



Leading Through Innovation



HSS & HSS-E

GOLD-P DRILLS

GOLD-P BOHRER

- Same Performance as Full TiN-coated Drills
- Gleiche Leistung, wie bei voll TiN-beschichteten Bohrern

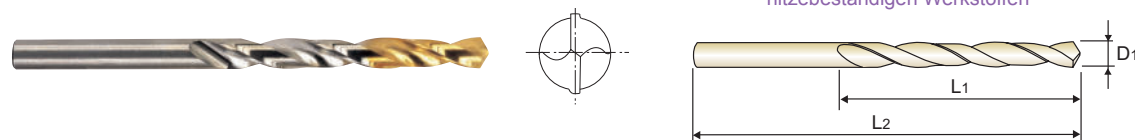


D1GP125 SERIES

JOBBER

COURTE

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 118° Normalanschiff
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Bohren von unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP125062	6.2	63	101	D1GP125088	8.8	81	125
D1GP125063	6.3	63	101	D1GP125089	8.9	81	125
D1GP125064	6.4	63	101	D1GP125090	9.0	81	125
D1GP125065	6.5	63	101	D1GP125091	9.1	81	125
D1GP125066	6.6	63	101	D1GP125092	9.2	81	125
D1GP125067	6.7	63	101	D1GP125093	9.3	81	125
D1GP125068	6.8	69	109	D1GP125094	9.4	81	125
D1GP125069	6.9	69	109	D1GP125095	9.5	81	125
D1GP125070	7.0	69	109	D1GP125096	9.6	87	133
D1GP125071	7.1	69	109	D1GP125097	9.7	87	133
D1GP125072	7.2	69	109	D1GP125098	9.8	87	133
D1GP125073	7.3	69	109	D1GP125099	9.9	87	133
D1GP125074	7.4	69	109	D1GP125100	10.0	87	133
D1GP125075	7.5	69	109	D1GP125101	10.1	87	133
D1GP125076	7.6	75	117	D1GP125102	10.2	87	133
D1GP125077	7.7	75	117	D1GP125103	10.3	87	133
D1GP125078	7.8	75	117	D1GP125104	10.4	87	133
D1GP125079	7.9	75	117	D1GP125105	10.5	87	133
D1GP125080	8.0	75	117	D1GP125106	10.6	87	133
D1GP125081	8.1	75	117	D1GP125107	10.7	94	142
D1GP125082	8.2	75	117	D1GP125108	10.8	94	142
D1GP125083	8.3	75	117	D1GP125109	10.9	94	142
D1GP125084	8.4	75	117	D1GP125110	11.0	94	142
D1GP125085	8.5	75	117	D1GP125111	11.1	94	142
D1GP125086	8.6	81	125	D1GP125112	11.2	94	142
D1GP125087	8.7	81	125	D1GP125113	11.3	94	142

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ISO	P										M					K							
Material Description	Non-alloy steel					Low alloy steel				High alloy 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	○	○	○						○							○							

A195

CARBIDE

HSS

GOLD-P DRILLS

D1GP125

SERIES

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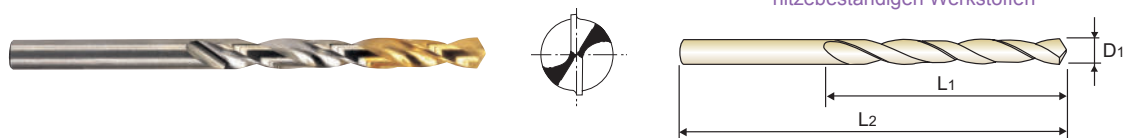


D1GP165 SERIES

JOBBER

**KURZ
COURTE
CORTA**

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 118° Normalanschliff
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Bohren von unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP165120	12.0	101	151	D1GP165126	12.6	101	151
D1GP165121	12.1	101	151	D1GP165127	12.7	101	151
D1GP165122	12.2	101	151	D1GP165128	12.8	101	151
D1GP165123	12.3	101	151	D1GP165129	12.9	101	151
D1GP165124	12.4	101	151	D1GP165130	13.0	101	151
D1GP165125	12.5	101	151				

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																				◎ : 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	36	37	55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○						○							○							

