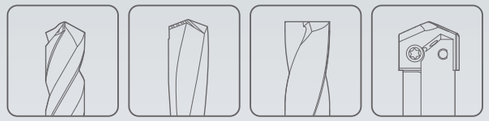
Global Cutting Tool Leader **YG-1**



DREAM DRILLS

Leading Through Innovation

NEW

SOLID CARBIDE

DREAM DRILL X

- Multi-Purpose Solid Carbide Drilling up to HRc50
- Proprietary coating upgrade boosting performance in Steel and Cast-Iron applications

NEW

DREAM DRILL X

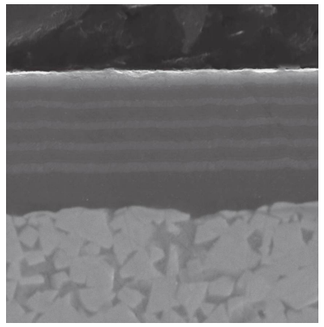
New Coating Technology *"RCH-Coating"*

Combining the major benefits of TiAlN and AlCrN into a new '**Nano Layered Multilayer**' coating generation provides unique advantages such as:

Extreme Wear Resistance

High Heat Endurance

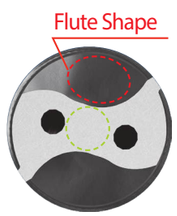
Chipping Protection



At insufficient coolant conditions where higher temperatures occur, **RCH-Coating** allows with its very high temperature stability for great tool life results.

FEATURES & BENEFITS

- **Universal Point Grinding**
  Soft cutting action and reduced axial forces; Easy to Recondition
- **Radius Thinning**
  Provides very good self centering even at low feed rates and unstable situations
- **Tailored Flute Design**
  Excellent chip breaking and evacuation
- **Edge Preparation**
  Maximizing tool life in various materials



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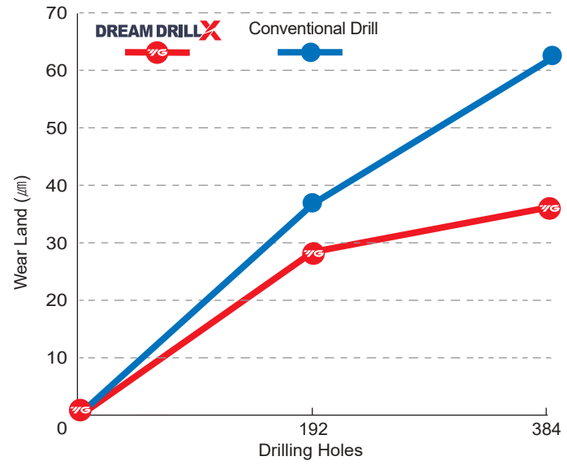
CASE STUDY

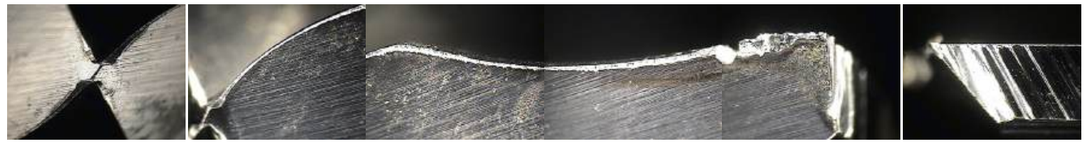
▶ SOLID CARBIDE DREAM DRILL X with Coolant Holes

CUTTING CONDITION	
Work Material	• DIN : C45 • AISI : 1045 • JIS : S45C (HRc20)
Drill Diameter(mm)	Ø10.0
Cutting Speed	109.99 m/min.
Feed	0.23 mm/rev
Drilling Depth	40mm
Coolant	Internal Cooling Wet Cut (9% Emulsion)
Machine	Vertical Machine



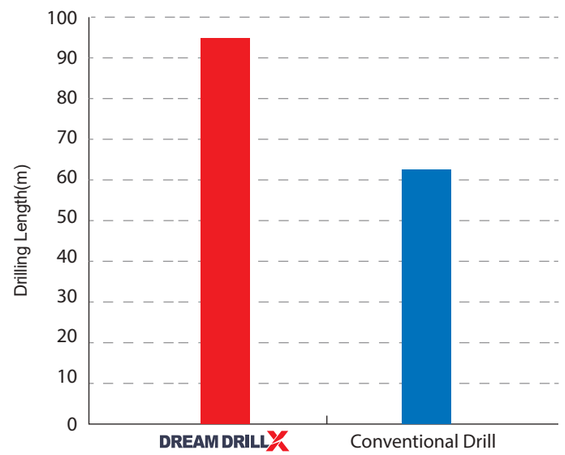
DREAM DRILL X — Total Drilling 384 Holes

Conventional Drill — Total Drilling 384 Holes



▶ SOLID CARBIDE DREAM DRILL X with Coolant Holes

CUTTING CONDITION	
Work Material	• DIN : GGG40 • AISI : 60-40-18 • JIS : FCD400
Drilling Diameter(mm)	Ø8.5
Cutting Speed	112m/min
Feed	0.33mm/rev.
Drilling Depth	18mm
Coolant	Internal Cooling
Machine	Machining Center (Horizontal)



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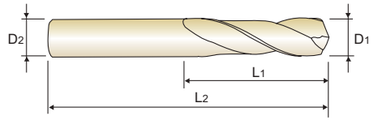
RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (3XD)

