



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

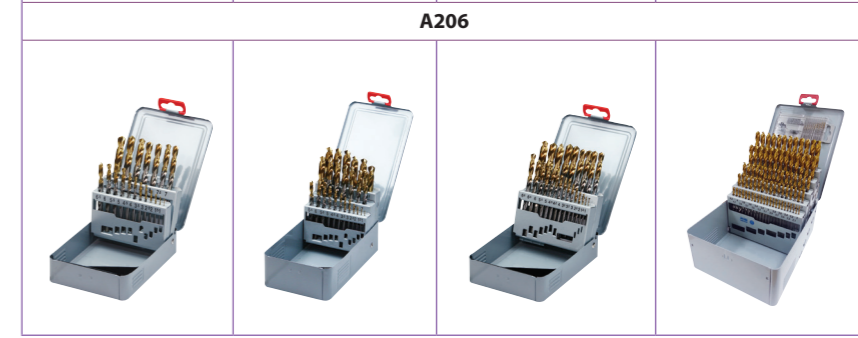


SERIES	D1GP125	D1GP165
STANDARD	DIN 338	DIN 338
LENGTH	JOBBER	JOBBER
SIZE MIN	D1.0	D1.6
SIZE MAX	D13.0	D13.0
PAGE	A194	A197

SERIES	DLGP195	DLGP506
STANDARD	DIN 338	DIN 338
LENGTH	JOBBER	JOBBER
SIZE MIN	D1.0	D2.0
SIZE MAX	D13.0	D13.0
PAGE	A200	A203

GOLD-P DRILL SETS

SET1	SET2	SET3	SET4
19pcs	25pcs	24pcs	91pcs
1.0mm ~ 10.0mm ×0.5mm step	1.0mm ~ 13.0mm ×0.5mm step	1.0mm ~ 10.5mm ×0.5mm step +3.3+4.2+6.8+10.2	1.0mm ~ 10.0mm ×0.1mm step



HSS & HSS-E
GOLD-P DRILLS

Same Performance as Full TiN-coated Drills

SURFACE TREATMENT TiN

TiN



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		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	Duroplastic, Fiber Reinforced Plastic				
	28		Rubber, Wood, etc.			○	○
	29						
	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			

◎	◎	1
◎	◎	2
◎	◎	3
○	○	4
		5
◎	◎	6 P
○	○	7
○	○	8
		9
○	○	10
		11
◎		12
○		13 M
○		14
○	○	15
○	○	16
○	○	17 K
	○	18
○	○	19
	○	20
○		21
○		22
○		23
		24
		25 N
		26
		27
		28
○		29
		30
		31
		32
		33
		34 S
		35
○		36
		37
		38
		39 H
		40
		41



D1GP125 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

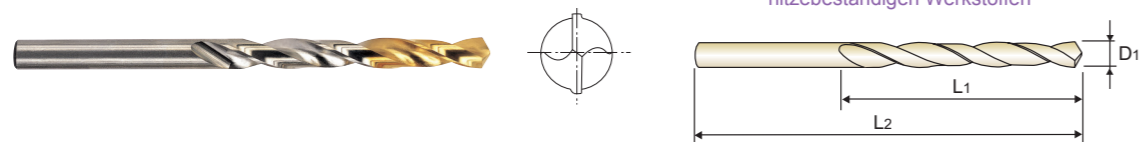
JOBBER

- 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



EDP No.	Drill Diameter			Flute Length			Overall Length		
	D1	L1	L2	D1	L1	L2	D1	L1	L2
D1GP125010	1.0	12	34	D1GP125036	3.6	39	70		
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	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	38	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							
	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	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	40	55	60	42	55	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○								○					○							



