



Leading Through Innovation



**HSS, HSS-E & HSS Co8**

# **STRAIGHT SHANK DRILLS**

**BOHRER MIT ZYLINDERSCHAFT**

- For General Purpose (Soft & Tough Materials)
- Für allgemeine Anwendungen (weiche & zähe Materialien)

SELECTION GUIDE



SERIES	D2107	D1107	D2105
STANDARD	DIN 1897	DIN 1897	DIN 338
LENGTH	STUB	STUB	JOBBER
SIZE MIN	D1.0	D1.0	D1.0
SIZE MAX	D31.0	D13.0	D20.0
PAGE	A220	A224	A227

SURFACE TREATMENT	Gold Coloring	Vap	Gold Coloring
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# HSS, HSS-E & HSS Co8 STRAIGHT SHANK DRILLS

For General Purpose (Soft & Tough Materials)



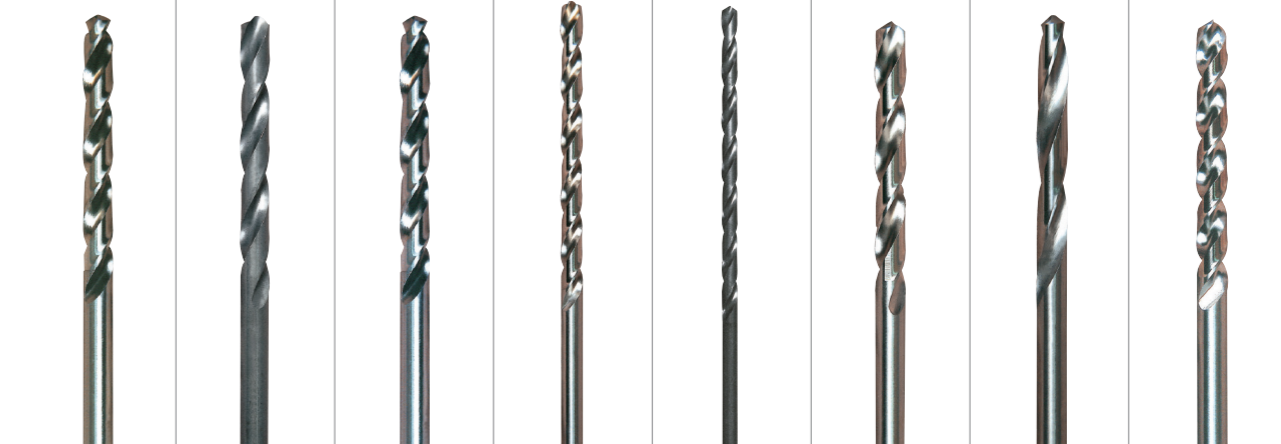
Please visit [globalyg1.com/mat](http://globalyg1.com/mat) for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A262

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)	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		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				

DL105	D1105	D1125	D2104	D1121	DL109	D1100	D1106
DIN 338	DIN 338	DIN 338	DIN 340	DIN 1869/1	DIN 338	DIN 338	DIN 338
JOBBER	JOBBER	JOBBER	LONG	EXTRA LONG	JOBBER	JOBBER	JOBBER
D1.0	D0.3	D2.0	D2.0	D2.0	D1.5	D1.5	D1.5
D20.0	D20.0	D20.0	D12.0	D13.0	D13.0	D13.0	D13.0
A230	A233	A238	A241	A243	A244	A245	A247
Gold Coloring	Vap	Bright	Gold Coloring	Vap	Bright		



◎	◎	◎	◎	◎	◎			1
◎	◎	◎	◎	◎	◎			2
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								5
◎	◎	◎	◎	◎	◎			6 P
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○	○	○	○	○	○			9
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								11
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								31
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								37
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								40 H
								41

