



Leading Through Innovation



HSS & HSS-E

GOLD-P DRILLS

GOLD-P BOHRER

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

SELECTION GUIDE



SERIES	D1GP125	D1GP165
STANDARD	DIN338	DIN338
LENGTH	JOBBER	JOBBER
SIZE MIN	D1.0	D1.6
SIZE MAX	D13.0	D13.0
PAGE	206	209

SURFACE TREATMENT

TIN

HSS & HSS-E GOLD-P DRILLS

Same Performance as Full TIN-coated Drills

Please visit global.yg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.219

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		Ferritic	130		
20	Malleable cast iron	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 (Bronze / Brass)	Cutting Alloys, PB>1%	110	
	27			CuZn, CuSnZn (Brass)	90	
	28	CuSn, lead-free copper and electrolytic copper		100		
	29	Non Metallic Materials	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		Cast	400	42	
	41		Hardened Cast Iron	Hardened	550	55



SERIES	DLGP195	DLGP506
STANDARD	DIN338	DIN338
LENGTH	JOBBER	JOBBER
SIZE MIN	D1.0	D2.0
SIZE MAX	D13.0	D13.0
PAGE	212	215

SURFACE TREATMENT

TIN



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GOLD-P DRILL SETS

SET1	SET2	SET3	SET4
19pcs	25pcs	24pcs	91pcs
1.0mm ~ 10.0mm × 0.5mm step	1.0mm ~ 13.0mm × 0.5mm step	1.0mm ~ 10.5mm × 0.5mm step +3.3 +4.2 +6.8 +10.2	1.0mm ~ 10.0mm × 0.1mm step

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

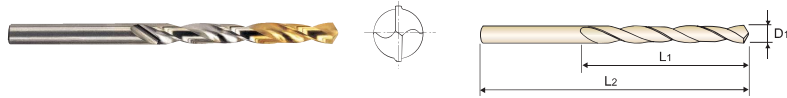
JOBBER

- 🇩🇪 HSS SPIRALBOHRER, GOLD-P BESCHICHTET
- 🇫🇷 Forets GOLD-P HSS queue cylindrique revêtus, série courte
- 🇮🇹 PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

- KURZ**
- COURTE**
- CORTA**

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 118°, Normal point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶ **Nutenform** : Rechtsspirale
- ▶ **Spitzenwinkel** : 118° Normalanschliff
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125010	1.0	12	34	D1GP125036	3.6	39	70
D1GP125011	1.1	14	36	D1GP125037	3.7	39	70
D1GP125012	1.2	16	38	D1GP125038	3.8	43	75
D1GP125013	1.3	16	38	D1GP125039	3.9	43	75
D1GP125014	1.4	18	40	D1GP125040	4.0	43	75
D1GP125015	1.5	18	40	D1GP125041	4.1	43	75
D1GP125016	1.6	20	43	D1GP125042	4.2	43	75
D1GP125017	1.7	20	43	D1GP125043	4.3	47	80
D1GP125018	1.8	22	46	D1GP125044	4.4	47	80
D1GP125019	1.9	22	46	D1GP125045	4.5	47	80
D1GP125020	2.0	24	49	D1GP125046	4.6	47	80
D1GP125021	2.1	24	49	D1GP125047	4.7	47	80
D1GP125022	2.2	27	53	D1GP125048	4.8	52	86
D1GP125023	2.3	27	53	D1GP125049	4.9	52	86
D1GP125024	2.4	30	57	D1GP125050	5.0	52	86
D1GP125025	2.5	30	57	D1GP125051	5.1	52	86
D1GP125026	2.6	30	57	D1GP125052	5.2	52	86
D1GP125027	2.7	33	61	D1GP125053	5.3	52	86
D1GP125028	2.8	33	61	D1GP125054	5.4	57	93
D1GP125029	2.9	33	61	D1GP125055	5.5	57	93
D1GP125030	3.0	33	61	D1GP125056	5.6	57	93
D1GP125031	3.1	36	65	D1GP125057	5.7	57	93
D1GP125032	3.2	36	65	D1GP125058	5.8	57	93
D1GP125033	3.3	36	65	D1GP125059	5.9	57	93
D1GP125034	3.4	39	70	D1GP125060	6.0	57	93
D1GP125035	3.5	39	70	D1GP125061	6.1	63	101