D1GP125 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

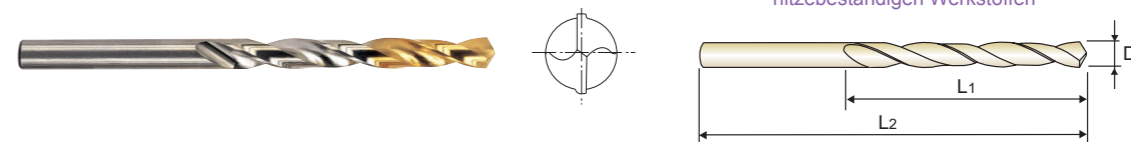
JOBBER

- 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



EDP No.	Drill Diameter			Flute Length			Overall Length		
	D1	L1	L2	D1	L1	L2	D1	L1	L2
D1GP125062	6.2	63	101	D1GP125088	8.8	81	125		
D1GP125063	6.3	63	101	D1GP125089	8.9	81	125		
D1GP125064	6.4	63	101	D1GP125090	9.0	81	125		
D1GP125065	6.5	63	101	D1GP125091	9.1	81	125		
D1GP125066	6.6	63	101	D1GP125092	9.2	81	125		
D1GP125067	6.7	63	101	D1GP125093	9.3	81	125		
D1GP125068	6.8	69	109	D1GP125094	9.4	81	125		
D1GP125069	6.9	69	109	D1GP125095	9.5	81	125		
D1GP125070	7.0	69	109	D1GP125096	9.6	87	133		
D1GP125071	7.1	69	109	D1GP125097	9.7	87	133		
D1GP125072	7.2	69	109	D1GP125098	9.8	87	133		
D1GP125073	7.3	69	109	D1GP125099	9.9	87	133		
D1GP125074	7.4	69	109	D1GP125100	10.0	87	133		
D1GP125075	7.5	69	109	D1GP125101	10.1	87	133		
D1GP125076	7.6	75	117	D1GP125102	10.2	87	133		
D1GP125077	7.7	75	117	D1GP125103	10.3	87	133		
D1GP125078	7.8	75	117	D1GP125104	10.4	87	133		
D1GP125079	7.9	75	117	D1GP125105	10.5	87	133		
D1GP125080	8.0	75	117	D1GP125106	10.6	87	133		
D1GP125081	8.1	75	117	D1GP125107	10.7	94	142		
D1GP125082	8.2	75	117	D1GP125108	10.8	94	142		
D1GP125083	8.3	75	117	D1GP125109	10.9	94	142		
D1GP125084	8.4	75	117	D1GP125110	11.0	94	142		
D1GP125085	8.5	75	117	D1GP125111	11.1	94	142		
D1GP125086	8.6	81	125	D1GP125112	11.2	94	142		
D1GP125087	8.7	81	125	D1GP125113	11.3	94	142		

► 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	38	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							
	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	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	40	55	60	42	55	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○								○					○							

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

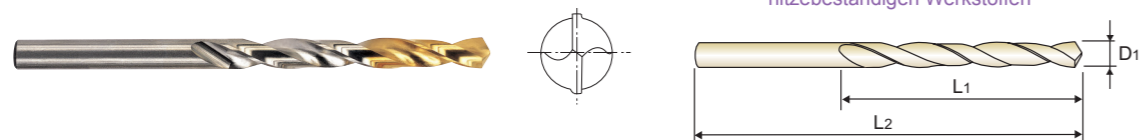
JOBBER

- 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

Unit : mm

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

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

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

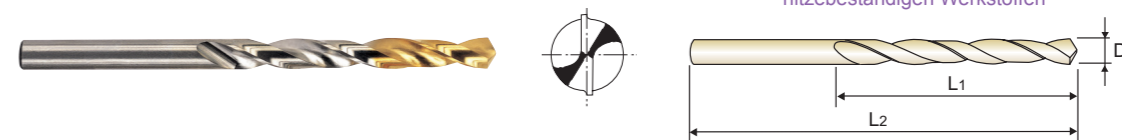
JOBBER

- 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

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165016	1.6	20	43
D1GP165017	1.7	20	43
D1GP165018	1.8	22	46
D1GP165019	1.9	22	46
D1GP165020	2.0	24	49
D1GP165021	2.1	24	49
D1GP165022	2.2	27	53
D1GP165023	2.3	27	53
D1GP165024	2.4	30	57
D1GP165025	2.5	30	57
D1GP165026	2.6	30	57
D1GP165027	2.7	33	61
D1GP165028	2.8	33	61
D1GP165029	2.9	33	61
D1GP165030	3.0	33	61
D1GP165031	3.1	36	65
D1GP165032	3.2	36	65
D1GP165033	3.3	36	65
D1GP165034	3.4	39	70
D1GP165035	3.5	39	70
D1GP165036	3.6	39	70
D1GP165037	3.7	39	70
D1GP165038	3.8	43	75
D1GP165039	3.9	43	75
D1GP165040	4.0	43	75
D1GP165041	4.1	43	75

