



Leading Through Innovation



HSS, HSS-E & HSSCo8

STRAIGHT SHANK DRILLS

BOHRER MIT ZYLINDERSCHAFT

- For General Purpose (Soft & Tough Materials)
- Für allgemeine Anwendungen (weiche & zähe Materialien)

SELECTION GUIDE



SERIES	D2107	D1107	D2105
STANDARD	DIN1897	DIN1897	DIN338
LENGTH	STUB	STUB	JOBBER
SIZE MIN	D1.0	D1.0	D1.0
SIZE MAX	D31.0	D13.0	D20.0
PAGE	A220	A224	A227

SURFACE TREATMENT	Gold Coloring	Steam Tempered	Gold Coloring
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HSS, HSS-E & HSSCo8
STRAIGHT SHANK
DRILLS

For General Purpose (Soft & Tough Materials)

Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A262

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc			
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	○	○	○
	5		About 0.75% C	Quenched & Tempered	300	32			
	6	Low alloy steel		Annealed	180	10	◎	◎	◎
	7			Quenched & Tempered	275	29	○	○	○
	8			Quenched & Tempered	300	32	○	○	○
	9			Quenched & Tempered	350	38			
	10	High alloyed steel, and tool steel		Annealed	200	15	○	○	○
	11			Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	◎	○	◎
	13		Martensitic	Quenched & Tempered	240	23	○	○	○
	14		Austenitic		180	10	○	○	○
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○
	16		Pearlitic (Martensitic)		260	26	○	○	○
	17	Nodular cast iron	Ferritic		160	3	○	○	○
	18		Pearlitic		250	25			
	19	Malleable cast iron	Ferritic		130		○	○	○
	20		Pearlitic		230	21			
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○
	22		Curable	Hardened	100		○	○	○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○
	24		≤ 12% Si, Curable	Hardened	90				
	25		> 12% Si, Not Curable		130				
	26	Copper and Copper Alloys	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90				
	28	Non Metallic Materials	CuSn, lead-free copper and electrolytic copper		100				
	29		Duroplastic, Fiber Reinforced Plastic				○	○	○
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15			
	32			Cured	280	30			
	33			Annealed	250	25			
	34		Ni or Co Based	Cured	350	38			
	35			Cast	320	34			
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○
	37		Alpha + Beta Alloys	Hardened	1050 Rm				
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42			
	41	Hardened Cast Iron		Hardened	550	55			

DL105	D1105	D1125	D2104	D1121	DL109	D1100	D1106
DIN338	DIN338	DIN338	DIN340	DIN1869/1	DIN338	DIN338	DIN338
JOBBER	JOBBER	JOBBER	LONG	EXTRA LONG	JOBBER	JOBBER	JOBBER
D1.0	D0.3	D2.0	D2.0	D2.0	D1.5	D1.5	D1.5
D20.0	D20.0	D20.0	D12.0	D13.0	D13.0	D13.0	D13.0
A230	A233	A238	A241	A243	A244	A245	A247
Gold Coloring	Steam Tempered	Bright	Gold Coloring	Steam Tempered	Bright		



◎	◎	◎	◎	◎	◎		1
◎	◎	◎	◎	◎	◎		2
◎	◎	◎	◎	◎	◎		3
○	○	○	○	○	○		4
							5
◎	◎	◎	◎	◎	◎		6 P
○	○	○	○	○	○		7
○	○	○	○	○	○		8
							9
○	○	○	○	○	○		10
							11
◎	○	○	◎	○	◎		12
○	○	○	○	○	○		13 M
○	○	○	○	○	○		14
○	○	○	○	○	○		15
○	○	○	○	○	○		16
○	○	○	○	○	○		17 K
							18
○	○	○	○	○	○		19
							20
○	○	○	○	○	○		21
○	○	○	○	○	○		22
○	○	○	○	○	○		23
							24
							25 N
							26
					◎		27
					◎		28
○	○	○	○	○	○		29
							30
							31
							32
							33
							34 S
							35
○	○	○	○	○	○		36
							37
							38
							39 H
							40
							41

SELECTION GUIDE



SERIES

STANDARD

LENGTH

SIZE MIN

SIZE MAX

PAGE

SURFACE TREATMENT

DH100 DL510	DH100 DL508	DH100 DL509
DIN1897	DIN338	DIN340
STUB	JOBBER	LONG
D2.0	D2.0	D2.0
D20.0	D16.0	D12.0
A249	A251	A253

Bright



HSS-E

STRAIGHT SHANK
DRILLS

For General Purpose (Soft & Tough Materials)



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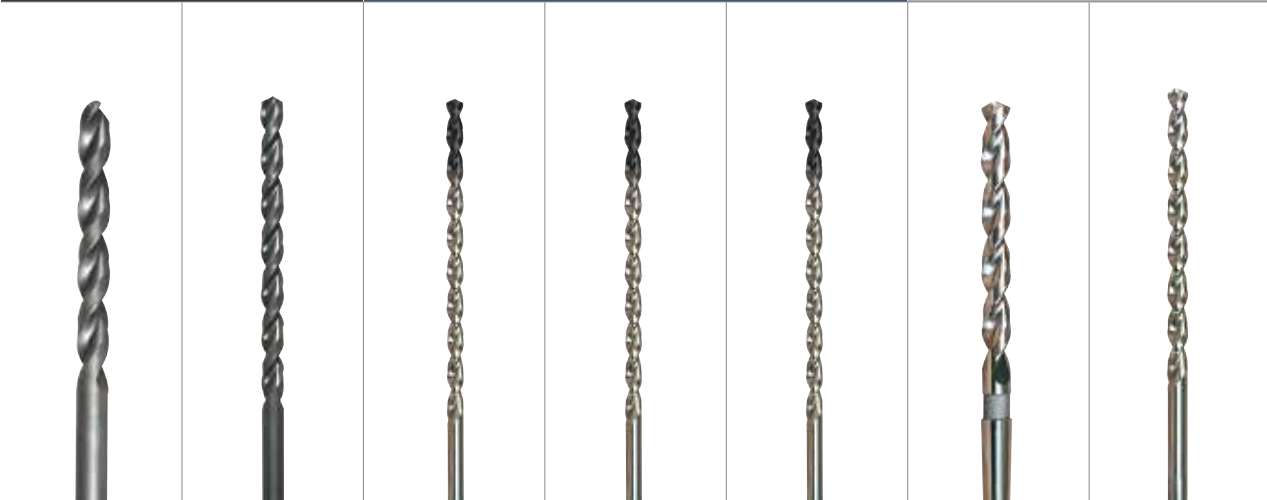
◎ : Excellent ○ : Good

Recommended cutting conditions : p.A262

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc			
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	○	○	○
	5		About 0.75% C	Quenched & Tempered	300	32			
	6	Low alloy steel		Annealed	180	10	◎	◎	◎
	7			Quenched & Tempered	275	29	○	○	○
	8			Quenched & Tempered	300	32	○	○	○
	9			Quenched & Tempered	350	38			
	10	High alloyed steel, and tool steel		Annealed	200	15	○	○	○
	11			Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15			
	13		Martensitic	Quenched & Tempered	240	23			
	14		Austenitic		180	10			
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○
	16		Pearlitic (Martensitic)		260	26	○	○	○
	17	Nodular cast iron	Ferritic		160	3	○	○	○
	18		Pearlitic		250	25	○	○	○
	19	Malleable cast iron	Ferritic		130		○	○	○
	20		Pearlitic		230	21	○	○	○
N	21	Aluminum- wrought alloy	Not Curable		60				◎
	22		Curable	Hardened	100				◎
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75				○
	24		≤ 12% Si, Curable	Hardened	90				
	25		> 12% Si, Not Curable		130				
	26	Copper and Copper Alloys	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90				
	28	Non Metallic Materials	CuSn, lead-free copper and electrolytic copper		100				
	29		Duroplastic, Fiber Reinforced Plastic						
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15			
	32			Cured	280	30			
	33		Ni or Co Based	Annealed	250	25			
	34			Cured	350	38			
	35			Cast	320	34			
	36	Titanium Alloys	Pure Titanium		400 Rm				
	37		Alpha + Beta Alloys	Hardened	1050 Rm				
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42			
	41	Hardened Cast Iron		Hardened	550	55			

DH100 DL505	DH100 DL504	DH100 DT600	DH100 DT692	DH100 DT693	DH100 DL608	DH50 DL507
DIN338	DIN340	DIN1869/1	DIN1869/2	DIN1869/3	DIN341	-
JOBBER	LONG	EXTRA LONG			LONG	EXTRA LONG
D2.0	D2.0	D2.0	D3.0	D4.0	D13.0	D2.0
D13.0	D13.0	D10.5	D10.2	D10.0	D30.0	D13.0
A255	A257	A258			A259	A260

Steam Tempered TiAIN Bright



◎	◎	◎	◎	◎	◎	○	1
◎	◎	◎	◎	◎	◎		2
◎	◎	◎	◎	◎	◎		3
○	○	○	○	○	○		4
							5
◎	◎	◎	◎	◎	◎		6 P
○	○	○	○	○	○		7
○	○	○	○	○	○		8
							9
○	○	○	○	○	○		10
							11
							12
							13 M
							14
○	○	○	○	○	○		15
○	○	○	○	○	○		16
○	○	○	○	○	○		17 K
○	○	○	○	○	○		18
○	○	○	○	○	○		19
○	○	○	○	○	○		20
						◎	21
						◎	22
						○	23
							24
							25 N
							26
							27
							28
							29
							30
							31
							32
							33
							34 S
							35
							36
							37
							38
							39 H
							40
							41

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

STUB

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

►Surface treatment : Coloring(Gold color)

►Application : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes

►Oberflächenbehandlung : Coloring(Goldfarbe)

►Verwendung : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

under 1.6mm

1.6mm & over

L1

L2

D1

DIN 1897

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Plain Shank

Page

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EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107010	1.0	6	26
D2107011	1.1	7	28
D2107012	1.2	8	30
D2107912	1.25	8	30
D2107013	1.3	8	30
D2107014	1.4	9	32
D2107015	1.5	9	32
D2107016	1.6	10	34
D2107017	1.7	10	34
D2107917	1.75	11	36
D2107018	1.8	11	36
D2107019	1.9	11	36
D2107020	2.0	12	38
D2107021	2.1	12	38
D2107022	2.2	13	40
D2107922	2.25	13	40
D2107023	2.3	13	40
D2107024	2.4	14	43
D2107025	2.5	14	43
D2107026	2.6	14	43
D2107027	2.7	16	46
D2107927	2.75	16	46
D2107028	2.8	16	46
D2107029	2.9	16	46
D2107030	3.0	16	46
D2107031	3.1	18	49

► HSS-E(DL107) is available on your request.

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : Excellent ○ : Good

ISO	P										M			K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
HRc	13	25	28	32	30	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										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
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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CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

STUB

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

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Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

under 1.6mm

1.6mm & over

L1

L2

D1

DIN 1897

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Plain Shank

Page

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EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107952	5.25	26	62
D2107053	5.3	26	62
D2107054	5.4	28	66
D2107055	5.5	28	66
D2107955	5.55	28	66
D2107056	5.6	28	66
D2107057	5.7	28	66
D2107957	5.75	28	66
D2107058	5.8	28	66
D2107059	5.9	28	66
D2107060	6.0	28	66
D2107061	6.1	31	70
D2107062	6.2	31	70
D2107962	6.25	31	70
D2107063	6.3	31	70
D2107064	6.4	31	70
D2107065	6.5	31	70
D2107066	6.6	31	70
D2107067	6.7	31	70
D2107967	6.75	34	74
D2107068	6.8	34	74
D2107069	6.9	34	74
D2107070	7.0	34	74
D2107071	7.1	34	74
D2107072	7.2	34	74
D2107972	7.25	34	74

► HSS-E(DL107) is available on your request.

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : Excellent ○ : Good

ISO	P										M			K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
HRc	13	25	28	32	30	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										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
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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CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment : Coloring(Gold color)

►Application : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes

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Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

under 1.6mm

1.6mm & over

L1

L2

D1

DIN 1897

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107993	9.35	40	84
D2107094	9.4	40	84
D2107095	9.5	40	84
D2107096	9.6	43	89
D2107097	9.7	43	89
D2107997	9.75	43	89
D2107098	9.8	43	89
D2107099	9.9	43	89
D2107100	10.0	43	89
D2107102	10.2	43	89
D2107802	10.25	43	89
D2107105	10.5	43	89
D2107807	10.75	47	95
D2107110	11.0	47	95
D2107812	11.25	47	95
D2107115	11.5	47	95
D2107817	11.75	47	95
D2107118	11.8	47	95
D2107120	12.0	51	102
D2107822	12.25	51	102
D2107125	12.5	51	102
D2107827	12.75	51	102
D2107130	13.0	51	102
D2107832	13.25	54	107
D2107135	13.5	54	107
D2107837	13.75	54	107

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Unit : mm

© : Excellent ○ : Good

ISO	P										M			K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
HRc	13	25	28	32	30	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										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron							
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	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-1 CO.,LTD.