▶ NEXT PAGE

◎ : 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 3523	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

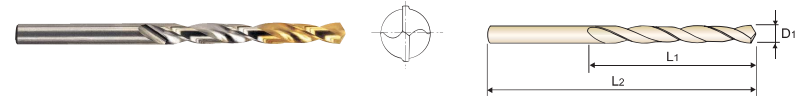
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- KURZ**
- COURTE**
- CORTA**

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 118°, Normal point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶ **Nutenform** : Rechtsspirale
- ▶ **Spitzenwinkel** : 118° Normalanschliff
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



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

▶ NEXT PAGE

◎ : 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 3523	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

D1GP125 SERIES

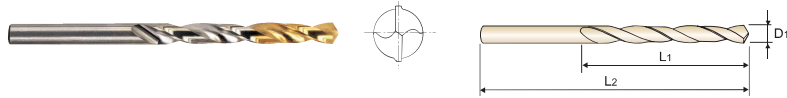
HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

- HSS SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS queue cylindrique revêtus, série courte
- PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

KURZ
COURTE
CORTA

- Flute Geometry** : Right hand helix
- Point Angle** : 118°, Normal point
- Surface treatment** : Bright body, TiN coating on working area
- Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron
- Nutenform** : Rechtsspirale
- Spitzenwinkel** : 118° Normalanschliff
- Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125114	11.4	94	142	D1GP125123	12.3	101	151
D1GP125115	11.5	94	142	D1GP125124	12.4	101	151
D1GP125116	11.6	94	142	D1GP125125	12.5	101	151
D1GP125117	11.7	94	142	D1GP125126	12.6	101	151
D1GP125118	11.8	94	142	D1GP125127	12.7	101	151
D1GP125119	11.9	101	151	D1GP125128	12.8	101	151
D1GP125120	12.0	101	151	D1GP125129	12.9	101	151
D1GP125121	12.1	101	151	D1GP125130	13.0	101	151
D1GP125122	12.2	101	151				

YG GOLD-P DRILLS

D1GP165 SERIES

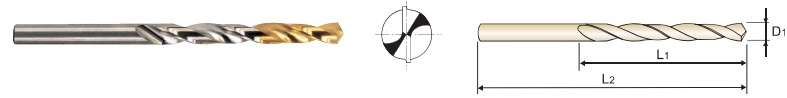
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EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP165016	1.6	20	43	D1GP165042	4.2	43	75
D1GP165017	1.7	20	43	D1GP165043	4.3	47	80
D1GP165018	1.8	22	46	D1GP165044	4.4	47	80
D1GP165019	1.9	22	46	D1GP165045	4.5	47	80
D1GP165020	2.0	24	49	D1GP165046	4.6	47	80
D1GP165021	2.1	24	49	D1GP165047	4.7	47	80
D1GP165022	2.2	27	53	D1GP165048	4.8	52	86
D1GP165023	2.3	27	53	D1GP165049	4.9	52	86
D1GP165024	2.4	30	57	D1GP165050	5.0	52	86
D1GP165025	2.5	30	57	D1GP165051	5.1	52	86
D1GP165026	2.6	30	57	D1GP165052	5.2	52	86
D1GP165027	2.7	33	61	D1GP165053	5.3	52	86
D1GP165028	2.8	33	61	D1GP165054	5.4	57	93
D1GP165029	2.9	33	61	D1GP165055	5.5	57	93
D1GP165030	3.0	33	61	D1GP165056	5.6	57	93
D1GP165031	3.1	36	65	D1GP165057	5.7	57	93
D1GP165032	3.2	36	65	D1GP165058	5.8	57	93
D1GP165033	3.3	36	65	D1GP165059	5.9	57	93
D1GP165034	3.4	39	70	D1GP165060	6.0	57	93
D1GP165035	3.5	39	70	D1GP165061	6.1	63	101
D1GP165036	3.6	39	70	D1GP165062	6.2	63	101
D1GP165037	3.7	39	70	D1GP165063	6.3	63	101
D1GP165038	3.8	43	75	D1GP165064	6.4	63	101
D1GP165039	3.9	43	75	D1GP165065	6.5	63	101
D1GP165040	4.0	43	75	D1GP165066	6.6	63	101
D1GP165041	4.1	43	75	D1GP165067	6.7	63	101