A199



DLGP195 SERIES

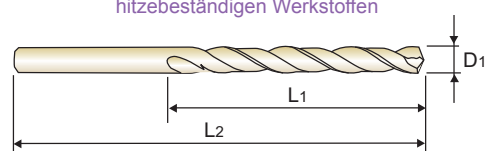
JOBBER

KURZ

COURTE

CORTA

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 135°, unter 1.6mm : Normalanschliff
1.6mm & über : Kreuzanschliff
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Bohren tiefer Bohrungen in unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



under 1.6mm 1.6mm & over



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DLGP195062	6.2	63	101	DLGP195088	8.8	81	125
DLGP195063	6.3	63	101	DLGP195089	8.9	81	125
DLGP195064	6.4	63	101	DLGP195090	9.0	81	125
DLGP195065	6.5	63	101	DLGP195091	9.1	81	125
DLGP195066	6.6	63	101	DLGP195092	9.2	81	125
DLGP195067	6.7	63	101	DLGP195093	9.3	81	125
DLGP195068	6.8	69	109	DLGP195094	9.4	81	125
DLGP195069	6.9	69	109	DLGP195095	9.5	81	125
DLGP195070	7.0	69	109	DLGP195096	9.6	87	133
DLGP195071	7.1	69	109	DLGP195097	9.7	87	133
DLGP195072	7.2	69	109	DLGP195098	9.8	87	133
DLGP195073	7.3	69	109	DLGP195099	9.9	87	133
DLGP195074	7.4	69	109	DLGP195100	10.0	87	133
DLGP195075	7.5	69	109	DLGP195101	10.1	87	133
DLGP195076	7.6	75	117	DLGP195102	10.2	87	133
DLGP195077	7.7	75	117	DLGP195103	10.3	87	133
DLGP195078	7.8	75	117	DLGP195104	10.4	87	133
DLGP195079	7.9	75	117	DLGP195105	10.5	87	133
DLGP195080	8.0	75	117	DLGP195106	10.6	87	133
DLGP195081	8.1	75	117	DLGP195107	10.7	94	142
DLGP195082	8.2	75	117	DLGP195108	10.8	94	142
DLGP195083	8.3	75	117	DLGP195109	10.9	94	142
DLGP195084	8.4	75	117	DLGP195110	11.0	94	142
DLGP195085	8.5	75	117	DLGP195111	11.1	94	142
DLGP195086	8.6	81	125	DLGP195112	11.2	94	142
DLGP195087	8.7	81	125	DLGP195113	11.3	94	142

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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	○	○	○						○							○							

A201



DLGP506 SERIES

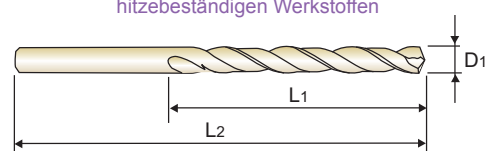
JOBBER

KURZ

COURTE

CORTA

- ▶ **Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
- ▶ **Spitzenwinkel** : Durch 130° Kreuzanschliff Gute Spanabfuhr
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Tieflochbohren in unlegierten und legierten Stählen sowie Gusseisen mit aktiver Unterstützung bei der Spanabfuhr



under 1.6mm 1.6mm & over



► **DH100**
worm pattern drills



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DLGP506020	2.0	24	49	DLGP506046	4.6	47	80
DLGP506021	2.1	24	49	DLGP506047	4.7	47	80
DLGP506022	2.2	27	53	DLGP506048	4.8	52	86
DLGP506023	2.3	27	53	DLGP506049	4.9	52	86
DLGP506024	2.4	30	57	DLGP506050	5.0	52	86
DLGP506025	2.5	30	57	DLGP506051	5.1	52	86
DLGP506026	2.6	30	57	DLGP506052	5.2	52	86
DLGP506027	2.7	33	61	DLGP506053	5.3	52	86
DLGP506028	2.8	33	61	DLGP506054	5.4	57	93
DLGP506029	2.9	33	61	DLGP506055	5.5	57	93
DLGP506030	3.0	33	61	DLGP506056	5.6	57	93
DLGP506031	3.1	36	65	DLGP506057	5.7	57	93
DLGP506032	3.2	36	65	DLGP506058	5.8	57	93
DLGP506033	3.3	36	65	DLGP506059	5.9	57	93
DLGP506034	3.4	39	70	DLGP506060	6.0	57	93
DLGP506035	3.5	39	70	DLGP506061	6.1	63	101
DLGP506036	3.6	39	70	DLGP506062	6.2	63	101
DLGP506037	3.7	39	70	DLGP506063	6.3	63	101
DLGP506038	3.8	43	75	DLGP506064	6.4	63	101
DLGP506039	3.9	43	75	DLGP506065	6.5	63	101
DLGP506040	4.0	43	75	DLGP506066	6.6	63	101
DLGP506041	4.1	43	75	DLGP506067	6.7	63	101
DLGP506042	4.2	43	75	DLGP506068	6.8	69	109
DLGP506043	4.3	47	80	DLGP506069	6.9	69	109
DLGP506044	4.4	47	80	DLGP506070	7.0	69	109
DLGP506045	4.5	47	80	DLGP506071	7.1	69	109