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment : Coloring(Gold color)

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under 1.6mm

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L1

L2

D1

DIN 1897

HSS Co8

33°

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135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107205	20.5	68	136
D2107210	21.0	68	136
D2107215	21.5	70	141
D2107220	22.0	70	141
D2107225	22.5	72	146
D2107230	23.0	72	146
D2107235	23.5	72	146
D2107240	24.0	75	151

► HSS-E(DL107) is available on your request.

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

Unit : mm

© : Excellent ○ : Good

ISO	P										M			K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
HRc	13	25	28	32	30	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										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron							
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	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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CARBIDE

HSS

STRAIGHT SHANK DRILLS

D1107 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

HSS, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS, queue cylindrique, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment

Steam Tempered(Black Oxide Finish)

Bright Finish under 2mm

►Application

Suitable for drilling thin materials with portable electric drills.

Special twist drills for automatic and turret lathes.

►Oberflächenbehandlung

Steam Homo(Schwarzoxidation)

Helle Beschaffenheit unter 2mm

►Verwendung

Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.

Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

DIN 1897

HSS

N

20~30°

h8

118°

Vap

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107010	1.0	6	26
D1107011	1.1	7	28
D1107012	1.2	8	30
D1107912	1.25	8	30
D1107013	1.3	8	30
D1107014	1.4	9	32
D1107015	1.5	9	32
D1107016	1.6	9	34
D1107017	1.7	10	34
D1107917	1.75	11	36
D1107018	1.8	11	36
D1107019	1.9	11	36
D1107020	2.0	12	38
D1107021	2.1	12	38
D1107022	2.2	13	40
D1107922	2.25	13	40
D1107023	2.3	13	40
D1107024	2.4	14	43
D1107025	2.5	14	43
D1107026	2.6	14	43
D1107027	2.7	16	46
D1107927	2.75	16	46
D1107028	2.8	16	46
D1107029	2.9	16	46
D1107030	3.0	16	46
D1107031	3.1	18	49

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107032	3.2	18	49
D1107932	3.25	18	49
D1107033	3.3	18	49
D1107034	3.4	20	52
D1107035	3.5	20	52
D1107036	3.6	20	52
D1107037	3.7	20	52
D1107937	3.75	20	52
D1107038	3.8	22	55
D1107039	3.9	22	55
D1107040	4.0	22	55
D1107041	4.1	22	55
D1107042	4.2	22	55
D1107942	4.25	22	55
D1107043	4.3	24	58
D1107044	4.4	24	58
D1107045	4.5	24	58
D1107046	4.6	24	58
D1107047	4.7	24	58
D1107947	4.75	24	58
D1107048	4.8	26	62
D1107049	4.9	26	62
D1107050	5.0	26	62
D1107051	5.1	26	62
D1107052	5.2	26	62
D1107952	5.25	26	62

Unit : mm

◎ : 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

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

160

250

130

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ISO

Material Description

VDI 3323

HRc

HB

Recommended

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

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

55

60

42

55

550

○

○

○

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HSS, STRAIGHT SHANK TWIST DRILLS

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PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment

Steam Tempered(Black Oxide Finish)

Suitable for drilling thin materials with portable electric drills.

►Application

Suitable for drilling thin materials with portable electric drills.

Special twist drills for automatic and turret lathes.

►Oberflächenbehandlung

Steam Homo(Schwarzoxidation)

Helle Beschaffenheit unter 2mm

►Verwendung

Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.

Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

DIN 1897

HSS

N

20~30°

h8

118°

Vap

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107053	5.3	26	62
D1107054	5.4	28	66
D1107055	5.5	28	66
D1107056	5.6	28	66
D1107057	5.7	28	66
D1107957	5.75	28	66
D1107058	5.8	28	66
D1107059	5.9	28	66
D1107060	6.0	28	66
D1107061	6.1	31	70
D1107062	6.2	31	70
D1107962	6.25	31	70
D1107063	6.3	31	70
D1107064	6.4	31	70
D1107065	6.5	31	70
D1107066	6.6	31	70
D1107067	6.7	31	70
D1107967	6.75	34	74
D1107068	6.8	34	74
D1107069	6.9	34	74
D1107070	7.0	34	74
D1107071	7.1	34	74
D1107072	7.2	34	74
D1107972	7.25	34	74
D1107073	7.3	34	74
D1107074	7.4	34	74

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107075	7.5	34	74
D1107076	7.6	37	79
D1107077	7.7	37	79
D1107977	7.75	37	79
D1107078	7.8	37	79
D1107079	7.9	37	79
D1107080	8.0	37	79
D1107081	8.1	37	79
D1107082	8.2	37	79
D1107982	8.25	37	79
D1107083	8.3	37	79
D1107084	8.4	37	79
D1107085	8.5	37	79
D1107086	8.6	40	84
D1107087	8.7	40	84
D1107987	8.75	40	84
D1107088	8.8	40	84
D1107089	8.9	40	84
D1107090	9.0	40	84
D1107091	9.1	40	84
D1107092	9.2	40	84
D1107992	9.25	40	84
D1107093	9.3	40	84
D1107094	9.4	40	84
D1107095	9.5	40	84
D1107096	9.6	43	89

Unit : mm

◎ : 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

1

2

3

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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

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ISO

Material Description

VDI 3323

HRc

HB

Recommended

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

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

55

60

42

55

550

○

○

○

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STRAIGHT SHANK DRILLS

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HSS, STRAIGHT SHANK TWIST DRILLS

HSS, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS, queue cylindrique, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment : Steam Tempered(Black Oxide Finish)

►Application : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes.

►Oberflächenbehandlung : Steam Homo(Schwarzoxidation)

►Verwendung : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

DIN 1897

HSS

N

20~30°

h8

118°

Vap

p.A262

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

Plain Shank

Page

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107097	9.7	43	89
D1107997	9.75	43	89
D1107098	9.8	43	89
D1107099	9.9	43	89
D1107100	10.0	43	89
D1107802	10.25	43	89
D1107105	10.5	43	89
D1107807	10.75	47	95
D1107110	11.0	47	95
D1107812	11.25	47	95
D1107115	11.5	47	95
D1107817	11.75	47	95

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1107120	12.0	51	102
D1107822	12.25	51	102
D1107125	12.5	51	102
D1107827	12.75	51	102
D1107130	13.0	51	102

Unit : mm

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2105 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

JOBBER

KURZ

COURTE

CORTA

►Surface treatment : Coloring(Gold color)

►Application : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

►Oberflächenbehandlung : Coloring(Goldfarbe)

►Verwendung : Zum Bohren von rostfreien und austenitischen. Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.

DIN 338

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

Plain Shank

Page

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2105010	1.0	12	34
D2105011	1.1	14	36
D2105012	1.2	16	38
D2105912	1.25	16	38
D2105013	1.3	16	38
D2105014	1.4	18	40
D2105015	1.5	18	40
D2105016	1.6	20	43
D2105017	1.7	20	43
D2105917	1.75	22	46
D2105018	1.8	22	46
D2105019	1.9	22	46
D2105020	2.0	24	49
D2105021	2.1	24	49
D2105022	2.2	27	53
D2105922	2.25	27	53
D2105023	2.3	27	53
D2105024	2.4	30	57
D2105025	2.5	30	57
D2105026	2.6	30	57
D2105027	2.7	33	61
D2105927	2.75	33	61
D2105028	2.8	33	61
D2105029	2.9	33	61
D2105030	3.0	33	61
D2105031	3.1	36	65

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2105032	3.2	36	65
D2105932	3.25	36	65
D2105033	3.3	36	65
D2105034	3.4	39	70
D2105035	3.5	39	70
D2105036	3.6	39	70
D2105037	3.7	39	70
D2105937	3.75	39	70
D2105038	3.8	43	75
D2105039	3.9	43	75
D2105040	4.0	43	75
D2105041	4.1	43	75
D2105042	4.2	43	75
D2105942	4.25	43	75
D2105043	4.3	47	80
D2105044	4.4	47	80
D2105045	4.5	47	80
D2105046	4.6	47	80
D2105047	4.7	47	80
D2105947	4.75	47	80
D2105048	4.8	52	86
D2105049	4.9	52	86
D2105050	5.0	52	86
D2105051	5.1	52	86
D2105052	5.2	52	86
D2105952	5.25	52	86

Unit : mm

► TiN(D4105), TiCN(D7105) and TiAlN(DQ105) 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				
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	20
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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400
Recommended	○	○	○						○							○				

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CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2105 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

JOBBER

KURZ

COURTE

CORTA

►Surface treatment : Coloring(Gold color)

►Application : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

►Oberflächenbehandlung : Coloring(Goldfarbe)

►Verwendung : Zum Bohren von rostfreien und austenitischen. Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.

DIN 338

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

Plain Shank

Page

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2105010	1.0	12	34
D2105011	1.1	14	36
D2105012	1.2	16	38
D2105912	1.25	16	38
D2105013	1.3	16	38
D2105014	1.4	18	40
D2105015	1.5	18	40
D2105016	1.6	20	43
D2105017	1.7	20	43
D2105917	1.75	22	46
D2105018	1.8	22	46
D2105019	1.9	22	46
D2105020	2.0	24	49
D2105021	2.1	24	49
D2105022	2.2	27	53
D2105922	2.25	27	53
D2105023	2.3	27	53
D2105024	2.4	30	57
D2105025	2.5	30	57
D2105026	2.6	30	57
D2105027	2.7	33	61
D2105927	2.75	33	61
D2105028	2.8	33	61
D2105029	2.9	33	61
D2105030	3.0	33	61
D2105031	3.1	36	65

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2105032	3.2	36	65
D2105932	3.25	36	65
D2105033	3.3	36	65
D2105034	3.4	39	70
D2105035	3.5	39	70
D2105036	3.6	39	70
D2105037	3.7	39	70
D2105937	3.75	39	70
D2105038	3.8	43	75
D2105039	3.9	43	75
D2105040	4.0	43	75
D2105041	4.1	43	75
D2105042	4.2	43	75
D2105942	4.25	43	75
D2105043	4.3	47	80
D2105044	4.4	47	80
D2105045	4.5	47	80
D2105046	4.6	47	80
D2105047	4.7	47	80
D2105947	4.75	47	80
D2105048	4.8	52	86
D2105049	4.9	52	86
D2105050	5.0	52	86
D2105051	5.1	52	86
D2105052	5.2	52	86
D2105952	5.25	52	86

Unit : mm

► TiN(D4105), TiCN(D7105) and TiAlN(DQ105) 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				
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	20
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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400
Recommended	○	○	○						○							○				

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STRAIGHT SHANK DRILLS

DL105 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS

HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique, Forme C, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS - E

►Surface treatment : Coloring(Gold color)

►Application : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

►Oberflächenbehandlung : Coloring(Goldfarbe)

►Verwendung : Zum Bohren von rostfreien und austenitischen. Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.

under 1.6mm

1.6mm & over

DIN 338

HSS-E

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

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EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

DL105010	1.0	12	34
DL105011	1.1	14	36
DL105012	1.2	16	38
DL105912	1.25	16	38
DL105013	1.3	16	38
DL105014	1.4	18	40
DL105015	1.5	18	40
DL105016	1.6	20	43
DL105017	1.7	20	43
DL105917	1.75	22	46
DL105018	1.8	22	46
DL105019	1.9	22	46
DL105020	2.0	24	49
DL105021	2.1	24	49
DL105022	2.2	27	53
DL105922	2.25	27	53
DL105023	2.3	27	53
DL105024	2.4	30	57
DL105025	2.5	30	57
DL105026	2.6	30	57
DL105027	2.7	33	61
DL105927	2.75	33	61
DL105028	2.8	33	61
DL105029	2.9	33	61
DL105030	3.0	33	61
DL105031	3.1	36	65

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

DL105032	3.2	36	65
DL105932	3.25	36	65
DL105033	3.3	36	65
DL105034	3.4	39	70
DL105035	3.5	39	70
DL105036	3.6	39	70
DL105037	3.7	39	70
DL105937	3.75	39	70
DL105038	3.8	43	75
DL105039	3.9	43	75
DL105040	4.0	43	75
DL105041	4.1	43	75
DL105042	4.2	43	75
DL105942	4.25	43	75
DL105043	4.3	47	80
DL105044	4.4	47	80
DL105045	4.5	47	80
DL105046	4.6	47	80
DL105047	4.7	47	80
DL105947	4.75	47	80
DL105048	4.8	52	86
DL105049	4.9	52	86
DL105050	5.0	52	86
DL105051	5.1	52	86
DL105052	5.2	52	86
DL105952	5.25	52	86

Unit : mm

► TiN(DN105), TiCN(DX105) and TiAlN(DT105) 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				
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	30	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)				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34
HB	60	100	75	90	130	110	90	100			200	280	250	350	320
Recommended	○	○	○						○		○	○	○	○	○