SELECTION GUIDE



SERIES	DH100 DL510	DH100 DL508	DH100 DL509
STANDARD	DIN 1897	DIN 338	DIN 340
LENGTH	STUB	JOBBER	LONG
SIZE MIN	D2.0	D2.0	D2.0
SIZE MAX	D20.0	D16.0	D12.0
PAGE	A249	A251	A253

SURFACE TREATMENT

Bright

# HSS-E STRAIGHT SHANK DRILLS

For General Purpose (Soft & Tough Materials)



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

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A262

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	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	○	○	○
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	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)	Cutting Alloys, PB>1%	110				
	27		CuZn, CuSnZn (Brass)	90				
28		CuSn, lead-free copper and electrolytic copper	100					
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30		Rubber, Wood, etc.						
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		Chilled Cast Iron	Cast	400	42		
41	Hardened Cast Iron		Hardened	550	55			

DH100 DL505	DH100 DL504	DH100 DT600	DH100 DT692	DH100 DT693	DH100 DL608	DH50 DL507
DIN 338	DIN 340	DIN 1869/1	DIN 1869/2	DIN 1869/3	DIN 341	-
JOBBER	LONG	EXTRA LONG			LONG	EXTRA LONG
D2.0	D2.0	D2.0	D3.0	D4.0	D13.0	D2.0
D13.0	D13.0	D10.5	D10.2	D10.0	D30.0	D13.0
A255	A257	A258			A259	A260

Vap

TiAIN

Bright



◎	◎	◎	◎	◎	◎	○	1
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# YTG STRAIGHT SHANK DRILLS

**D2107** SERIES

## HSS Co8, STRAIGHT SHANK TWIST DRILLS

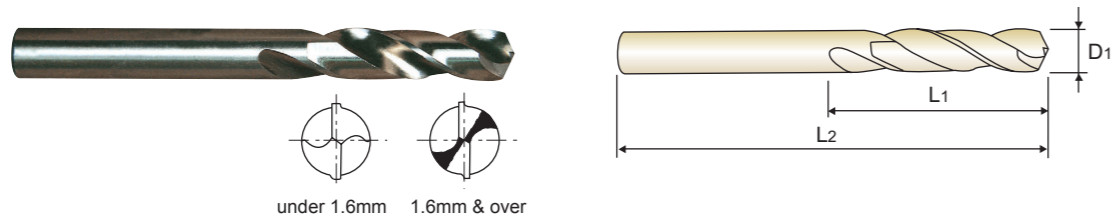
STUB

- HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, Forme C, série extra-courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

► **Surface treatment** : Coloring(Gold color)  
► **Application** : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
► **Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
 Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



**DIN 1897 HSS Co8 33° h8 135° Gold Coloring p.A262** | Plain Shank | Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length L1	Overall Length L2	EDP No.	Drill Diameter		Flute Length L1	Overall Length L2
	D1	D1				D1	D1		
D2107010	1.0	1.0	6	26	D2107032	3.2	3.2	18	49
D2107011	1.1	1.1	7	28	D2107932	3.25	3.25	18	49
D2107012	1.2	1.2	8	30	D2107033	3.3	3.3	18	49
D2107912	1.25	1.25	8	30	D2107034	3.4	3.4	20	52
D2107013	1.3	1.3	8	30	D2107035	3.5	3.5	20	52
D2107014	1.4	1.4	9	32	D2107036	3.6	3.6	20	52
D2107015	1.5	1.5	9	32	D2107037	3.7	3.7	20	52
D2107016	1.6	1.6	10	34	D2107937	3.75	3.75	20	52
D2107017	1.7	1.7	10	34	D2107038	3.8	3.8	22	55
D2107917	1.75	1.75	11	36	D2107039	3.9	3.9	22	55
D2107018	1.8	1.8	11	36	D2107040	4.0	4.0	22	55
D2107019	1.9	1.9	11	36	D2107041	4.1	4.1	22	55
D2107020	2.0	2.0	12	38	D2107042	4.2	4.2	22	55
D2107021	2.1	2.1	12	38	D2107942	4.25	4.25	22	55
D2107022	2.2	2.2	13	40	D2107043	4.3	4.3	24	58
D2107922	2.25	2.25	13	40	D2107044	4.4	4.4	24	58
D2107023	2.3	2.3	13	40	D2107045	4.5	4.5	24	58
D2107024	2.4	2.4	14	43	D2107046	4.6	4.6	24	58
D2107025	2.5	2.5	14	43	D2107946	4.65	4.65	24	58
D2107026	2.6	2.6	14	43	D2107047	4.7	4.7	24	58
D2107027	2.7	2.7	16	46	D2107947	4.75	4.75	24	58
D2107927	2.75	2.75	16	46	D2107048	4.8	4.8	26	62
D2107028	2.8	2.8	16	46	D2107049	4.9	4.9	26	62
D2107029	2.9	2.9	16	46	D2107050	5.0	5.0	26	62
D2107030	3.0	3.0	16	46	D2107051	5.1	5.1	26	62
D2107031	3.1	3.1	18	49	D2107052	5.2	5.2	26	62

