



**CARBIDE, DREAM DRILLS without COOLANT HOLES, TiAIN COATED**

**DH414 SERIES**

| WORK MATERIAL | CAST IRON |      | CAST IRON |      | CARBON STEELS |      | ALLOY STEELS |      |
|---------------|-----------|------|-----------|------|---------------|------|--------------|------|
|               | < HRc24   |      | > HRc24   |      | < HRc30       |      | HRc30 - 42   |      |
|               | N         | S    | N         | S    | N             | S    | N            | S    |
| 1/8 ~ 3/16    | 13120     | .006 | 8750      | .005 | 7880          | .005 | 7000         | .005 |
| 3/16 ~ 5/16   | 8200      | .008 | 5470      | .006 | 4920          | .006 | 4370         | .006 |
| 5/16 ~ 3/8    | 5970      | .011 | 3980      | .009 | 3560          | .009 | 3190         | .009 |
| 3/8 ~ 1/2     | 4690      | .014 | 3120      | .011 | 2810          | .011 | 2500         | .011 |
| 1/2 ~ 9/16    | 3860      | .016 | 2570      | .012 | 2310          | .012 | 2060         | .012 |
| 9/16 ~ 13/16  | 2980      | .018 | 1990      | .014 | 1790          | .014 | 1590         | .014 |

► Recommend to reduce the feed rate as following

**Feed 100% : DH414(3 × D)**

N = R.P.M

S = Inch per Revolution(inch/rev.)

**CARBIDE, DREAM DRILLS with COOLANT HOLES, TiAIN COATED**

**DH416, DH418 SERIES**

| WORK MATERIAL | CAST IRON |      | CAST IRON |      | CARBON STEELS |      | ALLOY STEELS |      |
|---------------|-----------|------|-----------|------|---------------|------|--------------|------|
|               | < HRc24   |      | > HRc24   |      | < HRc30       |      | HRc30 - 42   |      |
|               | N         | S    | N         | S    | N             | S    | N            | S    |
| 1/8 ~ 3/16    | 14870     | .006 | 9620      | .006 | 8750          | .006 | 7880         | .005 |
| 3/16 ~ 5/16   | 8200      | .008 | 6010      | .008 | 5470          | .008 | 4920         | .006 |
| 5/16 ~ 3/8    | 6760      | .011 | 4370      | .011 | 3980          | .011 | 3580         | .009 |
| 3/8 ~ 1/2     | 5310      | .014 | 3440      | .014 | 3120          | .014 | 2810         | .011 |
| 1/2 ~ 9/16    | 4370      | .016 | 2830      | .016 | 2570          | .016 | 2310         | .012 |
| 9/16 ~ 13/16  | 3380      | .018 | 2190      | .018 | 1990          | .018 | 1790         | .014 |

► Recommend to reduce the feed rate as following

**Feed 100% : DH416(3 × D)**

**Feed 85% : DH418(5 × D)**

N = R.P.M

S = Inch per Revolution(inch/rev.)

**CARBIDE, DREAM DRILLS without COOLANT HOLES, TiAIN COATED**

**DH404, DH424 SERIES**

| WORK MATERIAL |       | NON-ALLOY STEELS |      | ALLOY STEELS |      | SOFT GREY CAST IRON |      | HARD GREY CAST IRON |      |
|---------------|-------|------------------|------|--------------|------|---------------------|------|---------------------|------|
| STRENGTH      |       | < Hrc 20         |      | > Hrc 20     |      | < 240 BHN           |      | < 300 BHN           |      |
| DIAMETER      |       | N                | S    | N            | S    | N                   | S    | N                   | S    |
| METRIC        | INCH  |                  |      |              |      |                     |      |                     |      |
| 1.0           | .0394 | 13000            | .002 | 11250        | .002 | 21300               | .002 | 14200               | .002 |
| 2.0           | .0787 | 13000            | .002 | 11250        | .002 | 21300               | .002 | 14200               | .002 |
| 3.0           | .1181 | 13000            | .005 | 11000        | .005 | 21000               | .005 | 14000               | .005 |
| 4.0           | .1575 | 9500             | .006 | 8400         | .006 | 16000               | .006 | 10500               | .006 |
| 5.0           | .1969 | 7600             | .006 | 6700         | .006 | 13000               | .006 | 8300                | .006 |
| 6.0           | .2362 | 6400             | .007 | 5600         | .007 | 11000               | .007 | 6900                | .007 |
| 7.0           | .2756 | 5500             | .007 | 4800         | .007 | 9100                | .007 | 5900                | .007 |
| 8.0           | .3150 | 4800             | .008 | 4200         | .008 | 8000                | .008 | 5200                | .008 |
| 9.0           | .3543 | 4200             | .009 | 3700         | .009 | 7100                | .009 | 4600                | .009 |
| 10.0          | .3937 | 3800             | .010 | 3350         | .010 | 6400                | .010 | 4150                | .010 |
| 12.0          | .4724 | 3200             | .011 | 2800         | .011 | 5300                | .011 | 3450                | .011 |
| 14.0          | .5512 | 2750             | .011 | 2400         | .011 | 4550                | .011 | 3000                | .011 |
| 16.0          | .6299 | 2400             | .012 | 2100         | .012 | 4000                | .012 | 2600                | .012 |
| 18.0          | .7087 | 2100             | .013 | 1850         | .013 | 3550                | .013 | 2300                | .013 |
| 20.0          | .7874 | 1900             | .014 | 1650         | .014 | 3200                | .014 | 2100                | .014 |

