



Leading Through Innovation

HSS-PM

MULTI-1 DRILLS

MULTI-1 BOHRER

- Premium HSS-PM Drills
For Wide Range of Applications Particularly Stainless Steels and Titanium
- HSS-PM Bohrer
Für ein breites Anwendungsspektrum, insbesondere Edelstahl und Titan

YG YG-1 CO., LTD.



MULTI-1 DRILLS

CDRA03 SERIES

HSS-PM, MULTI-1 DRILLS

- 🇩🇪 HSS-PM MULTI-1 BOHRER
- 🇫🇷 Forets MULTI-1 HSS-PM Premium, série extra-courte
- 🇮🇹 PUNTA GAMBO CILINDRICO MULTI-1, HSS-PM

STUB

EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

- Application : Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, Stainless steels, Hardened steels(HRc30~45), Cast iron, Aluminum alloys, Nonferrous alloys, Titanium.
- Advantage : Point shape to maximize self-centering. Flute design for the best chip evacuation. Premium powder materials with excellent toughness.

- Anwendung : Baustähle, Kohlenstoffstähle, legierte Stähle, vorgehärtete Stähle, Formstähle, rostfreie Stähle, gehärtete Stähle (HRc30~45), Gusseisen, Aluminiumlegierungen, Nichteisen Legierungen, Titan.
- Vorteile : Maximale Selbstzentrierung durch besonderen Spitzenanschliff Bohrergeometrie für optimale Spanabfuhr. Premium Pulverstahl mit ausgezeichneter Zähigkeit.



EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03058	5.8	6	28	72
CDRA03059	5.9	6	28	72
CDRA03060	6.0	6	28	72
CDRA03061	6.1	8	31	75
CDRA03062	6.2	8	31	75
CDRA03063	6.3	8	31	75
CDRA03064	6.4	8	31	75
CDRA03065	6.5	8	31	75
CDRA03066	6.6	8	31	75
CDRA03067	6.7	8	31	75
CDRA03068	6.8	8	34	78
CDRA03069	6.9	8	34	78
CDRA03070	7.0	8	34	78
CDRA03071	7.1	8	34	78
CDRA03072	7.2	8	34	78
CDRA03073	7.3	8	34	78
CDRA03074	7.4	8	34	78
CDRA03075	7.5	8	34	78
CDRA03076	7.6	8	37	81
CDRA03077	7.7	8	37	81
CDRA03078	7.8	8	37	81
CDRA03079	7.9	8	37	81
CDRA03080	8.0	8	37	81
CDRA03081	8.1	10	37	87

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03082	8.2	10	37	87
CDRA03083	8.3	10	37	87
CDRA03084	8.4	10	37	87
CDRA03085	8.5	10	37	87
CDRA03086	8.6	10	40	90
CDRA03087	8.7	10	40	90
CDRA03088	8.8	10	40	90
CDRA03089	8.9	10	40	90
CDRA03090	9.0	10	40	90
CDRA03092	9.2	10	40	90
CDRA03093	9.3	10	40	90
CDRA03094	9.4	10	40	90
CDRA03095	9.5	10	40	90
CDRA03096	9.6	10	43	93
CDRA03097	9.7	10	43	93
CDRA03098	9.8	10	43	93
CDRA03100	10.0	10	43	93
CDRA03101	10.1	12	43	100
CDRA03102	10.2	12	43	100
CDRA03103	10.3	12	43	100
CDRA03104	10.4	12	43	100
CDRA03105	10.5	12	43	100
CDRA03106	10.6	12	43	100
CDRA03107	10.7	12	47	104

► 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	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎	○	○												○							

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YG-1 CO., LTD.

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EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03108	10.8	12	47	104
CDRA03109	10.9	12	47	104
CDRA03110	11.0	12	47	104
CDRA03111	11.1	12	47	104
CDRA03112	11.2	12	47	104
CDRA03113	11.3	12	47	104
CDRA03114	11.4	12	47	104
CDRA03115	11.5	12	47	104
CDRA03116	11.6	12	47	104
CDRA03117	11.7	12	47	104
CDRA03118	11.8	12	47	104
CDRA03119	11.9	12	51	108
CDRA03120	12.0	12	51	108
CDRA03121	12.1	12	51	108
CDRA03122	12.2	12	51	108
CDRA03123	12.3	12	51	108
CDRA03124	12.4	12	51	108
CDRA03125	12.5	12	51	108

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03126	12.6	12	51	108
CDRA03127	12.7	12	51	108
CDRA03128	12.8	12	51	108
CDRA03129	12.9	12	51	108
CDRA03130	13.0	12	51	108

◎ : 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																							
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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MULTI-1 DRILLS