▶ NEXT PAGE

◎ : 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	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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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	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

D1GP165 SERIES

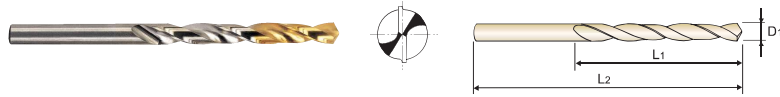
HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

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KURZ
COURTE
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- Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



Unit : mm				Unit : mm			
EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP165068	6.8	69	109	D1GP165094	9.4	81	125
D1GP165069	6.9	69	109	D1GP165095	9.5	81	125
D1GP165070	7.0	69	109	D1GP165096	9.6	87	133
D1GP165071	7.1	69	109	D1GP165097	9.7	87	133
D1GP165072	7.2	69	109	D1GP165098	9.8	87	133
D1GP165073	7.3	69	109	D1GP165099	9.9	87	133
D1GP165074	7.4	69	109	D1GP165100	10.0	87	133
D1GP165075	7.5	69	109	D1GP165101	10.1	87	133
D1GP165076	7.6	75	117	D1GP165102	10.2	87	133
D1GP165077	7.7	75	117	D1GP165103	10.3	87	133
D1GP165078	7.8	75	117	D1GP165104	10.4	87	133
D1GP165079	7.9	75	117	D1GP165105	10.5	87	133
D1GP165080	8.0	75	117	D1GP165106	10.6	87	133
D1GP165081	8.1	75	117	D1GP165107	10.7	94	142
D1GP165082	8.2	75	117	D1GP165108	10.8	94	142
D1GP165083	8.3	75	117	D1GP165109	10.9	94	142
D1GP165084	8.4	75	117	D1GP165110	11.0	94	142
D1GP165085	8.5	75	117	D1GP165111	11.1	94	142
D1GP165086	8.6	81	125	D1GP165112	11.2	94	142
D1GP165087	8.7	81	125	D1GP165113	11.3	94	142
D1GP165088	8.8	81	125	D1GP165114	11.4	94	142
D1GP165089	8.9	81	125	D1GP165115	11.5	94	142
D1GP165090	9.0	81	125	D1GP165116	11.6	94	142
D1GP165091	9.1	81	125	D1GP165117	11.7	94	142
D1GP165092	9.2	81	125	D1GP165118	11.8	94	142
D1GP165093	9.3	81	125	D1GP165119	11.9	101	151

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	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	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			31	32	33	34	35	36	37	38	39	40	41
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

D1GP165 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

- HSS SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS queue cylindrique revêtus, série courte
- PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

KURZ
COURTE
CORTA

- Flute Geometry** : Right hand helix
- Point Angle** : 118°, Split point
- Surface treatment** : Bright body, TiN coating on working area
- Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron
- Nutenform** : Rechtsspirale
- Spitzenwinkel** : 118° Kreuzanschliff
- Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



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

◎ : Excellent ○ : Good

ISO Material Description	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	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			31	32	33	34	35	36	37	38	39	40	41
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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HSS-E, STRAIGHT SHANK DRILLS, GOLD-P COATED

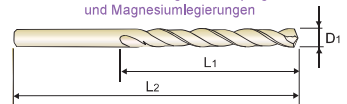
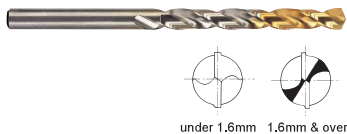
JOBBER

- HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, série courte
- PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