SERIES NEW DTX404

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6539 | CARBIDE | 30° | h6 | h7 | 140° | RCH Coating | p.40

STUB 3 × D

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404030	3.0	16	46
DTX404031	3.1	18	49
DTX404032	3.2	18	49
DTX404033	3.3	18	49
DTX404034	3.4	20	52
DTX404035	3.5	20	52
DTX404036	3.6	20	52
DTX404037	3.7	20	52
DTX404038	3.8	22	55
DTX404039	3.9	22	55
DTX404040	4.0	22	55
DTX404041	4.1	22	55
DTX404042	4.2	22	55
DTX404043	4.3	24	58
DTX404044	4.4	24	58
DTX404045	4.5	24	58
DTX404046	4.6	24	58
DTX404047	4.7	24	58
DTX404048	4.8	26	62
DTX404049	4.9	26	62
DTX404050	5.0	26	62
DTX404051	5.1	26	62
DTX404052	5.2	26	62
DTX404053	5.3	26	62
DTX404054	5.4	28	66
DTX404055	5.5	28	66
DTX404056	5.6	28	66
DTX404057	5.7	28	66

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404058	5.8	28	66
DTX404059	5.9	28	66
DTX404060	6.0	28	66
DTX404061	6.1	31	70
DTX404062	6.2	31	70
DTX404063	6.3	31	70
DTX404064	6.4	31	70
DTX404065	6.5	31	70
DTX404066	6.6	31	70
DTX404067	6.7	31	70
DTX404068	6.8	34	74
DTX404069	6.9	34	74
DTX404070	7.0	34	74
DTX404071	7.1	34	74
DTX404072	7.2	34	74
DTX404073	7.3	34	74
DTX404074	7.4	34	74
DTX404075	7.5	34	74
DTX404076	7.6	37	79
DTX404077	7.7	37	79
DTX404078	7.8	37	79
DTX404079	7.9	37	79
DTX404080	8.0	37	79
DTX404081	8.1	37	79
DTX404082	8.2	37	79
DTX404083	8.3	37	79
DTX404084	8.4	37	79
DTX404085	8.5	37	79

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

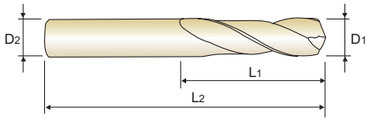
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (3XD)

SERIES NEW DTX404

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6539 | CARBIDE | 30° | h6 | h7 | 140° | RCH Coating | p.40

STUB 3 × D

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404086	8.6	40	84
DTX404087	8.7	40	84
DTX404088	8.8	40	84
DTX404089	8.9	40	84
DTX404090	9.0	40	84
DTX404091	9.1	40	84
DTX404092	9.2	40	84
DTX404093	9.3	40	84
DTX404094	9.4	40	84
DTX404095	9.5	40	84
DTX404096	9.6	43	89
DTX404097	9.7	43	89
DTX404098	9.8	43	89
DTX404099	9.9	43	89
DTX404100	10.0	43	89
DTX404102	10.2	43	89
DTX404105	10.5	43	89
DTX404110	11.0	47	95
DTX404115	11.5	47	95
DTX404120	12.0	51	102
DTX404130	13.0	51	102
DTX404135	13.5	54	107
DTX404140	14.0	54	107
DTX404145	14.5	56	111
DTX404150	15.0	56	111
DTX404155	15.5	58	115
DTX404160	16.0	58	115
DTX404165	16.5	60	119

EDP No.	Drill Diameter	Flute Length	Overall Length
RCH-Coating	D1=D2	L1	L2
DTX404170	17.0	60	119
DTX404175	17.5	62	123
DTX404180	18.0	62	123
DTX404185	18.5	64	127
DTX404190	19.0	64	127
DTX404195	19.5	66	131
DTX404200	20.0	66	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

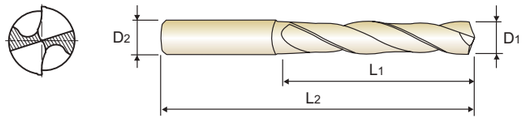
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (3XD)

SERIES NEW DTX423

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | RCH Coating

p.40

SHORT 3 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423030	3.0	6	20	62
DTX423031	3.1	6	20	62
DTX423032	3.2	6	20	62
DTX423033	3.3	6	20	62
DTX423034	3.4	6	20	62
DTX423035	3.5	6	20	62
DTX423036	3.6	6	20	62
DTX423037	3.7	6	20	62
DTX423038	3.8	6	24	66
DTX423039	3.9	6	24	66
DTX423040	4.0	6	24	66
DTX423041	4.1	6	24	66
DTX423042	4.2	6	24	66
DTX423043	4.3	6	24	66
DTX423044	4.4	6	24	66
DTX423045	4.5	6	24	66
DTX423046	4.6	6	24	66
DTX423047	4.7	6	24	66
DTX423048	4.8	6	28	66
DTX423049	4.9	6	28	66
DTX423050	5.0	6	28	66
DTX423051	5.1	6	28	66
DTX423052	5.2	6	28	66
DTX423053	5.3	6	28	66
DTX423054	5.4	6	28	66
DTX423055	5.5	6	28	66
DTX423056	5.6	6	28	66
DTX423057	5.7	6	28	66
DTX423058	5.8	6	28	66
DTX423059	5.9	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423060	6.0	6	28	66
DTX423061	6.1	8	34	79
DTX423062	6.2	8	34	79
DTX423063	6.3	8	34	79
DTX423064	6.4	8	34	79
DTX423065	6.5	8	34	79
DTX423066	6.6	8	34	79
DTX423067	6.7	8	34	79
DTX423068	6.8	8	34	79
DTX423069	6.9	8	34	79
DTX423070	7.0	8	34	79
DTX423071	7.1	8	41	79
DTX423072	7.2	8	41	79
DTX423073	7.3	8	41	79
DTX423074	7.4	8	41	79
DTX423075	7.5	8	41	79
DTX423076	7.6	8	41	79
DTX423077	7.7	8	41	79
DTX423078	7.8	8	41	79
DTX423079	7.9	8	41	79
DTX423080	8.0	8	41	79
DTX423081	8.1	10	47	89
DTX423082	8.2	10	47	89
DTX423083	8.3	10	47	89
DTX423084	8.4	10	47	89
DTX423085	8.5	10	47	89
DTX423086	8.6	10	47	89
DTX423087	8.7	10	47	89
DTX423088	8.8	10	47	89
DTX423089	8.9	10	47	89