▶ 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	○	○	○						○							○					

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YG YG-1 CO., LTD.

◎: Excellent ○: Good

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YG-1 CO., LTD.

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions

A203

CARBIDE

HSS

GOLD-P DRILLS

DLGP506

SERIES

HSS-E, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED

HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET

Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte

PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

JOBBER

KURZ

COURTE

CORTA

►Flute Geometry

: Right hand, 38° helix, DH100 worm pattern type.

►Point Angle

: 130°, Split point giving higher chip removal.

►Surface treatment

: Bright body, TiN coating on working area.

►Application

: Deep hole drilling in unalloyed and alloyed steels as well as cast irons that require support during chip removal

►Nutenform

: 38° Rechtsspirale, DH 100 Flachnut

►Spitzenwinkel

: Durch 130° Kreuzanschliff Gute Spanabfuhr

►Oberfläche

: Blank mit TiN-Beschichtung im Arbeitsbereich

►Anwendung

: Tieflochbohren in unlegierten und legierten Stählen sowie Gusseisen mit aktiver Unterstützung bei der Spanabfuhr

►DH100

worm pattern drills

DIN 338

HSS-E

38°

h8

130°

TiN

p.A207

Plain Shank

Recommended ToolHolder

ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506072	7.2	69	109
DLGP506073	7.3	69	109
DLGP506074	7.4	69	109
DLGP506075	7.5	69	109
DLGP506076	7.6	75	117
DLGP506077	7.7	75	117
DLGP506078	7.8	75	117
DLGP506079	7.9	75	117
DLGP506080	8.0	75	117
DLGP506081	8.1	75	117
DLGP506082	8.2	75	117
DLGP506083	8.3	75	117
DLGP506084	8.4	75	117
DLGP506085	8.5	75	117
DLGP506086	8.6	81	125
DLGP506087	8.7	81	125
DLGP506088	8.8	81	125
DLGP506089	8.9	81	125
DLGP506090	9.0	81	125
DLGP506091	9.1	81	125
DLGP506092	9.2	81	125
DLGP506093	9.3	81	125
DLGP506094	9.4	81	125
DLGP506095	9.5	81	125
DLGP506096	9.6	87	133
DLGP506097	9.7	87	133

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506098	9.8	87	133
DLGP506099	9.9	87	133
DLGP506100	10.0	87	133
DLGP506101	10.1	87	133
DLGP506102	10.2	87	133
DLGP506103	10.3	87	133
DLGP506104	10.4	87	133
DLGP506105	10.5	87	133
DLGP506106	10.6	87	133
DLGP506107	10.7	94	142
DLGP506108	10.8	94	142
DLGP506109	10.9	94	142
DLGP506110	11.0	94	142
DLGP506111	11.1	94	142
DLGP506112	11.2	94	142
DLGP506113	11.3	94	142
DLGP506114	11.4	94	142
DLGP506115	11.5	94	142
DLGP506116	11.6	94	142
DLGP506117	11.7	94	142
DLGP506118	11.8	94	142
DLGP506119	11.9	101	151
DLGP506120	12.0	101	151
DLGP506121	12.1	101	151
DLGP506122	12.2	101	151
DLGP506123	12.3	101	151

Unit : mm

◎ : Excellent ○ : Good

◎ : Excellent ○ : Good

ISO

Material Description

VDI 3323

HRC

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

K

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

H

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

300

180

275

300

350

200

325

200

240

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N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

H

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

550

630

400

41

55

550

Recommended

Recommended

Recommended

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YG-1 CO., LTD.