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165042	4.2	43	75
D1GP165043	4.3	47	80
D1GP165044	4.4	47	80
D1GP165045	4.5	47	80
D1GP165046	4.6	47	80
D1GP165047	4.7	47	80
D1GP165048	4.8	52	86
D1GP165049	4.9	52	86
D1GP165050	5.0	52	86
D1GP165051	5.1	52	86
D1GP165052	5.2	52	86
D1GP165053	5.3	52	86
D1GP165054	5.4	57	93
D1GP165055	5.5	57	93
D1GP165056	5.6	57	93
D1GP165057	5.7	57	93
D1GP165058	5.8	57	93
D1GP165059	5.9	57	93
D1GP165060	6.0	57	93
D1GP165061	6.1	63	101
D1GP165062	6.2	63	101
D1GP165063	6.3	63	101
D1GP165064	6.4	63	101
D1GP165065	6.5	63	101
D1GP165066	6.6	63	101
D1GP165067	6.7	63	101

▶ 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	35	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						
	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	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

◎ : Excellent ○ : Good

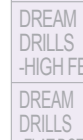
ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	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						
	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	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

JOBBER

KURZ
COURTE
CORTA

Flute Geometry : Right hand helix



DIN 338 HSS N 30° h8 118° TiN p.A207

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165016	1.6	20	43
D1GP165017	1.7	20	43
D1GP165018	1.8	22	46
D1GP165019	1.9	22	46
D1GP165020	2.0	24	49
D1GP165021	2.1	24	49
D1GP165022	2.2	27	53
D1GP165023	2.3	27	53
D1GP165024	2.4	30	57
D1GP165025	2.5	30	57
D1GP165026	2.6	30	57
D1GP165027	2.7	33	61
D1GP165028	2.8	33	61
D1GP165029	2.9	33	61
D1GP165030	3.0	33	61
D1GP165031	3.1	36	65
D1GP165032	3.2	36	65
D1GP165033	3.3	36	65
D1GP165034	3.4	39	70
D1GP165035	3.5	39	70
D1GP165036	3.6	39	70
D1GP165037	3.7	39	70
D1GP165038	3.8	43	75
D1GP165039	3.9	43	75
D1GP165040	4.0	43	75
D1GP165041	4.1	43	75

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1GP165042	4.2	43	75
D1GP165043	4.3	47	80
D1GP165044	4.4	47	80
D1GP165045	4.5	47	80
D1GP165046	4.6	47	80
D1GP165047	4.7	47	80
D1GP165048	4.8	52	86
D1GP165049	4.9	52	86
D1GP165050	5.0	52	86
D1GP165051	5.1	52	86
D1GP165052	5.2	52	86
D1GP165053	5.3	52	86
D1GP165054	5.4	57	93
D1GP165055	5.5	57	93
D1GP165056	5.6	57	93
D1GP165057	5.7	57	93
D1GP165058	5.8	57	93
D1GP165059	5.9	57	93
D1GP165060	6.0	57	93
D1GP165061	6.1	63	101
D1GP165062	6.2	63	101
D1GP165063	6.3	63	101
D1GP165064	6.4	63	101
D1GP165065	6.5	63	101
D1GP165066	6.6	63	101
D1GP165067	6.7	63	101

▶ 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	35	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				
	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
VDI 3323	21	22</																	

