



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

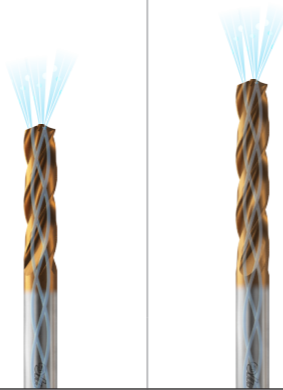


SERIES	DGR493	DGR495
DRILLING DEPTH	3XD	5XD
LENGTH	SHORT	LONG
SIZE MIN	D5.0	D5.0
SIZE MAX	D20.0	D20.0
PAGE	A101	A103

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



Please visit [globalyg1.com/mat](http://globalyg1.com/mat) for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A105

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		Ferritic	130		◎	◎
20	Malleable cast iron	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 (Bronze / Brass)	CuZn, CuSnZn (Brass)	90		
	27	Non Metallic Materials	CuSn, lead-free copper and electrolytic copper	100			
	28		Duroplastic, Fiber Reinforced Plastic				
	29		Rubber, Wood, etc.				
	30						
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15		
	32		Cured	280	30		
	33		Annealed	250	25		
	34		Ni or Co Based 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		Cast	400	42		
41	Hardened Cast Iron	Hardened	550	55			

## DREAM DRILLS - HIGH FEED

DGR493 SERIES

**CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES** **SHORT**  
 DREAM DRILLS HIGH FEED mit KÜHLKANAL **KURZ**  
 Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série courte **COURTE**  
 PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione) **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
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Self centering and chip breaking by R-thinning and coolant holes

- ▶ Bohren von Kohlenstoff-Stählen, legierten Stählen(-HRC35) und Gusseisen
- ▶ Höhere Produktivität durch den 1,5 bis 2-fach höheren Vorschub gegenüber herkömmlichen zweischneidigen Bohrern
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar H Coating p.A105 3 x D

Plain Shank  
 HYDRAULIC CHUCK  
 SHRINK FIT HOLDER  
 ER COLLET CHUCK

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
DGR493050	5.0	6	28	66	DGR493074	7.4	8	41	79
DGR493051	5.1	6	28	66	DGR493075	7.5	8	41	79
DGR493052	5.2	6	28	66	DGR493076	7.6	8	41	79
DGR493053	5.3	6	28	66	DGR493077	7.7	8	41	79
DGR493054	5.4	6	28	66	DGR493078	7.8	8	41	79
DGR493055	5.5	6	28	66	DGR493079	7.9	8	41	79
DGR493056	5.6	6	28	66	DGR493080	8.0	8	41	79
DGR493057	5.7	6	28	66	DGR493081	8.1	10	47	89
DGR493058	5.8	6	28	66	DGR493082	8.2	10	47	89
DGR493059	5.9	6	28	66	DGR493083	8.3	10	47	89
DGR493060	6.0	6	28	66	DGR493084	8.4	10	47	89
DGR493061	6.1	8	34	79	DGR493085	8.5	10	47	89
DGR493062	6.2	8	34	79	DGR493086	8.6	10	47	89
DGR493063	6.3	8	34	79	DGR493087	8.7	10	47	89
DGR493064	6.4	8	34	79	DGR493088	8.8	10	47	89
DGR493065	6.5	8	34	79	DGR493089	8.9	10	47	89
DGR493066	6.6	8	34	79	DGR493090	9.0	10	47	89
DGR493067	6.7	8	34	79	DGR493091	9.1	10	47	89
DGR493068	6.8	8	34	79	DGR493092	9.2	10	47	89
DGR493069	6.9	8	34	79	DGR493093	9.3	10	47	89
DGR493070	7.0	8	34	79	DGR493094	9.4	10	47	89
DGR493071	7.1	8	41	79	DGR493095	9.5	10	47	89
DGR493072	7.2	8	41	79	DGR493096	9.6	10	47	89
DGR493073	7.3	8	41	79	DGR493097	9.7	10	47	89

▶ Other shank types are available on your request.

▶ 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	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
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					
	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	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
Hrc																					
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	550	630	400	550
Recommended																					

# YG DREAM DRILLS - HIGH FEED

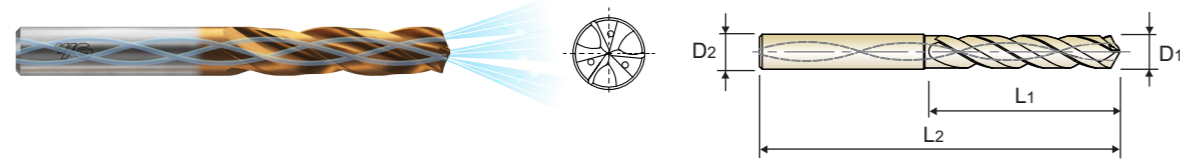
## DGR493 SERIES

### CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES SHORT

- DREAM DRILLS HIGH FEED mit KÜHLKANAL **KURZ**
- Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série courte **COURTE**
- PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione) **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
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Self centering and chip breaking by R-thinning and coolant holes