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

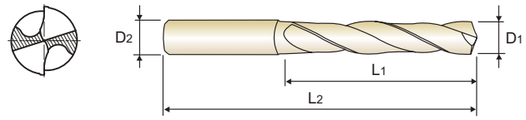
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (3XD)

SERIES NEW DTX423

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | RCH Coating

p.40

SHORT 3 × D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423090	9.0	10	47	89
DTX423091	9.1	10	47	89
DTX423092	9.2	10	47	89
DTX423093	9.3	10	47	89
DTX423094	9.4	10	47	89
DTX423095	9.5	10	47	89
DTX423096	9.6	10	47	89
DTX423097	9.7	10	47	89
DTX423098	9.8	10	47	89
DTX423099	9.9	10	47	89
DTX423100	10.0	10	47	89
DTX423101	10.1	12	55	102
DTX423102	10.2	12	55	102
DTX423103	10.3	12	55	102
DTX423104	10.4	12	55	102
DTX423105	10.5	12	55	102
DTX423106	10.6	12	55	102
DTX423107	10.7	12	55	102
DTX423108	10.8	12	55	102
DTX423109	10.9	12	55	102
DTX423110	11.0	12	55	102
DTX423111	11.1	12	55	102
DTX423112	11.2	12	55	102
DTX423113	11.3	12	55	102
DTX423114	11.4	12	55	102
DTX423115	11.5	12	55	102
DTX423116	11.6	12	55	102
DTX423117	11.7	12	55	102
DTX423118	11.8	12	55	102
DTX423119	11.9	12	55	102

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX423120	12.0	12	55	102
DTX423123	12.3	14	60	107
DTX423125	12.5	14	60	107
DTX423128	12.8	14	60	107
DTX423130	13.0	14	60	107
DTX423135	13.5	14	60	107
DTX423138	13.8	14	60	107
DTX423140	14.0	14	60	107
DTX423145	14.5	16	65	115
DTX423148	14.8	16	65	115
DTX423150	15.0	16	65	115
DTX423155	15.5	16	65	115
DTX423158	15.8	16	65	115
DTX423160	16.0	16	65	115
DTX423165	16.5	18	73	123
DTX423168	16.8	18	73	123
DTX423170	17.0	18	73	123
DTX423175	17.5	18	73	123
DTX423178	17.8	18	73	123
DTX423180	18.0	18	73	123
DTX423185	18.5	20	79	131
DTX423190	19.0	20	79	131
DTX423195	19.5	20	79	131
DTX423198	19.8	20	79	131
DTX423200	20.0	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

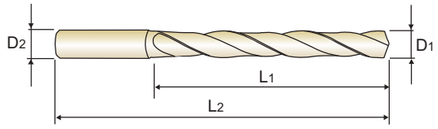
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (5XD)

SERIES NEW DTX424

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | RCH Coating | p.40

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424010	1.0	3	8	55
DTX424011	1.1	3	12	55
DTX424012	1.2	3	12	55
DTX424013	1.3	3	12	55
DTX424014	1.4	3	12	55
DTX424015	1.5	3	16	55
DTX424016	1.6	3	16	55
DTX424017	1.7	3	16	55
DTX424018	1.8	3	16	55
DTX424019	1.9	3	16	55
DTX424020	2.0	4	21	57
DTX424021	2.1	4	21	57
DTX424022	2.2	4	21	57
DTX424023	2.3	4	21	57
DTX424024	2.4	4	21	57
DTX424025	2.5	4	21	57
DTX424026	2.6	4	21	57
DTX424027	2.7	4	21	57
DTX424028	2.8	4	21	57
DTX424029	2.9	4	21	57
DTX424030	3.0	6	28	66
DTX424031	3.1	6	28	66
DTX424032	3.2	6	28	66
DTX424033	3.3	6	28	66
DTX424034	3.4	6	28	66
DTX424035	3.5	6	28	66
DTX424036	3.6	6	28	66
DTX424037	3.7	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424038	3.8	6	36	74
DTX424039	3.9	6	36	74
DTX424040	4.0	6	36	74
DTX424041	4.1	6	36	74
DTX424042	4.2	6	36	74
DTX424043	4.3	6	36	74
DTX424044	4.4	6	36	74
DTX424045	4.5	6	36	74
DTX424046	4.6	6	36	74
DTX424047	4.7	6	36	74
DTX424048	4.8	6	44	82
DTX424049	4.9	6	44	82
DTX424050	5.0	6	44	82
DTX424051	5.1	6	44	82
DTX424052	5.2	6	44	82
DTX424053	5.3	6	44	82
DTX424054	5.4	6	44	82
DTX424055	5.5	6	44	82
DTX424056	5.6	6	44	82
DTX424057	5.7	6	44	82
DTX424058	5.8	6	44	82
DTX424059	5.9	6	44	82
DTX424060	6.0	6	44	82
DTX424061	6.1	8	53	91
DTX424062	6.2	8	53	91
DTX424063	6.3	8	53	91
DTX424064	6.4	8	53	91
DTX424065	6.5	8	53	91