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

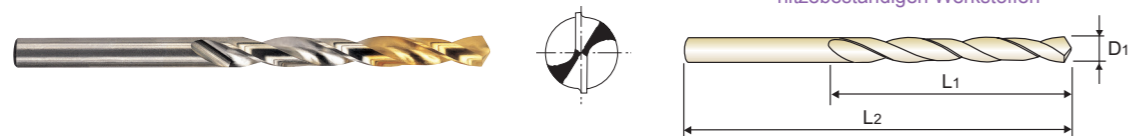
JOBBER

- 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

Unit : mm

EDP No.	Drill Diameter			Flute Length			Overall Length		
	D1	L1	L2	D1	L1	L2	D1	L1	L2
D1GP165068	6.8	69	109	D1GP165094	9.4	81	125		
D1GP165069	6.9	69	109	D1GP165095	9.5	81	125		
D1GP165070	7.0	69	109	D1GP165096	9.6	87	133		
D1GP165071	7.1	69	109	D1GP165097	9.7	87	133		
D1GP165072	7.2	69	109	D1GP165098	9.8	87	133		
D1GP165073	7.3	69	109	D1GP165099	9.9	87	133		
D1GP165074	7.4	69	109	D1GP165100	10.0	87	133		
D1GP165075	7.5	69	109	D1GP165101	10.1	87	133		
D1GP165076	7.6	75	117	D1GP165102	10.2	87	133		
D1GP165077	7.7	75	117	D1GP165103	10.3	87	133		
D1GP165078	7.8	75	117	D1GP165104	10.4	87	133		
D1GP165079	7.9	75	117	D1GP165105	10.5	87	133		
D1GP165080	8.0	75	117	D1GP165106	10.6	87	133		
D1GP165081	8.1	75	117	D1GP165107	10.7	94	142		
D1GP165082	8.2	75	117	D1GP165108	10.8	94	142		
D1GP165083	8.3	75	117	D1GP165109	10.9	94	142		
D1GP165084	8.4	75	117	D1GP165110	11.0	94	142		
D1GP165085	8.5	75	117	D1GP165111	11.1	94	142		
D1GP165086	8.6	81	125	D1GP165112	11.2	94	142		
D1GP165087	8.7	81	125	D1GP165113	11.3	94	142		
D1GP165088	8.8	81	125	D1GP165114	11.4	94	142		
D1GP165089	8.9	81	125	D1GP165115	11.5	94	142		
D1GP165090	9.0	81	125	D1GP165116	11.6	94	142		
D1GP165091	9.1	81	125	D1GP165117	11.7	94	142		
D1GP165092	9.2	81	125	D1GP165118	11.8	94	142		
D1GP165093	9.3	81	125	D1GP165119	11.9	101	151		

► 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)	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	60	100	75	90	130	110	90	100			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, STRAIGHT SHANK DRILLS, GOLD-P COATED

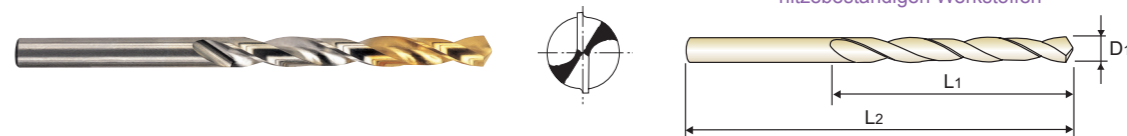
JOBBER

- 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

Unit : mm

EDP No.	Drill Diameter			Flute Length			Overall Length		
	D1	L1	L2	D1	L1	L2	D1	L1	L2
D1GP165120	12.0	101	151	D1GP165126	12.6	101	151		
D1GP165121	12.1	101	151	D1GP165127	12.7	101	151		
D1GP165122	12.2	101	151	D1GP165128	12.8	101	151		
D1GP165123	12.3	101	151	D1GP165129	12.9	101	151		
D1GP165124	12.4	101	151	D1GP165130	13.0	101	151		
D1GP165125	12.5	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	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)	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	60	100	75	90	130	110	90	100			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, STRAIGHT SHANK DRILLS, GOLD-P COATED

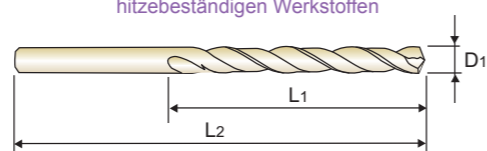
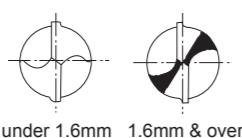
JOBBER