ISO	N					S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34
HB	60	100	75	90	130	110	90	100			200	280	250	350	320
Recommended	○	○	○						○		○	○	○	○	○

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CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL105 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS

HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique, Forme C, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS - E

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under 1.6mm

1.6mm & over

DIN 338

HSS-E

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

DL105053	5.3	52	86
DL105054	5.4	57	93
DL105055	5.5	57	93
DL105056	5.6	57	93
DL105057	5.7	57	93
DL105957	5.75	57	93
DL105058	5.8	57	93
DL105059	5.9	57	93
DL105060	6.0	57	93
DL105061	6.1	63	101
DL105062	6.2	63	101
DL105962	6.25	63	101
DL105063	6.3	63	101
DL105064	6.4	63	101
DL105065	6.5	63	101
DL105066	6.6	63	101
DL105067	6.7	63	101
DL105967	6.75	69	109
DL105068	6.8	69	109
DL105069	6.9	69	109
DL105070	7.0	69	109
DL105071	7.1	69	109
DL105072	7.2	69	109
DL105972	7.25	69	109
DL105073	7.3	69	109
DL105074	7.4	69	109

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

DL105075	7.5	69	109
DL105076	7.6	75	117
DL105077	7.7	75	117
DL105977	7.75	75	117
DL105078	7.8	75	117
DL105079	7.9	75	117
DL105080	8.0	75	117
DL105081	8.1	75	117
DL105082	8.2	75	117
DL105982	8.25	75	117
DL105083	8.3	75	117
DL105084	8.4	75	117
DL105085	8.5	75	117
DL105086	8.6	81	125
DL105087	8.7	81	125
DL105987	8.75	81	125
DL105088	8.8	81	125
DL105089	8.9	81	125
DL105090	9.0	81	125
DL105091	9.1	81	125
DL105092	9.2	81	125
DL105992	9.25	81	125
DL105093	9.3	81	125
DL105094	9.4	81	125
DL105095	9.5	81	125
DL105096	9.6	87	133

Unit : mm

► TiN(DN105), TiCN(DX105) and TiAlN(DT105) 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				
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	30	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)				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34
HB	60	100	75	90	130	110	90	100			200	280	250	350	320
Recommended	○	○	○						○		○	○	○	○	○

ISO	N					S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34
HB	60	100	75	90	130	110	90	100			200	280	250	350	320
Recommended	○	○	○						○		○	○	○	○	○

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CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL105 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS

HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique, Forme C, série courte

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►Surface treatment : Coloring(Gold color)

►Application : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

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►Verwendung : Zum Bohren von rostfreien und austenitischen. Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.

under 1.6mm

1.6mm & over

L1

L2

D1

DIN 338

HSS-E

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

Plain Shank

Page

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL105097	9.7	87	133
DL105997	9.75	87	133
DL105098	9.8	87	133
DL105099	9.9	87	133
DL105100	10.0	87	133
DL105102	10.2	87	133
DL105105	10.5	87	133
DL105110	11.0	94	142
DL105115	11.5	94	142
DL105120	12.0	101	151
DL105125	12.5	101	151
DL105130	13.0	101	151
DL105135	13.5	108	160
DL105140	14.0	108	160

► TiN(DN105), TiCN(DX105) and TiAlN(DT105) are available on your request.

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL105145	14.5	114	169
DL105150	15.0	114	169
DL105155	15.5	120	178
DL105160	16.0	120	178
DL105165	16.5	125	184
DL105170	17.0	125	184
DL105175	17.5	130	191
DL105180	18.0	130	191
DL105185	18.5	135	198
DL105190	19.0	135	198
DL105195	19.5	140	205
DL105200	20.0	140	205

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D1105 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

HSS, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSS, queue cylindrique, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

►Surface treatment : Steam Tempered(Black Oxide Finish)

Bright Finish under 2mm

►Application : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

►Oberflächenbehandlung : Steam Homo(Schwarzoxidation)

Helle Beschaffenheit unter 2mm

►Verwendung : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphärguß, Sintereisen, Graphite.

L1

L2

D1

DIN 338

HSS

20~30°

h8

118°

Vap

p.A262

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

Plain Shank

Page

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1105003	0.3	3	19
D1105004	0.4	5	20
D1105005	0.5	6	22
D1105006	0.6	7	24
D1105007	0.7	9	28
D1105008	0.8	10	30
D1105009	0.9	11	32
D1105010	1.0	12	34
D1105010	1.05	12	34
D1105011	1.1	14	36
D1105011	1.15	14	36
D1105012	1.2	16	38
D1105012	1.25	16	38
D1105013	1.3	16	38
D1105013	1.35	18	40
D1105014	1.4	18	40
D1105014	1.45	18	40
D1105015	1.5	18	40
D1105015	1.55	20	43
D1105016	1.6	20	43
D1105016	1.65	20	43
D1105017	1.7	20	43
D1105017	1.75	22	46
D1105018	1.8	22	46
D1105018	1.85	22	46
D1105019	1.9	22	46

► NEXT PAGE

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1105919	1.95	24	49
D1105020	2.0	24	49
D1105920	2.05	24	49
D1105021	2.1	24	49
D1105921	2.15	27	53
D1105022	2.2	27	53
D1105922	2.25	27	53
D1105023	2.3	27	53
D1105923	2.35	27	53
D1105024	2.4	30	57
D1105924	2.45	30	57
D1105025	2.5	30	57
D1105925	2.55	30	57
D1105026	2.6	30	57
D1105926	2.65	30	57
D1105027	2.7	33	61
D1105927	2.75	33	61
D1105028	2.8	33	61
D1105928	2.85	33	61
D1105029	2.9	33	61
D1105929	2.95	33	61
D1105030	3.0	33	61
D1105930	3.05	36	65
D1105031	3.1	36	65
D1105931	3.15	36	65
D1105032	3.2	36	65

© : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	40
Recommended	○	○	○						○											

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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				
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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	40
Recommended	○	○	○						○											

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D1105 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

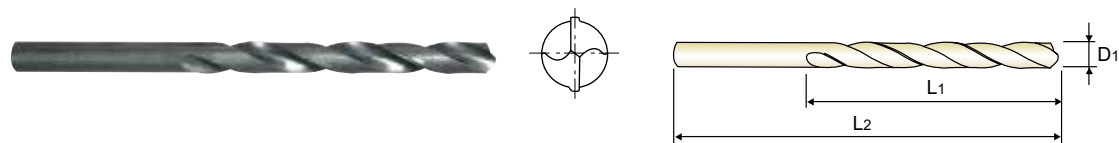
 HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
 Forets HSS, queue cylindrique, série courte
 PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

**KURZ
COURTE
CORTA**

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
Helle Beschaffenheit unter 2mm
- **Verwendung** : Zum Bohren von Stahl und Stahlguß,
Grauguß, Temperguß, Sphäroguß,
Sintereisen, Graphite.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1105932	3.25	36	65	D1105945	4.55	47	80
D1105033	3.3	36	65	D1105046	4.6	47	80
D1105933	3.35	36	65	D1105946	4.65	47	80
D1105034	3.4	39	70	D1105047	4.7	47	80
D1105934	3.45	39	70	D1105947	4.75	47	80
D1105035	3.5	39	70	D1105048	4.8	52	86
D1105935	3.55	39	70	D1105948	4.85	52	86
D1105036	3.6	39	70	D1105049	4.9	52	86
D1105936	3.65	39	70	D1105949	4.95	52	86
D1105037	3.7	39	70	D1105050	5.0	52	86
D1105937	3.75	39	70	D1105950	5.05	52	86
D1105038	3.8	43	75	D1105051	5.1	52	86
D1105938	3.85	43	75	D1105951	5.15	52	86
D1105039	3.9	43	75	D1105052	5.2	52	86
D1105939	3.95	43	75	D1105952	5.25	52	86
D1105040	4.0	43	75	D1105053	5.3	52	86
D1105940	4.05	43	75	D1105953	5.35	57	93
D1105041	4.1	43	75	D1105054	5.4	57	93
D1105941	4.15	43	75	D1105954	5.45	57	93
D1105042	4.2	43	75	D1105055	5.5	57	93
D1105942	4.25	43	75	D1105955	5.55	57	93
D1105043	4.3	47	80	D1105056	5.6	57	93
D1105943	4.35	47	80	D1105956	5.65	57	93
D1105044	4.4	47	80	D1105057	5.7	57	93
D1105944	4.45	47	80	D1105957	5.75	57	93
D1105045	4.5	47	80	D1105058	5.8	57	93

▶ 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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D1105 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

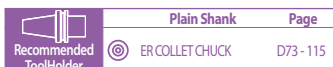
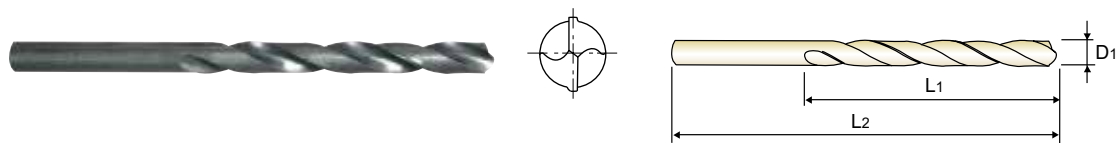
 HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
 Forets HSS, queue cylindrique, série courte
 PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

**KURZ
COURTE
CORTA**

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
Helle Beschaffenheit unter 2mm
- **Verwendung** : Zum Bohren von Stahl und Stahlguß,
Grauguß, Temperguß, Sphäroguß,
Sintereisen, Graphite.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1105958	5.85	57	93	D1105971	7.15	69	109
D1105059	5.9	57	93	D1105072	7.2	69	109
D1105959	5.95	57	93	D1105972	7.25	69	109
D1105060	6.0	57	93	D1105073	7.3	69	109
D1105960	6.05	63	101	D1105973	7.35	69	109
D1105061	6.1	63	101	D1105074	7.4	69	109
D1105961	6.15	63	101	D1105974	7.45	69	109
D1105062	6.2	63	101	D1105075	7.5	69	109
D1105962	6.25	63	101	D1105975	7.55	75	117
D1105063	6.3	63	101	D1105076	7.6	75	117
D1105963	6.35	63	101	D1105976	7.65	75	117
D1105064	6.4	63	101	D1105077	7.7	75	117
D1105964	6.45	63	101	D1105977	7.75	75	117
D1105065	6.5	63	101	D1105078	7.8	75	117
D1105965	6.55	63	101	D1105978	7.85	75	117
D1105066	6.6	63	101	D1105079	7.9	75	117
D1105966	6.65	63	101	D1105979	7.95	75	117
D1105067	6.7	63	101	D1105080	8.0	75	117
D1105967	6.75	69	109	D1105081	8.1	75	117
D1105068	6.8	69	109	D1105082	8.2	75	117
D1105968	6.85	69	109	D1105982	8.25	75	117
D1105069	6.9	69	109	D1105083	8.3	75	117
D1105969	6.95	69	109	D1105084	8.4	75	117
D1105070	7.0	69	109	D1105085	8.5	75	117
D1105970	7.05	69	109	D1105086	8.6	81	125
D1105071	7.1	69	109	D1105087	8.7	81	125

▶ 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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A235



D1105 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

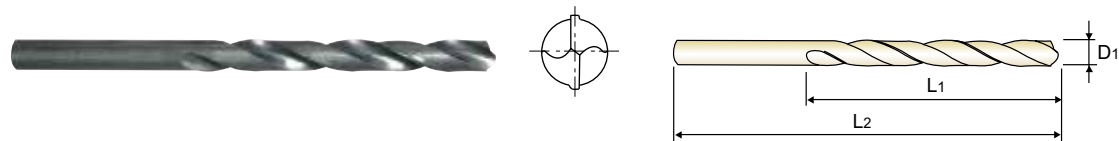
 **HSS, SPIRALBOHRER mit ZYLINDERSCHAFT**
 **Forets HSS, queue cylindrique, série courte**
 **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS**

