	89	D5432113	11.3	12	55	102
D5432090	9.0	10	47	89	D5432114	11.4	12	55	102
D5432091	9.1	10	47	89	D5432115	11.5	12	55	102
D5432092	9.2	10	47	89	D5432116	11.6	12	55	102
D5432093	9.3	10	47	89	D5432117	11.7	12	55	102
D5432094	9.4	10	47	89	D5432118	11.8	12	55	102
D5432095	9.5	10	47	89	D5432119	11.9	12	55	102
D5432096	9.6	10	47	89	D5432120	12.0	12	55	102
D5432097	9.7	10	47	89	D5432125	12.5	14	60	107
D5432098	9.8	10	47	89	D5432130	13.0	14	60	107
D5432099	9.9	10	47	89	D5432135	13.5	14	60	107
D5432100	10.0	10	47	89	D5432140	14.0	14	60	107
D5432101	10.1	12	55	102	D5432145	14.5	16	65	115

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

▶ NEXT PAGE

◎ : 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	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 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	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	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

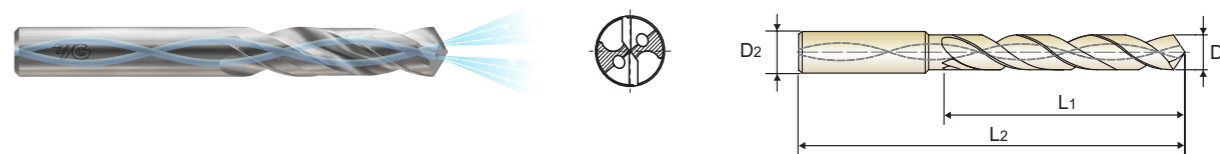
SHORT

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

KURZ
COURTE
CORTA

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- ▶ Wider and deeper flute gullets for maximum chip removal
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- ▶ Optimierte Ausspitzung für Aluminum & Aluminiumlegierungen zur Vermeidung von Verstopfungen durch das Aufschweißen der Späne
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- ▶ Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



DIN 6537 CARBIDE 30° h6 m7 118° 20 bar Bright p.A139 3 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter		Flute Length L1	Overall Length L2	EDP No.	Drill Diameter		Flute Length L1	Overall Length L2
	D1	D2				D1	D2		
D5432150	15.0	16	65	115	D5432190	19.0	20	79	131
D5432155	15.5	16	65	115	D5432195	19.5	20	79	131
D5432160	16.0	16	65	115	D5432200	20.0	20	79	131
D5432165	16.5	18	73	123					
D5432170	17.0	18	73	123					
D5432175	17.5	18	73	123					
D5432180	18.0	18	73	123					
D5432185	18.5	20	79	131					

- ▶ DLC coating is available on your request.
- ▶ 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	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 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	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG DREAM DRILLS - ALU

D5433 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

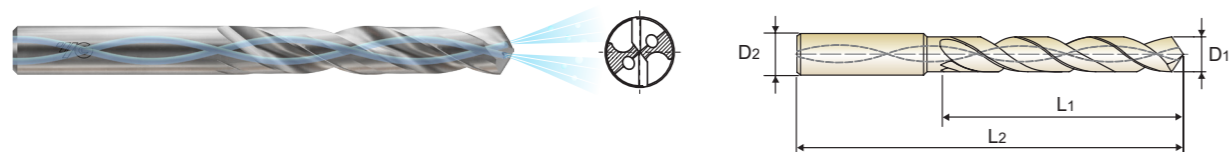
LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER - ALU mit KÜHLKANAL
- Forets DREAM DRILLS carbure pour ALU, avec arrosage central, série longue
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - ALU (CON FORI DI REFRIGERAZIONE)

LANG
LONGUE
LUNGA

- ▶ Optimized thinning for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
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DIN 6537 CARBIDE 30° h6 m7 118° 20 bar Bright p.A139 5 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter		Overall Length	
	D1	D2	L1	L2
D5433150	15.0	16	83	133
D5433155	15.5	16	83	133
D5433160	16.0	16	83	133
D5433165	16.5	18	93	143
D5433170	17.0	18	93	143
D5433175	17.5	18	93	143
D5433180	18.0	18	93	143
D5433185	18.5	20	101	153

EDP No.	Drill Diameter		Overall Length	
	D1	D2	L1	L2
D5433190	19.0	20	101	153
D5433195	19.5	20	101	153
D5433200	20.0	20	101	153