- KURZ**
- COURTE**
- CORTA**

- **Flute Geometry** : Right hand helix
- **Point Angle** : 135°, unter 1,6mm : Normal point
1,6mm & over : Split point
- **Surface treatment** : Bright body, TiN coating on working area
- **Application** : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 135°, unter 1,6mm : Normalanschleiß
1,6mm & über : Kreuzanschleiß
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen



under 1.6mm 1.6mm & over



EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195011	1.1	14	36
DLGP195012	1.2	16	38
DLGP195013	1.3	16	38
DLGP195014	1.4	18	40
DLGP195015	1.5	18	40
DLGP195016	1.6	20	43
DLGP195017	1.7	20	43
DLGP195018	1.8	22	46
DLGP195019	1.9	22	46
DLGP195020	2.0	24	49
DLGP195021	2.1	24	49
DLGP195022	2.2	27	53
DLGP195023	2.3	27	53
DLGP195024	2.4	30	57
DLGP195025	2.5	30	57
DLGP195026	2.6	30	57
DLGP195027	2.7	33	61
DLGP195028	2.8	33	61
DLGP195029	2.9	33	61
DLGP195030	3.0	33	61
DLGP195031	3.1	36	65
DLGP195032	3.2	36	65
DLGP195033	3.3	36	65
DLGP195034	3.4	39	70
DLGP195035	3.5	39	70

Unit : mm

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	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						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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							
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	60	100	75	90	130	110	90	100			31	200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

HSS-E, STRAIGHT SHANK DRILLS, GOLD-P COATED

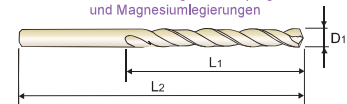
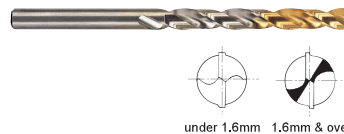
JOBBER

- HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, série courte
- PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

- KURZ**
- COURTE**
- CORTA**

- **Flute Geometry** : Right hand helix
- **Point Angle** : 135°, unter 1,6mm : Normal point
1,6mm & over : Split point
- **Surface treatment** : Bright body, TiN coating on working area
- **Application** : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 135°, unter 1,6mm : Normalanschleiß
1,6mm & über : Kreuzanschleiß
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen



under 1.6mm 1.6mm & over



EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195063	6.3	63	101
DLGP195064	6.4	63	101
DLGP195065	6.5	63	101
DLGP195066	6.6	63	101
DLGP195067	6.7	63	101
DLGP195068	6.8	69	109
DLGP195069	6.9	69	109
DLGP195070	7.0	69	109
DLGP195071	7.1	69	109
DLGP195072	7.2	69	109
DLGP195073	7.3	69	109
DLGP195074	7.4	69	109
DLGP195075	7.5	69	109
DLGP195076	7.6	75	117
DLGP195077	7.7	75	117
DLGP195078	7.8	75	117
DLGP195079	7.9	75	117
DLGP195080	8.0	75	117
DLGP195081	8.1	75	117
DLGP195082	8.2	75	117
DLGP195083	8.3	75	117
DLGP195084	8.4	75	117
DLGP195085	8.5	75	117
DLGP195086	8.6	81	125
DLGP195087	8.7	81	125

Unit : mm

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	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						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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							
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	60	100	75	90	130	110	90	100			31	200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

DLGP195 SERIES

HSS-E, STRAIGHT SHANK DRILLS, GOLD-P COATED

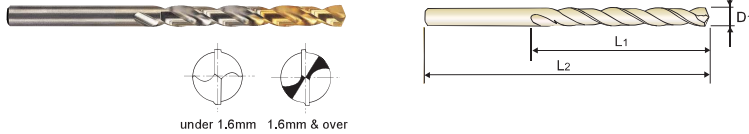
JOBBER

- HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, série courte
- PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

KURZ
COURTE
CORTA

- **Flute Geometry** : Right hand helix
- **Point Angle** : 135°, under 1,6mm : Normal point
1,6mm & over : Split point
- **Surface treatment** : Bright body, TiN coating on working area
- **Application** : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

