



# DREAM DRILLS for HIGH HARDENED STEELS

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

**CARBIDE, DREAM DRILLS for HIGH HARDENED STEELS (HRc50~HRc70), TiAlN COATED**  
**VOLLHARTMETALL DREAM BOHRER für HOCHGEHÄRTETE STÄHLE, TiAlN-BESCHICHTET**

### DH500 SERIES

| WORK MATERIAL  | P               |      | H                    |      |              |      |
|----------------|-----------------|------|----------------------|------|--------------|------|
|                | HARDENED STEELS |      | HIGH HARDENED STEELS |      |              |      |
| HARDNESS       | HRc 50~55       |      | HRc 55~60            |      | HRc 60~70    |      |
| DRILLING SPEED | 14 ~ 22 m/min   |      | 10 ~ 16 m/min        |      | 8 ~ 13 m/min |      |
| DIAMETER       | RPM             | FEED | RPM                  | FEED | RPM          | FEED |
| 3.0            | 1900            | 0.04 | 1330                 | 0.04 | 1250         | 0.04 |
| 4.0            | 1430            | 0.04 | 1000                 | 0.04 | 950          | 0.04 |
| 5.0            | 1150            | 0.04 | 800                  | 0.04 | 750          | 0.04 |
| 6.0            | 960             | 0.04 | 670                  | 0.04 | 630          | 0.04 |
| 8.0            | 720             | 0.04 | 500                  | 0.04 | 480          | 0.04 |
| 10.0           | 570             | 0.04 | 400                  | 0.04 | 380          | 0.04 |
| 12.0           | 480             | 0.04 | 330                  | 0.04 | 320          | 0.04 |
| 14.0           | 438             | 0.04 | 282                  | 0.04 | 272          | 0.04 |

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