



# 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.