



Leading Through Innovation



HSS Co8 & HSS-E

HPD STRAIGHT SHANK DRILLS

HPD BOHRER

- High Precision Drilling for General Steels & Stainless Steels
- Hochpräzises Bohren für allgemeine Stähle und rostfreie Stähle

YG-1 CO., LTD.





D4541 SERIES

HSS Co8, HPD TWIST DRILLS for STEELS

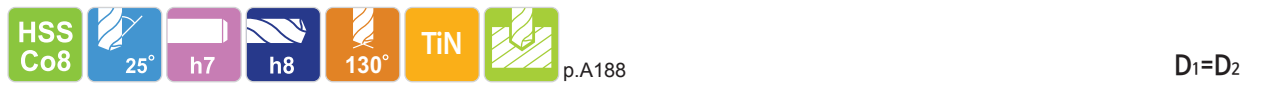
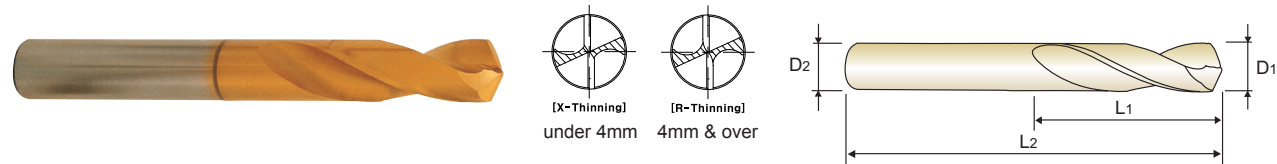
PREMIUM HSS KOBALT, HPD SPIRALBOHRER für STÄHLE
 Forets HPD HSSCo Premium pour Aciers, série extra-courte
 PUNTE ELICOIDALI HPD IN PREMIUM HSS Co, PER ACCIAI

STUB
EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

- **Application** : Designed for accurate drilling on NC/CNC machines. Drilling hard and tough materials, alloyed tool steels, inconel, nimonic, cast iron, aluminum die casting, etc.

► **Advantage** : Helical thinning - good chip removal, self-centering, reducing thrust and improving accuracy. Reinforced web and stub length - increasing rigidity, reducing vibration and deflection. Premium Cobalt HSS with superior TiN coating - higher speed and feed, longer tool life. High quality & good surface finish, high productivity
- **Anwendung** : Für präzises Bohren mit NC/CNC Maschinen, geeignet zum Bearbeiten von harten und zähen Werkstücken, Legierungen, Werkzeugstahl, Nimonic, Inconel, Gusseisen, Aluminium-Guss usw.

► **Vorteile** : Durch Kreuzanschliff gute Spanentfernung, reduzierter Druck, verbesserte Genauigkeit, selbstzentriert, extra kurze Ausführung, verbesserte Stabilität, weniger Vibrationen und Abdrängung, Premium Kobalt HSS mit hochwertiger TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Oberflächengüte und Produktivität.



Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
D4541944	4.45	24	68	D4541057	5.70	28	72
D4541045	4.50	24	68	D4541957	5.75	28	72
D4541945	4.55	24	68	D4541958	5.85	28	72
D4541046	4.60	24	68	D4541059	5.90	28	72
D4541946	4.65	24	68	D4541959	5.95	28	72
D4541047	4.70	24	68	D4541060	6.00	28	72
D4541947	4.75	24	68	D4541061	6.10	31	75
D4541048	4.80	26	70	D4541062	6.20	31	75
D4541049	4.90	26	70	D4541063	6.30	31	75
D4541949	4.95	26	70	D4541065	6.50	31	75
D4541050	5.00	26	70	D4541965	6.55	31	75
D4541950	5.05	26	70	D4541066	6.60	31	75
D4541051	5.10	26	70	D4541966	6.65	31	75
D4541951	5.15	26	70	D4541067	6.70	31	75
D4541052	5.20	26	70	D4541068	6.80	34	78
D4541952	5.25	26	70	D4541069	6.90	34	78
D4541053	5.30	26	70	D4541070	7.00	34	78
D4541954	5.45	28	72	D4541072	7.20	34	78
D4541055	5.50	28	72	D4541073	7.30	34	78
D4541955	5.55	28	72	D4541973	7.35	34	78
D4541056	5.60	28	72	D4541074	7.40	34	78
D4541956	5.65	28	72	D4541075	7.50	34	78