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P																			
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

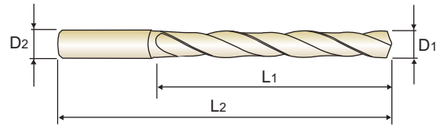
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (5XD)

SERIES NEW DTX424

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | RCH Coating | p.40

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424066	6.6	8	53	91
DTX424067	6.7	8	53	91
DTX424068	6.8	8	53	91
DTX424069	6.9	8	53	91
DTX424070	7.0	8	53	91
DTX424071	7.1	8	53	91
DTX424072	7.2	8	53	91
DTX424073	7.3	8	53	91
DTX424074	7.4	8	53	91
DTX424075	7.5	8	53	91
DTX424076	7.6	8	53	91
DTX424077	7.7	8	53	91
DTX424078	7.8	8	53	91
DTX424079	7.9	8	53	91
DTX424080	8.0	8	53	91
DTX424081	8.1	10	61	103
DTX424082	8.2	10	61	103
DTX424083	8.3	10	61	103
DTX424084	8.4	10	61	103
DTX424085	8.5	10	61	103
DTX424086	8.6	10	61	103
DTX424087	8.7	10	61	103
DTX424088	8.8	10	61	103
DTX424089	8.9	10	61	103
DTX424090	9.0	10	61	103
DTX424091	9.1	10	61	103
DTX424092	9.2	10	61	103
DTX424093	9.3	10	61	103

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424094	9.4	10	61	103
DTX424095	9.5	10	61	103
DTX424096	9.6	10	61	103
DTX424097	9.7	10	61	103
DTX424098	9.8	10	61	103
DTX424099	9.9	10	61	103
DTX424100	10.0	10	61	103
DTX424101	10.1	12	71	118
DTX424102	10.2	12	71	118
DTX424103	10.3	12	71	118
DTX424104	10.4	12	71	118
DTX424105	10.5	12	71	118
DTX424106	10.6	12	71	118
DTX424107	10.7	12	71	118
DTX424108	10.8	12	71	118
DTX424109	10.9	12	71	118
DTX424110	11.0	12	71	118
DTX424111	11.1	12	71	118
DTX424112	11.2	12	71	118
DTX424113	11.3	12	71	118
DTX424114	11.4	12	71	118
DTX424115	11.5	12	71	118
DTX424116	11.6	12	71	118
DTX424117	11.7	12	71	118
DTX424118	11.8	12	71	118
DTX424119	11.9	12	71	118
DTX424120	12.0	12	71	118
DTX424125	12.5	14	77	124

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P																			
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

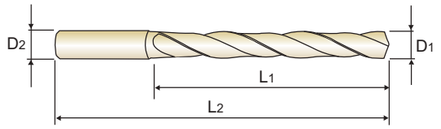
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X without COOLANT HOLES (5XD)

SERIES NEW DTX424

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | RCH Coating

p.40

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424130	13.0	14	77	124
DTX424135	13.5	14	77	124
DTX424140	14.0	14	77	124
DTX424145	14.5	16	83	133
DTX424150	15.0	16	83	133
DTX424155	15.5	16	83	133
DTX424160	16.0	16	83	133
DTX424165	16.5	18	93	143

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX424170	17.0	18	93	143
DTX424175	17.5	18	93	143
DTX424180	18.0	18	93	143
DTX424185	18.5	20	101	153
DTX424190	19.0	20	101	153
DTX424195	19.5	20	101	153
DTX424200	20.0	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

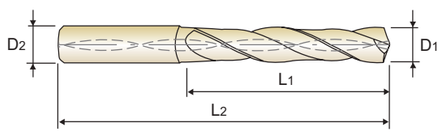
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (3XD)