KURZ
COURTE
CORTA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
Helle Beschaffenheit unter 2mm
- **Verwendung** : Zum Bohren von Stahl und Stahlguß,
Grauguß, Temperguß, Sphäroguß,
Sinterisen, Graphite.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1105987	8.75	81	125	D1105109	10.9	94	142
D1105088	8.8	81	125	D1105110	11.0	94	142
D1105089	8.9	81	125	D1105111	11.1	94	142
D1105090	9.0	81	125	D1105112	11.2	94	142
D1105091	9.1	81	125	D1105812	11.25	94	142
D1105092	9.2	81	125	D1105113	11.3	94	142
D1105992	9.25	81	125	D1105114	11.4	94	142
D1105093	9.3	81	125	D1105115	11.5	94	142
D1105094	9.4	81	125	D1105116	11.6	94	142
D1105095	9.5	81	125	D1105117	11.7	94	142
D1105096	9.6	87	133	D1105817	11.75	94	142
D1105097	9.7	87	133	D1105118	11.8	94	142
D1105997	9.75	87	133	D1105119	11.9	101	151
D1105098	9.8	87	133	D1105120	12.0	101	151
D1105099	9.9	87	133	D1105121	12.1	101	151
D1105100	10.0	87	133	D1105122	12.2	101	151
D1105101	10.1	87	133	D1105822	12.25	101	151
D1105102	10.2	87	133	D1105123	12.3	101	151
D1105802	10.25	87	133	D1105124	12.4	101	151
D1105103	10.3	87	133	D1105125	12.5	101	151
D1105104	10.4	87	133	D1105126	12.6	101	151
D1105105	10.5	87	133	D1105127	12.7	101	151
D1105106	10.6	87	133	D1105827	12.75	101	151
D1105107	10.7	94	142	D1105128	12.8	101	151
D1105807	10.75	94	142	D1105129	12.9	101	151
D1105108	10.8	94	142	D1105130	13.0	101	151

▶ 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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D1105 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

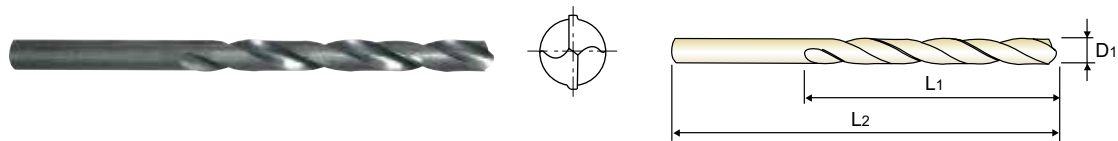
 **HSS, SPIRALBOHRER mit ZYLINDERSCHAFT**
 **Forets HSS, queue cylindrique, série courte**
 **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS**

**KURZ
COURTE
CORTA**

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
Helle Beschaffenheit unter 2mm
- **Verwendung** : Zum Bohren von Stahl und Stahlguß,
Grauguß, Temperguß, Sphäroguß,
Sinterisen, Graphite.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1105832	13.25	108	160	D1105867	16.75	125	184
D1105135	13.5	108	160	D1105170	17.0	125	184
D1105837	13.75	108	160	D1105872	17.25	130	191
D1105140	14.0	108	160	D1105175	17.5	130	191
D1105842	14.25	114	169	D1105877	17.75	130	191
D1105145	14.5	114	169	D1105180	18.0	130	191
D1105847	14.75	114	169	D1105882	18.25	135	198
D1105150	15.0	114	169	D1105185	18.5	135	198
D1105852	15.25	120	178	D1105887	18.75	135	198
D1105155	15.5	120	178	D1105190	19.0	135	198
D1105857	15.75	120	178	D1105892	19.25	140	205
D1105160	16.0	120	178	D1105195	19.5	140	205
D1105862	16.25	125	184	D1105897	19.75	140	205
D1105165	16.5	125	184	D1105200	20.0	140	205

◎ : 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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D1125 SERIES



D1125 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

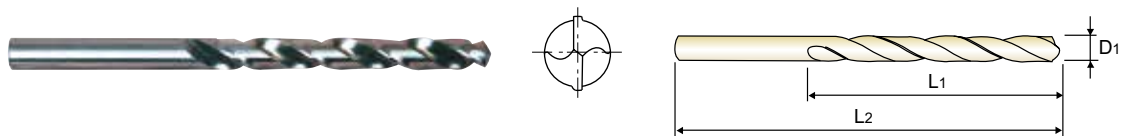
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 **HSS, SPIRALBOHRER mit ZYLINDERSCHAFT**
 **Forets HSS, queue cylindrique, série courte**
 **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS**

**KURZ
COURTE
CORTA**

► **Surface treatment** : Bright Finish
► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Helle Beschaffenheit
- **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphite.



Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1125020	2.0	24	49
D1125021	2.1	24	49
D1125022	2.2	27	53
D1125023	2.3	27	53
D1125024	2.4	30	57
D1125025	2.5	30	57
D1125026	2.6	30	57
D1125027	2.7	33	61
D1125028	2.8	33	61
D1125029	2.9	33	61
D1125030	3.0	33	61
D1125031	3.1	36	65
D1125032	3.2	36	65
D1125033	3.3	36	65
D1125034	3.4	39	70
D1125035	3.5	39	70
D1125036	3.6	39	70
D1125037	3.7	39	70
D1125038	3.8	43	75
D1125039	3.9	43	75
D1125040	4.0	43	75
D1125041	4.1	43	75
D1125042	4.2	43	75
D1125043	4.3	47	80
D1125044	4.4	47	80
D1125045	4.5	47	80

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1125046	4.6	47	80
D1125047	4.7	47	80
D1125048	4.8	52	86
D1125049	4.9	52	86
D1125050	5.0	52	86
D1125051	5.1	52	86
D1125052	5.3	52	86
D1125053	5.3	52	86
D1125054	5.4	57	93
D1125055	5.5	57	93
D1125056	5.6	57	93
D1125057	5.7	57	93
D1125058	5.8	57	93
D1125059	5.9	57	93
D1125060	6.0	57	93
D1125061	6.1	63	101
D1125062	6.2	63	101
D1125063	6.3	63	101
D1125064	6.4	63	101
D1125065	6.5	63	101
D1125066	6.6	63	101
D1125067	6.7	63	101
D1125068	6.8	69	109
D1125069	6.9	69	109
D1125070	7.0	69	109
D1125071	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	12	23	10	15	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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HSS, STRAIGHT SHANK TWIST DRILLS

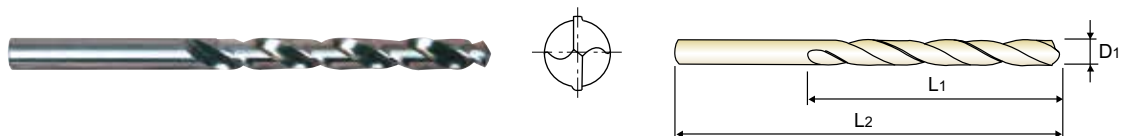
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 **HSS, SPIRALBOHRER mit ZYLINDERSCHAFT**
 **Forets HSS, queue cylindrique, série courte**
 **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS**

**KURZ
COURTE
CORTA**

► **Surface treatment** : Bright Finish
 ► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Helle Beschaffenheit
- **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphite.



Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1125072	7.2	69	109
D1125073	7.3	69	109
D1125074	7.4	69	109
D1125075	7.5	69	109
D1125076	7.6	75	117
D1125077	7.7	75	117
D1125078	7.8	75	117
D1125079	7.9	75	117
D1125080	8.0	75	117
D1125081	8.1	75	117
D1125082	8.2	75	117
D1125083	8.3	75	117
D1125084	8.4	75	117
D1125085	8.5	75	117
D1125086	8.6	81	125
D1125087	8.7	81	125
D1125088	8.8	81	125
D1125089	8.9	81	125
D1125090	9.0	81	125
D1125091	9.1	81	125
D1125092	9.2	81	125
D1125093	9.3	81	125
D1125094	9.4	81	125
D1125095	9.5	81	125
D1125096	9.6	87	133
D1125097	9.7	87	133

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1125098	9.8	87	133
D1125099	9.9	87	133
D1125100	10.0	87	133
D1125101	10.1	87	133
D1125102	10.2	87	133
D1125103	10.3	87	133
D1125104	10.4	87	133
D1125105	10.5	87	133
D1125106	10.6	87	133
D1125107	10.7	94	142
D1125108	10.8	94	142
D1125109	10.9	94	142
D1125110	11.0	94	142
D1125111	11.1	94	142
D1125112	11.2	94	142
D1125113	11.3	94	142
D1125114	11.4	94	142
D1125115	11.5	94	142
D1125116	11.6	94	142
D1125117	11.7	94	142
D1125118	11.8	94	142
D1125119	11.9	101	151
D1125120	12.0	101	151
D1125121	12.1	101	151
D1125122	12.2	101	151
D1125123	12.3	101	151

▶ 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		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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A239



D1125 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS

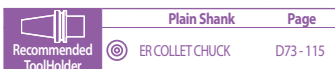
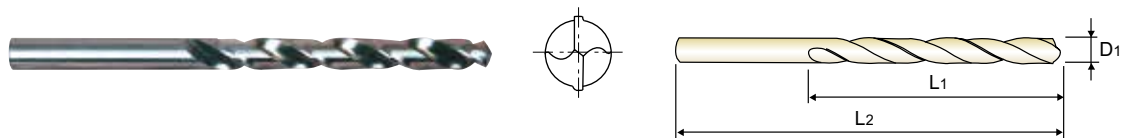
JOBBER

 **HSS, SPIRALBOHRER mit ZYLINDERSCHAFT**
 **Forets HSS, queue cylindrique, série courte**
 **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS**

**KURZ
COURTE
CORTA**

► **Surface treatment** : Bright Finish
► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

- **Oberflächenbehandlung** : Helle Beschaffenheit
- **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphite.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1125124	12.4	101	151	D1125150	15.0	114	169
D1125125	12.5	101	151	D1125155	15.5	120	178
D1125126	12.6	101	151	D1125160	16.0	120	178
D1125127	12.7	101	151	D1125165	16.5	125	184
D1125128	12.8	101	151	D1125170	17.0	125	184
D1125129	12.9	101	151	D1125175	17.5	130	191
D1125130	13.0	101	151	D1125180	18.0	130	191
D1125132	13.2	101	151	D1125185	18.5	135	198
D1125133	13.3	108	160	D1125190	19.0	135	198
D1125135	13.5	108	160	D1125195	19.5	140	205
D1125140	14.0	108	160	D1125200	20.0	140	205
D1125145	14.5	114	169				

◎ : 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-1 CO., LTD.



D2104 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

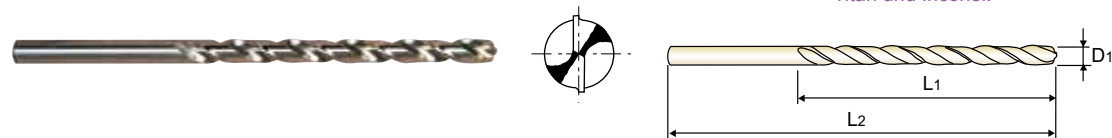
LONG

 HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT
 Forêts HSSCo8, queue cylindrique, série longue
 PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

LANG
LONGUE
LUNGA

- ▶ **Surface treatment** : Coloring(Gold color)
- ▶ **Application** : Drilling deep holes in stainless steels and difficult - to - cut materials such as titanium and inconel.

- **Oberflächenbehandlung** : Coloring(Goldfarbe)
- **Verwendung** : Für Bohrarbeiten mit Bohrungen oder an tief liegenden Stellen.
Zum Bohren von rostfreien und austenitischen Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D2104020	2.0	56	85	D2104046	4.6	82	126
D2104021	2.1	56	85	D2104047	4.7	82	126
D2104022	2.2	59	90	D2104048	4.8	87	132
D2104023	2.3	59	90	D2104049	4.9	87	132
D2104024	2.4	62	95	D2104050	5.0	87	132
D2104025	2.5	62	95	D2104051	5.1	87	132
D2104026	2.6	62	95	D2104052	5.2	87	132
D2104027	2.7	66	100	D2104053	5.3	87	132
D2104028	2.8	66	100	D2104054	5.4	91	139
D2104029	2.9	66	100	D2104055	5.5	91	139
D2104030	3.0	66	100	D2104056	5.6	91	139
D2104031	3.1	69	106	D2104057	5.7	91	139
D2104032	3.2	69	106	D2104058	5.8	91	139
D2104033	3.3	69	106	D2104059	5.9	91	139
D2104034	3.4	73	112	D2104060	6.0	91	139
D2104035	3.5	73	112	D2104061	6.1	97	148
D2104036	3.6	73	112	D2104062	6.2	97	148
D2104037	3.7	73	112	D2104063	6.3	97	148
D2104038	3.8	78	119	D2104064	6.4	97	148
D2104039	3.9	78	119	D2104065	6.5	97	148
D2104040	4.0	78	119	D2104066	6.6	97	148
D2104041	4.1	78	119	D2104067	6.7	97	148
D2104042	4.2	78	119	D2104068	6.8	102	156
D2104043	4.3	82	126	D2104069	6.9	102	156
D2104044	4.4	82	126	D2104070	7.0	102	156
D2104045	4.5	82	126	D2104071	7.1	102	156

- ▶ HSS-E(DL104) is available on your request.
- ▶ TiN(D4104), TiCN(D7104) and TiAlN(DQ104) 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	○	○	○						○							○						

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A241

STRAIGHT
SHANK DRILLS

DL109

SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for HEAVY DUTY

🇪🇺 HSS-E, SPIRALBOHRER für HOHE LEISTUNGEN mit ZYLINDERSCHAFT

🇫🇷 Forets HSS-E, queue cylindrique pour matériaux durs, série courte

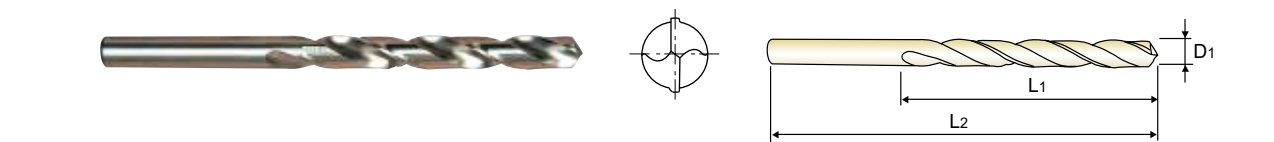
🇮🇹 PUNTE ELICOIDALI PER IMPIEGHI GRAVOSI, GAMBO CILINDRICO, HSS - E

JOBBER

KURZ
COURTE
CORTA

►Application : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

►Verwendung : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinter Eisen, Graphit.



