



Dream Stub Drills
Ultra High Performance



TiALN Coated Carbide Stub Drills

TIALN COATED CARBIDE
'ULTRA HIGH PERFORMANCE' STUB DRILLS
DH404 SERIES

Dia	Overall Length	Flute Length	2007 £
3.0	46	16	6.95
3.1	49	18	6.95
3.2			6.95
3.3			6.95
3.4			6.95
3.5	52	20	6.95
3.6			7.95
3.7			7.95
3.8			7.95
3.9	55	22	7.95
4.0			7.95
4.1			8.35
4.2			8.35
4.3	58	24	8.35
4.4			8.35
4.5			8.35
4.6			8.35
4.7	62	26	8.95
4.8			8.95
4.9			8.95
5.0			8.95
5.1	66	28	8.95
5.2			10.95
5.3			10.95
5.4			10.95
5.5	70	31	10.95
5.6			11.55
5.7			11.55
5.8			11.55
5.9	74	34	11.55
6.0			12.75
6.1			12.75
6.2			12.75
6.3	77	37	12.75
6.4			15.95
6.5			15.95
6.6			15.95
6.7	81	40	15.95
6.8			18.50
6.9			18.50
7.0			18.50
7.1	85	43	18.50
7.2			21.15
7.3			21.15
7.4			21.15
7.5	89	46	21.15
7.6			23.80
7.7			23.80
7.8			23.80
7.9	93	49	23.80
8.0			26.45
8.1			26.45
8.2			26.45
8.3	97	52	26.45
8.4			29.10
8.5			29.10
8.6			29.10
8.7	101	55	29.10
8.8			31.75
8.9			31.75
9.0			31.75
9.1	105	58	31.75
9.2			34.40
9.3			34.40
9.4			34.40
9.5	109	61	34.40
9.6			37.05
9.7			37.05
9.8			37.05
9.9	113	64	37.05
10.0			39.70
10.1			39.70
10.2			39.70
10.3	117	67	39.70
10.4			42.35
10.5			42.35
10.6			42.35
10.7	121	70	42.35
10.8			45.00
10.9			45.00
11.0			45.00
11.1	125	73	45.00
11.2			47.65
11.3			47.65
11.4			47.65
11.5	129	76	47.65
11.6			50.30
11.7			50.30
11.8			50.30
11.9	133	79	50.30
12.0			52.95
12.1			52.95
12.2			52.95
12.3	137	82	52.95
12.4			55.60
12.5			55.60
12.6			55.60
12.7	141	85	55.60
12.8			58.25
12.9			58.25
13.0			58.25
13.1	145	88	58.25
13.2			60.90
13.3			60.90
13.4			60.90
13.5	149	91	60.90
13.6			63.55
13.7			63.55
13.8			63.55
13.9	153	94	63.55
14.0			66.20
14.1			66.20
14.2			66.20
14.3	157	97	66.20
14.4			68.85
14.5			68.85
14.6			68.85
14.7	161	100	68.85
14.8			71.50
14.9			71.50
15.0			71.50
15.1	165	103	71.50
15.2			74.15
15.3			74.15
15.4			74.15
15.5	169	106	74.15
15.6			76.80
15.7			76.80
15.8			76.80
15.9	173	109	76.80
16.0			79.45
16.1			79.45
16.2			79.45
16.3	177	112	79.45
16.4			82.10
16.5			82.10
16.6			82.10
16.7	181	115	82.10
16.8			84.75
16.9			84.75
17.0			84.75
17.1	185	118	84.75
17.2			87.40
17.3			87.40
17.4			87.40
17.5	189	121	87.40
17.6			90.05
17.7			90.05
17.8			90.05
17.9	193	124	90.05
18.0			92.70
18.1			92.70
18.2			92.70
18.3	197	127	92.70
18.4			95.35
18.5			95.35
18.6			95.35
18.7	201	130	95.35
18.8			98.00
18.9			98.00
19.0			98.00
19.1	205	133	98.00
19.2			100.65
19.3			100.65
19.4			100.65
19.5	209	136	100.65
19.6			103.30
19.7			103.30
19.8			103.30
19.9	213	139	103.30
20.0			105.95
20.1			105.95
20.2			105.95