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

YG DREAM DRILLS - ALU

D5434 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

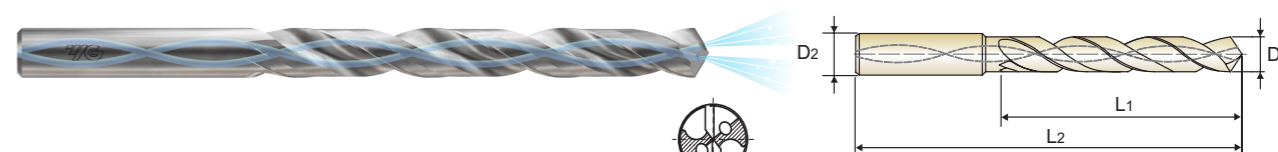
EXTRA LONG

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

ÜBERLANG
EXTRA-LONGUE
EXTRA LUNGA

- ▶ Optimized thinning for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
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DIN 6537 CARBIDE 30° h6 m7 118° 20 bar Bright p.A139 8 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter		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
D5434054	5.4	6	57	95

EDP No.	Drill Diameter		Overall Length	
	D1	D2	L1	L2
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
D5434078	7.8	8	76	114
D5434079	7.9	8	76	114

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▶ 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	30	32	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					
	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
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

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	30	32	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					
	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
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	◎	◎	◎	◎																		



D5434 SERIES



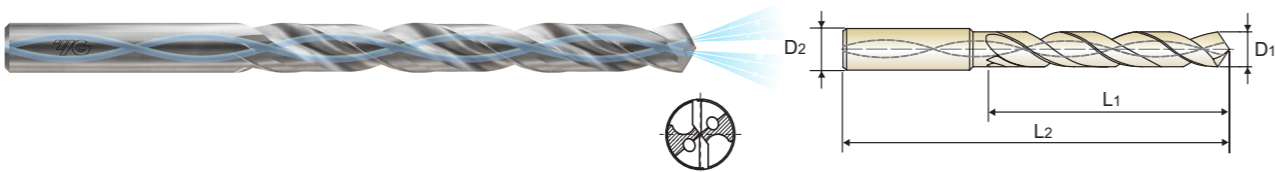
RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDPARAMETER

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES EXTRA LONG

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

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DIN 6537 CARBIDE 30° h6 m7 118° 20 bar Bright p.A139 8 x D

Plain Shank
HYDRAULIC CHUCK
SHRINK FIT HOLDER
ER COLLET CHUCK

EDP No.	Drill Diameter		Flute Length L1	Overall Length L2	EDP No.	Drill Diameter		Flute Length L1	Overall Length L2
	D1	D2				D1	D2		
D5434080	8.0	8	76	114	D5434105	10.5	12	114	162
D5434081	8.1	10	95	142	D5434106	10.6	12	114	162
D5434082	8.2	10	95	142	D5434107	10.7	12	114	162
D5434083	8.3	10	95	142	D5434108	10.8	12	114	162
D5434084	8.4	10	95	142	D5434109	10.9	12	114	162
D5434085	8.5	10	95	142	D5434110	11.0	12	114	162
D5434086	8.6	10	95	142	D5434111	11.1	12	114	162
D5434087	8.7	10	95	142	D5434112	11.2	12	114	162
D5434088	8.8	10	95	142	D5434113	11.3	12	114	162
D5434089	8.9	10	95	142	D5434114	11.4	12	114	162
D5434090	9.0	10	95	142	D5434115	11.5	12	114	162
D5434091	9.1	10	95	142	D5434116	11.6	12	114	162
D5434092	9.2	10	95	142	D5434117	11.7	12	114	162
D5434093	9.3	10	95	142	D5434118	11.8	12	114	162
D5434094	9.4	10	95	142	D5434119	11.9	12	114	162
D5434095	9.5	10	95	142	D5434120	12.0	12	114	162
D5434096	9.6	10	95	142	D5434125	12.5	14	133	178
D5434097	9.7	10	95	142	D5434130	13.0	14	133	178
D5434098	9.8	10	95	142	D5434135	13.5	14	133	178
D5434099	9.9	10	95	142	D5434140	14.0	14	133	178
D5434100	10.0	10	95	142					
D5434101	10.1	12	114	162					
D5434102	10.2	12	114	162					
D5434103	10.3	12	114	162					
D5434104	10.4	12	114	162					

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© : 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		
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HRc																				
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
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc																					
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
Recommended	⊙	⊙	⊙	⊙																	

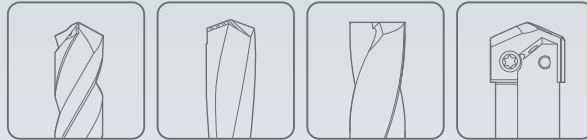
D5432, D5433, D5434 SERIES with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	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
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	Aluminum-cast, alloyed	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	Aluminum-cast, alloyed	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



Global Cutting Tool Leader **YG-1**



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