► Recommend to reduce the feed rate as following

**Feed 100% : DH404(3 × D)**

N = R.P.M

S = Inch per Revolution(inch/rev.)

I-DREAM DRILLS

DREAM DRILLS

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILL & COUNTER SINK

SPADE DRILLS

TECHNICAL DATA



**CARBIDE, DREAM DRILLS with COOLANT HOLES, TiAIN COATED**

**DH406, DH408, DH421 SERIES**

| WORK MATERIAL |       | NON-ALLOY STEELS |      | ALLOY STEELS |      | SOFT GREY CAST IRON |      | HARD GREY CAST IRON |      |
|---------------|-------|------------------|------|--------------|------|---------------------|------|---------------------|------|
| STRENGTH      |       | < HRc 20         |      | > HRc 20     |      | < 240 BHN           |      | < 300 BHN           |      |
| DIAMETER      |       | N                | S    | N            | S    | N                   | S    | N                   | S    |
| METRIC        | INCH  |                  |      |              |      |                     |      |                     |      |
| 1.0           | .0394 | 16250            | .002 | 14800        | .002 | 26600               | .002 | 17300               | .002 |
| 2.0           | .0787 | 16250            | .003 | 14800        | .003 | 26600               | .003 | 17300               | .003 |
| 3.0           | .1181 | 16000            | .006 | 14500        | .006 | 26000               | .006 | 17000               | .006 |
| 4.0           | .1575 | 12000            | .007 | 11000        | .007 | 20000               | .007 | 13000               | .007 |
| 5.0           | .1969 | 9550             | .007 | 8600         | .007 | 16000               | .007 | 10000               | .007 |
| 6.0           | .2362 | 8000             | .008 | 7200         | .008 | 13000               | .008 | 8500                | .008 |
| 7.0           | .2756 | 6800             | .009 | 6100         | .009 | 11500               | .009 | 7300                | .009 |
| 8.0           | .3150 | 6000             | .009 | 5400         | .009 | 9900                | .009 | 6400                | .009 |
| 9.0           | .3543 | 5300             | .011 | 4800         | .011 | 8800                | .011 | 5700                | .011 |
| 10.0          | .3937 | 4800             | .012 | 4300         | .012 | 8000                | .012 | 5100                | .012 |
| 12.0          | .4724 | 4000             | .013 | 3600         | .013 | 6600                | .013 | 4250                | .013 |
| 14.0          | .5512 | 3400             | .014 | 3050         | .014 | 5700                | .014 | 3650                | .014 |
| 16.0          | .6299 | 3000             | .015 | 2700         | .015 | 5000                | .015 | 3200                | .015 |
| 18.0          | .7087 | 2650             | .017 | 2400         | .017 | 4400                | .017 | 2850                | .017 |
| 20.0          | .7874 | 2400             | .018 | 2150         | .018 | 4000                | .018 | 2550                | .018 |

► Recommend to reduce the feed rate as following

**Feed 100%** : DH406(3 × D), **Feed 85%** : DH408(5 × D),  
**Feed 70%** : DH421(8 × D)

N = R.P.M

S = Inch per Revolution(inch/rev.)



**CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES, TiAIN COATED**

**DH463, DH464, DH451, DH452, DH453 SERIES**

| WORK MATERIAL |            |         | STAINLESS STEELS 400Series |      | STAINLESS STEELS 300Series |      | ALUMINUM |      | ALUMINUM |      |
|---------------|------------|---------|----------------------------|------|----------------------------|------|----------|------|----------|------|
| STRENGTH      |            |         | < 800 N/mm <sup>2</sup>    |      | > 800 N/mm <sup>2</sup>    |      | < 10% Si |      | > 10% Si |      |
| DIAMETER      |            |         | N                          | S    | N                          | S    | N        | S    | N        | S    |
| Metric(mm)    | Fractional | Decimal |                            |      |                            |      |          |      |          |      |
| 3.0           | 1/8        | .1181   | 7400                       | .002 | 4700                       | .001 | 23000    | .005 | 18500    | .004 |
| 4.0           | 5/32       | .1575   | 5600                       | .002 | 3600                       | .001 | 17500    | .007 | 13900    | .006 |
| 5.0           | 13/64      | .1969   | 4400                       | .002 | 2800                       | .001 | 14000    | .008 | 11000    | .007 |
| 6.0           | 15/64      | .2362   | 3700                       | .002 | 2400                       | .002 | 11700    | .010 | 9300     | .010 |
| 8.0           | 5/16       | .3150   | 2800                       | .003 | 1800                       | .002 | 8800     | .012 | 7000     | .012 |
| 10.0          | 25/64      | .3937   | 2200                       | .004 | 1400                       | .003 | 7000     | .016 | 5600     | .014 |
| 12.0          | 15/32      | .4724   | 1900                       | .005 | 1200                       | .004 | 5800     | .020 | 4600     | .016 |
| 14.0          | 35/64      | .5512   | 1600                       | .006 | 1000                       | .005 | 5000     | .024 | 4000     | .020 |
| 16.0          | 5/8        | .6299   | 1400                       | .008 | 900                        | .006 | 4380     | .031 | 3500     | .024 |
| 18.0          | 45/64      | .7087   | 1250                       | .009 | 800                        | .007 | 3900     | .039 | 3100     | .028 |
| 20.0          | 25/32      | .7874   | 1120                       | .009 | 720                        | .007 | 3500     | .047 | 2800     | .031 |

| WORK MATERIAL |            |         | TITANIUM Ti ALLOY |      | CARBON STEEL ALLOY STEEL |      | NON FRERROUS |      |
|---------------|------------|---------|-------------------|------|--------------------------|------|--------------|------|
| STRENGTH      |            |         | N                 | S    | N                        | S    | N            | S    |
| DIAMETER      |            |         |                   |      |                          |      |              |      |
| Metric(mm)    | Fractional | Decimal |                   |      |                          |      |              |      |
| 3.0           | 1/8        | .1181   | 5300              | .001 | 13000                    | .002 | 16000        | .003 |
| 4.0           | 5/32       | .1575   | 4000              | .002 | 10000                    | .002 | 11900        | .004 |
| 5.0           | 13/64      | .1969   | 3200              | .002 | 8000                     | .002 | 9500         | .005 |
| 6.0           | 15/64      | .2362   | 2650              | .002 | 6600                     | .002 | 8000         | .006 |
| 8.0           | 5/16       | .3150   | 2000              | .003 | 5000                     | .003 | 6000         | .007 |
| 10.0          | 25/64      | .3937   | 1600              | .003 | 4000                     | .004 | 4800         | .009 |
| 12.0          | 15/32      | .4724   | 1300              | .004 | 3300                     | .005 | 4000         | .010 |
| 14.0          | 35/64      | .5512   | 1100              | .005 | 2800                     | .006 | 3400         | .012 |
| 16.0          | 5/8        | .6299   | 1000              | .006 | 2500                     | .008 | 3000         | .016 |
| 18.0          | 45/64      | .7087   | 900               | .006 | 2200                     | .009 | 2650         | .018 |
| 20.0          | 25/32      | .7874   | 800               | .007 | 2000                     | .009 | 2400         | .020 |

► Recommend to reduce the feed rate as following

- Feed 100%** : DH463(3 × D), DH464(5 × D)  
                   DH451(3 × D), DH452(5 × D)
- Feed 85%** : DH453(8 × D)

N = R.P.M  
 S = Inch per Revolution(inch/rev.)