► TiCN(D7541), TiAlN(DQ541) are available on your request. ► NEXT PAGE

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



D4541 SERIES

HSS Co8, HPD TWIST DRILLS for STEELS

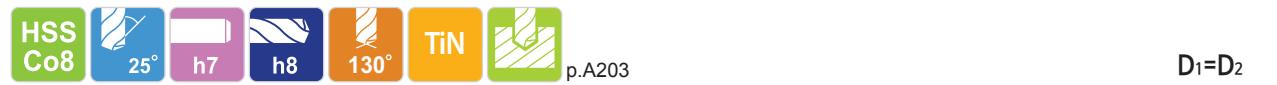
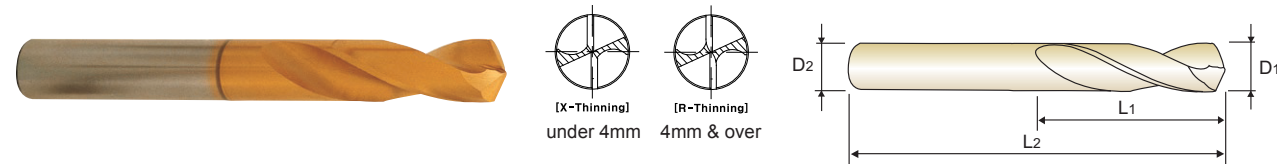
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Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
D4541076	7.60	37	81	D4541100	10.00	43	93
D4541976	7.65	37	81	D4541101	10.10	43	100
D4541077	7.70	37	81	D4541102	10.20	43	100
D4541078	7.80	37	81	D4541802	10.25	43	100
D4541079	7.90	37	81	D4541103	10.30	43	100
D4541080	8.00	37	81	D4541805	10.55	43	100
D4541081	8.10	37	87	D4541106	10.60	43	100
D4541083	8.30	37	87	D4541806	10.65	47	104
D4541983	8.35	37	87	D4541107	10.70	47	104
D4541085	8.50	37	87	D4541108	10.80	47	104
D4541985	8.55	40	90	D4541109	10.90	47	104
D4541086	8.60	40	90	D4541111	11.10	47	104
D4541087	8.70	40	90	D4541112	11.20	47	104
D4541088	8.80	40	90	D4541812	11.25	47	104
D4541089	8.90	40	90	D4541113	11.30	47	104
D4541090	9.00	40	90	D4541114	11.40	47	104
D4541091	9.10	40	90	D4541115	11.50	47	104
D4541092	9.20	40	90	D4541116	11.60	47	104
D4541093	9.30	40	90	D4541118	11.80	47	104
D4541095	9.50	40	90	D4541119	11.90	51	108
D4541098	9.80	43	93	D4541120	12.00	51	108
D4541099	9.90	43	93	D4541121	12.10	51	108

► TiCN(D7541), TiAlN(DQ541) are available on your request. ► NEXT PAGE

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



D4542 SERIES

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JOBBER

KURZ
COURTE
CORTA

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Drilling mild steels, cast iron, aluminum, alloyed tool steels, etc.

► **Advantage** : Helical thinning - good chip removal, self-centering, reducing thrust and improving accuracy.
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[X-Thinning] under 4mm
[R-Thinning] 4mm & over

D₂ D₁ L₁ L₂

HSS Co8

30°

h7

h6

h8

130°

TiN

p.A203

D₁=D₂

up to 13mm over 13mm

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D ₁	L ₁	L ₂
D4542047	4.70	47	91
D4542947	4.75	47	91
D4542048	4.80	52	96
D4542049	4.90	52	96
D4542949	4.95	52	96
D4542950	5.05	52	96
D4542051	5.10	52	96
D4542951	5.15	52	96
D4542052	5.20	52	96
D4542952	5.25	52	96
D4542053	5.30	52	96
D4542054	5.40	57	101
D4542055	5.50	57	101
D4542955	5.55	57	101
D4542056	5.60	57	101
D4542956	5.65	57	101
D4542057	5.70	57	101
D4542957	5.75	57	101
D4542058	5.80	57	101
D4542958	5.85	57	101
D4542059	5.90	57	101
D4542959	5.95	57	101
D4542060	6.00	57	101