► HSS-E(DL107) is available on your request. ► NEXT PAGE  
► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : 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	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	40	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

# YTG STRAIGHT SHANK DRILLS

**D2107** SERIES

## HSS Co8, STRAIGHT SHANK TWIST DRILLS

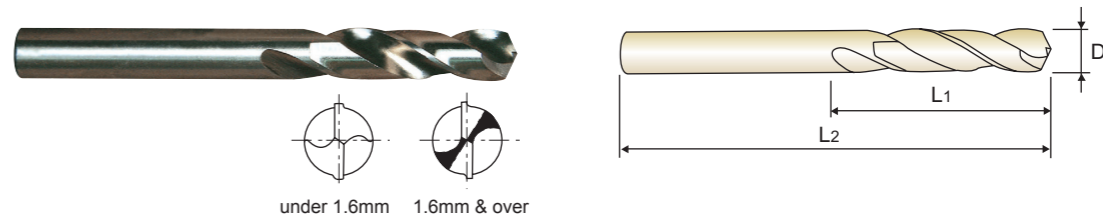
STUB

- HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, Forme C, série extra-courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

► **Surface treatment** : Coloring(Gold color)  
► **Application** : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
► **Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
 Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



**DIN 1897 HSS Co8 33° h8 135° Gold Coloring p.A262** | Plain Shank | Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length L1	Overall Length L2	EDP No.	Drill Diameter		Flute Length L1	Overall Length L2
	D1	D1				D1	D1		
D2107952	5.25	5.25	26	62	D2107073	7.3	7.3	34	74
D2107053	5.3	5.3	26	62	D2107074	7.4	7.4	34	74
D2107054	5.4	5.4	28	66	D2107974	7.45	7.45	34	74
D2107055	5.5	5.5	28	66	D2107075	7.5	7.5	34	74
D2107955	5.55	5.55	28	66	D2107076	7.6	7.6	37	79
D2107056	5.6	5.6	28	66	D2107077	7.7	7.7	37	79
D2107057	5.7	5.7	28	66	D2107977	7.75	7.75	37	79
D2107957	5.75	5.75	28	66	D2107078	7.8	7.8	37	79
D2107058	5.8	5.8	28	66	D2107079	7.9	7.9	37	79
D2107059	5.9	5.9	28	66	D2107080	8.0	8.0	37	79
D2107060	6.0	6.0	28	66	D2107081	8.1	8.1	37	79
D2107061	6.1	6.1	31	70	D2107082	8.2	8.2	37	79
D2107062	6.2	6.2	31	70	D2107982	8.25	8.25	37	79
D2107962	6.25	6.25	31	70	D2107083	8.3	8.3	37	79
D2107063	6.3	6.3	31	70	D2107084	8.4	8.4	37	79
D2107064	6.4	6.4	31	70	D2107085	8.5	8.5	37	79
D2107065	6.5	6.5	31	70	D2107086	8.6	8.6	40	84
D2107066	6.6	6.6	31	70	D2107087	8.7	8.7	40	84
D2107067	6.7	6.7	31	70	D2107987	8.75	8.75	40	84
D2107967	6.75	6.75	34	74	D2107088	8.8	8.8	40	84
D2107068	6.8	6.8	34	74	D2107089	8.9	8.9	40	84
D2107069	6.9	6.9	34	74	D2107090	9.0	9.0	40	84
D2107070	7.0	7.0	34	74	D2107091	9.1	9.1	40	84
D2107071	7.1	7.1	34	74	D2107092	9.2	9.2	40	84
D2107072	7.2	7.2	34	74	D2107992	9.25	9.25	40	84
D2107972	7.25	7.25	34	74	D2107093	9.3	9.3	40	84