SERIES NEW DTX406

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating

p.41

SHORT 3× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406030	3.0	6	20	62
DTX406031	3.1	6	20	62
DTX406032	3.2	6	20	62
DTX406033	3.3	6	20	62
DTX406034	3.4	6	20	62
DTX406035	3.5	6	20	62
DTX406036	3.6	6	20	62
DTX406037	3.7	6	20	62
DTX406038	3.8	6	24	66
DTX406039	3.9	6	24	66
DTX406040	4.0	6	24	66
DTX406041	4.1	6	24	66
DTX406042	4.2	6	24	66
DTX406043	4.3	6	24	66
DTX406044	4.4	6	24	66
DTX406045	4.5	6	24	66
DTX406046	4.6	6	24	66
DTX406047	4.7	6	24	66
DTX406048	4.8	6	28	66
DTX406049	4.9	6	28	66
DTX406050	5.0	6	28	66
DTX406051	5.1	6	28	66
DTX406052	5.2	6	28	66
DTX406053	5.3	6	28	66
DTX406054	5.4	6	28	66
DTX406055	5.5	6	28	66
DTX406056	5.6	6	28	66
DTX406057	5.7	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406058	5.8	6	28	66
DTX406059	5.9	6	28	66
DTX406060	6.0	6	28	66
DTX406061	6.1	8	34	79
DTX406062	6.2	8	34	79
DTX406063	6.3	8	34	79
DTX406064	6.4	8	34	79
DTX406065	6.5	8	34	79
DTX406066	6.6	8	34	79
DTX406067	6.7	8	34	79
DTX406068	6.8	8	34	79
DTX406069	6.9	8	34	79
DTX406070	7.0	8	34	79
DTX406071	7.1	8	41	79
DTX406072	7.2	8	41	79
DTX406073	7.3	8	41	79
DTX406074	7.4	8	41	79
DTX406075	7.5	8	41	79
DTX406076	7.6	8	41	79
DTX406077	7.7	8	41	79
DTX406078	7.8	8	41	79
DTX406079	7.9	8	41	79
DTX406080	8.0	8	41	79
DTX406081	8.1	10	47	89
DTX406082	8.2	10	47	89
DTX406083	8.3	10	47	89
DTX406084	8.4	10	47	89
DTX406085	8.5	10	47	89

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (3XD)

SERIES NEW DTX406

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating | p.41

SHORT 3× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406086	8.6	10	47	89
DTX406087	8.7	10	47	89
DTX406088	8.8	10	47	89
DTX406089	8.9	10	47	89
DTX406090	9.0	10	47	89
DTX406091	9.1	10	47	89
DTX406092	9.2	10	47	89
DTX406093	9.3	10	47	89
DTX406094	9.4	10	47	89
DTX406095	9.5	10	47	89
DTX406096	9.6	10	47	89
DTX406097	9.7	10	47	89
DTX406098	9.8	10	47	89
DTX406099	9.9	10	47	89
DTX406100	10.0	10	47	89
DTX406101	10.1	12	55	102
DTX406102	10.2	12	55	102
DTX406103	10.3	12	55	102
DTX406104	10.4	12	55	102
DTX406105	10.5	12	55	102
DTX406106	10.6	12	55	102
DTX406107	10.7	12	55	102
DTX406108	10.8	12	55	102
DTX406109	10.9	12	55	102
DTX406110	11.0	12	55	102
DTX406111	11.1	12	55	102
DTX406112	11.2	12	55	102
DTX406113	11.3	12	55	102

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX406114	11.4	12	55	102
DTX406115	11.5	12	55	102
DTX406116	11.6	12	55	102
DTX406117	11.7	12	55	102
DTX406118	11.8	12	55	102
DTX406119	11.9	12	55	102
DTX406120	12.0	12	55	102
DTX406125	12.5	14	60	107
DTX406130	13.0	14	60	107
DTX406135	13.5	14	60	107
DTX406140	14.0	14	60	107
DTX406145	14.5	16	65	115
DTX406150	15.0	16	65	115
DTX406155	15.5	16	65	115
DTX406160	16.0	16	65	115
DTX406165	16.5	18	73	123
DTX406170	17.0	18	73	123
DTX406175	17.5	18	73	123
DTX406180	18.0	18	73	123
DTX406185	18.5	20	79	131
DTX406190	19.0	20	79	131
DTX406195	19.5	20	79	131
DTX406200	20.0	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (5XD)

SERIES NEW DTX408

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating | p.41

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408010	1.0	3	8	55
DTX408011	1.1	3	12	55
DTX408012	1.2	3	12	55
DTX408013	1.3	3	12	55
DTX408014	1.4	3	12	55
DTX408015	1.5	3	16	55
DTX408016	1.6	3	16	55
DTX408017	1.7	3	16	55
DTX408018	1.8	3	16	55
DTX408019	1.9	3	16	55
DTX408020	2.0	4	21	57
DTX408021	2.1	4	21	57
DTX408022	2.2	4	21	57
DTX408023	2.3	4	21	57
DTX408024	2.4	4	21	57
DTX408025	2.5	4	21	57
DTX408026	2.6	4	21	57
DTX408027	2.7	4	21	57
DTX408028	2.8	4	21	57
DTX408029	2.9	4	21	57
DTX408030	3.0	6	28	66
DTX408031	3.1	6	28	66
DTX408032	3.2	6	28	66
DTX408033	3.3	6	28	66
DTX408034	3.4	6	28	66
DTX408035	3.5	6	28	66
DTX408036	3.6	6	28	66
DTX408037	3.7	6	28	66

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408038	3.8	6	36	74
DTX408039	3.9	6	36	74
DTX408040	4.0	6	36	74
DTX408041	4.1	6	36	74
DTX408042	4.2	6	36	74
DTX408043	4.3	6	36	74
DTX408044	4.4	6	36	74
DTX408045	4.5	6	36	74
DTX408046	4.6	6	36	74
DTX408047	4.7	6	36	74
DTX408048	4.8	6	44	82
DTX408049	4.9	6	44	82
DTX408050	5.0	6	44	82
DTX408051	5.1	6	44	82
DTX408052	5.2	6	44	82
DTX408053	5.3	6	44	82
DTX408054	5.4	6	44	82
DTX408055	5.5	6	44	82
DTX408056	5.6	6	44	82
DTX408057	5.7	6	44	82
DTX408058	5.8	6	44	82
DTX408059	5.9	6	44	82
DTX408060	6.0	6	44	82
DTX408061	6.1	8	53	91
DTX408062	6.2	8	53	91
DTX408063	6.3	8	53	91
DTX408064	6.4	8	53	91
DTX408065	6.5	8	53	91