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D ₁	L ₁	L ₂
D4542960	6.05	63	107
D4542061	6.10	63	107
D4542961	6.15	63	107
D4542062	6.20	63	107
D4542962	6.25	63	107
D4542064	6.40	63	107
D4542964	6.45	63	107
D4542065	6.50	63	107
D4542067	6.70	63	107
D4542967	6.75	69	113
D4542068	6.80	69	113
D4542968	6.85	69	113
D4542069	6.90	69	113
D4542969	6.95	69	113
D4542070	7.00	69	113
D4542970	7.05	69	113
D4542072	7.20	69	113
D4542972	7.25	69	113
D4542973	7.35	69	113
D4542074	7.40	69	113
D4542974	7.45	69	113
D4542075	7.50	69	113
D4542975	7.55	75	119

► TiCN(D7542), TiAlN(DQ542) 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	400Rm	1050Rm	550	630	400	550		
Recommended																							



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[X-Thinning] under 4mm
[R-Thinning] 4mm & over

D₂ D₁ L₁ L₂

HSS Co8

30°

h7

h6

h8

130°

TiN

p.A203

D₁=D₂

up to 13mm over 13mm

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D ₁	L ₁	L ₂
D4542077	7.70	75	119
D4542977	7.75	75	119
D4542078	7.80	75	119
D4542978	7.85	75	119
D4542979	7.95	75	119
D4542080	8.00	75	119
D4542980	8.05	75	125
D4542081	8.10	75	125
D4542981	8.15	75	125
D4542982	8.25	75	125
D4542083	8.30	75	125
D4542983	8.35	75	125
D4542084	8.40	75	125
D4542085	8.50	75	125
D4542985	8.55	81	131
D4542087	8.70	81	131
D4542987	8.75	81	131
D4542088	8.80	81	131
D4542089	8.90	81	131
D4542090	9.00	81	131
D4542990	9.05	81	131
D4542092	9.20	81	131
D4542992	9.25	81	131

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D ₁	L ₁	L ₂
D4542093	9.30	81	131
D4542094	9.40	81	131
D4542994	9.45	81	131
D4542095	9.50	81	131
D4542096	9.60	87	137
D4542996	9.65	87	137
D4542097	9.70	87	137
D4542997	9.75	87	137
D4542098	9.80	87	137
D4542999	9.95	87	137
D4542100	10.00	87	137
D4542800	10.05	87	144
D4542101	10.10	87	144
D4542102	10.20	87	144
D4542802	10.25	87	144
D4542103	10.30	87	144
D4542105	10.50	87	144
D4542106	10.60	87	144
D4542107	10.70	94	151
D4542807	10.75	94	151
D4542108	10.80	94	151
D4542109	10.90	94	151
D4542110	11.00	94	151

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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																		
HB																							
Recommended	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
	◎	◎	○			◎	○			○					◎								
ISO	N										S										H		
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HRc																							
HB																							
Recommended	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		



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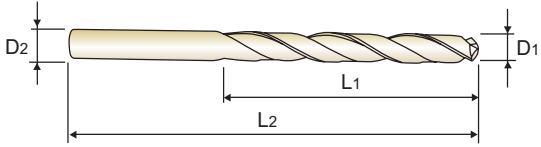
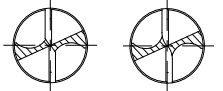
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[X-Thinning] under 4mm
[R-Thinning] 4mm & over

HSS Co8

30°

h7

h6

h8

130°

TiN

p.A203

D1=D2

up to 13mm over 13mm

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4542111	11.10	94	151
D4542112	11.20	94	151
D4542812	11.25	94	151
D4542113	11.30	94	151
D4542115	11.50	94	151
D4542815	11.55	94	151
D4542117	11.70	94	151
D4542817	11.75	94	151
D4542118	11.80	94	151
D4542819	11.95	101	158
D4542120	12.00	101	158
D4542121	12.10	101	158
D4542122	12.20	101	158
D4542123	12.30	101	158
D4542124	12.40	101	158
D4542125	12.50	101	158
D4542126	12.60	101	158
D4542127	12.70	101	158
D4542129	12.90	101	158
D4542130	13.00	101	158
D4542135	13.50	90	150
D4542140	14.00	90	150
D4542141	14.10	95	155

