



Leading Through Innovation

SOLID CARBIDE

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS - FLACHBOHRER

- For Holes on Various Angled Surfaces
- Für Bohrungen auf verschiedenen abgewinkelten Oberflächen

- ▶ Pilot Drilling Diameter : same size diameter

CARBIDE

HSS

DREAM DRILLS

- FLAT BOTTOM

DPP447

SERIES

CARBIDE, DREAM DRILLS - FLAT BOTTOM

VHM, DREAM DRILLS - FLACHBOHRER

DREAM DRILLS - FOND PLAT, FORET CARBURE MONOBLOC

PUNTE IN MD DREAM DRILLS, TESTA PIANA

SHORT

KURZ

COURTE

CORTA

► For holes on various angled surfaces.

► 180 degree point angle enables drilling of flat, inclined and curved surfaces.

► Optimized flute shape for excellent chip evacuation.

► High strength cutting edge to improve tool life and versatility drilling.

► For through holes, minimized burrs at entrance and exit when drilling thin plate.

Für Bohrungen auf verschiedenen abgewinkelten Flächen.

Der 180-Grad-Spitzenwinkel ermöglicht das Bohren von flachen, geneigten und gekrümmten Oberflächen.

Optimierte Nutenform für hervorragende Spanabfuhr.

Hochfeste Schneide zur Verbesserung der Standzeit und Vielseitigkeit beim Bohren.

Für Durchgangsbohrungen, minimierter Grat am Ein- und Austritt beim Bohren von dünnen Blechen.

CARBIDE

20°

h6

h7

180°

X Coating

p.A132

2 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447030	3.0	6	16	50
DPP447031	3.1	6	16	50
DPP447032	3.2	6	16	50
DPP447033	3.3	6	16	50
DPP447034	3.4	6	18	50
DPP447035	3.5	6	18	50
DPP447036	3.6	6	18	50
DPP447037	3.7	6	18	50
DPP447038	3.8	6	18	50
DPP447039	3.9	6	18	50
DPP447040	4.0	6	18	50
DPP447041	4.1	6	20	60
DPP447042	4.2	6	20	60
DPP447043	4.3	6	20	60
DPP447044	4.4	6	20	60
DPP447045	4.5	6	22	60
DPP447046	4.6	6	22	60
DPP447047	4.7	6	22	60
DPP447048	4.8	6	22	60
DPP447049	4.9	6	22	60
DPP447050	5.0	6	22	60
DPP447051	5.1	6	24	60
DPP447052	5.2	6	24	60
DPP447053	5.3	6	24	60
DPP447054	5.4	6	24	60
DPP447055	5.5	6	24	60

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447056	5.6	6	24	60
DPP447057	5.7	6	26	60
DPP447058	5.8	6	26	60
DPP447059	5.9	6	26	60
DPP447060	6.0	6	26	60
DPP447061	6.1	8	28	70
DPP447062	6.2	8	28	70
DPP447063	6.3	8	28	70
DPP447064	6.4	8	30	70
DPP447065	6.5	8	30	70
DPP447068	6.8	8	30	70
DPP447069	6.9	8	30	70
DPP447070	7.0	8	30	70
DPP447071	7.1	8	34	70
DPP447072	7.2	8	34	70
DPP447074	7.4	8	34	70
DPP447075	7.5	8	34	70
DPP447076	7.6	8	34	70
DPP447077	7.7	8	34	70
DPP447078	7.8	8	34	70
DPP447079	7.9	8	34	70
DPP447080	8.0	8	34	70
DPP447081	8.1	10	38	80
DPP447082	8.2	10	38	80
DPP447083	8.3	10	38	80
DPP447084	8.4	10	38	80

► Other diameters and shank types are available upon request.

► NEXT PAGE

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

K

Grey cast iron

Nodular cast iron

Malleable cast iron

1

2

3

4

5

6

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10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

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N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

H

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

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27

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31

32

33

34

35

36

37

38

39

40

41

60

100

75

90

130

110

90

100

15

30

25

38

34

400 Rm

1050 Rm

550

630

400

550

○

○

A128

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

YG-1 CO., LTD.