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (5XD)

SERIES NEW DTX408

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating | p.41

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408066	6.6	8	53	91
DTX408067	6.7	8	53	91
DTX408068	6.8	8	53	91
DTX408069	6.9	8	53	91
DTX408070	7.0	8	53	91
DTX408071	7.1	8	53	91
DTX408072	7.2	8	53	91
DTX408073	7.3	8	53	91
DTX408074	7.4	8	53	91
DTX408075	7.5	8	53	91
DTX408076	7.6	8	53	91
DTX408077	7.7	8	53	91
DTX408078	7.8	8	53	91
DTX408079	7.9	8	53	91
DTX408080	8.0	8	53	91
DTX408081	8.1	10	61	103
DTX408082	8.2	10	61	103
DTX408083	8.3	10	61	103
DTX408084	8.4	10	61	103
DTX408085	8.5	10	61	103
DTX408086	8.6	10	61	103
DTX408087	8.7	10	61	103
DTX408088	8.8	10	61	103
DTX408089	8.9	10	61	103
DTX408090	9.0	10	61	103
DTX408091	9.1	10	61	103
DTX408092	9.2	10	61	103
DTX408093	9.3	10	61	103

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408094	9.4	10	61	103
DTX408095	9.5	10	61	103
DTX408096	9.6	10	61	103
DTX408097	9.7	10	61	103
DTX408098	9.8	10	61	103
DTX408099	9.9	10	61	103
DTX408100	10.0	10	61	103
DTX408101	10.1	12	71	118
DTX408102	10.2	12	71	118
DTX408103	10.3	12	71	118
DTX408104	10.4	12	71	118
DTX408105	10.5	12	71	118
DTX408106	10.6	12	71	118
DTX408107	10.7	12	71	118
DTX408108	10.8	12	71	118
DTX408109	10.9	12	71	118
DTX408110	11.0	12	71	118
DTX408111	11.1	12	71	118
DTX408112	11.2	12	71	118
DTX408113	11.3	12	71	118
DTX408114	11.4	12	71	118
DTX408115	11.5	12	71	118
DTX408116	11.6	12	71	118
DTX408117	11.7	12	71	118
DTX408118	11.8	12	71	118
DTX408119	11.9	12	71	118
DTX408120	12.0	12	71	118
DTX408125	12.5	14	77	124

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled CastIron	Hardened CastIron
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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (5XD)

SERIES NEW DTX408

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating | p.41

LONG 5× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408130	13.0	14	77	124
DTX408135	13.5	14	77	124
DTX408140	14.0	14	77	124
DTX408145	14.5	16	83	133
DTX408150	15.0	16	83	133
DTX408155	15.5	16	83	133
DTX408160	16.0	16	83	133
DTX408165	16.5	18	93	143

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX408170	17.0	18	93	143
DTX408175	17.5	18	93	143
DTX408180	18.0	18	93	143
DTX408185	18.5	20	101	153
DTX408190	19.0	20	101	153
DTX408195	19.5	20	101	153
DTX408200	20.0	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled CastIron	Hardened CastIron
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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (8XD)

SERIES NEW DTX421

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation

DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating

p.41

EXTRA LONG 8× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421030	3.0	6	34	72
DTX421031	3.1	6	34	72
DTX421032	3.2	6	34	72
DTX421033	3.3	6	34	72
DTX421034	3.4	6	34	72
DTX421035	3.5	6	34	72
DTX421036	3.6	6	34	72
DTX421037	3.7	6	34	72
DTX421038	3.8	6	43	81
DTX421039	3.9	6	43	81
DTX421040	4.0	6	43	81
DTX421041	4.1	6	43	81
DTX421042	4.2	6	43	81
DTX421043	4.3	6	43	81
DTX421044	4.4	6	43	81
DTX421045	4.5	6	43	81
DTX421046	4.6	6	43	81
DTX421047	4.7	6	43	81
DTX421048	4.8	6	57	95
DTX421049	4.9	6	57	95
DTX421050	5.0	6	57	95
DTX421051	5.1	6	57	95
DTX421052	5.2	6	57	95
DTX421053	5.3	6	57	95
DTX421054	5.4	6	57	95
DTX421055	5.5	6	57	95
DTX421056	5.6	6	57	95
DTX421057	5.7	6	57	95

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421058	5.8	6	57	95
DTX421059	5.9	6	57	95
DTX421060	6.0	6	57	95
DTX421061	6.1	8	76	114
DTX421062	6.2	8	76	114
DTX421063	6.3	8	76	114
DTX421064	6.4	8	76	114
DTX421065	6.5	8	76	114
DTX421066	6.6	8	76	114
DTX421067	6.7	8	76	114
DTX421068	6.8	8	76	114
DTX421069	6.9	8	76	114
DTX421070	7.0	8	76	114
DTX421071	7.1	8	76	114
DTX421072	7.2	8	76	114
DTX421073	7.3	8	76	114
DTX421074	7.4	8	76	114
DTX421075	7.5	8	76	114
DTX421076	7.6	8	76	114
DTX421077	7.7	8	76	114
DTX421078	7.8	8	76	114
DTX421079	7.9	8	76	114
DTX421080	8.0	8	76	114
DTX421081	8.1	10	95	142
DTX421082	8.2	10	95	142
DTX421083	8.3	10	95	142
DTX421084	8.4	10	95	142
DTX421085	8.5	10	95	142