Ordering code DH404

Ultra High Performance Machining

3xD



Dia	Overall Length	Flute Length	2007 £
7.6	79	37	19.50
7.7			19.50
7.8			19.50
7.9			19.50
8.0	84	40	19.50
8.1			22.00
8.2			22.00
8.3			22.00
8.4	89	43	22.00
8.5			24.75
8.6			24.75
8.7			24.75
8.8	95	47	24.75
8.9			24.75
9.0			24.75
9.1			24.75
9.2	102	51	26.00
9.3			26.00
9.4			26.00
9.5			26.00
9.6	107	54	26.00
9.7			26.00
9.8			26.00
9.9			26.00
10.0	111	56	26.00
10.1			26.00
10.2			26.00
10.3			26.00
10.4	115	58	26.00
10.5			26.00
10.6			26.00
10.7			26.00
10.8	119	60	26.00
10.9			26.00
11.0			26.00
11.1			26.00
11.2	123	62	26.00
11.3			26.00
11.4			26.00
11.5			26.00
11.6	127	64	26.00
11.7			26.00
11.8			26.00
11.9			26.00
12.0	131	66	26.00
12.1			26.00
12.2			26.00
12.3			26.00
12.4	135	68	26.00
12.5			26.00
12.6			26.00
12.7			26.00
12.8	139	70	26.00
12.9			26.00
13.0			26.00
13.1			26.00
13.2	143	72	26.00
13.3			26.00
13.4			26.00
13.5			26.00
13.6	147	74	26.00
13.7			26.00
13.8			26.00
13.9			26.00
14.0	151	76	26.00
14.1			26.00
14.2			26.00
14.3			26.00
14.4	155	78	26.00
14.5			26.00
14.6			26.00
14.7			26.00
14.8	159	80	26.00
14.9			26.00
15.0			26.00
15.1			26.00
15.2	163	82	26.00
15.3			26.00
15.4			26.00
15.5			26.00
15.6	167	84	26.00
15.7			26.00
15.8			26.00
15.9			26.00
16.0	171	86	26.00
16.1			26.00
16.2			26.00
16.3			26.00
16.4	175	88	26.00
16.5			26.00
16.6			26.00
16.7			26.00
16.8	179	90	26.00
16.9			26.00
17.0			26.00
17.1			26.00
17.2	183	92	26.00
17.3			26.00
17.4			26.00
17.5			26.00
17.6	187	94	26.00
17.7			26.00
17.8			26.00
17.9			26.00
18.0	191	96	26.00
18.1			26.00
18.2			26.00
18.3			26.00
18.4	195	98	26.00
18.5			26.00
18.6			26.00
18.7			26.00
18.8	199	100	26.00
18.9			26.00
19.0			26.00
19.1			26.00
19.2	203	102	26.00
19.3			26.00
19.4			26.00
19.5			26.00
19.6	207	104	26.00
19.7			26.00
19.8			26.00
19.9			26.00
20.0	211	106	26.00
20.1			26.00
20.2			26.00
20.3			26.00

For ultra high performance machining



- All steels
- Cast iron
- Non-ferrous
- Stainless
- Light metals



EXTREME
TOOL LIFE

DRILLS

DRILLS Dream Drills Ultra High Performance



Dream Stub Drills

Ultra High Performance



TiALN Coated Carbide Stub Drills - Through Coolant

TiALN COATED CARBIDE
'ULTRA HIGH PERFORMANCE' STUB DRILLS
DH406 SERIES - THROUGH COOLANT

3xD



Dia	Shank	Overall Length	Flute Length	2007 £		
3.0	6.0	62	20	19.95		
3.1				19.95		
3.2				19.95		
3.3				19.95		
3.4				19.95		
3.5				19.95		
3.6				19.95		
3.7				19.95		
3.8				19.95		
3.9				19.95		
4.0		19.95				
4.1		19.95				
4.2		24	24	19.95		
4.3				19.95		
4.4				19.95		
4.5				19.95		
4.6				19.95		
4.7				19.95		
4.8				66	28	19.95
4.9						19.95
5.0	19.95					
5.1	19.95					
5.2	19.95					
5.3	19.95					
5.4	19.95					
5.5	19.95					
5.6	19.95					
5.7	19.95					
5.8	19.95					
5.9	19.95					
6.0	19.95					
6.1	8.0	79	25.00			
6.2			25.00			
6.3			25.00			
6.4			25.00			
6.5			25.00			
6.6			25.00			
6.7			25.00			
6.8			25.00			
6.9			25.00			
7.0			25.00			
7.1		25.00				
7.2		25.00				
7.3		25.00				
7.4		41	34	25.00		
7.5				25.00		
7.6				25.00		
7.7				25.00		
7.8				25.00		
	25.00					
	25.00					
	25.00					