CARBIDE

HSS

DREAM DRILLS

- FLAT BOTTOM

DPP447

SERIES

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2 × D

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447085	8.5	10	38	80
DPP447086	8.6	10	38	80
DPP447087	8.7	10	40	80
DPP447088	8.8	10	40	80
DPP447089	8.9	10	40	80
DPP447090	9.0	10	40	80
DPP447091	9.1	10	42	80
DPP447092	9.2	10	42	80
DPP447093	9.3	10	42	80
DPP447094	9.4	10	42	80
DPP447095	9.5	10	42	80
DPP447096	9.6	10	42	80
DPP447097	9.7	10	45	80
DPP447099	9.9	10	45	80
DPP447100	10.0	10	45	80
DPP447102	10.2	12	46	90
DPP447103	10.3	12	46	90
DPP447104	10.4	12	48	90
DPP447105	10.5	12	48	90
DPP447107	10.7	12	48	90
DPP447108	10.8	12	48	90
DPP447109	10.9	12	48	90
DPP447110	11.0	12	48	90
DPP447111	11.1	12	50	90
DPP447112	11.2	12	50	90
DPP447113	11.3	12	50	90

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447114	11.4	12	50	90
DPP447115	11.5	12	50	90
DPP447116	11.6	12	50	90
DPP447117	11.7	12	52	90
DPP447118	11.8	12	52	90
DPP447119	11.9	12	52	90
DPP447120	12.0	12	52	90
DPP447125	12.5	14	54	100
DPP447130	13.0	14	56	100
DPP447135	13.5	14	58	100
DPP447140	14.0	14	58	100
DPP447145	14.5	16	62	105
DPP447150	15.0	16	62	105
DPP447155	15.5	16	64	115
DPP447160	16.0	16	64	115
DPP447165	16.5	18	70	125
DPP447170	17.0	18	70	125
DPP447175	17.5	18	70	125
DPP447180	18.0	18	70	125
DPP447185	18.5	20	75	135
DPP447190	19.0	20	75	135
DPP447200	20.0	20	75	145

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110

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A129

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DPP447130	13.0	14	56	100
DPP447135	13.5	14	58	100
DPP447140	14.0	14	58	100
DPP447145	14.5	16	62	105
DPP447150	15.0	16	62	105
DPP447155	15.5	16	64	115
DPP447160	16.0	16	64	115
DPP447165	16.5	18	70	125
DPP447170	17.0	18	70	125
DPP447175	17.5	18	70	125
DPP447180	18.0	18	70	125
DPP447185	18.5	20	75	135
DPP447190	19.0	20	75	135
DPP447200	20.0	20	75	145

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270

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275

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325

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240

180

180

260

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS X

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

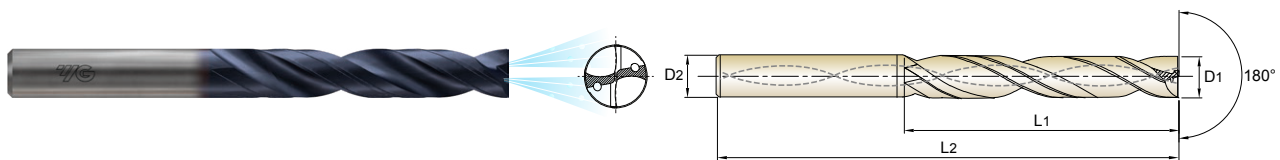
YIG DREAM DRILLS - FLAT BOTTOM

DH450 SERIES

CARBIDE, DREAM DRILLS - FLAT BOTTOM with COOLANT HOLES *LONG KURZ LONGUE LUNGA*

🇧🇪 **VHM, DREAM DRILLS - FLACHBOHRER**
🇫🇷 **DREAM DRILLS - FOND PLAT, FORET CARBURE MONOBLOC**
🇮🇹 **PUNTE IN MD DREAM DRILLS, TESTA PIANA**

- For holes on various angled surfaces.
► 180 degree point angle enables drilling of flat, inclined and curved surfaces.
► Optimized flute shape for excellent chip evacuation.
► High strength cutting edge to improve tool life and versatility drilling.
► For through holes, minimized burrs at entrance and exit when drilling thin plate.
► Pilot Drilling for 5XD
- Für Bohrungen auf verschiedenen abgewinkelten Flächen.
► Der 180-Grad-Spitzenwinkel ermöglicht das Bohren von flachen, geneigten und gekrümmten Oberflächen.
► Optimierte Nutenform für hervorragende Spanabfuhr.
► Hochfeste Schneide zur Verbesserung der Standzeit und Vielseitigkeit beim Bohren.
► Für Durchgangsbohrungen, minimierter Grat am Ein- und Austritt beim Bohren von dünnen Blechen.
► Pilotbohren 5XD