► HSS-E(DL107) is available on your request. ► NEXT PAGE  
► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : 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	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	40	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 Co8, STRAIGHT SHANK TWIST DRILLS

STUB

HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT

EXTRA KURZ

Forets HSS Co8, queue cylindrique, Forme C, série extra-courte

EXTRA-COURTE

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

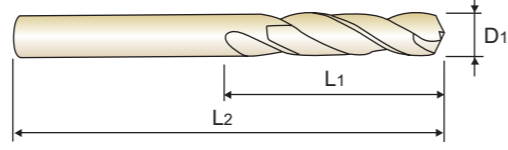
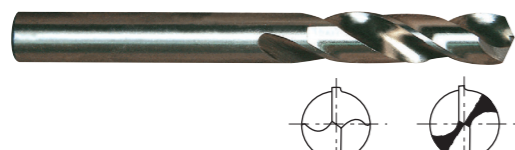
EXTRA CORTA

► **Surface treatment** : Coloring(Gold color)

► **Application** : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes

► **Oberflächenbehandlung** : Coloring(Goldfarbe)

► **Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



under 1.6mm 1.6mm & over



Unit : mm

EDP No.	Drill Diameter		Overall Length	EDP No.	Drill Diameter		Overall Length
	D1	L1			D1	L1	
D2107993	9.35	40	84	D2107138	13.8	54	107
D2107094	9.4	40	84	D2107140	14.0	54	107
D2107095	9.5	40	84	D2107842	14.25	56	111
D2107096	9.6	43	89	D2107145	14.5	56	111
D2107097	9.7	43	89	D2107847	14.75	56	111
D2107997	9.75	43	89	D2107150	15.0	56	111
D2107098	9.8	43	89	D2107852	15.25	58	115
D2107099	9.9	43	89	D2107155	15.5	58	115
D2107100	10.0	43	89	D2107857	15.75	58	115
D2107102	10.2	43	89	D2107160	16.0	58	115
D2107802	10.25	43	89	D2107862	16.25	60	119
D2107105	10.5	43	89	D2107165	16.5	60	119
D2107807	10.75	47	95	D2107867	16.75	60	119
D2107110	11.0	47	95	D2107170	17.0	60	119
D2107812	11.25	47	95	D2107872	17.25	62	123
D2107115	11.5	47	95	D2107175	17.5	62	123
D2107817	11.75	47	95	D2107877	17.75	62	123
D2107118	11.8	47	95	D2107180	18.0	62	123
D2107120	12.0	51	102	D2107882	18.25	64	127
D2107822	12.25	51	102	D2107185	18.5	64	127
D2107125	12.5	51	102	D2107887	18.75	64	127
D2107827	12.75	51	102	D2107190	19.0	64	127
D2107130	13.0	51	102	D2107892	19.25	66	131
D2107832	13.25	54	107	D2107195	19.5	66	131
D2107135	13.5	54	107	D2107897	19.75	66	131
D2107837	13.75	54	107	D2107200	20.0	66	131