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P																			
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

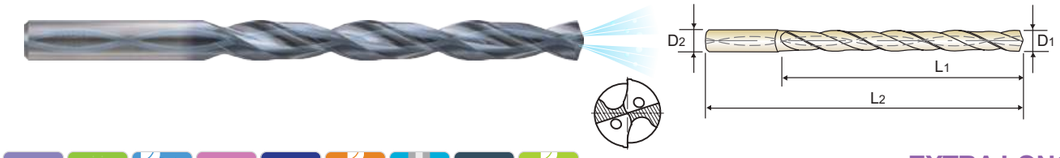
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze /Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

RCH-COATED SOLID CARBIDE

DREAM DRILL X with COOLANT HOLES (8XD)

SERIES NEW DTX421

- Upgraded coating for higher Tool Life in various materials
- Soft cutting action and reduced axial forces; Easy to Recondition
- Good self-centering even at low feed rates and unstable situations
- Excellent Chip breaking and chip evacuation



DIN 6537 | CARBIDE | 30° | h6 | m7 | 140° | 20 bar | RCH Coating

p.41

EXTRA LONG 8× D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421086	8.6	10	95	142
DTX421087	8.7	10	95	142
DTX421088	8.8	10	95	142
DTX421089	8.9	10	95	142
DTX421090	9.0	10	95	142
DTX421091	9.1	10	95	142
DTX421092	9.2	10	95	142
DTX421093	9.3	10	95	142
DTX421094	9.4	10	95	142
DTX421095	9.5	10	95	142
DTX421096	9.6	10	95	142
DTX421097	9.7	10	95	142
DTX421098	9.8	10	95	142
DTX421099	9.9	10	95	142
DTX421100	10.0	10	95	142
DTX421101	10.1	12	114	162
DTX421102	10.2	12	114	162
DTX421103	10.3	12	114	162
DTX421104	10.4	12	114	162
DTX421105	10.5	12	114	162
DTX421106	10.6	12	114	162
DTX421107	10.7	12	114	162
DTX421108	10.8	12	114	162
DTX421109	10.9	12	114	162
DTX421110	11.0	12	114	162
DTX421111	11.1	12	114	162
DTX421112	11.2	12	114	162
DTX421113	11.3	12	114	162

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
RCH-Coating	D1	D2	L1	L2
DTX421114	11.4	12	114	162
DTX421115	11.5	12	114	162
DTX421116	11.6	12	114	162
DTX421117	11.7	12	114	162
DTX421118	11.8	12	114	162
DTX421119	11.9	12	114	162
DTX421120	12.0	12	114	162
DTX421125	12.5	14	133	178
DTX421130	13.0	14	133	178
DTX421135	13.5	14	133	178
DTX421140	14.0	14	133	178

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

ISO	P																			
Material Description	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		◎	◎	◎	○	◎	◎	○	○	◎	○	○	○		◎	○	◎	○	◎	○

ISO	N										S							H			
Material Description	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	400 Rm	1050 Rm	550	630	400	550
Recommended																		○			

DTX404, DTX423, DTX424 SERIES without COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm) 1.0	2.0	3.0	4.0	5.0	6.0
P	2	Non-alloy steel	70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	3		70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	4		70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	5		60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	6	Low alloy steel	70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	7		60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	8		60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.02-0.04	0.03-0.05	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	9		30	RPM	9550	4770	4240	3180	2550	2120
				FEED	0.02-0.04	0.03-0.05	0.03-0.08	0.05-0.11	0.08-0.14	0.10-0.16
	10	High alloyed steel, and tool steel	50	RPM	15920	7960	7430	5570	4460	3710
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	11		30	RPM	9550	4770	4240	3180	2550	2120
				FEED	0.02-0.04	0.03-0.05	0.03-0.08	0.05-0.11	0.08-0.14	0.10-0.16
M	12	Stainless steel	50	RPM	15920	7960	7430	5570	4460	3710
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	13		35	RPM	11140	5570	4770	3580	2860	2390
				FEED	0.02-0.04	0.03-0.05	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
K	15	Grey cast iron	70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	16		65	RPM	20690	10350	8490	6370	5090	4240
				FEED	0.04-0.06	0.04-0.06	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	17	Nodular cast iron	70	RPM	22280	11140	10610	7960	6370	5310
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	18		50	RPM	15920	7960	7430	5570	4460	3710
				FEED	0.04-0.06	0.04-0.06	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	19	Malleable cast iron	60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	20		50	RPM	15920	7960	7430	5570	4460	3710
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
H	38	Hardened steel	20	RPM	6370	3180	2650	1990	1590	1330
				FEED	0.01-0.02	0.01-0.03	0.01-0.03	0.01-0.04	0.02-0.05	0.03-0.06