- 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

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
DLGP195010	1.0	12	34	DLGP195036	3.6	39	70
DLGP195011	1.1	14	36	DLGP195037	3.7	39	70
DLGP195012	1.2	16	38	DLGP195038	3.8	43	75
DLGP195013	1.3	16	38	DLGP195039	3.9	43	75
DLGP195014	1.4	18	40	DLGP195040	4.0	43	75
DLGP195015	1.5	18	40	DLGP195041	4.1	43	75
DLGP195016	1.6	20	43	DLGP195042	4.2	43	75
DLGP195017	1.7	20	43	DLGP195043	4.3	47	80
DLGP195018	1.8	22	46	DLGP195044	4.4	47	80
DLGP195019	1.9	22	46	DLGP195045	4.5	47	80
DLGP195020	2.0	24	49	DLGP195046	4.6	47	80
DLGP195021	2.1	24	49	DLGP195047	4.7	47	80
DLGP195022	2.2	27	53	DLGP195048	4.8	52	86
DLGP195023	2.3	27	53	DLGP195049	4.9	52	86
DLGP195024	2.4	30	57	DLGP195050	5.0	52	86
DLGP195025	2.5	30	57	DLGP195051	5.1	52	86
DLGP195026	2.6	30	57	DLGP195052	5.2	52	86
DLGP195027	2.7	33	61	DLGP195053	5.3	52	86
DLGP195028	2.8	33	61	DLGP195054	5.4	57	93
DLGP195029	2.9	33	61	DLGP195055	5.5	57	93
DLGP195030	3.0	33	61	DLGP195056	5.6	57	93
DLGP195031	3.1	36	65	DLGP195057	5.7	57	93
DLGP195032	3.2	36	65	DLGP195058	5.8	57	93
DLGP195033	3.3	36	65	DLGP195059	5.9	57	93
DLGP195034	3.4	39	70	DLGP195060	6.0	57	93
DLGP195035	3.5	39	70	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)		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	60	100	75	90	130	110	90	100			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, STRAIGHT SHANK DRILLS, GOLD-P COATED

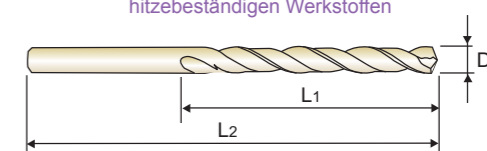
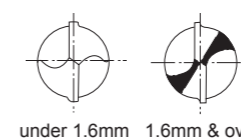
JOBBER

- 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

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
DLGP195062	6.2	63	101	DLGP195088	8.8	81	125
DLGP195063	6.3	63	101	DLGP195089	8.9	81	125
DLGP195064	6.4	63	101	DLGP195090	9.0	81	125
DLGP195065	6.5	63	101	DLGP195091	9.1	81	125
DLGP195066	6.6	63	101	DLGP195092	9.2	81	125
DLGP195067	6.7	63	101	DLGP195093	9.3	81	125
DLGP195068	6.8	69	109	DLGP195094	9.4	81	125
DLGP195069	6.9	69	109	DLGP195095	9.5	81	125
DLGP195070	7.0	69	109	DLGP195096	9.6	87	133
DLGP195071	7.1	69	109	DLGP195097	9.7	87	133
DLGP195072	7.2	69	109	DLGP195098	9.8	87	133
DLGP195073	7.3	69	109	DLGP195099	9.9	87	133
DLGP195074	7.4	69	109	DLGP195100	10.0	87	133
DLGP195075	7.5	69	109	DLGP195101	10.1	87	133
DLGP195076	7.6	75	117	DLGP195102	10.2	87	133
DLGP195077	7.7	75	117	DLGP195103	10.3	87	133
DLGP195078	7.8	75	117	DLGP195104	10.4	87	133
DLGP195079	7.9	75	117	DLGP195105	10.5	87	133
DLGP195080	8.0	75	117	DLGP195106	10.6	87	133
DLGP195081	8.1	75	117	DLGP195107	10.7	94	142
DLGP195082	8.2	75	117	DLGP195108	10.8	94	142
DLGP195083	8.3	75	117	DLGP195109	10.9	94	142
DLGP195084	8.4	75	117	DLGP195110	11.0	94	142
DLGP195085	8.5	75	117	DLGP195111	11.1	94	142
DLGP195086	8.6	81	125	DLGP195112	11.2	94	142
DLGP195087	8.7	81	125	DLGP195113	11.3	94	142