- ▶ Bohren von Kohlenstoff-Stählen, legierten Stählen(-HRC35) und Gusseisen
- ▶ Höhere Produktivität durch den 1,5 bis 2-fach höheren Vorschub gegenüber herkömmlichen zweischneidigen Bohrern
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar Coating p.A105 3 x D

Plain Shank  
 HYDRAULIC CHUCK  
 SHRINK FIT HOLDER  
 ER COLLET CHUCK  
 Recommended ToolHolder

Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2	H-Coating	D1	D2	L1	L2
DGR493098	9.8	10	47	89	DGR493118	11.8	12	55	102
DGR493099	9.9	10	47	89	DGR493119	11.9	12	55	102
DGR493100	10.0	10	47	89	DGR493120	12.0	12	55	102
DGR493101	10.1	12	55	102	DGR493125	12.5	14	60	107
DGR493102	10.2	12	55	102	DGR493130	13.0	14	60	107
DGR493103	10.3	12	55	102	DGR493135	13.5	14	60	107
DGR493104	10.4	12	55	102	DGR493140	14.0	14	60	107
DGR493105	10.5	12	55	102	DGR493145	14.5	16	65	115
DGR493106	10.6	12	55	102	DGR493150	15.0	16	65	115
DGR493107	10.7	12	55	102	DGR493155	15.5	16	65	115
DGR493108	10.8	12	55	102	DGR493160	16.0	16	65	115
DGR493109	10.9	12	55	102	DGR493165	16.5	18	73	123
DGR493110	11.0	12	55	102	DGR493170	17.0	18	73	123
DGR493111	11.1	12	55	102	DGR493175	17.5	18	73	123
DGR493112	11.2	12	55	102	DGR493180	18.0	18	73	123
DGR493113	11.3	12	55	102	DGR493185	18.5	20	79	131
DGR493114	11.4	12	55	102	DGR493190	19.0	20	79	131
DGR493115	11.5	12	55	102	DGR493195	19.5	20	79	131
DGR493116	11.6	12	55	102	DGR493200	20.0	20	79	131
DGR493117	11.7	12	55	102					

▶ Other shank types are available on your request.

◎ : 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			
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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	35	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)			Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
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						15	30	25	38	34	55	60	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																					

# YG DREAM DRILLS - HIGH FEED

## DGR495 SERIES

### CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES LONG

- DREAM DRILLS HIGH FEED mit KÜHLKANAL **KURZ**
- Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série longue **LONGUE**
- PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione) **LUNGA**

- ▶ 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
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Self centering and chip breaking by R-thinning and coolant holes

- ▶ Bohren von Kohlenstoff-Stählen, legierten Stählen(-HRC35) und Gusseisen
- ▶ Höhere Produktivität durch den 1,5 bis 2-fach höheren Vorschub gegenüber herkömmlichen zweischneidigen Bohrern
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar Coating p.A105 5 x D

Plain Shank  
 HYDRAULIC CHUCK  
 SHRINK FIT HOLDER  
 ER COLLET CHUCK  
 Recommended ToolHolder

Unit : mm					Unit : mm				
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
H-Coating	D1	D2	L1	L2	H-Coating	D1	D2	L1	L2
DGR495050	5.0	6	44	82	DGR495074	7.4	8	53	91
DGR495051	5.1	6	44	82	DGR495075	7.5	8	53	91
DGR495052	5.2	6	44	82	DGR495076	7.6	8	53	91
DGR495053	5.3	6	44	82	DGR495077	7.7	8	53	91
DGR495054	5.4	6	44	82	DGR495078	7.8	8	53	91
DGR495055	5.5	6	44	82	DGR495079	7.9	8	53	91
DGR495056	5.6	6	44	82	DGR495080	8.0	8	53	91
DGR495057	5.7	6	44	82	DGR495081	8.1	10	61	103
DGR495058	5.8	6	44	82	DGR495082	8.2	10	61	103
DGR495059	5.9	6	44	82	DGR495083	8.3	10	61	103
DGR495060	6.0	6	44	82	DGR495084	8.4	10	61	103
DGR495061	6.1	8	53	91	DGR495085	8.5	10	61	103
DGR495062	6.2	8	53	91	DGR495086	8.6	10	61	103
DGR495063	6.3	8	53	91	DGR495087	8.7	10	61	103
DGR495064	6.4	8	53	91	DGR495088	8.8	10	61	103
DGR495065	6.5	8	53	91	DGR495089	8.9	10	61	103
DGR495066	6.6	8	53	91	DGR495090	9.0	10	61	103
DGR495067	6.7	8	53	91	DGR495091	9.1	10	61	103
DGR495068	6.8	8	53	91	DGR495092	9.2	10	61	103
DGR495069	6.9	8	53	91	DGR495093	9.3	10	61	103
DGR495070	7.0	8	53	91	DGR495094	9.4	10	61	103
DGR495071	7.1	8	53	91	DGR495095	9.5	10	61	103
DGR495072	7.2	8	53	91	DGR495096	9.6	10	61	103
DGR495073	7.3	8	53	91	DGR495097	9.7	10	61	103

▶ Other shank types are available on your request.

