



Global Cutting Tool Leader **YG-1**



# HOLEMAKING



Leading Through Innovation

**SOLID CARBIDE**

# DREAM DRILLS -HIGH FEED DREAM DRILLS - HIGH FEED

- 1.5 to 2 Times Faster Feeding Speed than 2-Flute Drill For Carbon Steels, Alloy Steels(up to HRC35) and Cast Iron
- 1.5 bis 2 mal höhere Vorschubgeschwindigkeit als Bohrer mit 2 Schneiden, für Kohlenstoffstähle, legierte Stähle (bis HRC35) und Grauguss

**SELECTION GUIDE**  
HOLEMAKING TOOLS

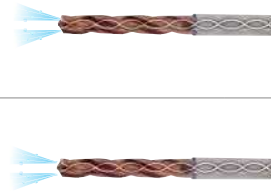
SERIES		DGR493	DGR495
DRILLING DEPTH		3XD	5XD
LENGTH		SHORT	LONG
SIZE MIN		D5.0	D5.0
SIZE MAX		D20.0	D20.0
PAGE		101	103
SURFACE TREATMENT		H-Coating	

**SOLID CARBIDE**  
**DREAM DRILLS**  
**HIGH FEED**

1.5 to 2 Times Faster Feeding Speed than 2-Flute Drill for Carbon Steels, Alloy Steels(up to HRc35) and Cast Iron

①: Excellent ○: Good  
Recommended cutting conditions: P.105

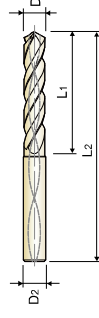
ISO	VDI	Material Description	Composition / Structure / Heat Treatment	HB	HRc
1	125	Non-alloy steel	About 0.15% C Annealed	125	19
2	125	Non-alloy steel	About 0.45% C Annealed	200	13
3	125	Non-alloy steel	About 0.45% C Quenched & Tempered	250	25
4	125	Non-alloy steel	About 0.75% C Annealed	270	28
5	125	Non-alloy steel	About 0.75% C Quenched & Tempered	300	32
6	125	Non-alloy steel	About 0.75% C Annealed	180	10
7	125	Non-alloy steel	About 0.75% C Quenched & Tempered	275	29
8	125	Non-alloy steel	About 0.75% C Quenched & Tempered	300	32
9	125	Non-alloy steel	About 0.75% C Quenched & Tempered	350	38
10	125	High alloyed steel and tool steel	Annealed	200	15
11	125	High alloyed steel and tool steel	Quenched & Tempered	325	35
12	125	Stainless steel	Ferritic / Martensitic	200	15
13	125	Stainless steel	Annealed	240	23
14	125	Stainless steel	Quenched & Tempered	200	23
15	125	Grey cast iron	Austenitic	180	10
16	125	Grey cast iron	Pearlitic / Ferritic	180	10
17	125	Nodular cast iron	Pearlitic (Martensitic)	260	26
18	125	Nodular cast iron	Ferritic	160	3
19	125	Malleable cast iron	Pearlitic	250	25
20	125	Malleable cast iron	Pearlitic	130	21
21	125	Aluminum- wrought alloy	Not Curable	60	
22	125	Aluminum- wrought alloy	Curable	100	
23	125	Aluminum- cast, alloyed	≤ 12% Si, Not Curable	75	
24	125	Aluminum- cast, alloyed	≤ 12% Si, Curable	90	
25	125	Copper and Copper Alloys	> 12% Si, Not Curable	130	
26	125	Copper and Copper Alloys	Cutting Alloys PB> 1%	110	
27	125	Copper and Copper Alloys	Cu, Zn, Cu&Zn (Brass)	90	
28	125	Non Metallic Materials	Cu&Sn lead-free copper and electrolytic copper	100	
29	125	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic, Rubber, Wood, etc.		
31	125	Heat Resistant Super Alloys	Annealed	200	15
32	125	Heat Resistant Super Alloys	Cured	280	30
33	125	Heat Resistant Super Alloys	Annealed	250	25
34	125	Heat Resistant Super Alloys	Ni or Co Based	350	38
35	125	Heat Resistant Super Alloys	Cast	320	34
36	125	Titanium Alloys	Pure Titanium	400 Rm	
37	125	Titanium Alloys	Alpha + Beta Alloys	1050 Rm	
38	125	Hardened steel	Hardened	550	55
39	125	Chilled Cast Iron	Hardened	630	60
40	125	Chilled Cast Iron	Cast	400	42
41	125	Hardened Cast Iron	Hardened	550	55