DIN 338

HSS-E







Bright



p.A262



Plain Shank

Page

ER COLLET CHUCK

D73 - 115

				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DL109015	1.5	18	40	DL109080	8.0	75	117
DL109917	1.75	22	46	DL109982	8.25	75	117
DL109020	2.0	24	49	DL109085	8.5	75	117
DL109922	2.25	27	53	DL109987	8.75	81	125
DL109025	2.5	30	57	DL109090	9.0	81	125
DL109927	2.75	33	61	DL109992	9.25	81	125
DL109030	3.0	33	61	DL109095	9.5	81	125
DL109932	3.25	36	65	DL109997	9.75	87	133
DL109035	3.5	39	70	DL109100	10.0	87	133
DL109937	3.75	39	70	DL109105	10.5	87	133
DL109040	4.0	43	75	DL109110	11.0	94	142
DL109942	4.25	43	75	DL109115	11.5	94	142
DL109045	4.5	47	80	DL109120	12.0	101	151
DL109947	4.75	47	80	DL109125	12.5	101	151
DL109050	5.0	52	86	DL109130	13.0	101	151
DL109952	5.25	52	86				
DL109055	5.5	57	93				
DL109957	5.75	57	93				
DL109060	6.0	57	93				
DL109962	6.25	63	101				
DL109065	6.5	63	101				
DL109967	6.75	69	109				
DL109070	7.0	69	109				
DL109972	7.25	69	109				
DL109075	7.5	69	109				
DL109977	7.75	75	117				

► TiN(DN109), TiCN(DX109) and TiAlN(DT109) 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	180	275	300	350	200	325	200	240	180	180	260		160	250	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	○	○	○						○							○							

STRAIGHT
SHANK DRILLS

D1100

SERIES

HSS, STRAIGHT SHANK TWIST DRILLS for BRASS/BRONZE

🇪🇺 HSS, SPIRALBOHRER für MESSING/BRONZE mit ZYLINDERSCHAFT

🇫🇷 Forets HSS, queue cylindrique pour Laiton/Bronze, série courte

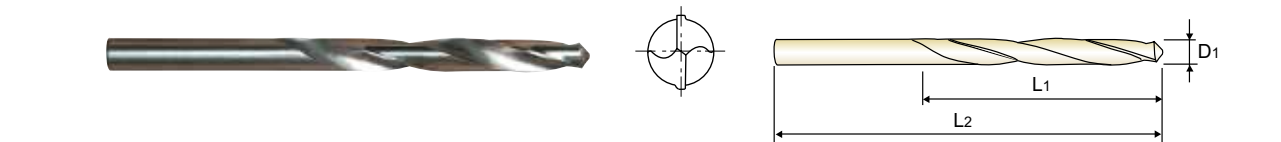
🇮🇹 PUNTE ELICOIDALI, GAMBO CILINDRICO PER OTTONE (HSS)

JOBBER

KURZ
COURTE
CORTA

►Application : Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze and magnesium alloys.

►Verwendung : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



DIN 338

HSS







Bright



p.A263



Plain Shank

Page

ER COLLET CHUCK

D73 - 115

				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1100015	1.5	18	40	D1100041	4.1	43	75
D1100016	1.6	20	43	D1100042	4.2	43	75
D1100017	1.7	20	43	D1100043	4.3	47	80
D1100018	1.8	22	46	D1100044	4.4	47	80
D1100019	1.9	22	46	D1100045	4.5	47	80
D1100020	2.0	24	49	D1100046	4.6	47	80
D1100021	2.1	24	49	D1100047	4.7	47	80
D1100022	2.2	27	53	D1100048	4.8	52	86
D1100023	2.3	27	53	D1100049	4.9	52	86
D1100024	2.4	30	57	D1100050	5.0	52	86
D1100025	2.5	30	57	D1100051	5.1	52	86
D1100026	2.6	30	57	D1100052	5.2	52	86
D1100027	2.7	33	61	D1100053	5.3	52	86
D1100028	2.8	33	61	D1100054	5.4	57	93
D1100029	2.9	33	61	D1100055	5.5	57	93
D1100030	3.0	33	61	D1100056	5.6	57	93
D1100031	3.1	36	65	D1100057	5.7	57	93
D1100032	3.2	36	65	D1100058	5.8	57	93
D1100033	3.3	36	65	D1100059	5.9	57	93
D1100034	3.4	39	70	D1100060	6.0	57	93
D1100035	3.5	39	70	D1100061	6.1	63	101
D1100036	3.6	39	70	D1100062	6.2	63	101
D1100037	3.7	39	70	D1100063	6.3	63	101
D1100038	3.8	43	75	D1100064	6.4	63	101
D1100039	3.9	43	75	D1100065	6.5	63	101
D1100040	4.0	43	75	D1100066	6.6	63	101

► 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	36	37	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							◎	◎															

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D1100 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS for BRASS/BRONZE

HSS, SPIRALBOHRER für MESSING/BRONZE mit ZYLINDERSCHAFT

Forets HSS, queue cylindrique pour Laiton/Bronze, série courte

PUNTE ELICOIDALI, GAMBO CILINDRICO PER OTTONE (HSS)

Application

Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze and magnesium alloys.

Verwendung

Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.

DIN 338

HSS

N

15 ~ 20°

h8

118°

Bright

p.A263

Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

Plain Shank

EDP No.

Drill Diameter

Flute Length

Overall Length

D1100067

6.7

63

101

D1100068

6.8

69

109

D1100069

6.9

69

109

D1100070

7.0

69

109

D1100071

7.1

69

109

D1100072

7.2

69

109

D1100073

7.3

69

109

D1100074

7.4

69

109

D1100075

7.5

69

109

D1100076

7.6

75

117

D1100077

7.7

75

117

D1100078

7.8

75

117

D1100079

7.9

75

117

D1100080

8.0

75

117

D1100081

8.1

75

117

D1100082

8.2

75

117

D1100083

8.3

75

117

D1100084

8.4

75

117

D1100085

8.5

75

117

D1100086

8.6

81

125

EDP No.