- i-DREAM DRILLS
- DREAM DRILLS
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- STANDARD CARBIDE DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- STRAIGHT SHANK DRILLS
- AIRCRAFT DRILLS
- SILVER & DEMING DRILLS
- TAPER SHANK DRILLS
- NC SPOTTING DRILLS
- COMBINATION DRILL & COUNTER SINK
- SPADE DRILLS
- TECHNICAL DATA

**CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES, DLC COATED**

**DGE466, DGE433 SERIES**

| WORK MATERIAL |               | ALUMINUM ALLOY CASTING<br>ALUMINUM DIE CASTING |             | WROUGHT ALUMINUM ALLOY |             |
|---------------|---------------|--|-------------|------------------------|-------------|
| DIAMETER      |               | N  | S           | N                      | S           |
| METRIC        | INCH          |  |             |                        |             |
| 3.0 ~ 6.0     | .1181 ~ .2362 | 8000 ~ 15000                                   | .008 ~ .020 | 8000 ~ 15000           | .006 ~ .012 |
| 10.0          | ~ .3937       | 6000 ~ 10500                                   | .012 ~ .039 | 6000 ~ 10500           | .008 ~ .016 |
| 14.0          | ~ .5512       | 4500 ~ 5800                                    | .012 ~ .039 | 4500 ~ 5800            | .008 ~ .016 |
| 20.0          | ~ .7874       | 3200 ~ 4600                                    | .012 ~ .039 | 3200 ~ 4600            | .008 ~ .016 |

N = R.P.M  
S = Inch per Revolution(inch/rev.)

i-DREAM DRILLS

DREAM DRILLS

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILL & COUNTER SINK

SPADE DRILLS

TECHNICAL DATA



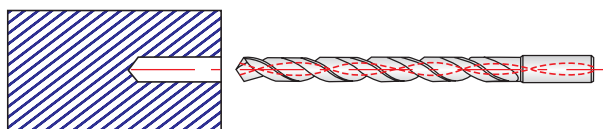
**CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES, TiAIN COATED**

**DH510, DH515, DH520 SERIES**

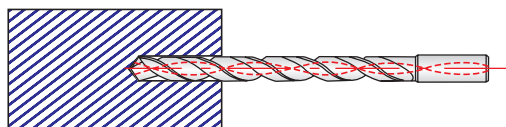
| WORK MATERIAL |       | CARBON STEELS ALLOY STEELS ~ 1060 N/mm <sup>2</sup> |             | CAST IRON 250 ~ 350 N/mm <sup>2</sup> |             | DUCTILE CAST IRON 400 ~ 500 N/mm <sup>2</sup> |             | DUCTILE CAST IRON |             |
|---------------|-------|---|-------------|---------------------------------------|-------------|---|-------------|-------------------|-------------|
| STRENGTH      |       | < HRc 25  |             | < HRc 10                              |             | > HRc 10                                      |             |                   |             |
| DIAMETER      |       | N   | S           | N                                     | S           | N   | S           | N                 | S           |
| METRIC        | INCH  |   |             |                                       |             |   |             |                   |             |
| 3.0           | .1181 | 7500  | .0023~.0047 | 7500                                  | .0023~.0047 | 7500  | .0023~.0047 | 5300              | .0023~.0047 |
| 4.0           | .1575 | 6400  | .0031~.0063 | 6400                                  | .0031~.0063 | 5600  | .0031~.0063 | 5000              | .0031~.0063 |
| 5.0           | .1969 | 5800  | .0039~.0078 | 5800                                  | .0039~.0078 | 4500  | .0039~.0078 | 4500              | .0039~.0078 |
| 6.0           | .2362 | 4800  | .0047~.0094 | 4800                                  | .0047~.0094 | 3800  | .0047~.0094 | 3800              | .0047~.0094 |
| 8.0           | .3150 | 3600  | .0063~.0110 | 3600                                  | .0063~.0110 | 2800  | .0063~.0110 | 2800              | .0063~.0110 |
| 10.0          | .3937 | 2900  | .0078~.0137 | 2900                                  | .0078~.0137 | 2300  | .0078~.0137 | 2300              | .0078~.0137 |
| 12.0          | .4724 | 2400  | .0094~.0165 | 2400                                  | .0094~.0165 | 1900  | .0094~.0165 | 1900              | .0094~.0165 |

► **Coolant Pressure : 900 PSI**

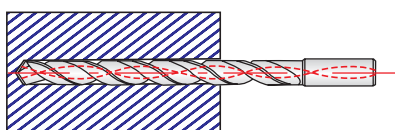
N = R.P.M  
S = Inch per Revolution(inch/rev)



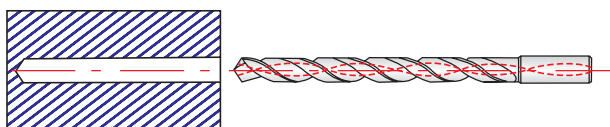
1. Use a YG 3xD Drill to produce a guide hole no larger than .004 over the required drill size. Drill the pilot hole 2xD deep hole.



