



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
STANDARD
LENGTH
SIZE MIN
SIZE MAX
PAGE

D1GP125	D1GP165
DIN 338	DIN 338
JOBBER	JOBBER
D1.0	D1.6
D13.0	D13.0
A208	A212

SURFACE TREATMENT

TiN

HSS & HSS-E
GOLD-P DRILLS

Same Performance as Full TiN-coated Drills



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A219

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		

DLGP195	DLGP506
DIN 338	DIN 338
JOBBER	JOBBER
D1.0	D2.0
D13.0	D13.0
A213	A216

TiN

◎	◎	1
◎	◎	2
◎	◎	3
○	○	4
		5
◎	◎	6
○	○	7
○	○	8
		9
○	○	10
		11
◎		12
○		13
○		14
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○	○	17
	○	18
○	○	19
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○		36
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		41

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
A205			



D1GP125 SERIES

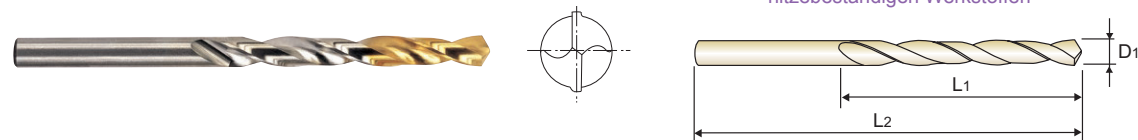
HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

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 unalloyed and alloyed steels, stainless steels as well as certain cast irons, non-ferrous and heat resistant materials
- Nutenform : Rechtsspirale
- Spitzenwinkel : 118° Normalanschliff
- Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich
- Anwendung : Bohren von unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP125010	1.0	12	34	D1GP125040	4.0	43	75
D1GP125011	1.1	14	36	D1GP125041	4.1	43	75
D1GP125012	1.2	16	38	D1GP125042	4.2	43	75
D1GP125013	1.3	16	38	D1GP125043	4.3	47	80
D1GP125014	1.4	18	40	D1GP125044	4.4	47	80
D1GP125015	1.5	18	40	D1GP125045	4.5	47	80
D1GP125016	1.6	20	43	D1GP125046	4.6	47	80
D1GP125017	1.7	20	43	D1GP125047	4.7	47	80
D1GP125018	1.8	22	46	D1GP125048	4.8	52	86
D1GP125019	1.9	22	46	D1GP125049	4.9	52	86
D1GP125020	2.0	24	49	D1GP125050	5.0	52	86
D1GP125021	2.1	24	49	D1GP125051	5.1	52	86
D1GP125022	2.2	27	53	D1GP125052	5.2	52	86
D1GP125023	2.3	27	53	D1GP125053	5.3	52	86
D1GP125024	2.4	30	57	D1GP125054	5.4	57	93
D1GP125025	2.5	30	57	D1GP125055	5.5	57	93
D1GP125026	2.6	30	57	D1GP125056	5.6	57	93
D1GP125027	2.7	33	61	D1GP125057	5.7	57	93
D1GP125028	2.8	33	61	D1GP125058	5.8	57	93
D1GP125029	2.9	33	61	D1GP125059	5.9	57	93
D1GP125030	3.0	33	61	D1GP125060	6.0	57	93
D1GP125031	3.1	36	65	D1GP125061	6.1	63	101
D1GP125032	3.2	36	65	D1GP125062	6.2	63	101
D1GP125033	3.3	36	65	D1GP125063	6.3	63	101
D1GP125034	3.4	39	70	D1GP125064	6.4	63	101
D1GP125035	3.5	39	70	D1GP125065	6.5	63	101
D1GP125036	3.6	39	70	D1GP125066	6.6	63	101
D1GP125037	3.7	39	70	D1GP125067	6.7	63	101
D1GP125038	3.8	43	75	D1GP125068	6.8	69	109
D1GP125039	3.9	43	75	D1GP125071	7.1	69	109

► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	○	○	○	○	○	○	○	○	○	
ISO	N										S					H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron		Hardened Cast iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34	40	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	○	○	○						○							○					

A208

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D1GP125 SERIES

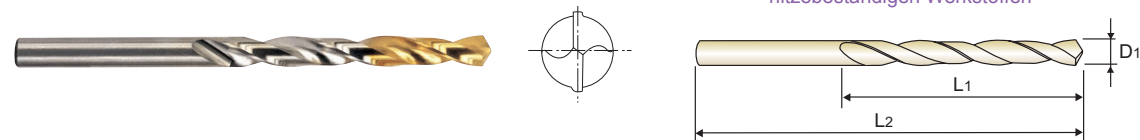
HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