Ordering code DH406

Dia	Shank	Overall Length	Flute Length	2007 £			
7.9	8.0	79	41	25.00			
8.0				25.00			
8.1				30.00			
8.2				30.00			
8.3				30.00			
8.4				30.00			
8.5				30.00			
8.6				30.00			
8.7				30.00			
8.8				30.00			
8.9	10.0	89	47	30.00			
9.0				30.00			
9.1				30.00			
9.2				30.00			
9.3				30.00			
9.4				30.00			
9.5				30.00			
9.6				30.00			
9.7				30.00			
9.8				30.00			
9.9	12.0	102	55	30.00			
10.0				45.00			
10.2				45.00			
10.5				45.00			
11.0				45.00			
11.5				45.00			
12.0				45.00			
12.5				59.00			
13.0				59.00			
13.5				59.00			
14.0	14.0	107	60	59.00			
14.5				69.00			
15.0				69.00			
15.5				69.00			
16.0				69.00			
16.5				125.00			
17.0				18.0	123	73	125.00
17.5							125.00
18.0							125.00
18.5							145.00
19.0	145.00						
19.5	145.00						
20.0	145.00						
22.0	20.0	131	79				145.00
24.0							POA
25.0							POA
26.0				POA			
28.0				POA			
30.0				POA			
				POA			
				POA			
				POA			
				POA			

DRILLS

DRILLS Dream Drills Ultra High Performance

SELF CENTRING

REAMED FINISH

THROUGH COOLANT





Dream Jobber Drills
Ultra High Performance



TiAlN Coated Carbide Jobber Drills



5xD

TIALN COATED CARBIDE 'ULTRA HIGH PERFORMANCE' JOBBER DRILLS DH424 SERIES

Dia	Shank	Overall Length	Flute Length	2007 £
3.0	6.0	66	28	17.40
3.1				17.40
3.2				17.40
3.3				17.40
3.4				17.40
3.5				17.40
3.6				17.40
3.7				17.40
3.8				17.40
3.9				17.40
4.0		74	36	17.40
4.1				17.40
4.2				17.40
4.3				17.40
4.4				17.40
4.5				17.40
4.6				17.40
4.7				17.40
4.8				17.40
4.9				17.40
5.0	82	44	17.40	
5.1			17.40	
5.2			17.40	
5.3			17.40	
5.4			17.40	
5.5			17.40	
5.6			17.40	
5.7			17.40	
5.8			17.40	
5.9			17.40	
6.0	8.0	91	53	17.40
6.1				19.50
6.2				19.50
6.3				19.50
6.4				19.50
6.5				19.50
6.6				19.50
6.7				19.50
6.8				19.50
6.9				19.50
7.0				19.50
7.1				19.50
7.2	19.50			
7.3	19.50			
7.4	19.50			
7.5	19.50			
7.6	19.50			
7.7	19.50			
7.8	19.50			
7.9	19.50			
8.0	19.50			

Ordering code DH424

Dia	Shank	Overall Length	Flute Length	2007 £
8.1	10.0	103	61	22.85
8.2				22.85
8.3				22.85
8.4				22.85
8.5				22.85
8.6				22.85
8.7				22.85
8.8				22.85
8.9				22.85
9.0				12.0
9.1	22.85			
9.2	22.85			
9.3	22.85			
9.4	22.85			
9.5	22.85			
9.6	22.85			
9.7	22.85			
9.8	22.85			
9.9	22.85			
10.0	14.0	124	77	22.85
10.1				22.85
10.2				22.85
10.3				22.85
10.4				22.85
10.5				22.85
10.6				22.85
10.7				22.85
10.8				22.85
10.9				22.85
11.0	16.0	133	83	22.85
11.1				22.85
11.2				22.85
11.3				22.85
11.4				22.85
11.5				22.85
11.6				22.85
11.7				22.85
11.8				22.85
11.9				22.85
12.0	18.0	143	93	22.85
12.5				22.85
13.0				22.85
13.5				22.85
14.0				22.85
14.5				22.85
15.0				22.85
15.5				22.85
16.0				22.85
16.5				22.85
17.0	20.0	153	101	22.85
17.5				22.85
18.0				22.85
18.5				22.85
19.0				22.85
19.5				22.85
20.0				22.85