DIN 6537

CARBIDE

30°

h6

h7

180°

20 bar

TiAIN

p.A133

5 × D

Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAIN	D1	D2	L1	L2	TiAIN	D1	D2	L1	L2
DH450030	3.0	6	28	66	DH450057	5.7	6	44	82
DH450031	3.1	6	28	66	DH450058	5.8	6	44	82
DH450032	3.2	6	28	66	DH450059	5.9	6	44	82
DH450033	3.3	6	28	66	DH450060	6.0	6	44	82
DH450034	3.4	6	28	66	DH450061	6.1	8	53	91
DH450035	3.5	6	28	66	DH450062	6.2	8	53	91
DH450036	3.6	6	28	66	DH450063	6.3	8	53	91
DH450037	3.7	6	28	66	DH450064	6.4	8	53	91
DH450038	3.8	6	36	74	DH450065	6.5	8	53	91
DH450039	3.9	6	36	74	DH450066	6.6	8	53	91
DH450040	4.0	6	36	74	DH450067	6.7	8	53	91
DH450041	4.1	6	36	74	DH450068	6.8	8	53	91
DH450042	4.2	6	36	74	DH450069	6.9	8	53	91
DH450043	4.3	6	36	74	DH450070	7.0	8	53	91
DH450044	4.4	6	36	74	DH450073	7.3	8	53	91
DH450046	4.6	6	36	74	DH450074	7.4	8	53	91
DH450047	4.7	6	36	74	DH450075	7.5	8	53	91
DH450048	4.8	6	44	82	DH450076	7.6	8	53	91
DH450049	4.9	6	44	82	DH450077	7.7	8	53	91
DH450050	5.0	6	44	82	DH450078	7.8	8	53	91
DH450051	5.1	6	44	82	DH450079	7.9	8	53	91
DH450052	5.2	6	44	82	DH450080	8.0	8	53	91
DH450053	5.3	6	44	82	DH450081	8.1	10	61	103
DH450054	5.4	6	44	82	DH450082	8.2	10	61	103
DH450055	5.5	6	44	82	DH450083	8.3	10	61	103
DH450056	5.6	6	44	82	DH450084	8.4	10	61	103

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◎ : Excellent ○ : Good																				
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	20
HB		125	190	250	270	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	36	37	55	60	42
HB											200	280	250	350	320	400 Rm	1050 Rm	550	630	400
Recommended	○	○																		

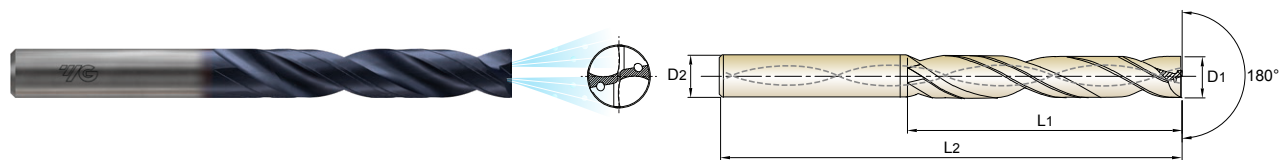
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► Pilotbohren 5XD



DIN 6537

CARBIDE

30°

h6

h7

180°

20 bar

TiAIN

p.A133

5 × D

Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
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DH450086	8.6	10	61	103	DH450160	16.0	16	83	133
DH450087	8.7	10	61	103	DH450170	17.0	18	93	143
DH450088	8.8	10	61	103	DH450175	17.5	18	93	143
DH450089	8.9	10	61	103	DH450180	18.0	18	93	143
DH450090	9.0	10	61	103	DH450190	19.0	20	101	153
DH450091	9.1	10	61	103	DH450200	20.0	20	101	153
DH450092	9.2	10	61	103					
DH450093	9.3	10	61	103					
DH450095	9.5	10	61	103					
DH450097	9.7	10	61	103					
DH450098	9.8	10	61	103					
DH450100	10.0	10	61	103					
DH450102	10.2	12	71	118					
DH450105	10.5	12	71	118					
DH450110	11.0	12	71	118					
DH450115	11.5	12	71	118					
DH450118	11.8	12	71	118					
DH450119	11.9	12	71	118					
DH450120	12.0	12	71	118					
DH450125	12.5	14	77	124					
DH450130	13.0	14	77	124					
DH450135	13.5	14	77	124					
DH450140	14.0	14	77	124					
DH450145	14.5	16	83	133					
DH450150	15.0	16	83	133					

► Other diameters and shank types are available upon request.