- **Nutenform** : Rechtsspirale
- **Spitzenwinkel** : 135°, unter 1,6mm : Normalanschiff
1,6mm & über : Kreuzanschiff
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen



Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195114	11.4	94	142
DLGP195115	11.5	94	142
DLGP195116	11.6	94	142
DLGP195117	11.7	94	142
DLGP195118	11.8	94	142
DLGP195119	11.9	101	151
DLGP195120	12.0	101	151
DLGP195121	12.1	101	151
DLGP195122	12.2	101	151

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195123	12.3	101	151
DLGP195124	12.4	101	151
DLGP195125	12.5	101	151
DLGP195126	12.6	101	151
DLGP195127	12.7	101	151
DLGP195128	12.8	101	151
DLGP195129	12.9	101	151
DLGP195130	13.0	101	151

YG GOLD-P DRILLS

DLGP506 SERIES

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

JOBBER

- HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte
- PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

KURZ
COURTE
CORTA

- **Flute Geometry** : Right hand, 38° helix, DH100 worm pattern type.
- **Point Angle** : 130°, Split point giving higher chip removal.
- **Surface treatment** : Bright body, TiN coating on working area.
- **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, or magnesium alloys.

- **Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
- **Spitzenwinkel** : Durch 130° Kreuzanschiff Gute Spanabfuhr
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen



► DH100 worm pattern drills

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506020	2.0	24	49
DLGP506021	2.1	24	49
DLGP506022	2.2	27	53
DLGP506023	2.3	27	53
DLGP506024	2.4	30	57
DLGP506025	2.5	30	57
DLGP506026	2.6	30	57
DLGP506027	2.7	33	61
DLGP506028	2.8	33	61
DLGP506029	2.9	33	61
DLGP506030	3.0	33	61
DLGP506031	3.1	36	65
DLGP506032	3.2	36	65
DLGP506033	3.3	36	65
DLGP506034	3.4	39	70
DLGP506035	3.5	39	70
DLGP506036	3.6	39	70
DLGP506037	3.7	39	70
DLGP506038	3.8	43	75
DLGP506039	3.9	43	75
DLGP506040	4.0	43	75
DLGP506041	4.1	43	75
DLGP506042	4.2	43	75
DLGP506043	4.3	47	80
DLGP506044	4.4	47	80
DLGP506045	4.5	47	80

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506046	4.6	47	80
DLGP506047	4.7	47	80
DLGP506048	4.8	52	86
DLGP506049	4.9	52	86
DLGP506050	5.0	52	86
DLGP506051	5.1	52	86
DLGP506052	5.2	52	86
DLGP506053	5.3	52	86
DLGP506054	5.4	57	93
DLGP506055	5.5	57	93
DLGP506056	5.6	57	93
DLGP506057	5.7	57	93
DLGP506058	5.8	57	93
DLGP506059	5.9	57	93
DLGP506060	6.0	57	93
DLGP506061	6.1	63	101
DLGP506062	6.2	63	101
DLGP506063	6.3	63	101
DLGP506064	6.4	63	101
DLGP506065	6.5	63	101
DLGP506066	6.6	63	101
DLGP506067	6.7	63	101
DLGP506068	6.8	69	109
DLGP506069	6.9	69	109
DLGP506070	7.0	69	109
DLGP506071	7.1	69	109

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			31	32	33	34	35	36	37	38	39	40	41
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

DLGP506 SERIES

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

JOBBER

- HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte
- PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

KURZ
COURTE
CORTA

- **Flute Geometry** : Right hand, 38° helix, DH100 worm pattern type.
- **Point Angle** : 130°, Split point giving higher chip removal.
- **Surface treatment** : Bright body, TiN coating on working area.
- **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, or magnesium alloys.