2. Enter the guide hole at 50 SFM surface and .010 feed rate / per rev.



3. Before hitting the bottom of the guide hole, Increase SFM and feed rate for normal drilling.



4. After drilling, to withdraw drill, reduce SFM to 50 @ 10 inches per minute.

**CARBIDE, DREAM DRILLS for High HARDENED STEEL HRc50~HRc70, TiAIN COATED**

**DH501 SERIES**

| WORK MATERIAL  | HARDENED STEELS |         |             |         |             |         |
|----------------|-----------------|---------|-------------|---------|-------------|---------|
|                | HRc 50 ~ 55     |         | HRc 55 ~ 60 |         | HRc 60 ~ 70 |         |
| DRILLING SPEED | 45 ~ 72 SFM     |         | 32 ~ 52 SFM |         | 26 ~ 42 SFM |         |
| DIAMETER       | N               | S       | N           | S       | N           | S       |
| 5/64           | 2860            | ~ .0015 | 2000        | ~ .0015 | 1900        | ~ .0011 |
| 1/8            | 1900            | ~ .0015 | 1330        | ~ .0015 | 1250        | ~ .0015 |
| 5/32           | 1430            | ~ .0015 | 1000        | ~ .0015 | 950         | ~ .0015 |
| 13/64          | 1150            | ~ .0015 | 800         | ~ .0015 | 750         | ~ .0015 |
| 15/64          | 960             | ~ .0015 | 670         | ~ .0015 | 630         | ~ .0015 |
| 5/16           | 720             | ~ .0015 | 500         | ~ .0015 | 480         | ~ .0015 |
| 25/64          | 570             | ~ .0015 | 400         | ~ .0015 | 380         | ~ .0015 |
| 15/32          | 480             | ~ .0015 | 330         | ~ .0015 | 320         | ~ .0015 |
| 9/16           | 435             | ~ .0015 | 280         | ~ .0015 | 270         | ~ .0015 |
| 41/64          | 380             | ~ .0015 | 250         | ~ .0015 | 240         | ~ .0015 |
| 11/16          | 325             | ~ .0015 | 235         | ~ .0015 | 190         | ~ .0015 |
| 47/64          | 310             | ~ .0015 | 220         | ~ .0015 | 180         | ~ .0015 |

N = R.P.M  
S = Inch per Revolution(inch/rev.)

**DH500 SERIES**

| WORK MATERIAL  |       | HARDENED STEELS |         |             |         |             |         |
|----------------|-------|-----------------|---------|-------------|---------|-------------|---------|
|                |       | HRc 50 ~ 55     |         | HRc 55 ~ 60 |         | HRc 60 ~ 70 |         |
| DRILLING SPEED |       | 45 ~ 72 SFM     |         | 32 ~ 52 SFM |         | 26 ~ 42 SFM |         |
| DIAMETER       |       | N               | S       | N           | S       | N           | S       |
| METRIC         | INCH  |                 |         |             |         |             |         |
| 3.0            | .1181 | 1900            | ~ .0015 | 1330        | ~ .0015 | 1250        | ~ .0015 |
| 4.0            | .1575 | 1430            | ~ .0015 | 1000        | ~ .0015 | 950         | ~ .0015 |
| 5.0            | .1969 | 1150            | ~ .0015 | 800         | ~ .0015 | 750         | ~ .0015 |
| 6.0            | .2362 | 960             | ~ .0015 | 670         | ~ .0015 | 630         | ~ .0015 |
| 8.0            | .3150 | 720             | ~ .0015 | 500         | ~ .0015 | 480         | ~ .0015 |
| 10.0           | .3937 | 570             | ~ .0015 | 400         | ~ .0015 | 380         | ~ .0015 |
| 12.0           | .4724 | 480             | ~ .0015 | 330         | ~ .0015 | 320         | ~ .0015 |
| 14.0           | .5512 | 438             | ~ .0015 | 282         | ~ .0015 | 272         | ~ .0015 |

N = R.P.M  
S = Inch per Revolution(inch/rev.)