Drill Diameter (mm)	Corner Chamfer (mm)
Ø3.0 ~ Ø6.0	0.06
Ø6.1 ~ Ø10.0	0.12
Ø10.1 ~ Ø14.0	0.18
Ø14.1 ~ Ø20.0	0.26

◎ : 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	36	37	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	○	○																			

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS X

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

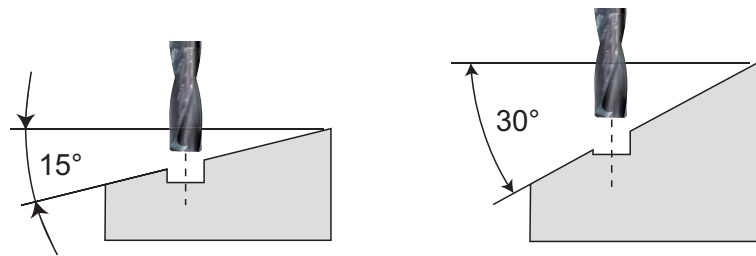
YG DREAM DRILLS - FLAT BOTTOM

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**

DPP447 SERIES without COOLANT HOLES (2XD)

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

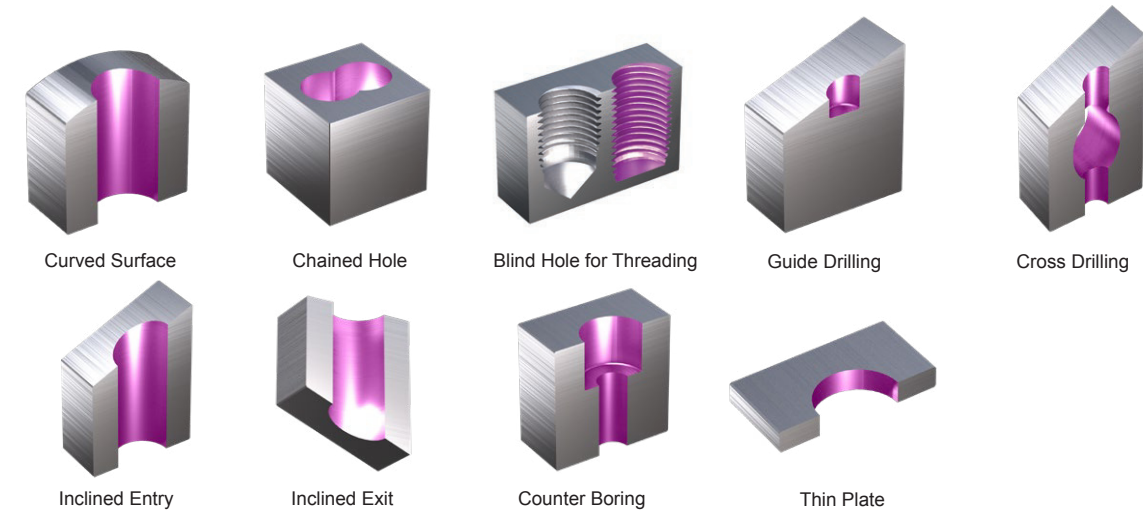
ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1	Non-alloy steel	80	RPM	8490	6370	5090	4240	3180	2550	2120	1590	1270
	FEED			0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.08-0.14	0.11-0.17	0.11-0.21	0.18-0.28	0.28-0.38	
	2		80	RPM	8490	6370	5090	4240	3180	2550	2120	1590	1270
				FEED	0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.08-0.14	0.11-0.17	0.11-0.21	0.18-0.28	0.28-0.38
	3	70	RPM	7430	5570	4460	3710	2790	2230	1860	1390	1110	
			FEED	0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.07-0.13	0.11-0.17	0.11-0.21	0.18-0.28	0.24-0.34	
	4	40	RPM	4240	3180	2550	2120	1590	1270	1060	800	640	
			FEED	0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.07-0.13	0.11-0.17	0.11-0.21	0.18-0.28	0.24-0.34	
	5	38	RPM	4030	3020	2420	2020	1510	1210	1010	760	600	
FEED			0.02-0.05	0.02-0.06	0.03-0.08	0.03-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.21-0.31		
Low alloy steel	6	45	RPM	4770	3580	2860	2390	1790	1430	1190	900	720	
			FEED	0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.07-0.13	0.11-0.17	0.11-0.21	0.18-0.28	0.24-0.34	
	7	40	RPM	4240	3180	2550	2120	1590	1270	1060	800	640	
			FEED	0.02-0.05	0.03-0.07	0.03-0.08	0.04-0.10	0.07-0.13	0.11-0.17	0.11-0.21	0.18-0.28	0.24-0.34	
	8	38	RPM	4030	3020	2420	2020	1510	1210	1010	760	600	
FEED			0.02-0.05	0.02-0.06	0.03-0.08	0.03-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.21-0.31		
9	25	RPM	2650	1990	1590	1330	990	800	660	500	400		
		FEED	0.01-0.03	0.02-0.04	0.02-0.05	0.03-0.06	0.03-0.08	0.05-0.10	0.06-0.12	0.06-0.16	0.10-0.20		
M	12	Stainless steel	30	RPM	3180	2390	1910	1590	1190	950	800	600	480
K	Grey cast iron	70		FEED	0.01-0.03	0.01-0.03	0.02-0.04	0.02-0.05	0.03-0.06	0.03-0.08	0.03-0.08	0.05-0.10	0.06-0.12
			16	60	RPM	7430	5570	4460	3710	2790	2230	1860	1390
FEED	0.02-0.05	0.02-0.06			0.03-0.08	0.03-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
N	21	Aluminum-wrought alloy	165	RPM	6370	4770	3820	3180	2390	1910	1590	1190	950
				FEED	0.02-0.05	0.02-0.05	0.03-0.06	0.03-0.07	0.04-0.10	0.07-0.13	0.06-0.16	0.11-0.21	0.15-0.25
	22		165	RPM	17510	13130	10500	8750	6570	5250	4380	3280	2630
				FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40
				RPM	17510	13130	10500	8750	6570	5250	4380	3280	2630
				FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40



