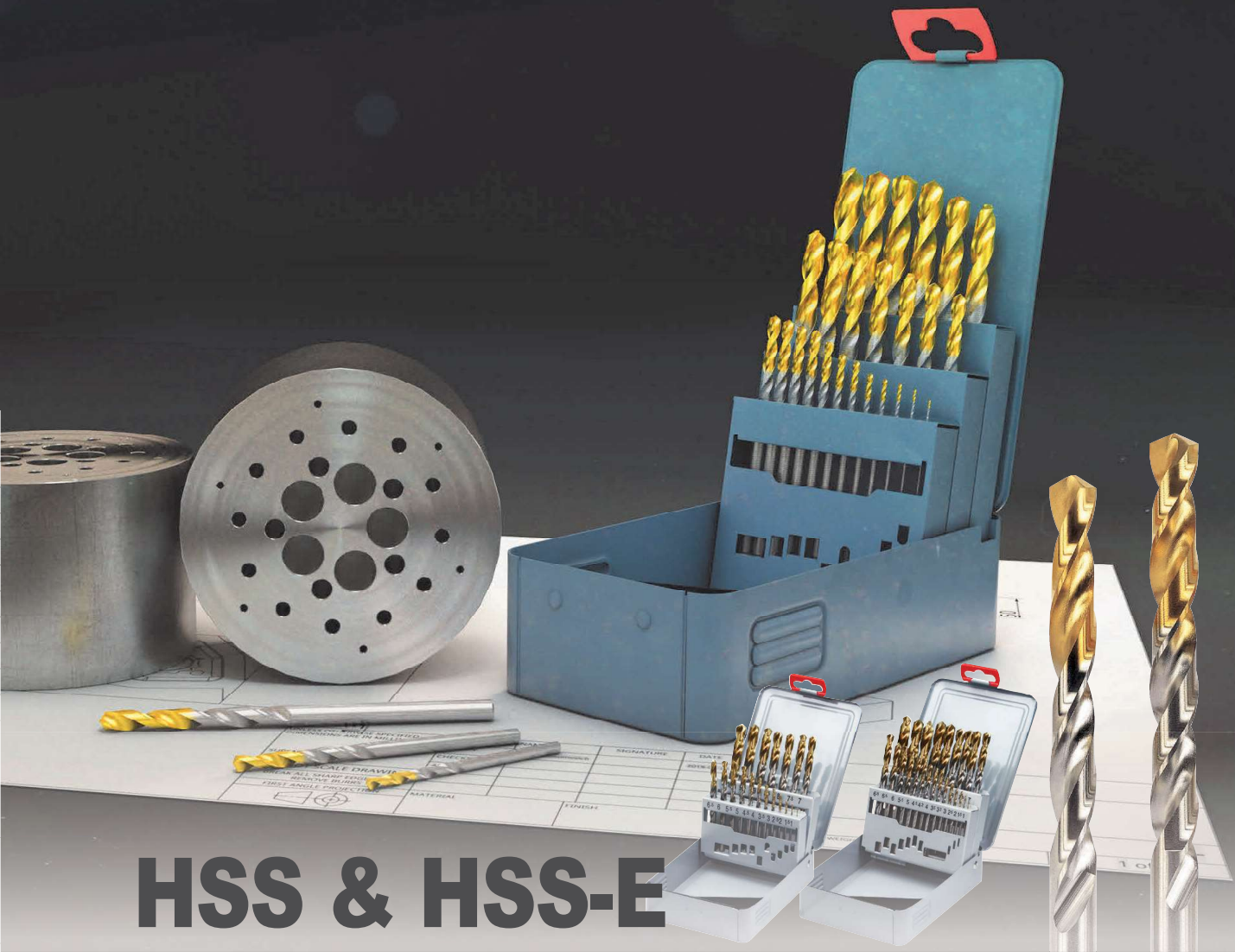




Leading Through Innovation



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



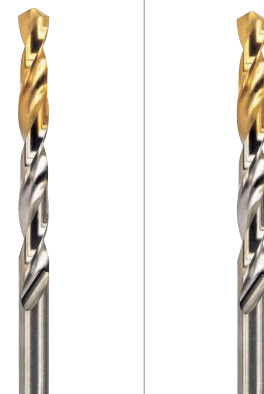
SERIES	D1GP125	D1GP165
STANDARD	DIN 338	DIN 338
LENGTH	JOBBER	JOBBER
SIZE MIN	D1.0	D1.6
SIZE MAX	D13.0	D13.0
PAGE	A194	A197