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm) 8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	2	Non-alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	3		100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	4		100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	5		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	6	Low alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	7		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	8		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	9		40	RPM	1590	1270	1060	910	800	710	640
				FEED	0.12-0.18	0.13-0.19	0.14-0.20	0.15-0.21	0.16-0.22	0.17-0.25	0.18-0.28
	10	High alloyed steel, and tool steel	70	RPM	2790	2230	1860	1590	1390	1240	1110
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	11		40	RPM	1590	1270	1060	910	800	710	640
				FEED	0.12-0.18	0.13-0.19	0.14-0.20	0.15-0.21	0.16-0.22	0.17-0.25	0.18-0.28
M	12	Stainless steel	70	RPM	2790	2230	1860	1590	1390	1240	1110
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	13		45	RPM	1790	1430	1190	1020	900	800	720
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
K	15	Grey cast iron	100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	16		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	17	Nodular cast iron	100	RPM	3980	3180	2650	2270	1990	1770	1590
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	18		70	RPM	2790	2230	1860	1590	1390	1240	1110
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	19	Malleable cast iron	80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	20		70	RPM	2790	2230	1860	1590	1390	1240	1110
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
H	38	Hardened steel	25	RPM	990	800	660	570	500	440	400
				FEED	0.03-0.06	0.04-0.07	0.04-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10

▶ Recommend to reduce the feed rate as following **Feed 100%** : DTX404(3×D), DTX423(3×D), DTX424(5×D)

DTX406, DTX408, DTX421 SERIES with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm) 1.0	2.0	3.0	4.0	5.0	6.0
P	2	Non-alloy steel	80	RPM	25460	12730	11670	8750	7000	5840
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	3		80	RPM	25460	12730	11670	8750	7000	5840
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	4		80	RPM	25460	12730	11670	8750	7000	5840
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	5		70	RPM	22280	11140	9550	7160	5730	4770
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	6	Low alloy steel	80	RPM	25460	12730	11670	8750	7000	5840
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	7		70	RPM	22280	11140	9550	7160	5730	4770
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	8		70	RPM	22280	11140	9550	7160	5730	4770
				FEED	0.02-0.04	0.03-0.05	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	9		40	RPM	12730	6370	5310	3980	3180	2650
				FEED	0.02-0.04	0.03-0.05	0.03-0.08	0.05-0.11	0.08-0.14	0.10-0.16
	10	High alloyed steel, and tool steel	60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.03-0.05	0.05-0.07	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
	11		40	RPM	12730	6370	4770	3580	2860	2390
				FEED	0.02-0.04	0.03-0.05	0.03-0.08	0.05-0.11	0.08-0.14	0.10-0.16
M	12	Stainless steel	60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	13		45	RPM	14320	7160	5840	4380	3500	2920
				FEED	0.02-0.04	0.03-0.05	0.04-0.10	0.07-0.13	0.10-0.16	0.12-0.18
K	15	Grey cast iron	80	RPM	25460	12730	11670	8750	7000	5840
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	16		75	RPM	23870	11940	10080	7560	6050	5040
				FEED	0.04-0.06	0.04-0.06	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	17	Nodular cast iron	90	RPM	28650	14320	12730	9550	7640	6370
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	18		60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.04-0.06	0.04-0.06	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
	19	Malleable cast iron	70	RPM	22280	11140	9550	7160	5730	4770
				FEED	0.04-0.06	0.04-0.06	0.08-0.14	0.12-0.18	0.15-0.22	0.20-0.26
	20		60	RPM	19100	9550	8490	6370	5090	4240
				FEED	0.03-0.05	0.05-0.07	0.06-0.12	0.08-0.14	0.14-0.20	0.16-0.22
H	38	Hardened steel	25	RPM	7960	3980	3180	2390	1910	1590
				FEED	0.01-0.02	0.01-0.03	0.01-0.03	0.01-0.04	0.02-0.05	0.03-0.06

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm) 8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	2	Non-alloy steel	110	RPM	4380	3500	2920	2500	2190	1950	1750
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	3		110	RPM	4380	3500	2920	2500	2190	1950	1750
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	4		110	RPM	4380	3500	2920	2500	2190	1950	1750
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	5		90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	6	Low alloy steel	110	RPM	4380	3500	2920	2500	2190	1950	1750
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	7		90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	8		90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	9		50	RPM	1990	1590	1330	1140	990	880	800
				FEED	0.12-0.18	0.13-0.19	0.14-0.20	0.15-0.21	0.16-0.22	0.17-0.25	0.18-0.28
	10	High alloyed steel, and tool steel	80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
	11		45	RPM	1790	1430	1190	1020	900	800	720
				FEED	0.12-0.18	0.13-0.19	0.14-0.20	0.15-0.21	0.16-0.22	0.17-0.25	0.18-0.28
M	12	Stainless steel	80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	13		55	RPM	2190	1750	1460	1250	1090	970	880
				FEED	0.14-0.20	0.15-0.23	0.17-0.25	0.18-0.26	0.19-0.27	0.20-0.30	0.22-0.32
K	15	Grey cast iron	110	RPM	4380	3500	2920	2500	2190	1950	1750
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	16		95	RPM	3780	3020	2520	2160	1890	1680	1510
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	17	Nodular cast iron	120	RPM	4770	3820	3180	2730	2390	2120	1910
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	18		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
	19	Malleable cast iron	90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.22-0.28	0.25-0.33	0.27-0.35	0.29-0.37	0.31-0.39	0.32-0.42	0.34-0.44
	20		80	RPM	3180	2550	2120	1820	1590	1410	1270
				FEED	0.18-0.24	0.19-0.27	0.21-0.29	0.23-0.31	0.25-0.33	0.28-0.38	0.30-0.40
H	38	Hardened steel	30	RPM	1190	950	800	680	600	530	480
				FEED	0.03-0.06	0.04-0.07	0.04-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10

▶ Recommend to reduce the feed rate as following **Feed 100%** : DTX406(3×D), DTX408(5×D) **Feed 75%** : DTX421(8×D)