DRILLS Dream Drills Ultra High Performance



Dream Jobber Drills

Ultra High Performance



TiAlN Coated Carbide Jobber Drills

TiAlN COATED CARBIDE
'ULTRA HIGH PERFORMANCE' JOBBER DRILLS
DH408 SERIES - THROUGH COOLANT

Dia	Shank	Overall Length	Flute Length	2007 £
3.0	6.0	66	28	27.00
3.1				27.00
3.2				27.00
3.3				27.00
3.4				27.00
3.5				27.00
3.6				27.00
3.7				27.00
3.8		74	36	27.00
3.9				27.00
4.0				27.00
4.1				27.00
4.2				27.00
4.3				27.00
4.4				27.00
4.5				27.00
4.6	82	44	27.00	
4.7			27.00	
4.8			27.00	
4.9			27.00	
5.0			27.00	
5.1			27.00	
5.2			27.00	
5.3			27.00	
5.4	8.0	91	27.00	
5.5			27.00	
5.6			27.00	
5.7			27.00	
5.8			27.00	
5.9			27.00	
6.0			27.00	
6.1			29.50	
6.2	29.50			
6.3	29.50			
6.4	29.50			
6.5	29.50			
6.6	29.50			
6.7	29.50			
6.8	29.50			
6.9	29.50			
7.0	29.50			
7.1	29.50			
7.2	29.50			
7.3	29.50			
7.4	29.50			
7.5	29.50			
7.6	29.50			
7.7	29.50			
7.8	29.50			

Ordering code DH408

Ultra High Performance Machining



Dia	Shank	Overall Length	Flute Length	2007 £			
7.9	8.0	91	53	29.50			
8.0				29.50			
8.1				35.00			
8.2				35.00			
8.3				35.00			
8.4				35.00			
8.5				35.00			
8.6				35.00			
8.7				35.00			
8.8				35.00			
8.9	10.0	103	61	35.00			
9.0				35.00			
9.1				35.00			
9.2				35.00			
9.3				35.00			
9.4				35.00			
9.5				35.00			
9.6				35.00			
9.7				35.00			
9.8				35.00			
9.9	12.0	118	71	35.00			
10.0				35.00			
10.2				49.00			
10.5				49.00			
11.0				49.00			
11.5				49.00			
12.0				49.00			
12.5				66.00			
13.0				66.00			
13.5				66.00			
14.0	14.0	124	77	66.00			
14.5				87.00			
15.0				87.00			
15.5				87.00			
16.0				87.00			
16.5				129.00			
17.0				129.00			
17.5				129.00			
18.0				129.00			
18.5				149.00			
19.0	18.0	143	93	149.00			
19.5				149.00			
20.0				149.00			
22.0				149.00			
24.0				20.0	153	101	149.00
25.0							149.00
26.0							149.00
28.0							149.00
30.0							149.00
24.0							25.0
25.0	POA						
26.0	POA						
28.0	POA						
30.0	POA						
32.0	32.0	186	248	POA			
30.0				POA			

DRILLS

DRILLS Dream Drills Ultra High Performance

EXTREME TOOL LIFE

TiAlN COATED



5xD



Dream Long Drills
Ultra High Performance



TiALN Coated Carbide Stub Drills - Through Coolant

TIALN COATED CARBIDE
'ULTRA HIGH PERFORMANCE' STUB DRILLS
DH421 SERIES - THROUGH COOLANT



DRILLS

DRILLS Dream Drills Ultra High Performance

Dia	Shank	Overall Length	Flute Length	2007 £
3.0	6.0	72	34	49.00
3.1				49.00
3.2				49.00
3.3				49.00
3.4				49.00
3.5				49.00
3.6				49.00
3.7		49.00		
3.8		81	43	49.00
3.9				49.00
4.0				49.00
4.1				49.00
4.2				49.00
4.3				49.00
4.4	49.00			
4.5	95	57	49.00	
4.6			49.00	
4.7			49.00	
4.8			49.00	
4.9			49.00	
5.0			49.00	
5.1			49.00	
5.2	8.0	114	76	54.00
5.3				54.00
5.4				54.00
5.5				54.00
5.6				54.00
5.7				54.00
5.8				54.00
5.9		54.00		
6.0		54.00		
6.1		54.00		
6.2		54.00		
6.3		54.00		
6.4		54.00		
6.5		54.00		
6.6	54.00			
6.7	54.00			
6.8	54.00			
6.9	54.00			
7.0	54.00			
7.1	54.00			
7.2	54.00			
7.3	54.00			
7.4	54.00			

Ordering code DH421

Dia	Shank	Overall Length	Flute Length	2007 £
7.5	8.0	114	76	54.00
7.6				54.00
7.7				54.00
7.8				54.00
7.9				54.00
8.0				54.00
8.1				10.0
8.2	75.00			
8.3	75.00			
8.4	75.00			
8.5	75.00			
8.6	75.00			
8.7	75.00			
8.8	75.00			
8.9	75.00			
9.0	75.00			
9.1	75.00			
9.2	75.00			
9.3	75.00			
9.4	75.00			
9.5	75.00			
9.6	75.00			
9.7	75.00			
9.8	75.00			
9.9	75.00			
10.0	75.00			
10.1	12.0	162	114	99.00
10.2				99.00
10.3				99.00
10.4				99.00
10.5				99.00
10.6				99.00
10.7				99.00
10.8		99.00		
10.9		99.00		
11.0		99.00		
11.1		99.00		
11.2		99.00		
11.3		99.00		
11.4		99.00		
11.5	99.00			
11.6	99.00			
11.7	99.00			
11.8	99.00			
11.9	99.00			
12.0	99.00			