► HSS-E(DL107) is available on your request. ▶ NEXT PAGE

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) 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	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	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	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎			◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

### HSS Co8, STRAIGHT SHANK TWIST DRILLS

STUB

HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT

EXTRA KURZ

Forets HSS Co8, queue cylindrique, Forme C, série extra-courte

EXTRA-COURTE

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

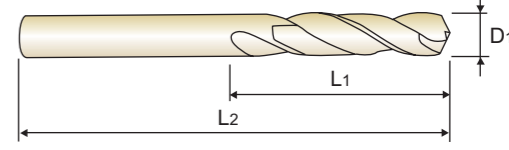
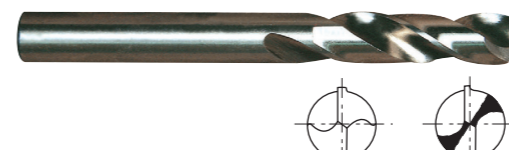
EXTRA CORTA

► **Surface treatment** : Coloring(Gold color)

► **Application** : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes

► **Oberflächenbehandlung** : Coloring(Goldfarbe)

► **Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



under 1.6mm 1.6mm & over



Unit : mm

EDP No.	Drill Diameter		Overall Length	EDP No.	Drill Diameter		Overall Length
	D1	L1			L2	D1	
D2107205	20.5	68	136	D2107245	24.5	75	151
D2107210	21.0	68	136	D2107250	25.0	75	151
D2107215	21.5	70	141	D2107260	26.0	78	156
D2107220	22.0	70	141	D2107270	27.0	81	162
D2107225	22.5	72	146	D2107280	28.0	81	162
D2107230	23.0	72	146	D2107290	29.0	84	168
D2107235	23.5	72	146	D2107300	30.0	84	168
D2107240	24.0	75	151	D2107310	31.0	87	174

► HSS-E(DL107) is available on your request.

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) 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	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	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	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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎			◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



D1107 SERIES

**HSS, STRAIGHT SHANK TWIST DRILLS**

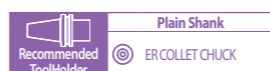
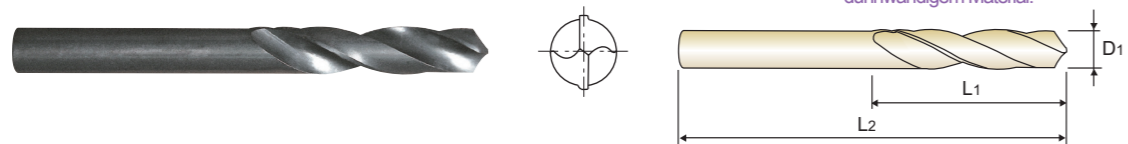
STUB

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série extra-courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

►Surface treatment : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm  
►Application : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes.

►Oberflächenbehandlung : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm  
►Verwendung : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1107011	1.1	7	28	D1107932	3.25	18	49
D1107012	1.2	8	30	D1107033	3.3	18	49
D1107912	1.25	8	30	D1107034	3.4	20	52
D1107013	1.3	8	30	D1107035	3.5	20	52
D1107014	1.4	9	32	D1107036	3.6	20	52
D1107015	1.5	9	32	D1107037	3.7	20	52
D1107016	1.6	9	34	D1107937	3.75	20	52
D1107017	1.7	10	34	D1107038	3.8	22	55
D1107917	1.75	11	36	D1107039	3.9	22	55
D1107018	1.8	11	36	D1107040	4.0	22	55
D1107019	1.9	11	36	D1107041	4.1	22	55
D1107020	2.0	12	38	D1107042	4.2	22	55
D1107021	2.1	12	38	D1107942	4.25	22	55
D1107022	2.2	13	40	D1107043	4.3	24	58
D1107922	2.25	13	40	D1107044	4.4	24	58
D1107023	2.3	13	40	D1107045	4.5	24	58
D1107024	2.4	14	43	D1107046	4.6	24	58
D1107025	2.5	14	43	D1107047	4.7	24	58
D1107026	2.6	14	43	D1107947	4.75	24	58
D1107027	2.7	16	46	D1107048	4.8	26	62
D1107927	2.75	16	46	D1107049	4.9	26	62
D1107028	2.8	16	46	D1107050	5.0	26	62
D1107029	2.9	16	46	D1107051	5.1	26	62
D1107030	3.0	16	46	D1107052	5.2	26	62
D1107031	3.1	18	49	D1107952	5.25	26	62

