

SERIES	D5432	D5433	D5434
DRILLING DEPTH	3XD	5XD	8XD
LENGTH	SHORT	LONG	EXTRA LONG
SIZE MIN	D3.0	D3.0	D3.0
SIZE MAX	D20.0	D20.0	D14.0
PAGE	133	136	139

SURFACE TREATMENT

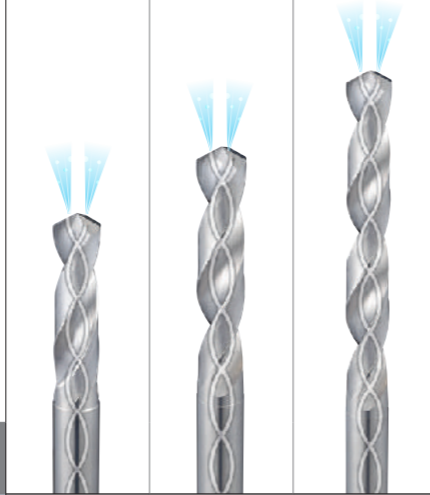
Bright

SOLID CARBIDE DREAM DRILLS ALU

For Aluminum and Aluminum Alloys

◎ : Excellent ○ : Good

Recommended cutting conditions : P.141



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	Malleable cast iron	Ferritic	130					
	20		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		Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110				
	27	Non Metallic Materials	CuZn, CuSnZn (Brass)	90					
	28		CuSn, lead-free copper and electrolytic copper	100					
	29		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		Ni or Co Based 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 - ALU with COOLANT HOLES

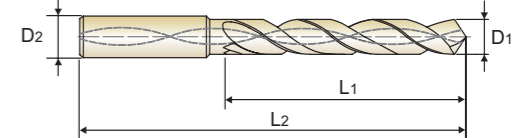
SHORT

- 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 Aluminium & 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 P.141

3 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2		D1	D2	L1	L2
D5432030	3.0	6	20	62	D5432052	5.2	6	28	66
D5432031	3.1	6	20	62	D5432053	5.3	6	28	66
D5432032	3.2	6	20	62	D5432054	5.4	6	28	66
D5432033	3.3	6	20	62	D5432055	5.5	6	28	66
D5432034	3.4	6	20	62	D5432056	5.6	6	28	66
D5432035	3.5	6	20	62	D5432057	5.7	6	28	66
D5432036	3.6	6	20	62	D5432058	5.8	6	28	66
D5432037	3.7	6	20	62	D5432059	5.9	6	28	66
D5432038	3.8	6	24	66	D5432060	6.0	6	28	66
D5432039	3.9	6	24	66	D5432061	6.1	8	34	79
D5432040	4.0	6	24	66	D5432062	6.2	8	34	79
D5432041	4.1	6	24	66	D5432063	6.3	8	34	79
D5432042	4.2	6	24	66	D5432064	6.4	8	34	79
D5432043	4.3	6	24	66	D5432065	6.5	8	34	79
D5432044	4.4	6	24	66	D5432066	6.6	8	34	79
D5432045	4.5	6	24	66	D5432067	6.7	8	34	79
D5432046	4.6	6	24	66	D5432068	6.8	8	34	79
D5432047	4.7	6	24	66	D5432069	6.9	8	34	79
D5432048	4.8	6	28	66	D5432070	7.0	8	34	79
D5432049	4.9	6	28	66	D5432071	7.1	8	41	79
D5432050	5.0	6	28	66	D5432072	7.2	8	41	79
D5432051	5.1	6	28	66	D5432073	7.3	8	41	79

- DLC coating is available on your request.
- 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	
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	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	13	25	28	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	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	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	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

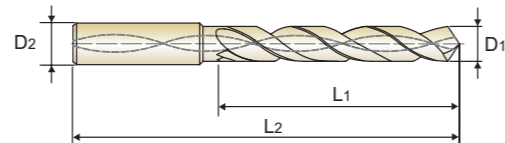
SHORT

- 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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- Breitere und tiefere Spannuten für maximale Spanabfuhr
- Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



3 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5432074	7.4	8	41	79
D5432075	7.5	8	41	79
D5432076	7.6	8	41	79
D5432077	7.7	8	41	79
D5432078	7.8	8	41	79
D5432079	7.9	8	41	79
D5432080	8.0	8	41	79
D5432081	8.1	10	47	89
D5432082	8.2	10	47	89
D5432083	8.3	10	47	89
D5432084	8.4	10	47	89
D5432085	8.5	10	47	89
D5432086	8.6	10	47	89
D5432087	8.7	10	47	89
D5432088	8.8	10	47	89
D5432089	8.9	10	47	89
D5432090	9.0	10	47	89
D5432091	9.1	10	47	89
D5432092	9.2	10	47	89
D5432093	9.3	10	47	89
D5432094	9.4	10	47	89
D5432095	9.5	10	47	89