Surface Angle	Cutting Conditions	
	RPM	FEED
0° - 15°	100%	100%
15° - 30°	100%	50%
30° -	70%	30%

- ▶ The cutting conditions are for 2xD.
- ▶ The rigid and precise machine and holder are required.
- ▶ The recommended depth of hole is measured from the highest point of the hole on drilling in inclined and angled surfaces.
- ▶ The recommended cutting conditions are those for drilling on flat and horizontal surfaces.
- ▶ Please adjust feed rate according to the above surface angle when drilling on an inclined surface.
 - The recommended feed rate 50% or lower, in case of 15°-30° of the incline angle.
 - The recommended feed rate 30% or lower and RPM 70%, in case of 30° - of the incline angle.
- ▶ Please decrease cutting speed as material hardness increases.
- ▶ Only use drilling tool. Side milling, traversing, helical milling are not usable.

VARIETY OF DRILLING



YG DREAM DRILLS - FLAT BOTTOM

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**

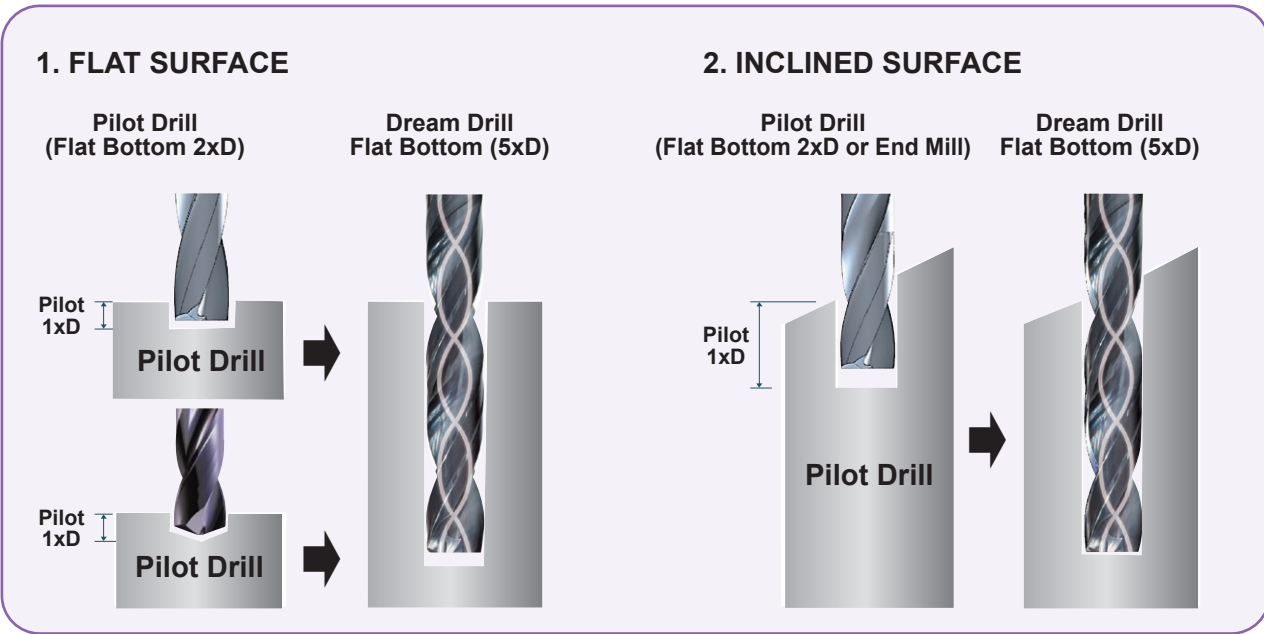
DH450 SERIES with COOLANT HOLES (5XD)

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1	Non-alloy steel	100	RPM	10610	7960	6370	5310	3980	3180	2650	1990	1590
				FEED	0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60
			90	RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430
				FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40
	90		RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430	
			FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40	
	75		RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190	
			FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30	
	2	Low alloy steel	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190
				FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30
			85	RPM	9020	6760	5410	4510	3380	2710	2250	1690	1350
				FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40