► 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	13	25	28	32	38	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							
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											15	30	25	38	34	40	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○



D1107 SERIES

**HSS, STRAIGHT SHANK TWIST DRILLS**

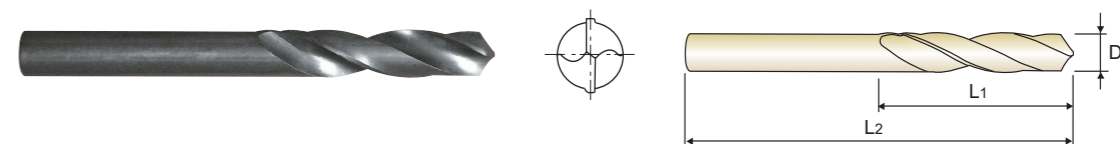
STUB

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série extra-courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

►Surface treatment : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm  
►Application : Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes.

►Oberflächenbehandlung : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm  
►Verwendung : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.  
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1107054	5.4	28	66	D1107076	7.6	37	79
D1107055	5.5	28	66	D1107077	7.7	37	79
D1107056	5.6	28	66	D1107977	7.75	37	79
D1107057	5.7	28	66	D1107078	7.8	37	79
D1107957	5.75	28	66	D1107079	7.9	37	79
D1107058	5.8	28	66	D1107080	8.0	37	79
D1107059	5.9	28	66	D1107081	8.1	37	79
D1107060	6.0	28	66	D1107082	8.2	37	79
D1107061	6.1	31	70	D1107982	8.25	37	79
D1107062	6.2	31	70	D1107083	8.3	37	79
D1107962	6.25	31	70	D1107084	8.4	37	79
D1107063	6.3	31	70	D1107085	8.5	37	79
D1107064	6.4	31	70	D1107086	8.6	40	84
D1107065	6.5	31	70	D1107087	8.7	40	84
D1107066	6.6	31	70	D1107987	8.75	40	84
D1107067	6.7	31	70	D1107088	8.8	40	84
D1107967	6.75	34	74	D1107089	8.9	40	84
D1107068	6.8	34	74	D1107090	9.0	40	84
D1107069	6.9	34	74	D1107091	9.1	40	84
D1107070	7.0	34	74	D1107092	9.2	40	84
D1107071	7.1	34	74	D1107992	9.25	40	84
D1107072	7.2	34	74	D1107093	9.3	40	84
D1107972	7.25	34	74	D1107094	9.4	40	84
D1107073	7.3	34	74	D1107095	9.5	40	84
D1107074	7.4	34	74	D1107096	9.6	43	89

► 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	13	25	28	32	38	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							
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											15	30	25	38	34	40	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

# YMG STRAIGHT SHANK DRILLS

## D1107 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS

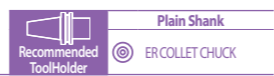
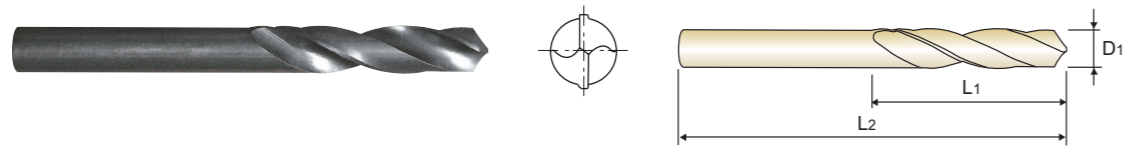
STUB