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4542145	14.50	95	155
D4542150	15.00	95	161
D4542155	15.50	100	166
D4542160	16.00	100	166
D4542165	16.50	106	172
D4542170	17.00	106	172
D4542175	17.50	112	178
D4542176	17.60	112	178
D4542180	18.00	112	178
D4542190	19.00	118	194
D4542195	19.50	125	201
D4542200	20.00	125	201
D4542205	20.50	128	204
D4542210	21.00	128	204
D4542220	22.00	132	208
D4542235	23.50	136	212
D4542250	25.00	140	220
D4542255	25.50	145	225
D4542265	26.50	145	225
D4542280	28.00	150	230
D4542290	29.00	155	235
D4542310	31.00	160	240

► TiCN(D7542), TiAIN(DQ542) 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	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230				
Recommended	◎	◎	○			◎	○			○					◎									
ISO	N										S										H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41			
HRc											15	30	25	38	34	36	37	55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550			
Recommended																								



DJ543 SERIES

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

● HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE
● Forets HPD-SUS HSS-E pour INOX, série extra-courte
● PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX

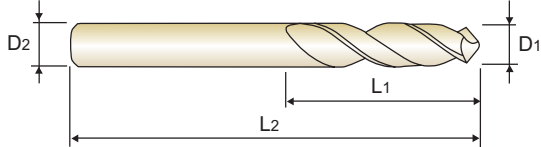
STUB

EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

- Application : Designed for drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

►Advantage : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.
- Anwendung : Geeignet zum Bearbeiten von rostfreier stähle, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierungen usw.

►Vorteile : Durch hohen Helix wird Spanstau vermieden, geeignet zum Hochleistungsbohren, durch die breiten Schneiden und die kurze Ausführung wird die Spanabfuhr erhöht und Vibrationen und Stoß reduziert. Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Oberflächengüte und Produktivität.



four facet

HSS-E

38°

h7

h8

130°

120°

TiN

p.A203

D1=D2

up to 4mm over 4mm

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ543020	2.00	12	44
DJ543021	2.10	12	44
DJ543022	2.20	13	45
DJ543024	2.40	14	46
DJ543025	2.50	14	46
DJ543026	2.60	14	46
DJ543027	2.70	16	48
DJ543028	2.80	16	48
DJ543030	3.00	16	48
DJ543031	3.10	18	50
DJ543032	3.20	18	50
DJ543033	3.30	18	50
DJ543034	3.40	20	52
DJ543035	3.50	20	52
DJ543036	3.60	20	52
DJ543037	3.70	20	52
DJ543038	3.80	22	54
DJ543039	3.90	22	54
DJ543040	4.00	22	54
DJ543041	4.10	22	66
DJ543042	4.20	22	66
DJ543043	4.30	24	68

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ543044	4.40	24	68
DJ543045	4.50	24	68
DJ543046	4.60	24	68
DJ543047	4.70	24	68
DJ543048	4.80	26	70
DJ543049	4.90	26	70
DJ543050	5.00	26	70
DJ543051	5.10	26	70
DJ543052	5.20	26	70
DJ543053	5.30	26	70
DJ543054	5.40	28	72
DJ543055	5.50	28	72
DJ543056	5.60	28	72
DJ543057	5.70	28	72
DJ543058	5.80	28	72
DJ543059	5.90	28	72
DJ543060	6.00	28	72
DJ543061	6.10	31	75
DJ543062	6.20	31	75
DJ543063	6.30	31	75
DJ543064	6.40	31	75
DJ543065	6.50	31	75

► TiCN(DW543), TiAIN(DY543) 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	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	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎				○																	

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

 HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE
 Forets HPD-SUS HSS-E pour INOX, série extra-courte
 PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Application : Designed for drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

►Advantage : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.

►Anwendung : Geeignet zum Bearbeiten von rostfreier stähle, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierungen usw.