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 unalloyed and alloyed steels, stainless steels as well as certain cast irons, non-ferrous and heat resistant materials
- Nutenform : Rechtsspirale
- Spitzenwinkel : 118° Normalanschliff
- Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich
- Anwendung : Bohren von unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP125072	7.2	69	109	D1GP125102	10.2	87	133
D1GP125073	7.3	69	109	D1GP125103	10.3	87	133
D1GP125074	7.4	69	109	D1GP125104	10.4	87	133
D1GP125075	7.5	69	109	D1GP125105	10.5	87	133
D1GP125076	7.6	75	117	D1GP125106	10.6	87	133
D1GP125077	7.7	75	117	D1GP125107	10.7	94	142
D1GP125078	7.8	75	117	D1GP125108	10.8	94	142
D1GP125079	7.9	75	117	D1GP125109	10.9	94	142
D1GP125080	8.0	75	117	D1GP125110	11.0	94	142
D1GP125081	8.1	75	117	D1GP125111	11.1	94	142
D1GP125082	8.2	75	117	D1GP125112	11.2	94	142
D1GP125083	8.3	75	117	D1GP125113	11.3	94	142
D1GP125084	8.4	75	117	D1GP125114	11.4	94	142
D1GP125085	8.5	75	117	D1GP125115	11.5	94	142
D1GP125087	8.7	81	125	D1GP125116	11.6	94	142
D1GP125088	8.8	81	125	D1GP125117	11.7	94	142
D1GP125089	8.9	81	125	D1GP125118	11.8	94	142
D1GP125090	9.0	81	125	D1GP125119	11.9	101	151
D1GP125091	9.1	81	125	D1GP125120	12.0	101	151
D1GP125092	9.2	81	125	D1GP125121	12.1	101	151
D1GP125093	9.3	81	125	D1GP125122	12.2	101	151
D1GP125094	9.4	81	125	D1GP125123	12.3	101	151
D1GP125095	9.5	81	125	D1GP125124	12.4	101	151
D1GP125096	9.6	87	133	D1GP125125	12.5	101	151
D1GP125097	9.7	87	133	D1GP125126	12.6	101	151
D1GP125098	9.8	87	133	D1GP125127	12.7	101	151
D1GP125099	9.9	87	133	D1GP125128	12.8	101	151
D1GP125100	10.0	87	133	D1GP125129	12.9	101	151
D1GP125101	10.1	87	133	D1GP125130	13.0	101	151

◎ : 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	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	○	○	○						○							○					

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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°, Normal point
- Surface treatment

: Bright body, TiN coating on working area
- Application

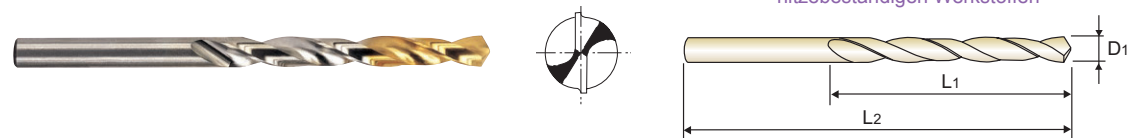
: Drilling unalloyed and alloyed steels,
stainless steels as well as certain cast irons,
non-ferrous and heat resistant materials
- Nutenform

: Rechtsspirale
- Spitzenwinkel

: 118° Normalanschliff
- Oberfläche

: Blank mit TiN-Beschichtung im Arbeitsbereich
- Anwendung

: Bohren von unlegierten und legierten Stählen,
nichtrostenden Stählen sowie bestimmten
Gusseisen, Nichteisenmetallen und
hitzebeständigen Werkstoffen



Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	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								
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					
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	○	○	○						○							○							



D1GP165 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

- 🇩🇪 HSS SPIRALBOHRER, GOLD-P BESCHICHTET
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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 unalloyed and alloyed steels,
stainless steels as well as certain cast irons,
non-ferrous and heat resistant materials
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: Rechtsspirale
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- Oberfläche

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: Bohren von unlegierten und legierten Stählen,
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Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	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	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	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			
HRC											15	30	30	34	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	○	○	○						○							○							



DLGP195 SERIES

JOBBER

**KURZ
COURTE
CORTA**

Technical drawing of a drill bit. The drawing includes a 3D perspective view of the drill bit, a cross-sectional view showing the double-flute design, and a side view with dimensions. The side view shows the total length L_2 and the length of the cutting edge L_1 . The diameter of the drill bit is labeled D .