- **Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
- **Spitzenwinkel** : Durch 130° Kreuzanschiff Gute Spanabfuhr
- **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- **Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen



► DH100 worm pattern drills

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506020	2.0	24	49
DLGP506021	2.1	24	49
DLGP506022	2.2	27	53
DLGP506023	2.3	27	53
DLGP506024	2.4	30	57
DLGP506025	2.5	30	57
DLGP506026	2.6	30	57
DLGP506027	2.7	33	61
DLGP506028	2.8	33	61
DLGP506029	2.9	33	61
DLGP506030	3.0	33	61
DLGP506031	3.1	36	65
DLGP506032	3.2	36	65
DLGP506033	3.3	36	65
DLGP506034	3.4	39	70
DLGP506035	3.5	39	70
DLGP506036	3.6	39	70
DLGP506037	3.7	39	70
DLGP506038	3.8	43	75
DLGP506039	3.9	43	75
DLGP506040	4.0	43	75
DLGP506041	4.1	43	75
DLGP506042	4.2	43	75
DLGP506043	4.3	47	80
DLGP506044	4.4	47	80
DLGP506045	4.5	47	80

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506046	4.6	47	80
DLGP506047	4.7	47	80
DLGP506048	4.8	52	86
DLGP506049	4.9	52	86
DLGP506050	5.0	52	86
DLGP506051	5.1	52	86
DLGP506052	5.2	52	86
DLGP506053	5.3	52	86
DLGP506054	5.4	57	93
DLGP506055	5.5	57	93
DLGP506056	5.6	57	93
DLGP506057	5.7	57	93
DLGP506058	5.8	57	93
DLGP506059	5.9	57	93
DLGP506060	6.0	57	93
DLGP506061	6.1	63	101
DLGP506062	6.2	63	101
DLGP506063	6.3	63	101
DLGP506064	6.4	63	101
DLGP506065	6.5	63	101
DLGP506066	6.6	63	101
DLGP506067	6.7	63	101
DLGP506068	6.8	69	109
DLGP506069	6.9	69	109
DLGP506070	7.0	69	109
DLGP506071	7.1	69	109

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	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				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			31	32	33	34	35	36	37	38	39	40	41
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

DLGP506 SERIES

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

● HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET KURZ
● Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte COURTE
● PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P CORTA

- | | |
|---|--|
| <p>► Flute Geometry : Right hand, 38° helix, DH100 worm pattern type.</p> <p>► Point Angle : 130°, Split point giving higher chip removal.</p> <p>► Surface treatment : Bright body, TiN coating on working area.</p> <p>► Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, or magnesium alloys.</p> | <p>► Nutenform : 38° Rechtsspirale, DH 100 Flachnut</p> <p>► Spitzenwinkel : Durch 130° Kreuzanschliff Gute Spanabfuhr</p> <p>► Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich</p> <p>► Anwendung : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen</p> |
|---|--|



DIN 338
HSS-E
38°
h8
130°
P.219

► DH100 worm pattern drills

Unit : mm				Unit : mm			
EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506072	7.2	69	109	DLGP506098	9.8	87	133
DLGP506073	7.3	69	109	DLGP506099	9.9	87	133
DLGP506074	7.4	69	109	DLGP506100	10.0	87	133
DLGP506075	7.5	69	109	DLGP506101	10.1	87	133
DLGP506076	7.6	75	117	DLGP506102	10.2	87	133
DLGP506077	7.7	75	117	DLGP506103	10.3	87	133
DLGP506078	7.8	75	117	DLGP506104	10.4	87	133
DLGP506079	7.9	75	117	DLGP506105	10.5	87	133
DLGP506080	8.0	75	117	DLGP506106	10.6	87	133
DLGP506081	8.1	75	117	DLGP506107	10.7	94	142
DLGP506082	8.2	75	117	DLGP506108	10.8	94	142
DLGP506083	8.3	75	117	DLGP506109	10.9	94	142
DLGP506084	8.4	75	117	DLGP506110	11.0	94	142
DLGP506085	8.5	75	117	DLGP506111	11.1	94	142
DLGP506086	8.6	81	125	DLGP506112	11.2	94	142
DLGP506087	8.7	81	125	DLGP506113	11.3	94	142
DLGP506088	8.8	81	125	DLGP506114	11.4	94	142
DLGP506089	8.9	81	125	DLGP506115	11.5	94	142
DLGP506090	9.0	81	125	DLGP506116	11.6	94	142
DLGP506091	9.1	81	125	DLGP506117	11.7	94	142
DLGP506092	9.2	81	125	DLGP506118	11.8	94	142
DLGP506093	9.3	81	125	DLGP506119	11.9	101	151
DLGP506094	9.4	81	125	DLGP506120	12.0	101	151
DLGP506095	9.5	81	125	DLGP506121	12.1	101	151
DLGP506096	9.6	87	133	DLGP506122	12.2	101	151
DLGP506097	9.7	87	133	DLGP506123	12.3	101	151