Drill Diameter

Flute Length

Overall Length

D1100087

8.7

81

125

D1100088

8.8

81

125

D1100089

8.9

81

125

D1100090

9.0

81

125

D1100091

9.1

81

125

D1100092

9.2

81

125

D1100093

9.3

81

125

D1100094

9.4

81

125

D1100095

9.5

81

125

D1100096

9.6

87

133

D1100097

9.7

87

133

D1100098

9.8

87

133

D1100099

9.9

87

133

D1100100

10.0

87

133

D1100105

10.5

87

133

D1100110

11.0

94

142

D1100115

11.5

94

142

D1100120

12.0

101

151

D1100125

12.5

101

151

D1100130

13.0

101

151

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106015

1.5

18

40

D1106016

1.6

20

43

D1106017

1.7

20

43

D1106018

1.8

22

46

D1106019

1.9

22

46

D1106020

2.0

24

49

D1106021

2.1

24

49

D1106022

2.2

27

53

D1106023

2.3

27

53

D1106024

2.4

30

57

D1106025

2.5

30

57

D1106026

2.6

30

57

D1106027

2.7

33

61

D1106028

2.8

33

61

D1106029

2.9

33

61

D1106030

3.0

33

61

D1106031

3.1

36

65

D1106032

3.2

36

65

D1106033

3.3

36

65

D1106034

3.4

39

70

D1106035

3.5

39

70

D1106036

3.6

39

70

D1106037

3.7

39

70

D1106038

3.8

43

75

D1106039

3.9

43

75

D1106040

4.0

43

75

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106041

4.1

43

75

D1106042

4.2

43

75

D1106043

4.3

47

80

D1106044

4.4

47

80

D1106045

4.5

47

80

D1106046

4.6

47

80

D1106047

4.7

47

80

D1106048

4.8

52

86

D1106049

4.9

52

86

D1106050

5.0

52

86

D1106051

5.1

52

86

D1106052

5.2

52

86

D1106053

5.3

52

86

D1106054

5.4

57

93

D1106055

5.5

57

93

D1106056

5.6

57

93

D1106057

5.7

57

93

D1106058

5.8

57

93

D1106059

5.9

57

93

D1106060

6.0

57

93

D1106061

6.1

63

101

D1106062

6.2

63

101

D1106063

6.3

63

101

D1106064

6.4

63

101

D1106065

6.5

63

101

D1106066

6.6

63

101

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106015

1.5

18

40

D1106016

1.6

20

43

D1106017

1.7

20

43

D1106018

1.8

22

46

D1106019

1.9

22

46

D1106020

2.0

24

49

D1106021

2.1

24

49

D1106022

2.2

27

53

D1106023

2.3

27

53

D1106024

2.4

30

57

D1106025

2.5

30

57

D1106026

2.6

30

57

D1106027

2.7

33

61

D1106028

2.8

33

61

D1106029

2.9

33

61

D1106030

3.0

33

61

D1106031

3.1

36

65

D1106032

3.2

36

65

D1106033

3.3

36

65

D1106034

3.4

39

70

D1106035

3.5

39

70

D1106036

3.6

39

70

D1106037

3.7

39

70

D1106038

3.8

43

75

D1106039

3.9

43

75

D1106040

4.0

43

75

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106041

4.1

43

75

D1106042

4.2

43

75

D1106043

4.3

47

80

D1106044

4.4

47

80

D1106045

4.5

47

80

D1106046

4.6

47

80

D1106047

4.7

47

80

D1106048

4.8

52

86

D1106049

4.9

52

86

D1106050

5.0

52

86

D1106051

5.1

52

86

D1106052

5.2

52

86

D1106053

5.3

52

86

D1106054

5.4

57

93

D1106055

5.5

57

93

D1106056

5.6

57

93

D1106057

5.7

57

93

D1106058

5.8

57

93

D1106059

5.9

57

93

D1106060

6.0

57

93

D1106061

6.1

63

101

D1106062

6.2

63

101

D1106063

6.3

63

101

D1106064

6.4

63

101

D1106065

6.5

63

101

D1106066

6.6

63

101

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106015

1.5

18

40

D1106016

1.6

20

43

D1106017

1.7

20

43

D1106018

1.8

22

46

D1106019

1.9

22

46

D1106020

2.0

24

49

D1106021

2.1

24

49

D1106022

2.2

27

53

D1106023

2.3

27

53

D1106024

2.4

30

57

D1106025

2.5

30

57

D1106026

2.6

30

57

D1106027

2.7

33

61

D1106028

2.8

33

61

D1106029

2.9

33

61

D1106030

3.0

33

61

D1106031

3.1

36

65

D1106032

3.2

36

65

D1106033

3.3

36

65

D1106034

3.4

39

70

D1106035

3.5

39

70

D1106036

3.6

39

70

D1106037

3.7

39

70

D1106038

3.8

43

75

D1106039

3.9

43

75

D1106040

4.0

43

75

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106041

4.1

43

75

D1106042

4.2

43

75

D1106043

4.3

47

80

D1106044

4.4

47

80

D1106045

4.5

47

80

D1106046

4.6

47

80

D1106047

4.7

47

80

D1106048

4.8

52

86

D1106049

4.9

52

86

D1106050

5.0

52

86

D1106051

5.1

52

86

D1106052

5.2

52

86

D1106053

5.3

52

86

D1106054

5.4

57

93

D1106055

5.5

57

93

D1106056

5.6

57

93

D1106057

5.7

57

93

D1106058

5.8

57

93

D1106059

5.9

57

93

D1106060

6.0

57

93

D1106061

6.1

63

101

D1106062

6.2

63

101

D1106063

6.3

63

101

D1106064

6.4

63

101

D1106065

6.5

63

101

D1106066

6.6

63

101

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106015

1.5

18

40

D1106016

1.6

20

43

D1106017

1.7

20

43

D1106018

1.8

22

46

D1106019

1.9

22

46

D1106020

2.0

24

49

D1106021

2.1

24

49

D1106022

2.2

27

53

D1106023

2.3

27

53

D1106024

2.4

30

57

D1106025

2.5

30

57

D1106026

2.6

30

57

D1106027

2.7

33

61

D1106028

2.8

33

61

D1106029

2.9

33

61

D1106030

3.0

33

61

D1106031

3.1

36

65

D1106032

3.2

36

65

D1106033

3.3

36

65

D1106034

3.4

39

70

D1106035

3.5

39

70

D1106036

3.6

39

70

D1106037

3.7

39

70

D1106038

3.8

43

75

D1106039

3.9

43

75

D1106040

4.0

43

75

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106041

4.1

43

75

D1106042

4.2

43

75

D1106043

4.3

47

80

D1106044

4.4

47

80

D1106045

4.5

47

80

D1106046

4.6

47

80

D1106047

4.7

47

80

D1106048

4.8

52

86

D1106049

4.9

52

86

D1106050

5.0

52

86

D1106051

5.1

52

86

D1106052

5.2

52

86

D1106053

5.3

52

86

D1106054

5.4

57

93

D1106055

5.5

57

93

D1106056

5.6

57

93

D1106057

5.7

57

93

D1106058

5.8

57

93

D1106059

5.9

57

93

D1106060

6.0

57

93

D1106061

6.1

63

101

D1106062

6.2

63

101

D1106063

6.3

63

101

D1106064

6.4

63

101

D1106065

6.5

63

101

D1106066

6.6

63

101

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106015

1.5

18

40

D1106016

1.6

20

43

D1106017

1.7

20

43

D1106018

1.8

22

46

D1106019

1.9

22

46

D1106020

2.0

24

49

D1106021

2.1

24

49

D1106022

2.2

27

53

D1106023

2.3

27

53

D1106024

2.4

30

57

D1106025

2.5

30

57

D1106026

2.6

30

57

D1106027

2.7

33

61

D1106028

2.8

33

61

D1106029

2.9

33

61

D1106030

3.0

33

61

D1106031

3.1

36

65

D1106032

3.2

36

65

D1106033

3.3

36

65

D1106034

3.4

39

70

D1106035

3.5

39

70

D1106036

3.6

39

70

D1106037

3.7

39

70

D1106038

3.8

43

75

D1106039

3.9

43

75

D1106040

4.0

43

75

EDP No.

Drill Diameter

Flute Length

Overall Length

D1106041

4.1

43

75

D1106042

4.2

43

75

D1106043

4.3

47

80

D1106044

4.4

47

80

D1106045

4.5

47

80

D1106046

4.6

47

80

D1106047

4.7

47

80

D1106048

4.8

52

86

D1106049

4.9

52

86

D1106050

5.0

52

86

D1106051

5.1

52

86

D1106052

5.2

52

86

D1106053

5.3

52

86

D1106054

5.4

57

93

D1106055

5.5

57

93

D1106056

5.6

57

93

D1106057

5.7

57

93

D1106058

5.8

57

93

 **STRAIGHT
SHANK DRILLS**

D1106 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS for ALUMINUM

 **HSS, SPIRALBOHRER für ALUMINIUM mit ZYLINDERSCHAFT**

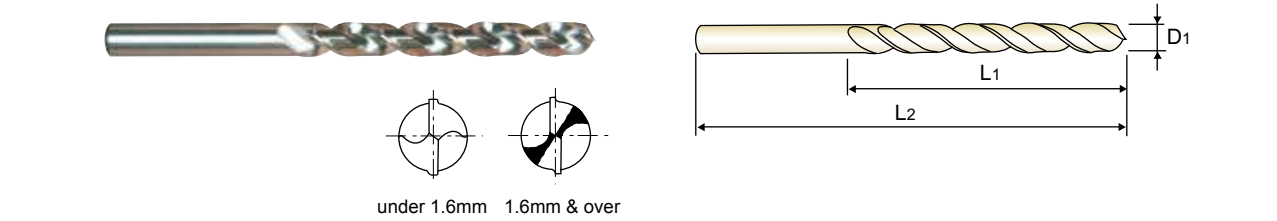
 **Forets HSS, queue cylindrique pour ALU, Forme C, série courte**

 **PUNTE ELICOIDALI, GAMBO CILINDRICO, PER ALLUMINIO (HSS)**

JOBBER
KURZ
COURTE
CORTA

►Application : Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze aluminum and magnesium alloys.

►Verwendung : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



 **DIN 338**

 **HSS**

 **38°**

 **h8**

 **135°**

 **Bright**

 **p.A263**

 **Recommended ToolHolder**

 **ER COLLET CHUCK**

Plain Shank

Page
D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1106067	6.7	63	101	D1106087	8.7	81	125
D1106068	6.8	69	109	D1106088	8.8	81	125
D1106069	6.9	69	109	D1106089	8.9	81	125
D1106070	7.0	69	109	D1106090	9.0	81	125
D1106071	7.1	69	109	D1106091	9.1	81	125
D1106072	7.2	69	109	D1106092	9.2	81	125
D1106073	7.3	69	109	D1106093	9.3	81	125
D1106074	7.4	69	109	D1106094	9.4	81	125
D1106075	7.5	69	109	D1106095	9.5	81	125
D1106076	7.6	75	117	D1106096	9.6	87	133
D1106077	7.7	75	117	D1106097	9.7	87	133
D1106078	7.8	75	117	D1106098	9.8	87	133
D1106079	7.9	75	117	D1106099	9.9	87	133
D1106080	8.0	75	117	D1106100	10.0	87	133
D1106081	8.1	75	117	D1106105	10.5	87	133
D1106082	8.2	75	117	D1106110	11.0	94	142
D1106083	8.3	75	117	D1106115	11.5	94	142
D1106084	8.4	75	117	D1106120	12.0	101	151
D1106085	8.5	75	117	D1106125	12.5	101	151
D1106086	8.6	81	125	D1106130	13.0	101	151

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	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				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	40
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

 **STRAIGHT
SHANK DRILLS**

DL510 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

 **HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT**

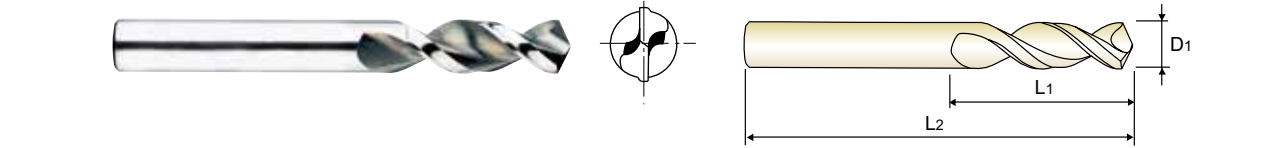
 **Forets HSS-E, queue cylindrique pour perçage profond, série extra-courte**

 **PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP**

STUB
EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

►Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

►Verwendung : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



 **DIN 1897**

 **HSS-E**

 **42°**

 **h8**

 **130°**

 **Bright**

 **p.A264**

 **Recommended ToolHolder**

 **ER COLLET CHUCK**

Plain Shank

Page
D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DL510020	2.0	12	38	DL510046	4.6	24	58
DL510021	2.1	12	38	DL510047	4.7	24	58
DL510022	2.2	13	40	DL510048	4.8	26	62
DL510023	2.3	13	40	DL510049	4.9	26	62
DL510024	2.4	14	43	DL510050	5.0	26	62
DL510025	2.5	14	43	DL510051	5.1	26	62
DL510026	2.6	14	43	DL510052	5.2	26	62
DL510027	2.7	16	46	DL510053	5.3	26	66
DL510028	2.8	16	46	DL510054	5.4	28	66
DL510029	2.9	16	46	DL510055	5.5	28	66
DL510030	3.0	16	46	DL510056	5.6	28	66
DL510031	3.1	18	49	DL510057	5.7	28	66
DL510032	3.2	18	49	DL510058	5.8	28	66
DL510033	3.3	18	49	DL510059	5.9	28	66
DL510034	3.4	20	52	DL510060	6.0	28	66
DL510035	3.5	20	52	DL510061	6.1	31	70
DL510036	3.6	20	52	DL510062	6.2	31	70
DL510037	3.7	20	52	DL510063	6.3	31	70
DL510038	3.8	22	55	DL510064	6.4	31	70
DL510039	3.9	22	55	DL510065	6.5	31	70
DL510040	4.0	22	55	DL510066	6.6	31	70
DL510041	4.1	22	55	DL510067	6.7	31	70
DL510042	4.2	22	55	DL510068	6.8	34	74
DL510043	4.3	24	58	DL510069	6.9	34	74
DL510044	4.4	24	58	DL510070	7.0	34	74
DL510045	4.5	24	58	DL510071	7.1	34	74

► NEXT PAGE

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	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				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	40
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL510SERIES

HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique pour perçage profond, série extra-courte

PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

Verwendung : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.

► DH100

worm pattern drills

DIN 1897

HSS-E

42°

h8

130°

Bright

p.A264

Plain Shank

Page

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL510072	7.2	34	74
DL510073	7.3	34	74
DL510074	7.4	34	74
DL510075	7.5	34	74
DL510076	7.6	37	79
DL510077	7.7	37	79
DL510078	7.8	37	79
DL510079	7.9	37	79
DL510080	8.0	37	79
DL510081	8.1	37	79
DL510082	8.2	37	79
DL510083	8.3	37	79
DL510084	8.4	37	79
DL510085	8.5	37	79
DL510086	8.6	40	84
DL510087	8.7	40	84
DL510088	8.8	40	84
DL510089	8.9	40	84
DL510090	9.0	40	84
DL510091	9.1	40	84
DL510092	9.2	40	84
DL510093	9.3	40	84
DL510094	9.4	40	84
DL510095	9.5	40	84
DL510096	9.6	43	89
DL510097	9.7	43	89
DL510098	9.8	43	89
DL510099	9.9	43	89

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL510100	10.0	43	89
DL510102	10.2	43	89
DL510105	10.5	43	89
DL510108	10.8	47	95
DL510110	11.0	47	95
DL510112	11.2	47	95
DL510115	11.5	47	95
DL510118	11.8	47	95
DL510120	12.0	51	102
DL510125	12.5	51	102
DL510130	13.0	51	102
DL510135	13.5	54	107
DL510140	14.0	54	107
DL510145	14.5	56	111
DL510150	15.0	56	111
DL510155	15.5	58	115
DL510160	16.0	58	115
DL510165	16.5	60	119
DL510170	17.0	60	119
DL510175	17.5	62	123
DL510180	18.0	62	123
DL510185	18.5	64	127
DL510190	19.0	64	127
DL510195	19.5	66	131
DL510200	20.0	66	131

Unit : mm

© : Excellent ○ : Good

A250

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

YG-1 CO., LTD.

CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL508SERIES

HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique pour perçage profond, série courte

PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

JOBBER

KURZ

COURTE

CORTA

Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

Verwendung : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.

► DH100

worm pattern drills

DIN 338

HSS-E

42°

h8

130°

Bright

p.A264

Plain Shank

Page

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL508020	2.0	24	49
DL508021	2.1	24	49
DL508022	2.2	27	53
DL508023	2.3	27	53
DL508024	2.4	30	57
DL508025	2.5	30	57
DL508026	2.6	30	57
DL508027	2.7	33	61
DL508028	2.8	33	61
DL508029	2.9	33	61
DL508030	3.0	33	61
DL508031	3.1	36	65
DL508032	3.2	36	65
DL508033	3.3	36	65
DL508034	3.4	39	70
DL508035	3.5	39	70
DL508036	3.6	39	70
DL508037	3.7	39	70
DL508038	3.8	43	75
DL508039	3.9	43	75
DL508040	4.0	43	75
DL508041	4.1	43	75
DL508042	4.2	43	75
DL508043	4.3	47	80
DL508044	4.4	47	80
DL508045	4.5	47	80

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL508046	4.6	47	80
DL508047	4.7	47	80
DL508048	4.8	52	86
DL508049	4.9	52	86
DL508050	5.0	52	86
DL508051	5.1	52	86
DL508052	5.2	52	86
DL508053	5.3	52	86
DL508054	5.4	57	93
DL508055	5.5	57	93
DL508056	5.6	57	93
DL508057	5.7	57	93
DL508058	5.8	57	93
DL508059	5.9	57	93
DL508060	6.0	57	93
DL508061	6.1	63	101
DL508062	6.2	63	101
DL508063	6.3	63	101
DL508064	6.4	63	101
DL508065	6.5	63	101
DL508066	6.6	63	101
DL508067	6.7	63	101
DL508068	6.8	69	109
DL508069	6.9	69	109
DL508070	7.0	69	109
DL508071	7.1	69	109

Unit : mm

© : Excellent ○ : Good

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i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

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DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

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STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