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D ₁	L ₁	L ₂		D ₁	L ₁	L ₂
DLGP195010	1.0	12	34	DLGP195036	3.6	39	70
DLGP195011	1.1	14	36	DLGP195037	3.7	39	70
DLGP195012	1.2	16	38	DLGP195038	3.8	43	75
DLGP195013	1.3	16	38	DLGP195039	3.9	43	75
DLGP195014	1.4	18	40	DLGP195040	4.0	43	75
DLGP195015	1.5	18	40	DLGP195041	4.1	43	75
DLGP195016	1.6	20	43	DLGP195042	4.2	43	75
DLGP195017	1.7	20	43	DLGP195043	4.3	47	80
DLGP195018	1.8	22	46	DLGP195044	4.4	47	80
DLGP195019	1.9	22	46	DLGP195045	4.5	47	80
DLGP195020	2.0	24	49	DLGP195046	4.6	47	80
DLGP195021	2.1	24	49	DLGP195047	4.7	47	80
DLGP195022	2.2	27	53	DLGP195048	4.8	52	86
DLGP195023	2.3	27	53	DLGP195049	4.9	52	86
DLGP195024	2.4	30	57	DLGP195050	5.0	52	86
DLGP195025	2.5	30	57	DLGP195051	5.1	52	86
DLGP195026	2.6	30	57	DLGP195052	5.2	52	86
DLGP195027	2.7	33	61	DLGP195053	5.3	52	86
DLGP195028	2.8	33	61	DLGP195054	5.4	57	93
DLGP195029	2.9	33	61	DLGP195055	5.5	57	93
DLGP195030	3.0	33	61	DLGP195056	5.6	57	93
DLGP195031	3.1	36	65	DLGP195057	5.7	57	93
DLGP195032	3.2	36	65	DLGP195058	5.8	57	93
DLGP195033	3.3	36	65	DLGP195059	5.9	57	93
DLGP195034	3.4	39	70	DLGP195060	6.0	57	93
DLGP195035	3.5	39	70	DLGP195061	6.1	63	101

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◎ : Excellent ○ : Good

ISO	P									M			K									
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	⊙	⊙	⊙		○	⊙			○	○		⊙	○	○		○	○		○			
ISO	N									S										H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			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	○	○	○						○							○						

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

A213

CARBIDE

HSS

GOLD-P DRILLS

DLGP195

SERIES

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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*

- **Flute Geometry** : Right hand, 38° helix, DH100 worm pattern type.
► **Point Angle** : 130°, Split point giving higher chip removal.
► **Surface treatment** : Bright body, TiN coating on working area.
► **Application** : Deep hole drilling in unalloyed and alloyed steels as well as cast irons that require support during chip removal
- **Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
► **Spitzenwinkel** : Durch 130° Kreuzanschliff Gute Spanabfuhr
► **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
► **Anwendung** : Tieflochbohren in unlegierten und legierten Stählen sowie Gusseisen mit aktiver Unterstützung bei der Spanabfuhr



► **DH100**
worm pattern drills



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DLGP506020	2.0	24	49	DLGP506056	5.6	57	93
DLGP506021	2.1	24	49	DLGP506058	5.8	57	93
DLGP506022	2.2	27	53	DLGP506059	5.9	57	93
DLGP506023	2.3	27	53	DLGP506060	6.0	57	93
DLGP506025	2.5	30	57	DLGP506062	6.2	63	101
DLGP506026	2.6	30	57	DLGP506063	6.3	63	101
DLGP506028	2.8	33	61	DLGP506064	6.4	63	101
DLGP506030	3.0	33	61	DLGP506066	6.6	63	101
DLGP506033	3.3	36	65	DLGP506067	6.7	63	101
DLGP506034	3.4	39	70	DLGP506068	6.8	69	109
DLGP506035	3.5	39	70	DLGP506069	6.9	69	109
DLGP506036	3.6	39	70	DLGP506070	7.0	69	109
DLGP506038	3.8	43	75	DLGP506075	7.5	69	109
DLGP506039	3.9	43	75	DLGP506076	7.6	75	117
DLGP506040	4.0	43	75	DLGP506077	7.7	75	117
DLGP506041	4.1	43	75	DLGP506078	7.8	75	117
DLGP506042	4.2	43	75	DLGP506080	8.0	75	117
DLGP506044	4.4	47	80	DLGP506082	8.2	75	117
DLGP506046	4.6	47	80	DLGP506083	8.3	75	117
DLGP506048	4.8	52	86	DLGP506084	8.4	75	117
DLGP506050	5.0	52	86	DLGP506085	8.5	75	117
DLGP506051	5.1	52	86	DLGP506086	8.6	81	125
DLGP506052	5.2	52	86	DLGP506087	8.7	81	125
DLGP506053	5.3	52	86	DLGP506089	8.9	81	125
DLGP506054	5.4	57	93	DLGP506090	9.0	81	125
DLGP506055	5.5	57	93	DLGP506091	9.1	81	125