► NEXT PAGE

◎ : 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	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

DLGP506 SERIES

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

● HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET KURZ
● Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte COURTE
● PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P CORTA

- | | |
|---|--|
| <p>► Flute Geometry : Right hand, 38° helix, DH100 worm pattern type.</p> <p>► Point Angle : 130°, Split point giving higher chip removal.</p> <p>► Surface treatment : Bright body, TiN coating on working area.</p> <p>► Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, or magnesium alloys.</p> | <p>► Nutenform : 38° Rechtsspirale, DH 100 Flachnut</p> <p>► Spitzenwinkel : Durch 130° Kreuzanschliff Gute Spanabfuhr</p> <p>► Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich</p> <p>► Anwendung : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen</p> |
|---|--|



DIN 338
HSS-E
38°
h8
130°
P.219

► DH100 worm pattern drills

Unit : mm				Unit : mm			
EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506124	12.4	101	151	DLGP506128	12.8	101	151
DLGP506125	12.5	101	151	DLGP506129	12.9	101	151
DLGP506126	12.6	101	151	DLGP506130	13.0	101	151
DLGP506127	12.7	101	151				

◎ : 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	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG GOLD-P DRILLS

GOLD-P COATED DRILL SETS

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



DIN338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

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

YG GOLD-P DRILLS

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**

D1GP125, D1GP165, DLGP195, DLGP506 SERIES HSS & HSS-E GOLD-P DRILLS RPM = rev./min. FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)						
					2.0	3.0	4.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	40	RPM	6370	4240	3180	2120	1590	1270	980
			FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
			35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
			30	RPM	4770	3180	2390	1590	1190	950	730
	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24			
	20	RPM	3180	2120	1590	1060	800	640	490		
	FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18			
	6	Low alloy steel	35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
			30	RPM	4770	3180	2390	1590	1190	950	730
FEED			0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
30			RPM	4770	3180	2390	1590	1190	950	730	
FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18				
10	High alloyed steel, and tool steel	20	RPM	3180	2120	1590	1060	800	640	490	
		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
M	Stainless steel	25	RPM	3980	2650	1990	1330	990	800	610	
		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
		20	RPM	3180	2120	1590	1060	800	640	490	
FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24				
15	FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18			
K	Grey cast iron	40	RPM	6370	4240	3180	2120	1590	1270	980	
		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
	35	FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18		
	Nodular cast iron	40	RPM	6370	4240	3180	2120	1590	1270	980	
		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
	30	FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18		
Malleable cast iron	35	RPM	5570	3710	2790	1860	1390	1110	860		
	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24			
30	RPM	4770	3180	2390	1590	1190	950	730			
FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18				
N	Aluminum-wrought alloy	65	RPM	10350	6900	5170	3450	2590	2070	1590	
		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28		
	Aluminum-cast, alloyed	65	RPM	10350	6900	5170	3450	2590	2070	1590	
		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28		
	Copper and Copper Alloys (Bronze / Brass)	50	RPM	7960	5310	3980	2650	1990	1590	1220	
		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28		
	Non Metallic Materials	30	RPM	4770	3180	2390	1590	1190	950	730	
		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24		
	S	Heat Resistant Super Alloys									
Titanium Alloys		20	RPM	3180	2120	1590	1060	800	640	490	
		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.13	0.08-0.14		
H	Hardened steel										
	Chilled Cast Iron										