CARBIDE

HSS

GOLD-P DRILLS

DLGP506

SERIES

HSS-E, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED

HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET

Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte

PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

JOBBER

KURZ

COURTE

CORTA

►Flute Geometry

: Right hand, 38° helix, DH100 worm pattern type.

►Point Angle

: 130°, Split point giving higher chip removal.

►Surface treatment

: Bright body, TiN coating on working area.

►Application

: Deep hole drilling in unalloyed and alloyed steels as well as cast irons that require support during chip removal

►Nutenform

: 38° Rechtsspirale, DH 100 Flachnut

►Spitzenwinkel

: Durch 130° Kreuzanschliff Gute Spanabfuhr

►Oberfläche

: Blank mit TiN-Beschichtung im Arbeitsbereich

►Anwendung

: Tieflochbohren in unlegierten und legierten Stählen sowie Gusseisen mit aktiver Unterstützung bei der Spanabfuhr

►DH100

worm pattern drills

DIN 338

HSS-E

38°

h8

130°

TiN

p.A207

Plain Shank

Recommended ToolHolder

ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506124	12.4	101	151
DLGP506125	12.5	101	151
DLGP506126	12.6	101	151
DLGP506127	12.7	101	151

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506128	12.8	101	151
DLGP506129	12.9	101	151
DLGP506130	13.0	101	151

Unit : mm

◎ : Excellent ○ : Good

◎ : Excellent ○ : Good

ISO

Material Description

VDI 3323

HRC

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

K

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

H

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

300

180

275

300

350

200

325

200

240

180

180

260

3

25

130

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N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

H

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

550

630

400

41

55

550

Recommended

Recommended

Recommended

Recommended

Recommended

Recommended

Recommended

Recommended

Recommended

Recommended

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Recommended

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A205

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YG-1 CO., LTD.



GOLD-P COATED DRILL SETS

- GOLD-P BESCHICHTET BOHRER SATS
- Coffrets de Forets GOLD-P revêtus
- SET DI PUNTE GOLD-P



DIN 338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

EDP No.	DESCRIPTON	SIZE	Q'TY
D1GP165SET1	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
D1GP165SET2	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
D1GP165SET3	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGP195SET1	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
DLGP195SET2	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
DLGP195SET3	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGPSET982	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.1mm step	91 pcs



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

D1GP125, D1GP165, DLGP195, DLGP506 SERIES

HSS & HSS-E GOLD-P DRILLS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)	Vc	Parameter	Drill Diameter (mm)						
					1.0			2.0	3.0	4.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
	2		25	FEED	0.01-0.03	35	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	3		20	RPM	7960	30	RPM	5570	3710	2790	1860	1390	1110	860
	4		15	FEED	0.01-0.03	20	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	6	Low alloy steel	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
	7		15	FEED	0.01-0.02	20	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	8		20	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
	10	High alloyed steel, and tool steel	20	FEED	0.01-0.03	30	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
M	12	Stainless steel	18	RPM	5730	25	RPM	4770	3180	2390	1590	1190	950	730
	13		15	FEED	0.01-0.03	20	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	14		10	RPM	4770	15	RPM	3180	2120	1590	1060	800	640	490
K	15	Grey cast iron	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
	16		25	FEED	0.01-0.03	35	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	17	Nodular cast iron	28	RPM	7960	40	RPM	5570	3710	2790	1860	1390	1110	860
	18		20	FEED	0.01-0.02	30	FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	19	Malleable cast iron	25	RPM	8910	35	RPM	6370	4240	3180	2120	1590	1270	980
	20		20	FEED	0.01-0.03	30	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
N	21	Aluminum-wrought alloy	45	RPM	14320	65	RPM	10350	6900	5170	3450	2590	2070	1590
	22		45	FEED	0.02-0.05	65	FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	23	Aluminum-cast, alloyed	35	RPM	14320	50	RPM	10350	6900	5170	3450	2590	2070	1590
	29	Non Metallic Materials	20	FEED	0.02-0.05	30	FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
S	36	Titanium Alloys	15	RPM	11140	20	RPM	7960	5310	3980	2650	1990	1590	1220
				FEED	0.02-0.03		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
					6370		RPM	4770	3180	2390	1590	1190	950	730
					0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
					4770		RPM	3180	2120	1590	1060	800	640	490
					0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.13	0.08-0.14