▶ 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			
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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	35	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)			Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
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						15	30	25	38	34	55	60	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																					

# YG DREAM DRILLS - HIGH FEED

## DGR495 SERIES

### CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES LONG

- DREAM DRILLS HIGH FEED mit KÜHLKANAL** **KURZ**
- Forets DREAM DRILLS carbure Grande Avance avec arrosage central, série longue** **LONGUE**
- PUNTE DREAM DRILL HIGH FEED (con i fori di refrigerazione)** **LUNGA**

- ▶ 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
- ▶ Multi-Layer coating delivers much better productivity and reliability
- ▶ Self centering and chip breaking by R-thinning and coolant holes

- ▶ Bohren von Kohlenstoff-Stählen, legierten Stählen(-HRc35) und Gusseisen
- ▶ Höhere Produktivität durch den 1,5 bis 2-fach höheren Vorschub gegenüber herkömmlichen zweischneidigen Bohrern
- ▶ Die Multi-Layer Beschichtung ermöglicht eine bessere Produktivität und Zuverlässigkeit
- ▶ Selbst zentrierend und guter Spanbruch durch die R-Ausspitzung



DIN 6537
CARBIDE
30°
h6
m7
140°
20 bar
H Coating
p.A105
5 x D

P					K				
EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
DGR495098	9.8	10	61	103	DGR495118	11.8	12	71	118
DGR495099	9.9	10	61	103	DGR495119	11.9	12	71	118
DGR495100	10.0	10	61	103	DGR495120	12.0	12	71	118
DGR495101	10.1	12	71	118	DGR495125	12.5	14	77	124
DGR495102	10.2	12	71	118	DGR495130	13.0	14	77	124
DGR495103	10.3	12	71	118	DGR495135	13.5	14	77	124
DGR495104	10.4	12	71	118	DGR495140	14.0	14	77	124
DGR495105	10.5	12	71	118	DGR495145	14.5	16	83	133
DGR495106	10.6	12	71	118	DGR495150	15.0	16	83	133
DGR495107	10.7	12	71	118	DGR495155	15.5	16	83	133
DGR495108	10.8	12	71	118	DGR495160	16.0	16	83	133
DGR495109	10.9	12	71	118	DGR495165	16.5	18	93	143
DGR495110	11.0	12	71	118	DGR495170	17.0	18	93	143
DGR495111	11.1	12	71	118	DGR495175	17.5	18	93	143
DGR495112	11.2	12	71	118	DGR495180	18.0	18	93	143
DGR495113	11.3	12	71	118	DGR495185	18.5	20	101	153
DGR495114	11.4	12	71	118	DGR495190	19.0	20	101	153
DGR495115	11.5	12	71	118	DGR495195	19.5	20	101	153
DGR495116	11.6	12	71	118	DGR495200	20.0	20	101	153
DGR495117	11.7	12	71	118					

▶ Other shank types are available on your request.

© : 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	29	32	38	35	35	15	23	10	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	400Rm	1050Rm	550	630	400	550
Recommended																					

# YG DREAM DRILLS - HIGH FEED

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

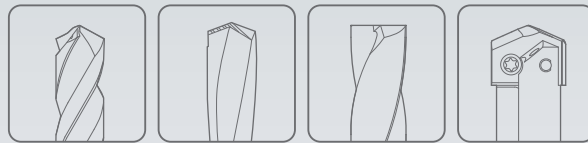
### DGR493, DGR495 SERIES with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)										
					5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0		
P	2	Non-alloy steel	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590		
			FEED	0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.6	0.56-0.7	0.56-0.72	0.63-0.81	0.7-0.88			
			100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590		
	FEED		0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.6	0.56-0.7	0.56-0.72	0.63-0.81	0.7-0.88				
	100		RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590			
	FEED		0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67				
	3	Low alloy steel	80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270		
			FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67			
			100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590		
	FEED		0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.54	0.56-0.63	0.56-0.64	0.63-0.72	0.68-0.81				
	80		RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270			
FEED	0.2-0.25		0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.54	0.56-0.63	0.56-0.64	0.63-0.72	0.68-0.81					
4	High alloyed steel, and tool steel	80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270			
		FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67				
		40	RPM	2550	2120	1590	1270	1060	910	800	710	640			
FEED		0.13-0.18	0.16-0.22	0.21-0.29	0.26-0.36	0.32-0.38	0.36-0.43	0.36-0.45	0.38-0.47	0.41-0.54					
5		Grey cast iron	70	RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110		
			FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67			
	40		RPM	2550	2120	1590	1270	1060	910	800	710	640			
FEED	0.13-0.18		0.16-0.22	0.21-0.29	0.26-0.36	0.32-0.38	0.36-0.43	0.36-0.45	0.38-0.47	0.41-0.54					
6	Nodular cast iron		100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590		
			FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98			
		80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270			
FEED		0.20-0.25	0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90					
7		Malleable cast iron	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590		
			FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98			
	70		RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110			
FEED	0.20-0.25		0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90					
8			80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270		
			FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98			
		70	RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110			
FEED		0.20-0.25	0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90					



Global Cutting Tool Leader **YG-1**



# HOLEMAKING