►Vorteile : Durch hohen Helix wird Spanstau vermieden, geeignet zum Hochleistungsbohren, durch die breiten Schneiden und die kurze Ausführung wird die Spanabfuhr erhöht und Vibrationen und Stoß reduziert. Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Oberflächengüte und Produktivität.



for STAINLESS STEELS
für rostfreier Stäle

HSS-E

 38°

 h7

 h8

 130°

 120°

 TiN



up to 4mm over 4mm

p.A203

D1=D2

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ543066	6.60	31	75
DJ543067	6.70	31	75
DJ543068	6.80	34	78
DJ543069	6.90	34	78
DJ543070	7.00	34	78
DJ543071	7.10	34	78
DJ543072	7.20	34	78
DJ543073	7.30	34	78
DJ543074	7.40	34	78
DJ543075	7.50	34	78
DJ543076	7.60	37	81
DJ543077	7.70	37	81
DJ543078	7.80	37	81
DJ543079	7.90	37	81
DJ543080	8.00	37	81
DJ543081	8.10	37	87
DJ543082	8.20	37	87
DJ543083	8.30	37	87
DJ543084	8.40	37	87
DJ543085	8.50	37	87
DJ543086	8.60	40	90
DJ543087	8.70	40	90

► TiCN(DW543), TiAlN(DY543) 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	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎				○																

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

 HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE
 Forets HPD-SUS HSS-E pour INOX, série extra-courte
 PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Application : Designed for drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

►Advantage : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.

►Anwendung : Geeignet zum Bearbeiten von rostfreier stähle, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierungen usw.

►Vorteile : Durch hohen Helix wird Spanstau vermieden, geeignet zum Hochleistungsbohren, durch die breiten Schneiden und die kurze Ausführung wird die Spanabfuhr erhöht und Vibrationen und Stoß reduziert. Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Oberflächengüte und Produktivität.



for STAINLESS STEELS
für rostfreier Stäle

HSS-E

 38°

 h7

 h8

 130°

 120°

 TiN



up to 4mm over 4mm

p.A203

D1=D2

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ543111	11.10	47	104
DJ543112	11.20	47	104
DJ543113	11.30	47	104
DJ543114	11.40	47	104
DJ543115	11.50	47	104
DJ543116	11.60	47	104
DJ543117	11.70	47	104
DJ543118	11.80	47	104
DJ543119	11.90	51	108
DJ543120	12.00	51	108
DJ543121	12.10	51	108
DJ543122	12.20	51	108

► TiCN(DW543), TiAlN(DY543) 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	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			130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎				○																	



DJ544 SERIES

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

🇪🇺 **HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE**
🇫🇷 **Forets HPD-SUS HSS-E pour INOX, série courte**
🇮🇹 **PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX**

JOBBER
KURZ
COURTE
CORTA

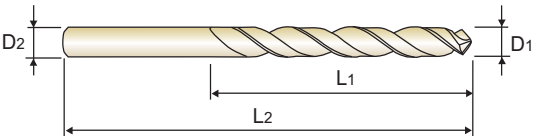
- **Application** : Designed for 4D~5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

► **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D~5D drilling.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.
- **Anwendung** : Für 4D~5D Bohrtiefe, geeignet für rostfreier stähle, Stahl, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierung usw.

► **Vorteile** : Helixwinkel, durch scharfe Hauptschneide wird Spanstau vermieden, geeignet zum Hochleistungsbohren, verstärkte Kerndicke, kurze Ausführung, Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Stabilität, Oberflächengüte und Produktivität.



up to 13mm over 13mm



D1=D2



up to 4mm over 4mm

p.A203

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544020	2.00	24	56
DJ544021	2.10	24	56
DJ544022	2.20	27	59
DJ544023	2.30	27	59
DJ544024	2.40	30	62
DJ544025	2.50	30	62
DJ544026	2.60	30	62
DJ544027	2.70	33	65
DJ544028	2.80	33	65
DJ544029	2.90	33	65
DJ544030	3.00	33	65
DJ544031	3.10	36	68
DJ544032	3.20	36	68
DJ544033	3.30	36	68
DJ544034	3.40	39	71
DJ544035	3.50	39	71
DJ544036	3.60	39	71
DJ544037	3.70	39	71
DJ544038	3.80	43	75
DJ544039	3.90	43	75
DJ544040	4.00	43	75
DJ544041	4.10	43	87