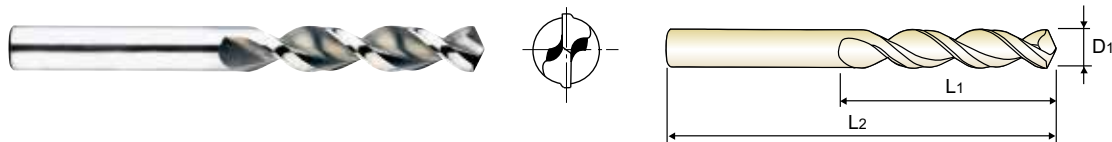


DL508 SERIES

JOBBER

**KURZ
COURTE
CORTA**

► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



► **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
DL508072	7.2	69	109	DL508096	9.6	87	133
DL508073	7.3	69	109	DL508097	9.7	87	133
DL508074	7.4	69	109	DL508098	9.8	87	133
DL508075	7.5	69	109	DL508099	9.9	87	133
DL508076	7.6	75	117	DL508100	10.0	87	133
DL508077	7.7	75	117	DL508102	10.2	87	133
DL508078	7.8	75	117	DL508105	10.5	87	133
DL508079	7.9	75	117	DL508110	11.0	94	142
DL508080	8.0	75	117	DL508112	11.2	94	142
DL508081	8.1	75	117	DL508115	11.5	94	142
DL508082	8.2	75	117	DL508120	12.0	101	151
DL508083	8.3	75	117	DL508125	12.5	101	151
DL508084	8.4	75	117	DL508130	13.0	101	151
DL508085	8.5	75	117	DL508135	13.5	108	160
DL508086	8.6	81	125	DL508140	14.0	108	160
DL508087	8.7	81	125	DL508145	14.5	114	169
DL508088	8.8	81	125	DL508150	15.0	114	169
DL508089	8.9	81	125	DL508155	15.5	120	178
DL508090	9.0	81	125	DL508160	16.0	120	178
DL508091	9.1	81	125				
DL508092	9.2	81	125				
DL508093	9.3	81	125				
DL508094	9.4	81	125				
DL508095	9.5	81	125				

◎ : Excellent ○ : Good

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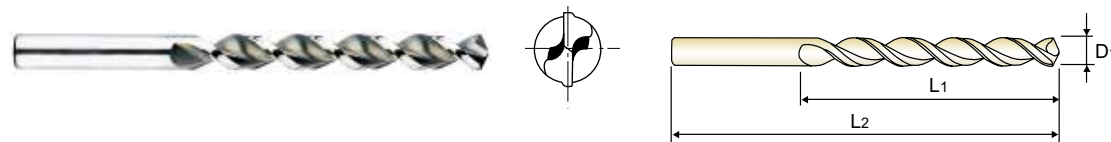


DL509 SERIES

LONG

LANG
LONGUE
LUNGA

► **Verwendung** : Zum Bohren von legiertem und unlegiertem Stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



► **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
DL509020	2.0	56	85	DL509046	4.6	82	126
DL509021	2.1	56	85	DL509047	4.7	82	126
DL509022	2.2	59	90	DL509048	4.8	87	132
DL509023	2.3	59	90	DL509049	4.9	87	132
DL509024	2.4	62	95	DL509050	5.0	87	132
DL509025	2.5	62	95	DL509051	5.1	87	132
DL509026	2.6	62	95	DL509052	5.2	87	132
DL509027	2.7	66	100	DL509053	5.3	87	132
DL509028	2.8	66	100	DL509054	5.4	91	139
DL509029	2.9	66	100	DL509055	5.5	91	139
DL509030	3.0	66	100	DL509056	5.6	91	139
DL509031	3.1	69	106	DL509057	5.7	91	139
DL509032	3.2	69	106	DL509058	5.8	91	139
DL509033	3.3	69	106	DL509059	5.9	91	139
DL509034	3.4	73	112	DL509060	6.0	91	139
DL509035	3.5	73	112	DL509061	6.1	97	148
DL509036	3.6	73	112	DL509062	6.2	97	148
DL509037	3.7	73	112	DL509063	6.3	97	148
DL509038	3.8	78	119	DL509064	6.4	97	148
DL509039	3.9	78	119	DL509065	6.5	97	148
DL509040	4.0	78	119	DL509066	6.6	97	148
DL509041	4.1	78	119	DL509067	6.7	97	148
DL509042	4.2	78	119	DL509068	6.8	102	156
DL509043	4.3	82	126	DL509069	6.9	102	156
DL509044	4.4	82	126	DL509070	7.0	102	156
DL509045	4.5	82	126	DL509071	7.1	102	156

▶ NEXT PAGE

◎: Excellent ○: Good

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A253



DL505 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

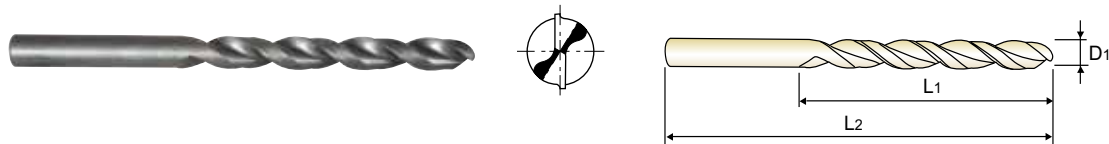
JOBBER

 HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
 Forets HSS-E, queue cylindrique pour perçage profond, série courte
 PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

**KURZ
COURTE
CORTA**

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
 ► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
- **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



▶ 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
DL505072	7.2	69	109	DL505098	9.8	87	133
DL505073	7.3	69	109	DL505099	9.9	87	133
DL505074	7.4	69	109	DL505100	10.0	87	133
DL505075	7.5	69	109	DL505101	10.1	87	133
DL505076	7.6	75	117	DL505102	10.2	87	133
DL505077	7.7	75	117	DL505105	10.5	87	133
DL505078	7.8	75	117	DL505108	10.8	94	142
DL505079	7.9	75	117	DL505110	11.0	94	142
DL505080	8.0	75	117	DL505112	11.2	94	142
DL505081	8.1	75	117	DL505115	11.5	94	142
DL505082	8.2	75	117	DL505118	11.8	94	142
DL505083	8.3	75	117	DL505120	12.0	101	151
DL505084	8.4	75	117	DL505122	12.2	101	151
DL505085	8.5	75	117	DL505125	12.5	101	151
DL505086	8.6	81	125	DL505128	12.8	101	151
DL505087	8.7	81	125	DL505130	13.0	101	151
DL505088	8.8	81	125				
DL505089	8.9	81	125				
DL505090	9.0	81	125				
DL505091	9.1	81	125				
DL505092	9.2	81	125				
DL505093	9.3	81	125				
DL505094	9.4	81	125				
DL505095	9.5	81	125				
DL505096	9.6	87	133				
DL505097	9.7	87	133				

► TiN(DN505), TiCN(DX505) and TiAlN(DT505) are available on your request.

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DL504 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

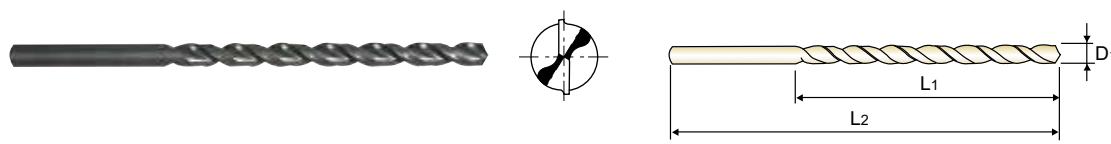
LONG

 **HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT**
 **Forets HSS-E, queue cylindrique pour perçage profond, série longue**
 **PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP**

LANG
LONGUE
LUNGA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
 ► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

- **Oberflächenbehandlung** : Steam Homo (Schwarzoxidation)
- **Verwendung** : Zum Bohren von legiertem und unlegiertem Stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



► **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
DL504020	2.0	56	85	DL504055	5.5	91	139
DL504021	2.1	56	85	DL504058	5.8	91	139
DL504022	2.2	59	90	DL504060	6.0	91	139
DL504023	2.3	59	90	DL504062	6.2	97	148
DL504024	2.4	62	95	DL504065	6.5	97	148
DL504025	2.5	62	95	DL504068	6.8	102	156
DL504026	2.6	62	95	DL504070	7.0	102	156
DL504027	2.7	66	100	DL504072	7.2	102	156
DL504028	2.8	66	100	DL504075	7.5	102	156
DL504029	2.9	66	100	DL504078	7.8	109	165
DL504030	3.0	66	100	DL504080	8.0	109	165
DL504031	3.1	69	106	DL504082	8.2	109	165
DL504032	3.2	69	106	DL504085	8.5	109	165
DL504033	3.3	69	106	DL504090	9.0	115	175
DL504034	3.4	73	112	DL504095	9.5	115	175
DL504035	3.5	73	112	DL504098	9.8	121	184
DL504036	3.6	73	112	DL504100	10.0	121	184
DL504037	3.7	73	112	DL504105	10.5	121	184
DL504038	3.8	78	119	DL504110	11.0	128	195
DL504039	3.9	78	119	DL504115	11.5	128	195
DL504040	4.0	78	119	DL504120	12.0	134	205
DL504042	4.2	78	119	DL504125	12.5	134	205
DL504045	4.5	82	126	DL504130	13.0	134	205
DL504048	4.8	87	132				
DL504050	5.0	87	132				
DL504052	5.2	87	132				

► TiN(DN504), TiCN(DX504) and TiAlN(DT504) are available on your request

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A257

CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL507 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES

HSS-E, SPIRALBOHRER für ALUMINIUM TIEFLOCH mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique pour ALU, perçage profond, série extra-longue

PUNTE HSS-E, GAMBO CILINDRICO PER FORATURE NON - STOP SU ALLUMINIO

EXTRA LONG

ÜBERLANG

EXTRA-LONGUE

EXTRA LUNGA

►Application : Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials.

►Verwendung : Zum Bohren von weichen und langspanenden Werkstoffen wie Alu-Legierungen, Zink, Kupfer, Kunststoffe und Holz.

►DH50 worm pattern drills

HSS-E

38°

h8

118°

Bright

p.A265

Plain Shank

Page

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL507120	2.0	40	75
DL507121	2.1	40	75
DL507220	2.0	50	100
DL507221	2.1	50	100
DL507225	2.5	50	100
DL507227	2.7	50	100
DL507230	3.0	50	100
DL507233	3.3	50	100
DL507235	3.5	50	100
DL507320	2.0	75	150
DL507321	2.1	75	150
DL507325	2.5	75	150
DL507327	2.7	75	150
DL507330	3.0	75	150
DL507333	3.3	75	150
DL507335	3.5	75	150
DL507340	4.0	75	150
DL507342	4.2	75	150
DL507345	4.5	75	150
DL507350	5.0	75	150
DL507353	5.3	75	150
DL507355	5.5	75	150
DL507360	6.0	75	150

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL507430	3.0	100	200
DL507433	3.3	100	200
DL507435	3.5	100	200
DL507440	4.0	100	200
DL507442	4.2	100	200
DL507445	4.5	100	200
DL507450	5.0	100	200
DL507453	5.3	100	200
DL507455	5.5	100	200
DL507460	6.0	100	200
DL507465	6.5	100	200
DL507468	6.8	100	200
DL507470	7.0	100	200
DL507475	7.5	100	200
DL507480	8.0	100	200
DL507485	8.5	100	200
DL507488	8.8	100	200
DL507490	9.0	100	200
DL507495	9.5	100	200
DL507700	10.0	100	200
DL507540	4.0	150	250
DL507542	4.2	150	250
DL507545	4.5	150	250
DL507550	5.0	150	250
DL507553	5.3	150	250

Unit : mm

◎ : 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
HRc											15	30	25	38	34	55	60	42	55	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	550
Recommended	◎	◎	○																	

A260

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CARBIDE

HSS

STRAIGHT SHANK DRILLS

DL507 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES

HSS-E, SPIRALBOHRER für ALUMINIUM TIEFLOCH mit ZYLINDERSCHAFT

Forets HSS-E, queue cylindrique pour ALU, perçage profond, série extra-longue

PUNTE HSS-E, GAMBO CILINDRICO PER FORATURE NON - STOP SU ALLUMINIO

EXTRA LONG

ÜBERLANG

EXTRA-LONGUE

EXTRA LUNGA

►Application : Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials.

►Verwendung : Zum Bohren von weichen und langspanenden Werkstoffen wie Alu-Legierungen, Zink, Kupfer, Kunststoffe und Holz.