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.A207

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		≤ 12% Si, Not Curable	75		○	○	
	24	Aluminum-cast, alloyed	≤ 12% Si, Curable Hardened	90				
	25		> 12% Si, Not Curable	130				
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110				
	27		CuZn, CuSnZn (Brass)	90				
	28		CuSn, lead-free copper and electrolytic copper	100				
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic			○	○	
	30		Rubber, Wood, etc.					
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15		
	32			Cured	280	30		
	33		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			

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

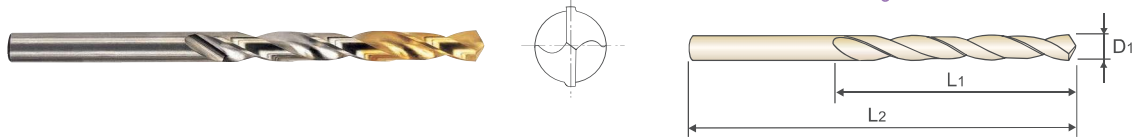
JOBBER

- 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



DIN 338
HSS
N 30°
h8
118°
TiN
p.A207

Plain Shank
 ER COLLET CHUCK

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

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	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	36	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	◎	◎	○	○	○	○	○	◎	○	○	○	○	○	○	○	○

ISO Material Description	N										S						H				
	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	13	25	28	32	36	10	29	32	38	15	35	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	○	○	○						○							○					

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

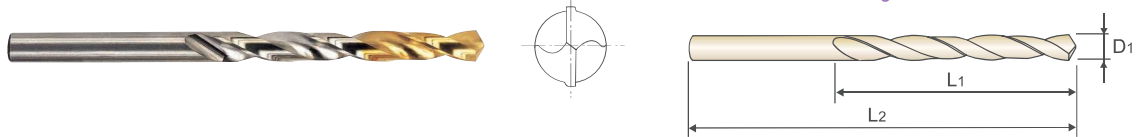
JOBBER

- 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



DIN 338
HSS
N 30°
h8
118°
TiN
p.A207

Plain Shank
 Recommended ToolHolder
 ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP125114	11.4	94	142
D1GP125115	11.5	94	142
D1GP125116	11.6	94	142
D1GP125117	11.7	94	142
D1GP125118	11.8	94	142
D1GP125119	11.9	101	151
D1GP125120	12.0	101	151
D1GP125121	12.1	101	151
D1GP125122	12.2	101	151
D1GP125123	12.3	101	151

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP125124	12.4	101	151
D1GP125125	12.5	101	151
D1GP125126	12.6	101	151
D1GP125127	12.7	101	151
D1GP125128	12.8	101	151
D1GP125129	12.9	101	151
D1GP125130	13.0	101	151

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	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	30	180	275	300	350	200	325	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 Material Description	N					S					H										
	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	200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550					
HB	60	100	75	90	130	110	90	100													
Recommended	○	○	○						○							○					

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

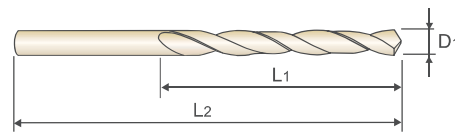
JOBBER

- 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



DIN 338
HSS
N 30°
h8
118°
TiN
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Plain Shank
 ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165068	6.8	69	109
D1GP165069	6.9	69	109
D1GP165070	7.0	69	109
D1GP165071	7.1	69	109
D1GP165072	7.2	69	109
D1GP165073	7.3	69	109
D1GP165074	7.4	69	109
D1GP165075	7.5	69	109
D1GP165076	7.6	75	117
D1GP165077	7.7	75	117
D1GP165078	7.8	75	117
D1GP165079	7.9	75	117
D1GP165080	8.0	75	117
D1GP165081	8.1	75	117
D1GP165082	8.2	75	117
D1GP165083	8.3	75	117
D1GP165084	8.4	75	117
D1GP165085	8.5	75	117
D1GP165086	8.6	81	125
D1GP165087	8.7	81	125
D1GP165088	8.8	81	125
D1GP165089	8.9	81	125
D1GP165090	9.0	81	125
D1GP165091	9.1	81	125
D1GP165092	9.2	81	125
D1GP165093	9.3	81	125