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544042	4.20	43	87
DJ544043	4.30	47	91
DJ544044	4.40	47	91
DJ544045	4.50	47	91
DJ544046	4.60	47	91
DJ544047	4.70	47	91
DJ544048	4.80	52	96
DJ544049	4.90	52	96
DJ544050	5.00	52	96
DJ544051	5.10	52	96
DJ544052	5.20	52	96
DJ544053	5.30	52	96
DJ544055	5.50	57	101
DJ544056	5.60	57	101
DJ544057	5.70	57	101
DJ544058	5.80	57	101
DJ544059	5.90	57	101
DJ544060	6.00	57	101
DJ544061	6.10	63	107
DJ544062	6.20	63	107
DJ544063	6.30	63	107
DJ544064	6.40	63	107

► TiCN(DW544), TiAlN(DY544) 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	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎				○															



DJ544 SERIES

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

🇪🇺 **HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE**
🇫🇷 **Forets HPD-SUS HSS-E pour INOX, série courte**
🇮🇹 **PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX**

JOBBER
KURZ
COURTE
CORTA

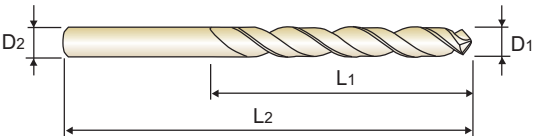
- **Application** : Designed for 4D~5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

► **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D~5D drilling.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.
- **Anwendung** : Für 4D~5D Bohrtiefe, geeignet für rostfreier stähle, Stahl, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierung usw.

► **Vorteile** : Helixwinkel, durch scharfe Hauptschneide wird Spanstau vermieden, geeignet zum Hochleistungsbohren, verstärkte Kerndicke, kurze Ausführung, Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Stabilität, Oberflächengüte und Produktivität.



up to 13mm over 13mm



D1=D2



up to 4mm over 4mm

p.A203

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544065	6.50	63	107
DJ544066	6.60	63	107
DJ544067	6.70	63	107
DJ544068	6.80	69	113
DJ544069	6.90	69	113
DJ544070	7.00	69	113
DJ544071	7.10	69	113
DJ544072	7.20	69	113
DJ544073	7.30	69	113
DJ544074	7.40	69	113
DJ544075	7.50	69	113
DJ544076	7.60	75	119
DJ544077	7.70	75	119
DJ544078	7.80	75	119
DJ544079	7.90	75	119
DJ544080	8.00	75	119
DJ544081	8.10	75	125
DJ544082	8.20	75	125
DJ544083	8.30	75	125
DJ544084	8.40	75	125
DJ544085	8.50	75	125
DJ544086	8.60	81	131

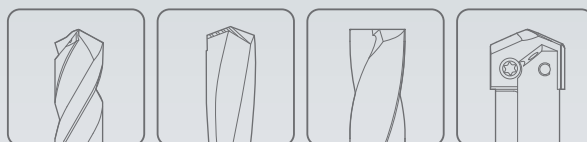
EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544087	8.70	81	131
DJ544088	8.80	81	131
DJ544089	8.90	81	131
DJ544090	9.00	81	131
DJ544091	9.10	81	131
DJ544092	9.20	81	131
DJ544093	9.30	81	131
DJ544094	9.40	81	131
DJ544095	9.50	81	131
DJ544096	9.60	87	137
DJ544097	9.70	87	137
DJ544098	9.80	87	137
DJ544099	9.90	87	137
DJ544100	10.00	87	137
DJ544101	10.10	87	144
DJ544102	10.20	87	144
DJ544103	10.30	87	144
DJ544104	10.40	87	144
DJ544105	10.50	87	144
DJ544106	10.60	87	144
DJ544107	10.70	94	151
DJ544108	10.80	94	151

► TiCN(DW544), TiAlN(DY544) 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 CopperAlloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34	36	37	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎				○															



Global Cutting Tool Leader **YG-1**



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