► 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)		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	60	100	75	90	130	110	90	100			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	○	○	○								○					○					

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER BORES

TECHNICAL DATA

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

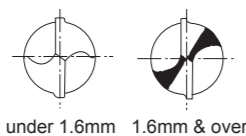
JOBBER

- 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

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

Unit : mm

◎ : 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	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	21	22	23	24	25	26	27	28	29	30	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

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

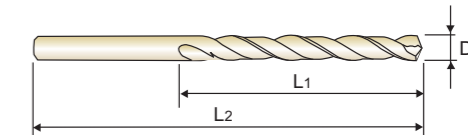
JOBBER

- 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

DIN 338 HSS-E 38° h8 130° TiN p.A207

Plain Shank
Recommended Toolholder ER COLLET CHUCK

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506020	2.0	24	49
DLGP506021	2.1	24	49
DLGP506022	2.2	27	53
DLGP506023	2.3	27	53
DLGP506024	2.4	30	57
DLGP506025	2.5	30	57
DLGP506026	2.6	30	57
DLGP506027	2.7	33	61
DLGP506028	2.8	33	61
DLGP506029	2.9	33	61
DLGP506030	3.0	33	61
DLGP506031	3.1	36	65
DLGP506032	3.2	36	65
DLGP506033	3.3	36	65
DLGP506034	3.4	39	70
DLGP506035	3.5	39	70
DLGP506036	3.6	39	70
DLGP506037	3.7	39	70
DLGP506038	3.8	43	75
DLGP506039	3.9	43	75
DLGP506040	4.0	43	75
DLGP506041	4.1	43	75
DLGP506042	4.2	43	75
DLGP506043	4.3	47	80
DLGP506044	4.4	47	80
DLGP506045	4.5	47	80

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DLGP506046	4.6	47	80
DLGP506047	4.7	47	80
DLGP506048	4.8	52	86
DLGP506049	4.9	52	86
DLGP506050	5.0	52	86
DLGP506051	5.1	52	86
DLGP506052	5.2	52	86
DLGP506053	5.3	52	86
DLGP506054	5.4	57	93
DLGP506055	5.5	57	93
DLGP506056	5.6	57	93
DLGP506057	5.7	57	93
DLGP506058	5.8	57	93
DLGP506059	5.9	57	93
DLGP506060	6.0	57	93
DLGP506061	6.1	63	101
DLGP506062	6.2	63	101
DLGP506063	6.3	63	101
DLGP506064	6.4	63	101
DLGP506065	6.5	63	101
DLGP506066	6.6	63	101
DLGP506067	6.7	63	101
DLGP506068	6.8	69	109
DLGP506069	6.9	69	109
DLGP506070	7.0	69	109
DLGP506071	7.1	69	109

▶ 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	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	21	22	23	24	25	26	27	28	29	30	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