For ultra high performance machining

- All steels
- Cast iron
- Non-ferrous
- Stainless
- Light metals

DIN 8537 MG 120° MS

8xD MS M7 140°



Dream Drills

Recommended Cutting Conditions



Solid Carbide, TiAlN Coated Dream Drills, DH404/DH423/DH424 Series

Work Material	Non-Alloy Steels		Alloy Steels		Soft Grey Cast Iron		Hard Grey Cast Iron		Stainless Steels	
	Strength < 700 N/mm ²		Strength < 1000 N/mm ²		Strength < HB240, GG25		Strength < HB300, GG40			
Diameter (mm)	N	S	N	S	N	S	N	S	N	S
3	13000	0.13	11000	0.13	21000	0.13	14000	0.13	4780	0.07
4	9500	0.14	8400	0.14	16000	0.14	10500	0.14	3600	0.08
5	7600	0.15	6700	0.15	13000	0.15	8300	0.15	2850	0.09
6	6400	0.17	5600	0.17	11000	0.17	6900	0.17	2400	0.10
7	5500	0.19	4800	0.19	9100	0.19	5900	0.19	2050	0.11
8	4800	0.21	4200	0.21	8000	0.21	5200	0.21	1800	0.12
9	4200	0.23	3700	0.23	7100	0.23	4600	0.23	1600	0.13
10	3800	0.25	3350	0.25	6400	0.25	4150	0.25	1450	0.15
12	3200	0.27	2800	0.27	5300	0.27	3450	0.27	1200	0.17
14	2750	0.29	2400	0.29	4550	0.29	3000	0.29	1000	0.19
16	2400	0.31	2100	0.31	4000	0.31	2600	0.31	900	0.21
18	2100	0.33	1850	0.33	3550	0.33	2300	0.33	800	0.23
20	1900	0.35	1650	0.35	3200	0.35	2100	0.35	700	0.25

N = R.P.M.

S = Feed per revolution (mm/rev)

Kf $\frac{DH404}{1.0} \frac{DH423}{1.0} \frac{DH424}{0.85}$

We recommend you reduce the feed rate to Kf when you use DH424 drills

Solid Carbide, TiAlN Coated Dream Drills, With Coolant Holes DIN6537, DH406/DH408/DH421 Series

Work Material	Non-Alloy Steels		Alloy Steels		Soft Grey Cast Iron		Hard Grey Cast Iron		Stainless Steels	
	Strength < 700 N/mm ²		Strength < 1000 N/mm ²		Strength < HB240, GG25		Strength < HB300, GG40			
Diameter (mm)	N	S	N	S	N	S	N	S	N	S
3	16000	0.16	14500	0.16	26000	0.16	17000	0.16	6400	0.10
4	12000	0.17	11000	0.17	20000	0.17	13000	0.17	4800	0.11
5	9550	0.18	8600	0.18	16000	0.18	10000	0.18	3800	0.13
6	8000	0.20	7200	0.20	13000	0.20	8500	0.20	3200	0.14
7	6800	0.22	6100	0.22	11500	0.22	7300	0.22	2700	0.15
8	6000	0.24	5400	0.24	9900	0.24	6400	0.24	2400	0.17
9	5300	0.27	4800	0.27	8800	0.27	5700	0.27	2100	0.18
10	4800	0.30	4300	0.30	8000	0.30	5100	0.30	1900	0.21
12	4000	0.33	3600	0.33	6600	0.33	4250	0.33	1600	0.24
14	3400	0.36	3050	0.36	5700	0.36	3650	0.36	1350	0.27
16	3000	0.39	2700	0.39	5000	0.39	3200	0.39	1200	0.29
18	2650	0.42	2400	0.42	4400	0.42	2850	0.42	1050	0.32
20	2400	0.45	2150	0.45	4000	0.45	2550	0.45	955	0.35

N = R.P.M.

S = Feed per revolution (mm/rev)

Kf $\frac{DH406}{1.0} \frac{DH408}{1.0} \frac{DH421}{0.70}$

We recommend you reduce the feed rate to Kf when you use DH408 and DH421 drills

DRILLS

DRILLS Dream Drills Ultra High Performance