CDRA04 SERIES

HSS-PM, MULTI-1 DRILLS

 **HSS-PM MULTI-1 BOHRER**
 **Forets MULTI-1 HSS-PM Premium, série courte**
 **PUNTA GAMBO CILINDRICO MULTI-1, HSS-PM**

JOBBER
KURZ
COURTE
CORTA

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Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA04020	2.0	3	24	56	CDRA04044	4.4	6	47	89
CDRA04021	2.1	3	24	56	CDRA04045	4.5	6	47	89
CDRA04022	2.2	3	25	56	CDRA04047	4.7	6	47	89
CDRA04023	2.3	3	25	56	CDRA04048	4.8	6	52	94
CDRA04024	2.4	3	30	61	CDRA04049	4.9	6	52	94
CDRA04025	2.5	3	30	61	CDRA04050	5.0	6	52	94
CDRA04026	2.6	3	30	61	CDRA04051	5.1	6	52	94
CDRA04027	2.7	3	33	64	CDRA04052	5.2	6	52	94
CDRA04028	2.8	3	33	64	CDRA04053	5.3	6	52	94
CDRA04029	2.9	3	33	64	CDRA04054	5.4	6	57	99
CDRA04030	3.0	3	33	64	CDRA04055	5.5	6	57	99
CDRA04031	3.1	4	36	68	CDRA04056	5.6	6	57	99
CDRA04032	3.2	4	36	68	CDRA04058	5.8	6	57	99
CDRA04033	3.3	4	36	68	CDRA04059	5.9	6	57	99
CDRA04034	3.4	4	39	71	CDRA04060	6.0	6	57	99
CDRA04035	3.5	4	39	71	CDRA04061	6.1	8	63	107
CDRA04036	3.6	4	39	71	CDRA04062	6.2	8	63	107
CDRA04037	3.7	4	39	71	CDRA04063	6.3	8	63	107
CDRA04038	3.8	4	43	75	CDRA04064	6.4	8	63	107
CDRA04039	3.9	4	43	75	CDRA04065	6.5	8	63	107
CDRA04040	4.0	4	43	75	CDRA04066	6.6	8	63	107
CDRA04041	4.1	6	43	85	CDRA04067	6.7	8	63	107
CDRA04042	4.2	6	43	85	CDRA04068	6.8	8	69	113
CDRA04043	4.3	6	47	89	CDRA04069	6.9	8	69	113

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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	10	29	32	38	15	35	15	23	10	10	26	3	25	21	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	◎	◎	○	○												○						

MULTI-1 DRILLS

CDRA04 SERIES

HSS-PM, MULTI-1 DRILLS

 **HSS-PM MULTI-1 BOHRER**
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Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA04070	7.0	8	69	113	CDRA04096	9.6	10	87	137
CDRA04071	7.1	8	69	113	CDRA04097	9.7	10	87	137
CDRA04072	7.2	8	69	113	CDRA04098	9.8	10	87	137
CDRA04073	7.3	8	69	113	CDRA04100	10.0	10	87	137
CDRA04074	7.4	8	69	113	CDRA04101	10.1	12	87	144
CDRA04075	7.5	8	69	113	CDRA04102	10.2	12	87	144
CDRA04076	7.6	8	75	119	CDRA04103	10.3	12	87	144
CDRA04077	7.7	8	75	119	CDRA04104	10.4	12	87	144
CDRA04078	7.8	8	75	119	CDRA04105	10.5	12	87	144
CDRA04079	7.9	8	75	119	CDRA04106	10.6	12	87	144
CDRA04080	8.0	8	75	119	CDRA04107	10.7	12	94	151
CDRA04081	8.1	10	75	125	CDRA04108	10.8	12	94	151
CDRA04082	8.2	10	75	125	CDRA04109	10.9	12	94	151
CDRA04083	8.3	10	75	125	CDRA04110	11.0	12	94	151
CDRA04085	8.5	10	75	125	CDRA04111	11.1	12	94	151
CDRA04086	8.6	10	81	131	CDRA04112	11.2	12	94	151
CDRA04087	8.7	10	81	131	CDRA04113	11.3	12	94	151
CDRA04088	8.8	10	81	131	CDRA04114	11.4	12	94	151
CDRA04089	8.9	10	81	131	CDRA04115	11.5	12	94	151
CDRA04090	9.0	10	81	131	CDRA04116	11.6	12	94	151
CDRA04092	9.2	10	81	131	CDRA04117	11.7	12	94	151
CDRA04093	9.3	10	81	131	CDRA04118	11.8	12	94	151
CDRA04094	9.4	10	81	131	CDRA04119	11.9	12	101	158
CDRA04095	9.5	10	81	131	CDRA04120	12.0	12	101	158

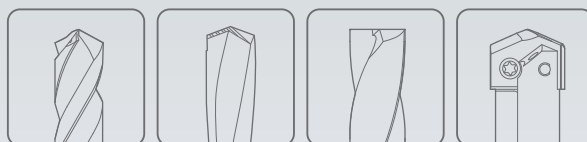
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◎ : Excellent ○ : Good

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	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○												○					



Global Cutting Tool Leader **YG-1**



HOLEMAKING