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

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

DIN 338
HSS-E
38°
h8
130°
TiN
p.A207

Plain Shank
Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter			EDP No.	Drill Diameter		
	D1	L1	L2		D1	L1	L2
DLGP506072	7.2	69	109	DLGP506098	9.8	87	133
DLGP506073	7.3	69	109	DLGP506099	9.9	87	133
DLGP506074	7.4	69	109	DLGP506100	10.0	87	133
DLGP506075	7.5	69	109	DLGP506101	10.1	87	133
DLGP506076	7.6	75	117	DLGP506102	10.2	87	133
DLGP506077	7.7	75	117	DLGP506103	10.3	87	133
DLGP506078	7.8	75	117	DLGP506104	10.4	87	133
DLGP506079	7.9	75	117	DLGP506105	10.5	87	133
DLGP506080	8.0	75	117	DLGP506106	10.6	87	133
DLGP506081	8.1	75	117	DLGP506107	10.7	94	142
DLGP506082	8.2	75	117	DLGP506108	10.8	94	142
DLGP506083	8.3	75	117	DLGP506109	10.9	94	142
DLGP506084	8.4	75	117	DLGP506110	11.0	94	142
DLGP506085	8.5	75	117	DLGP506111	11.1	94	142
DLGP506086	8.6	81	125	DLGP506112	11.2	94	142
DLGP506087	8.7	81	125	DLGP506113	11.3	94	142
DLGP506088	8.8	81	125	DLGP506114	11.4	94	142
DLGP506089	8.9	81	125	DLGP506115	11.5	94	142
DLGP506090	9.0	81	125	DLGP506116	11.6	94	142
DLGP506091	9.1	81	125	DLGP506117	11.7	94	142
DLGP506092	9.2	81	125	DLGP506118	11.8	94	142
DLGP506093	9.3	81	125	DLGP506119	11.9	101	151
DLGP506094	9.4	81	125	DLGP506120	12.0	101	151
DLGP506095	9.5	81	125	DLGP506121	12.1	101	151
DLGP506096	9.6	87	133	DLGP506122	12.2	101	151
DLGP506097	9.7	87	133	DLGP506123	12.3	101	151

▶ 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	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	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, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED **JOBBER**

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

DIN 338
HSS-E
38°
h8
130°
TiN
p.A207

Plain Shank
Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter			EDP No.	Drill Diameter		
	D1	L1	L2		D1	L1	L2
DLGP506124	12.4	101	151	DLGP506128	12.8	101	151
DLGP506125	12.5	101	151	DLGP506129	12.9	101	151
DLGP506126	12.6	101	151	DLGP506130	13.0	101	151
DLGP506127	12.7	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	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	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	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																					

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.	DESCRIPTON	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

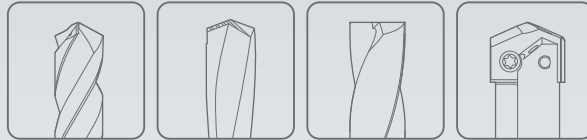
D1GP125, D1GP165, DLGP195, DLGP506 SERIES HSS & HSS-E GOLD-P DRILLS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)	Vc	Parameter	Drill Diameter (mm)						
								1.0	2.0	3.0	4.0	6.0	8.0	10.0
P	1	Non-alloy steel	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
			25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
	FEED			0.01-0.03	FEED		0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
	20		RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730	
			FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490		
		FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18		
	6	Low alloy steel	25	RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860
				FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
20			RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730	
			FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730			
	FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18			
10	High alloyed steel, and tool steel	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490	
			FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
		RPM	5730	25	RPM	3980	2650	1990	1330	990	800	610		
M	Stainless steel	18	FEED	0.01-0.03	25	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
			RPM	4770		20	RPM	3180	2120	1590	1060	800	640	490
		FEED	0.01-0.03	FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24			
10	14	RPM	3180	15	RPM	2390	1590	1190	800	600	480	370		
		FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18		
K	15	Grey cast iron	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	25		RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860	
			FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18	
	28	Nodular cast iron	28	RPM	8910	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	20	Malleable cast iron	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	25		RPM	7960	35	RPM	5570	3710	2790	1860	1390	1110	860	
			FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730			
	FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18			
N	21	Aluminum-wrought alloy	45	RPM	14320	65	RPM	10350	6900	5170	3450	2590	2070	1590
				FEED	0.02-0.05		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	45	RPM	14320	65	RPM	10350	6900	5170	3450	2590	2070	1590		
		FEED	0.02-0.05		FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28		
	35	Aluminum-cast, alloyed	35	RPM	11140	50	RPM	7960	5310	3980	2650	1990	1590	1220
FEED				0.02-0.05	FEED		0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28	
20	Non Metallic Materials	20	RPM	6370	30	RPM	4770	3180	2390	1590	1190	950	730	
			FEED	0.01-0.03		FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24	
S	36	Titanium Alloys	15	RPM	4770	20	RPM	3180	2120	1590	1060	800	640	490
				FEED	0.01-0.02		FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.13	0.08-0.14



Global Cutting Tool Leader **YG-1**



HOLEMAKING