►DH50 worm pattern drills

HSS-E

38°

h8

118°

Bright

p.A265

Plain Shank

Page

Recommended ToolHolder

ER COLLET CHUCK

D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL507555	5.5	150	250
DL507560	6.0	150	250
DL507565	6.5	150	250
DL507568	6.8	150	250
DL507570	7.0	150	250
DL507575	7.5	150	250
DL507580	8.0	150	250
DL507585	8.5	150	250
DL507588	8.8	150	250
DL507590	9.0	150	250
DL507595	9.5	150	250
DL507800	10.0	150	250
DL507803	10.3	150	250
DL507805	10.5	150	250
DL507810	11.0	150	250
DL507815	11.5	150	250
DL507820	12.0	150	250
DL507825	12.5	150	250
DL507830	13.0	150	250

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DL507650	5.0	180	300
DL507653	5.3	180	300
DL507655	5.5	180	300
DL507660	6.0	180	300
DL507665	6.5	180	300
DL507668	6.8	180	300
DL507670	7.0	180	300
DL507675	7.5	180	300
DL507680	8.0	180	300
DL507685	8.5	180	300
DL507688	8.8	180	300
DL507690	9.0	180	300
DL507695	9.5	180	300
DL507900	10.0	180	300
DL507903	10.3	180	300
DL507905	10.5	180	300
DL507910	11.0	180	300
DL507915	11.5	180	300
DL507920	12.0	180	300
DL507925	12.5	180	300
DL507930	13.0	180	300

Unit : mm

◎ : 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
HRc											15	30	25	38	34	55	60	42	55	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	550
Recommended	◎	◎	○																	

A261

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YG-1 CO., LTD.

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107, D1107, D2105, DL105, D1105, D1125, D2104, D1121, DL109

SERIES

RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDPARAMETER

HSS, HSS-E & HSSCo8

COBALT DRILLS

VC = M/MIN

RPM = rev./min.

FEED = mm/rev.

ISO

VDI 3323

Material Description

Vc

Parameter

Drill Diameter (mm)

2.0

3.0

4.0

6.0

8.0

10.0

13.0

16.0

18.0

20.0

30.0

P

1

Non-alloy steel

2

Non-alloy steel

3

Non-alloy steel

4

Non-alloy steel

6

Low alloy steel

7

Low alloy steel

8

Low alloy steel

10

High alloyed steel, and tool steel

M

12

Stainless steel

13

Stainless steel

14

Stainless steel

K

15

Grey cast iron

16

Grey cast iron

17

Nodular cast iron

19

Malleable cast iron

N

21

Aluminum-wrought alloy

22

Aluminum-wrought alloy

23

Aluminum-cast, alloyed

29

Non Metallic Materials

36

Titanium Alloys

RPM

FEED

4770

0.02~0.04

3180

0.03~0.05

2390

0.04~0.06

1590

0.05~0.08

1190

0.10~0.13

950

0.11~0.15

730

0.11~0.17

600

0.12~0.18

530

0.14~0.20

480

0.19~0.25

320

0.22~0.28

RPM

FEED

3980

0.02~0.04

2650

0.03~0.05

1990

0.04~0.06

1330

0.05~0.08

990

0.10~0.13

800

0.11~0.15

610

0.11~0.17

500

0.12~0.18

440

0.14~0.20

400

0.19~0.25

270

0.22~0.28

RPM

FEED

3180

0.02~0.04

2120

0.03~0.05

1590

0.04~0.06

1060

0.05~0.08

800

0.10~0.13

640

0.11~0.15

490

0.11~0.17

400

0.12~0.18

350

0.14~0.20

320

0.19~0.25

210

0.22~0.28

RPM

FEED

3180

0.01~0.02

2120

0.01~0.03

1590

0.02~0.04

1060

0.02~0.05

800

0.03~0.06

640

0.03~0.06

490

0.04~0.10

400

0.06~0.12

350

0.08~0.14

320

0.10~0.16

210

0.12~0.18

RPM

FEED

3980

0.02~0.04

2650

0.03~0.05

1990

0.04~0.06

1330

0.05~0.08

990

0.10~0.13

800

0.11~0.15

610

0.11~0.17

500

0.12~0.18

440

0.14~0.20

400

0.19~0.25

270

0.22~0.28

RPM

FEED

3180

0.02~0.04

2120

0.03~0.05

1590

0.04~0.06

1060

0.05~0.08

800

0.10~0.13

640

0.11~0.15

490

0.11~0.17

400

0.12~0.18

350

0.14~0.20

320

0.19~0.25

210

0.22~0.28

RPM

FEED

3180

0.02~0.04

2120

0.03~0.05

1590

0.04~0.06

1060

0.05~0.08

800

0.10~0.13

640

0.11~0.15

490

0.11~0.17

400

0.12~0.18

350

0.14~0.20

320

0.19~0.25

210

0.22~0.28

RPM

FEED

2390

0.02~0.04

1590

0.03~0.05

1190

0.04~0.06

800

0.05~0.08

600

0.10~0.13

480

0.11~0.15

370

0.11~0.17

300

0.12~0.18

270

0.14~0.20

240

0.19~0.25

160

0.22~0.28

RPM

FEED

3180

0.02~0.04

2120

0.03~0.05

1590

0.04~0.06

1060

0.05~0.08

800

0.10~0.13

640

0.11~0.15

490

0.11~0.17

400

0.12~0.18

350

0.14~0.20

320

0.19~0.25

210

0.22~0.28

RPM

FEED

2390

0.02~0.04

1590

0.03~0.05

1190

0.04~0.06

800

0.05~0.08

600

0.10~0.13

480

0.11~0.15

370

0.11~0.17

300

0.12~0.18

270

0.14~0.20

240

0.19~0.25

160

0.22~0.28

RPM

FEED

1590

0.01~0.02

1060

0.01~0.03

800

0.02~0.04

530

0.02~0.05

400

0.03~0.06

320

0.03~0.06

240

0.04~0.10

200

0.06~0.12

180

0.08~0.14

160

0.10~0.16

110

0.12~0.18

RPM

FEED

4770

0.02~0.04

3180

0.03~0.05

2390

0.04~0.06

1590

0.05~0.08

1190

0.10~0.13

950

0.11~0.15

730

0.11~0.17

600

0.12~0.18

530

0.14~0.20

480

0.19~0.25

320

0.22~0.28

RPM

FEED

3980

0.01~0.02

2650

0.01~0.03

1990

0.02~0.04

1330

0.02~0.05

990

0.03~0.06

800

0.03~0.06

610

0.04~0.10

500

0.06~0.12

440

0.08~0.14

400

0.10~0.16

270

0.12~0.18

RPM

FEED

4770

0.02~0.04

3180

0.03~0.05

2390

0.04~0.06

1590

0.05~0.08

1190

0.10~0.13

950

0.11~0.15

730

0.11~0.17

600

0.12~0.18

530

0.14~0.20

480

0.19~0.25

320

0.22~0.28

RPM

FEED

3980

0.02~0.04

2650

0.03~0.05

1990

0.04~0.06

1330

0.05~0.08

990

0.10~0.13

800

0.11~0.15

610

0.11~0.17

500

0.12~0.18

440

0.14~0.20

400

0.19~0.25

270

0.22~0.28

RPM

FEED

8750

0.03~0.06

5840

0.05~0.09

4380

0.07~0.11

2920

0.12~0.16

2190

0.12~0.18

1750

0.14~0.20

1350

0.16~0.22

1090

0.18~0.24

970

0.20~0.28

880

0.20~0.30

580

0.28~0.38

RPM

FEED

8750

0.03~0.06

5840

0.05~0.09

4380

0.07~0.11

2920

0.12~0.16

2190

0.12~0.18

1750

0.14~0.20

1350

0.16~0.22

1090

0.18~0.24

970

0.20~0.28

880

0.20~0.30

580

0.28~0.38

RPM

FEED

6370

0.03~0.06

4240

0.05~0.09

3180

0.07~0.11

2120

0.12~0.16

1590

0.12~0.18

1270

0.14~0.20

980

0.16~0.22

800

0.18~0.24

710

0.20~0.28

640

0.20~0.30

420

0.28~0.38

RPM

FEED

3180

0.02~0.04

2120

0.03~0.05

1590

0.04~0.06

1060

0.05~0.08

800

0.10~0.13

640

0.11~0.15

490

0.11~0.17

400

0.12~0.18

350

0.14~0.20

320

0.19~0.25

210

0.22~0.28

RPM

FEED

1590

0.01~0.03

1060

0.02~0.04

800

0.03~0.05

530

0.04~0.07

400

0.05~0.08

320

0.05~0.09

240

0.06~0.10

200

0.05~0.11

180

0.06~0.12

160

0.09~0.13

110

0.12~0.18

A262

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YG-1 CO., LTD.

STRAIGHT SHANK DRILLS

D1100

SERIES

HSS, TWIST DRILLS for BRASS / BRONZE

VC = M/MIN

RPM = rev./min.

FEED = mm/rev.

ISO

VDI 3323

Material Description

Vc

Parameter

Drill Diameter (mm)

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

N

27

Copper and Copper Alloys (Bronze / Brass)

28

Copper and Copper Alloys (Bronze / Brass)

Vc

Parameter

45

RPM

FEED

0.03~0.06

Vc

Parameter

30

RPM

FEED

0.01~0.03

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

9550

0.05~0.08

4770

0.06~0.10

3580

0.08~0.12

2860

0.10~0.14

2390

0.12~0.16

1790

0.16~0.20

1430

0.19~0.25

1100

0.22~0.32

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

6370

0.02~0.05

4770

0.03~0.06

3180

0.04~0.08

2390

0.05~0.09

1910

0.07~0.11

1190

0.09~0.13

950

0.10~0.16

730

0.11~0.21

D1106

SERIES

HSS, TWIST DRILLS for ALUMINUM

ISO

VDI 3323

Material Description

Vc

Parameter

Drill Diameter (mm)

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

N

21

Aluminum-wrought alloy

22

Aluminum-wrought alloy

23

Aluminum-cast, alloyed

24

Aluminum-cast, alloyed

Vc

Parameter

50

RPM

FEED

0.03~0.06

Vc

Parameter

50

RPM

FEED

0.03~0.06

Vc

Parameter

40

RPM

FEED

0.03~0.06

Vc

Parameter

30

RPM

FEED

0.01~0.04

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

10610

0.05~0.08

7960

0.06~0.10

5310

0.08~0.12

3980

0.10~0.14

3180

0.14~0.18

2650

0.14~0.20

1990

0.19~0.25

1590

0.25~0.35

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

10610

0.05~0.08

7960

0.06~0.10

5310

0.08~0.12

3980

0.10~0.14

3180

0.14~0.18

2650

0.14~0.20

1990

0.19~0.25

1590

0.25~0.35

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

8490

0.05~0.08

6370

0.06~0.10

4240

0.08~0.12

3180

0.10~0.14

2550

0.14~0.18

2120

0.14~0.20

1590

0.19~0.25

1270

0.25~0.35

980

0.25~0.35

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

6370

0.03~0.06

4770

0.05~0.08

3180

0.06~0.10

2390

0.08~0.12

1910

0.10~0.14

1590

0.14~0.18

1190

0.19~0.25

950

0.25~0.35

730

0.25~0.35

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YG-1 CO., LTD.

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D1100

SERIES

RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDPARAMETER

HSS, HSS-E & HSSCo8

COBALT DRILLS

VC = M/MIN

RPM = rev./min.

FEED = mm/rev.

ISO

VDI 3323

Material Description

Vc

Parameter

Drill Diameter (mm)

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

N

27

Copper and Copper Alloys (Bronze / Brass)

28

Copper and Copper Alloys (Bronze / Brass)

Vc

Parameter

45

RPM

FEED

0.03~0.06

Vc

Parameter

30

RPM

FEED

0.01~0.03

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

9550

0.05~0.08

4770

0.06~0.10

3580

0.08~0.12

2860

0.10~0.14

2390

0.12~0.16

1790

0.16~0.20

1430

0.19~0.25

1100

0.22~0.32

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

6370

0.02~0.05

4770

0.03~0.06

3180

0.04~0.08

2390

0.05~0.09

1910

0.07~0.11

1190

0.09~0.13

950

0.10~0.16

730

0.11~0.21

D1106

SERIES

HSS, TWIST DRILLS for ALUMINUM

ISO

VDI 3323

Material Description

Vc

Parameter

Drill Diameter (mm)

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

N

21

Aluminum-wrought alloy

22

Aluminum-wrought alloy

23

Aluminum-cast, alloyed

24

Aluminum-cast, alloyed

Vc

Parameter

50

RPM

FEED

0.03~0.06

Vc

Parameter

50

RPM

FEED

0.03~0.06

Vc

Parameter

40

RPM

FEED

0.03~0.06

Vc

Parameter

30

RPM

FEED

0.01~0.04

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

10610

0.05~0.08

7960

0.06~0.10

5310

0.08~0.12

3980

0.10~0.14

3180

0.14~0.18

2650

0.14~0.20

1990

0.19~0.25

1590

0.25~0.35

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

10610

0.05~0.08

7960

0.06~0.10

5310

0.08~0.12

3980

0.10~0.14

3180

0.14~0.18

2650

0.14~0.20

1990

0.19~0.25

1590

0.25~0.35

1.5

2.0

3.0

4.0

5.0

6.0

8.0

10.0

13.0

8490

0.05~0.08

6370

0.06~0.10

4240

0.08~0.12

3180

0.10~0.14

2550

0.14~0.18

2120

0.14~0.20

1590

0.19~0.25

1270

0.25~0.35

980

0.25~0.35

1.5

<