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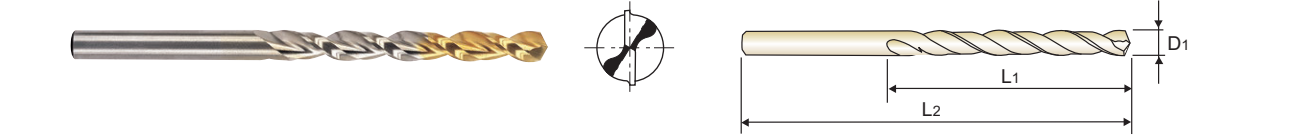
																				◎ : Excellent ○ : Good							
ISO	P											M				K											
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20							
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25									
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																											



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*

- **Flute Geometry** : Right hand, 38° helix, DH100 worm pattern type.
► **Point Angle** : 130°, Split point giving higher chip removal.
► **Surface treatment** : Bright body, TiN coating on working area.
► **Application** : Deep hole drilling in unalloyed and alloyed steels as well as cast irons that require support during chip removal
- **Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
► **Spitzenwinkel** : Durch 130° Kreuzanschliff Gute Spanabfuhr
► **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
► **Anwendung** : Tieflochbohren in unlegierten und legierten Stählen sowie Gusseisen mit aktiver Unterstützung bei der Spanabfuhr



► **DH100**
worm pattern drills



				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DLGP506092	9.2	81	125	DLGP506126	12.6	101	151
DLGP506093	9.3	81	125	DLGP506127	12.7	101	151
DLGP506095	9.5	81	125	DLGP506129	12.9	101	151
DLGP506096	9.6	87	133	DLGP506130	13.0	101	151
DLGP506098	9.8	87	133				
DLGP506099	9.9	87	133				
DLGP506100	10.0	87	133				
DLGP506101	10.1	87	133				
DLGP506102	10.2	87	133				
DLGP506103	10.3	87	133				
DLGP506104	10.4	87	133				
DLGP506105	10.5	87	133				
DLGP506106	10.6	87	133				
DLGP506107	10.7	94	142				
DLGP506110	11.0	94	142				
DLGP506111	11.1	94	142				
DLGP506112	11.2	94	142				
DLGP506115	11.5	94	142				
DLGP506116	11.6	94	142				
DLGP506117	11.7	94	142				
DLGP506118	11.8	94	142				
DLGP506119	11.9	101	151				
DLGP506121	12.1	101	151				
DLGP506123	12.3	101	151				
DLGP506124	12.4	101	151				
DLGP506125	12.5	101	151				

																				◎ : 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	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	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																													



GOLD-P COATED DRILL SETS

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



DIN 338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

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



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

D1GP125, D1GP165, DLGP195, DLGP506 SERIES

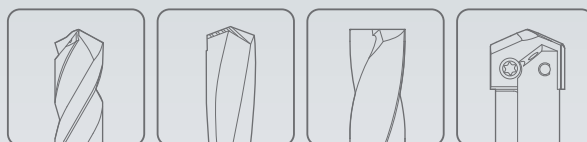
HSS & HSS-E GOLD-P DRILLS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)	Vc	Parameter	Drill Diameter (mm)						
					1.0			2.0	3.0	4.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	2		25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	3		20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	4	Low alloy steel	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490
			FEED		0.01-0.02		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		25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	7	Low alloy steel	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	8	Low alloy steel	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.02		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	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
M	12	Stainless steel	18	RPM	5730	25	RPM	3980	2650	1990	1330	990	800	610
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	13		15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	14	Stainless steel	10	RPM	3180	15	RPM	2390	1590	1190	800	600	480	370
			FEED		0.01-0.02		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	15	Grey cast iron	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	16	Grey cast iron	25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED		0.01-0.02		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
	17	Nodular cast iron	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	18	Nodular cast iron	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.02		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	19	Malleable cast iron	25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	20	Malleable cast iron	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.02		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	21	Aluminum-wrought alloy	45	RPM	14320	65	RPM	10350	6900	5170	3450	2590	2070	1590
			FEED		0.02-0.05		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
	22	Aluminum-wrought alloy	45	RPM	14320	65	RPM	10350	6900	5170	3450	2590	2070	1590
			FEED		0.02-0.05		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	23	Aluminum-cast, alloyed	35	RPM	11140	50	RPM	7960	5310	3980	2650	1990	1590	1220
S	29	Non Metallic Materials	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
			FEED		0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
S	36	Titanium Alloys	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490
			FEED		0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.13	0.08-0.14



Global Cutting Tool Leader **YG-1**



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