**DREAM DRILLS - HIGH FEED**

**CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES**  
SHORT KURZE COURTE  
COURTE COURTE  
CORTA CORTA

- ▶ Drilling for Carbon Steels, Alloy Steels(HRc35) and Cast Iron
- ▶ Higher productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
- ▶ Higher productivity through den 1.5 bis 2-fach höheren Vorschub
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Self centering and chip breaking by R-tinning and coolant holes
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



**DIN 6537** CARBIDE **h6** **m7** **140°** 20 bar

P.105

3 x D

EDP No.	H-Coating	Drill Diameter		Flute Length	Overall Length	EDP No.	H-Coating	Drill Diameter		Flute Length	Overall Length
		D1	D2					D1	D2		
DGR493050	5.0	6	28	66	66	DGR493074	7.5	8	41	79	
DGR493051	5.1	6	28	66	66	DGR493075	7.5	8	41	79	
DGR493052	5.2	6	28	66	66	DGR493076	7.6	8	41	79	
DGR493053	5.3	6	28	66	66	DGR493077	7.7	8	41	79	
DGR493054	5.4	6	28	66	66	DGR493078	7.8	8	41	79	
DGR493055	5.5	6	28	66	66	DGR493079	7.9	8	41	79	
DGR493056	5.6	6	28	66	66	DGR493080	8.0	8	41	79	
DGR493057	5.7	6	28	66	66	DGR493081	8.1	10	47	89	
DGR493058	5.8	6	28	66	66	DGR493082	8.2	10	47	89	
DGR493059	5.9	6	28	66	66	DGR493083	8.3	10	47	89	
DGR493060	6.0	6	28	66	66	DGR493084	8.4	10	47	89	
DGR493061	6.1	8	34	79	79	DGR493085	8.5	10	47	89	
DGR493062	6.2	8	34	79	79	DGR493086	8.6	10	47	89	
DGR493063	6.3	8	34	79	79	DGR493087	8.7	10	47	89	
DGR493064	6.4	8	34	79	79	DGR493088	8.8	10	47	89	
DGR493065	6.5	8	34	79	79	DGR493089	8.9	10	47	89	
DGR493066	6.6	8	34	79	79	DGR493090	9.0	10	47	89	
DGR493067	6.7	8	34	79	79	DGR493091	9.1	10	47	89	
DGR493068	6.8	8	34	79	79	DGR493092	9.2	10	47	89	
DGR493069	6.9	8	34	79	79	DGR493093	9.3	10	47	89	
DGR493070	7.0	8	34	79	79	DGR493094	9.4	10	47	89	
DGR493071	7.1	8	41	79	79	DGR493095	9.5	10	47	89	
DGR493072	7.2	8	41	79	79	DGR493096	9.6	10	47	89	
DGR493073	7.3	8	41	79	79	DGR493097	9.7	10	47	89	

Other shank types are available on your request.

▶ NEXT PAGE

ISO Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Non-alloy steel	125	130	150	200	270	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000
Aluminum- wrought alloy	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Aluminum- cast, alloyed	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Copper and Copper Alloys (Bronze, Brass)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Heat Resistant Super Alloys	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Non Metallic Materials	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Chilled Cast Iron	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Hardened Cast Iron	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

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