

**HSS & HSS 8% COBALT DRILLS, DIN1897, DIN338, DIN340, DIN1869**  
**HSS & HSSCo8 SPIRALBOHRER, DIN 1897, DIN 338, DIN 340, DIN 1869**

I-ONE DRILLS

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

**STRAIGHT SHANK DRILLS**

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

**D1107, D2107, D1105, D1125, D2105, DL105, D2104, D1121 SERIES**

WORK MATERIAL	P											M		
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		TOOL STEELS		STAINLESS STEELS	
HARDNESS			~ HRC23		~ HRC23 ~ 28		HRC23 ~ 34		HRC34 ~ 38				HRC23	
STRENGTH	~ 570 N/mm <sup>2</sup>		~ 830 N/mm <sup>2</sup>		830 ~ 950 N/mm <sup>2</sup>		830 ~ 1110 N/mm <sup>2</sup>		1110 ~ 1260 N/mm <sup>2</sup>		~ 270 N/mm <sup>2</sup>		830 N/mm <sup>2</sup>	
DRILLING SPEED	22 ~ 27 m/min		15 ~ 20 m/min		10 ~ 15 m/min		15 ~ 20 m/min		8 ~ 12 m/min		20 ~ 25 m/min		15 ~ 20 m/min	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.5	3380	0.025	2550	0.025	1900	0.015	2380	0.020	1400	0.015	3180	0.042	2550	0.025
3.0	2700	0.050	2000	0.050	1500	0.025	1880	0.050	1100	0.020	2500	0.050	2000	0.050
5.0	1700	0.063	1280	0.063	960	0.038	1190	0.063	700	0.025	1590	0.063	1280	0.063
8.0	1050	0.130	780	0.130	590	0.076	730	0.130	430	0.038	970	0.130	780	0.130
11.0	750	0.150	560	0.150	425	0.076	520	0.180	310	0.050	700	0.180	560	0.150
19.0	440	0.230	330	0.230	255	0.130	300	0.230	180	0.050	440	0.230	330	0.230
31.0	260	0.280	195	0.280	145	0.180	180	0.280	107	0.076	240	0.300	195	0.280

WORK MATERIAL	K		N						S			
	CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTICS		TITANIUM ALLOYS	
HARDNESS	~ HRC21											
STRENGTH	~ 800 N/mm <sup>2</sup>										410 N/mm <sup>2</sup>	
DRILLING SPEED	15 ~ 20 m/min		45 ~ 50 m/min		55 ~ 65 m/min		40 ~ 50 m/min		20 ~ 25 m/min		8 ~ 12 m/min	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.5	2250	0.025	6400	0.038	8600	0.038	6400	0.038	3380	0.025	1400	0.020
3.0	2000	0.050	5000	0.063	6800	0.063	5000	0.063	2700	0.050	1100	0.025
5.0	1280	0.063	3200	0.076	4300	0.076	3200	0.076	1700	0.063	700	0.038
8.0	780	0.130	2000	0.180	2600	0.180	2000	0.180	1050	0.130	430	0.076
11.0	560	0.150	1400	0.200	1900	0.200	1400	0.200	750	0.150	430	0.076
19.0	330	0.230	820	0.300	1100	0.300	820	0.300	440	0.230	180	0.130
31.0	195	0.280	490	0.380	660	0.380	490	0.380	260	0.280	107	0.180

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