75	RPM		7960	5970	4770	3980	2980	2390	1990	1490	1190		
	FEED		0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40		
75	RPM		7960	5970	4770	3980	2980	2390	1990	1490	1190		
	FEED		0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
5	90	RPM	5310	3980	3180	2650	1990	1590	1330	990	800		
		FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
M	12	Stainless steel	60	RPM	6370	4770	3820	3180	2390	1910	1590	1190	950
				FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40
K	15	Grey cast iron	90	RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430
	FEED		0.02-0.05	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
	16	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190	
				FEED	0.02-0.05	0.02-0.05	0.03-0.06	0.03-0.07	0.04-0.10	0.07-0.13	0.06-0.16	0.11-0.21	0.15-0.25
N	21	Aluminum-wrought alloy	160	RPM	16980	12730	10190	8490	6370	5090	4240	3180	2550
	FEED		0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60		
	22	160	RPM	16980	12730	10190	8490	6370	5090	4240	3180	2550	
				FEED	0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60

- ▶ Required pilot hole of the same diameter before using the 5xD Flat bottom Drills.
- ▶ The above table values is for under 5xD depth with pilot drilling operation.

DREAM DRILLS FLAT BOTTOM - Pilot Drilling for 5 X D



- ▶ For Flat bottom 5xD drilling depth, Slope surface needs Pilot Drilling with YG-1 Flat Bottom Drill (2XD) and Flat surface needs Pilot Drilling with YG-1 Dream Drill General.
- ▶ Pilot Drilling Depth : around 1XD
- ▶ Pilot Drilling Diameter : same size diameter

CARBIDE

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS X

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

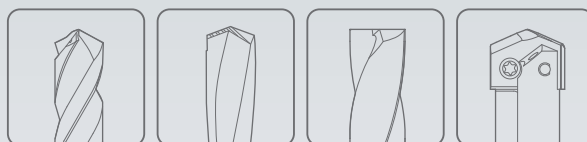
REAMERS

COUNTER SINKS

COUNTER BORES



Global Cutting Tool Leader **YG-1**



HOLEMAKING