i-DREAM DRILLS

DREAM DRILLS

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILL & COUNTER SINK

SPADE DRILLS

TECHNICAL DATA

**CARBIDE DRILLS**

**D5412, D5413, D5417 SERIES**

| WORK MATERIAL<br>DIAMETER | NON-ALLOY STEELS |       | ALLOY STEELS |       | SOFT GREY CAST IRON |       | HARD GREY CAST IRON |       |
|---------------------------|------------------|-------|--------------|-------|---------------------|-------|---------------------|-------|
|                           | N                | S     | N            | S     | N                   | S     | N                   | S     |
| 3/64                      | 23000            | .0012 | 17200        | .0012 | 32000               | .0016 | 23000               | .0016 |
| 5/64                      | 11500            | .0016 | 8600         | .0016 | 16000               | .0020 | 11500               | .0020 |
| 1/8                       | 7800             | .0020 | 5750         | .0020 | 10500               | .0024 | 7600                | .0024 |
| 5/32                      | 5800             | .0024 | 4300         | .0024 | 7800                | .0028 | 5700                | .0028 |
| 13/64                     | 4700             | .0028 | 3450         | .0028 | 6200                | .0031 | 4550                | .0031 |
| 15/64                     | 3900             | .0031 | 2850         | .0031 | 5200                | .0035 | 3800                | .0035 |
| 9/32                      | 3350             | .0035 | 2450         | .0035 | 4500                | .0039 | 3250                | .0039 |
| 5/16                      | 2900             | .0039 | 2150         | .0039 | 3900                | .0047 | 2850                | .0047 |
| 23/64                     | 2600             | .0043 | 1900         | .0043 | 3450                | .0055 | 2550                | .0055 |
| 25/64                     | 2350             | .0047 | 1700         | .0047 | 3100                | .0063 | 2300                | .0063 |
| 7/16                      | 2150             | .0051 | 1600         | .0051 | 2850                | .0071 | 2100                | .0071 |
| 15/32                     | 1950             | .0055 | 1450         | .0055 | 2600                | .0079 | 1900                | .0079 |
| 33/64                     | 1800             | .0063 | 1350         | .0063 | 2400                | .0079 | 1750                | .0079 |

| WORK MATERIAL<br>DIAMETER | STAINLESS STEELS |       | Al-Si ALLOY,<br>Si<10% |       | Al-Si ALLOY,<br>Si>10% |       | Ti, Ni ALLOY STEELS |       |
|---------------------------|------------------|-------|------------------------|-------|------------------------|-------|---------------------|-------|
|                           | N                | S     | N                      | S     | N                      | S     | N                   | S     |
| 3/64                      | 12000            | .0016 | 54000                  | .0020 | 42000                  | .0020 | 11800               | .0008 |
| 5/64                      | 6000             | .0012 | 27000                  | .0024 | 21000                  | .0024 | 5900                | .0012 |
| 1/8                       | 4000             | .0016 | 18000                  | .0028 | 14000                  | .0028 | 3900                | .0016 |
| 5/32                      | 3000             | .0020 | 13000                  | .0031 | 10500                  | .0031 | 2950                | .0020 |
| 13/64                     | 2400             | .0024 | 10500                  | .0035 | 8500                   | .0035 | 2350                | .0024 |
| 15/64                     | 2000             | .0028 | 8800                   | .0043 | 7100                   | .0043 | 1950                | .0028 |
| 9/32                      | 1700             | .0031 | 7600                   | .0051 | 6100                   | .0051 | 1700                | .0031 |
| 5/16                      | 1500             | .0035 | 6600                   | .0059 | 5350                   | .0059 | 1450                | .0035 |
| 23/64                     | 1350             | .0039 | 5900                   | .0067 | 4750                   | .0067 | 1300                | .0039 |
| 25/64                     | 1200             | .0043 | 5300                   | .0075 | 4250                   | .0075 | 1200                | .0043 |
| 7/16                      | 1100             | .0047 | 4850                   | .0083 | 3900                   | .0083 | 1050                | .0047 |
| 15/32                     | 1000             | .0051 | 4450                   | .0091 | 3550                   | .0091 | 980                 | .0051 |
| 33/64                     | 950              | .0051 | 4100                   | .0098 | 3300                   | .0098 | 905                 | .0051 |

N = R.P.M  
S = Inch per Revolution(inch/rev.)

i-DREAM DRILLS

DREAM DRILLS

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILL & COUNTER SINK

SPADE DRILLS

TECHNICAL DATA