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

▶ NEXT PAGE

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																				
HB	125	190	250	270	300	180	290	320	350	200	325	200	240	180	180	260	160	250	130	230
Recommended																				

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

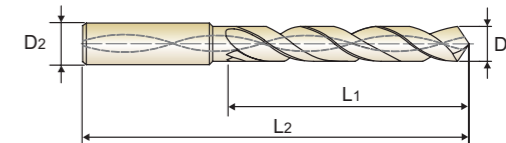
SHORT

- 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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- Breitere und tiefere Spannuten für maximale Spanabfuhr
- Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



3 x D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5432118	11.8	12	55	102
D5432119	11.9	12	55	102
D5432120	12.0	12	55	102
D5432125	12.5	14	60	107
D5432130	13.0	14	60	107
D5432135	13.5	14	60	107
D5432140	14.0	14	60	107
D5432145	14.5	16	65	115
D5432150	15.0	16	65	115
D5432155	15.5	16	65	115

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

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																				
HB	125	190	250	270	300	180	290	320	350	200	325	200	240	180	180	260	160	250	130	230
Recommended																				

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
- ▶ Wider and deeper flute gullets for maximum chip removal
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- ▶ Breitere und tiefere Spannuten für maximale Spanabfuhr
- ▶ Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



5 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5433030	3.0	6	28	66
D5433031	3.1	6	28	66
D5433032	3.2	6	28	66
D5433033	3.3	6	28	66
D5433034	3.4	6	28	66
D5433035	3.5	6	28	66
D5433036	3.6	6	28	66
D5433037	3.7	6	28	66
D5433038	3.8	6	36	74
D5433039	3.9	6	36	74
D5433040	4.0	6	36	74
D5433041	4.1	6	36	74
D5433042	4.2	6	36	74
D5433043	4.3	6	36	74
D5433044	4.4	6	36	74
D5433045	4.5	6	36	74
D5433046	4.6	6	36	74
D5433047	4.7	6	36	74
D5433048	4.8	6	44	82
D5433049	4.9	6	44	82
D5433050	5.0	6	44	82
D5433051	5.1	6	44	82

- ▶ 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	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																				

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

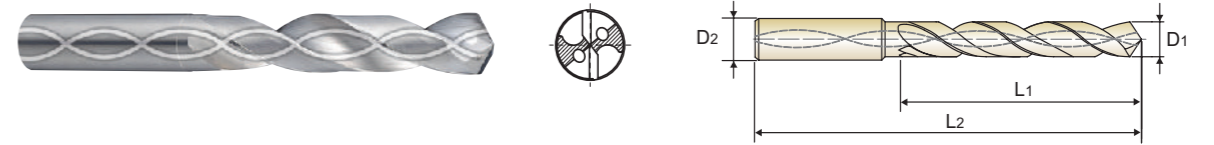
LONG

- 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
- ▶ 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



5 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5433074	7.4	8	53	91
D5433075	7.5	8	53	91
D5433076	7.6	8	53	91
D5433077	7.7	8	53	91
D5433078	7.8	8	53	91
D5433079	7.9	8	53	91
D5433080	8.0	8	53	91
D5433081	8.1	10	61	103
D5433082	8.2	10	61	103
D5433083	8.3	10	61	103
D5433084	8.4	10	61	103
D5433085	8.5	10	61	103
D5433086	8.6	10	61	103
D5433087	8.7	10	61	103
D5433088	8.8	10	61	103
D5433089	8.9	10	61	103
D5433090	9.0	10	61	103
D5433091	9.1	10	61	103
D5433092	9.2	10	61	103
D5433093	9.3	10	61	103
D5433094	9.4	10	61	103
D5433095	9.5	10	61	103

- ▶ 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	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																				

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

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- Breitere und tiefere Spannuten für maximale Spanabfuhr
- Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



5 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5433118	11.8	12	71	118
D5433119	11.9	12	71	118
D5433120	12.0	12	71	118
D5433125	12.5	14	77	124
D5433130	13.0	14	77	124
D5433135	13.5	14	77	124
D5433140	14.0	14	77	124
D5433145	14.5	16	83	133
D5433150	15.0	16	83	133
D5433155	15.5	16	83	133

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
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
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.

◎ : 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	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 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											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 - 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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- Spezielle Geometrie und glatte Beschichtung reduzieren Aufbauschneidenbildung und verbessern die Oberflächen



8 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	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

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
D5434054	5.4	6	57	95
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

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

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◎ : 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	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 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											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	◎	◎	◎	◎																	