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165094	9.4	81	125
D1GP165095	9.5	81	125
D1GP165096	9.6	87	133
D1GP165097	9.7	87	133
D1GP165098	9.8	87	133
D1GP165099	9.9	87	133
D1GP165100	10.0	87	133
D1GP165101	10.1	87	133
D1GP165102	10.2	87	133
D1GP165103	10.3	87	133
D1GP165104	10.4	87	133
D1GP165105	10.5	87	133
D1GP165106	10.6	87	133
D1GP165107	10.7	94	142
D1GP165108	10.8	94	142
D1GP165109	10.9	94	142
D1GP165110	11.0	94	142
D1GP165111	11.1	94	142
D1GP165112	11.2	94	142
D1GP165113	11.3	94	142
D1GP165114	11.4	94	142
D1GP165115	11.5	94	142
D1GP165116	11.6	94	142
D1GP165117	11.7	94	142
D1GP165118	11.8	94	142
D1GP165119	11.9	101	151

Unit : mm

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	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	30	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 Material Description	N										S						H				
	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	○	○	○						○							○					

HSS-E, STRAIGHT SHANK DRILLS, GOLD-P COATED

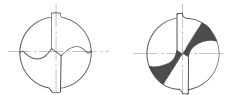
JOBBER

- HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, série courte
- PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

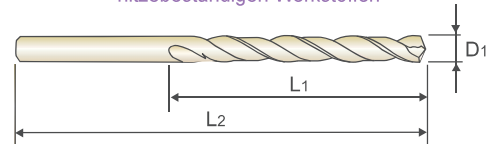
**KURZ
COURTE
CORTA**

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 135°, under 1.6mm : Normal point
1.6mm & over : Split point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Deep hole drilling in unalloyed and alloyed steels, stainless steels as well as certain cast irons, non-ferrous and heat resistant materials

- ▶ **Nutenform** : Rechtsspirale
- ▶ **Spitzenwinkel** : 135°, unter 1,6mm : Normalanschliff
1,6mm & über : Kreuzanschliff
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Bohren tiefer Bohrungen in unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



under 1.6mm 1.6mm & over



DIN 338
HSS-E
33°
h8
135°
TiN
p.A207

Plain Shank

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP195010	1.0	12	34
DLGP195011	1.1	14	36
DLGP195012	1.2	16	38
DLGP195013	1.3	16	38
DLGP195014	1.4	18	40
DLGP195015	1.5	18	40
DLGP195016	1.6	20	43
DLGP195017	1.7	20	43
DLGP195018	1.8	22	46
DLGP195019	1.9	22	46
DLGP195020	2.0	24	49
DLGP195021	2.1	24	49
DLGP195022	2.2	27	53
DLGP195023	2.3	27	53
DLGP195024	2.4	30	57
DLGP195025	2.5	30	57
DLGP195026	2.6	30	57
DLGP195027	2.7	33	61
DLGP195028	2.8	33	61
DLGP195029	2.9	33	61
DLGP195030	3.0	33	61
DLGP195031	3.1	36	65
DLGP195032	3.2	36	65
DLGP195033	3.3	36	65
DLGP195034	3.4	39	70
DLGP195035	3.5	39	70

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP195036	3.6	39	70
DLGP195037	3.7	39	70
DLGP195038	3.8	43	75
DLGP195039	3.9	43	75
DLGP195040	4.0	43	75
DLGP195041	4.1	43	75
DLGP195042	4.2	43	75
DLGP195043	4.3	47	80
DLGP195044	4.4	47	80
DLGP195045	4.5	47	80
DLGP195046	4.6	47	80
DLGP195047	4.7	47	80
DLGP195048	4.8	52	86
DLGP195049	4.9	52	86
DLGP195050	5.0	52	86
DLGP195051	5.1	52	86
DLGP195052	5.2	52	86
DLGP195053	5.3	52	86
DLGP195054	5.4	57	93
DLGP195055	5.5	57	93
DLGP195056	5.6	57	93
DLGP195057	5.7	57	93
DLGP195058	5.8	57	93
DLGP195059	5.9	57	93
DLGP195060	6.0	57	93
DLGP195061	6.1	63	101

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	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	30	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 Material Description	N					S					H										
	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	○	○	○							○						○					

HSS-E, STRAIGHT SHANK DRILLS, GOLD-P COATED

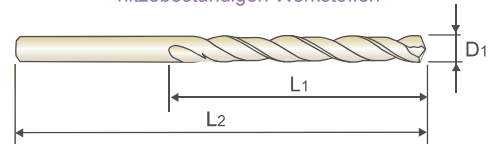
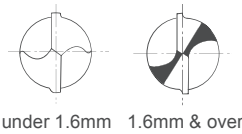
JOBBER

- HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, série courte
- PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

**KURZ
COURTE
CORTA**

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 135°, under 1.6mm : Normal point
1.6mm & over : Split point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Deep hole drilling in unalloyed and alloyed steels, stainless steels as well as certain cast irons, non-ferrous and heat resistant materials

- ▶ **Nutenform** : Rechtsspirale
- ▶ **Spitzenwinkel** : 135°, unter 1,6mm : Normalanschliff
1,6mm & über : Kreuzanschliff
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Bohren tiefer Bohrungen in unlegierten und legierten Stählen, nichtrostenden Stählen sowie bestimmten Gusseisen, Nichteisenmetallen und hitzebeständigen Werkstoffen



DIN 338
HSS-E
33°
h8
135°
TiN
p.A207

Plain Shank
 Recommended ToolHolder
 ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP195114	11.4	94	142
DLGP195115	11.5	94	142
DLGP195116	11.6	94	142
DLGP195117	11.7	94	142
DLGP195118	11.8	94	142
DLGP195119	11.9	101	151
DLGP195120	12.0	101	151
DLGP195121	12.1	101	151
DLGP195122	12.2	101	151
DLGP195123	12.3	101	151

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP195124	12.4	101	151
DLGP195125	12.5	101	151
DLGP195126	12.6	101	151
DLGP195127	12.7	101	151
DLGP195128	12.8	101	151
DLGP195129	12.9	101	151
DLGP195130	13.0	101	151

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	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	30	180	275	300	350	200	325	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 Material Description	N										S						H				
	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	○	○	○						○							○					

HSS-E, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED

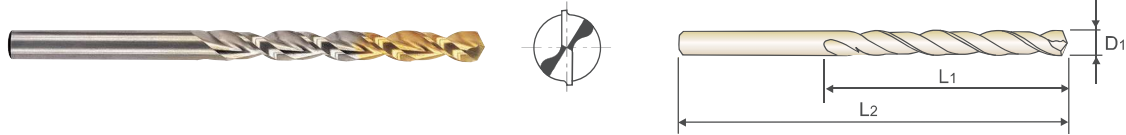
JOBBER

- HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET
- Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte
- PUNTE GAMBO CILINDRICO DH100 in HSS-E, PER FORI PROFONDI, GOLD-P

KURZ
COURTE
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

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506072	7.2	69	109
DLGP506073	7.3	69	109
DLGP506074	7.4	69	109
DLGP506075	7.5	69	109
DLGP506076	7.6	75	117
DLGP506077	7.7	75	117
DLGP506078	7.8	75	117
DLGP506079	7.9	75	117
DLGP506080	8.0	75	117
DLGP506081	8.1	75	117
DLGP506082	8.2	75	117
DLGP506083	8.3	75	117
DLGP506084	8.4	75	117
DLGP506085	8.5	75	117
DLGP506086	8.6	81	125
DLGP506087	8.7	81	125
DLGP506088	8.8	81	125
DLGP506089	8.9	81	125
DLGP506090	9.0	81	125
DLGP506091	9.1	81	125
DLGP506092	9.2	81	125
DLGP506093	9.3	81	125
DLGP506094	9.4	81	125
DLGP506095	9.5	81	125
DLGP506096	9.6	87	133
DLGP506097	9.7	87	133

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
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
DLGP506108	10.8	94	142
DLGP506109	10.9	94	142
DLGP506110	11.0	94	142
DLGP506111	11.1	94	142
DLGP506112	11.2	94	142
DLGP506113	11.3	94	142
DLGP506114	11.4	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
DLGP506120	12.0	101	151
DLGP506121	12.1	101	151
DLGP506122	12.2	101	151
DLGP506123	12.3	101	151

Unit : mm

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
	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	30	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				
	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																					



GOLD-P COATED DRILL SETS

🇩🇪 GOLD-P BESCHICHTET BOHRER SATS

🇫🇷 Coffrets de Forets GOLD-P revêtus

🇮🇹 SET DI PUNTE GOLD-P

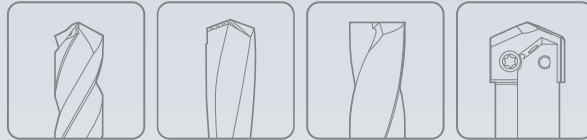


DIN 338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

EDP No.	DESCRIPTION	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



Global Cutting Tool Leader **YG-1**



HOLEMAKING