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série extra-courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
 ► **Application** : Suitable for drilling thin materials with portable electric drills. Special twist drills for automatic and turret lathes.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
 ► **Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken. Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



EDP No.	Drill Diameter		Flute Length		Overall Length
	D1	L1	L2	L1	L2
D1107097	9.7	43	89		
D1107997	9.75	43	89		
D1107098	9.8	43	89		
D1107099	9.9	43	89		
D1107100	10.0	43	89		
D1107802	10.25	43	89		
D1107105	10.5	43	89		
D1107807	10.75	47	95		
D1107110	11.0	47	95		
D1107812	11.25	47	95		
D1107115	11.5	47	95		
D1107817	11.75	47	95		

EDP No.	Drill Diameter		Flute Length		Overall Length
	D1	L1	L2	L1	L2
D1107120	12.0	51	102		
D1107822	12.25	51	102		
D1107125	12.5	51	102		
D1107827	12.75	51	102		
D1107130	13.0	51	102		

Unit : mm

# YMG STRAIGHT SHANK DRILLS

## D2105 SERIES

### HSS Co8, STRAIGHT SHANK TWIST DRILLS

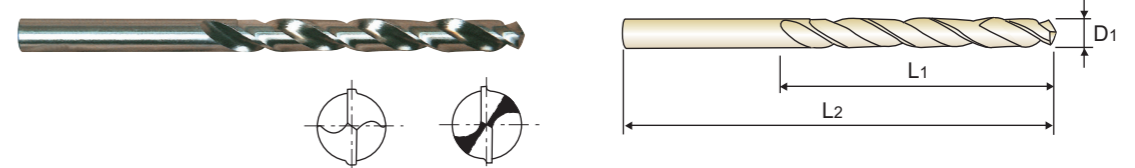
JOBBER

- HSS CO8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

KURZ  
COURTE  
CORTA

► **Surface treatment** : Coloring(Gold color)  
 ► **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
 ► **Verwendung** : Zum Bohren von rostfreien und austenitischen Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.



EDP No.	Drill Diameter		Flute Length		Overall Length
	D1	L1	L2	L1	L2
D2105010	1.0	12	34		
D2105011	1.1	14	36		
D2105012	1.2	16	38		
D2105912	1.25	16	38		
D2105013	1.3	16	38		
D2105014	1.4	18	40		
D2105015	1.5	18	40		
D2105016	1.6	20	43		
D2105017	1.7	20	43		
D2105917	1.75	22	46		
D2105018	1.8	22	46		
D2105019	1.9	22	46		
D2105020	2.0	24	49		
D2105021	2.1	24	49		
D2105022	2.2	27	53		
D2105922	2.25	27	53		
D2105023	2.3	27	53		
D2105024	2.4	30	57		
D2105025	2.5	30	57		
D2105026	2.6	30	57		
D2105027	2.7	33	61		
D2105927	2.75	33	61		
D2105028	2.8	33	61		
D2105029	2.9	33	61		
D2105030	3.0	33	61		
D2105031	3.1	36	65		

EDP No.	Drill Diameter		Flute Length		Overall Length
	D1	L1	L2	L1	L2
D2105032	3.2	36	65		
D2105932	3.25	36	65		
D2105033	3.3	36	65		
D2105034	3.4	39	70		
D2105035	3.5	39	70		
D2105036	3.6	39	70		
D2105037	3.7	39	70		
D2105937	3.75	39	70		
D2105038	3.8	43	75		
D2105039	3.9	43	75		
D2105040	4.0	43	75		
D2105041	4.1	43	75		
D2105042	4.2	43	75		
D2105942	4.25	43	75		
D2105043	4.3	47	80		
D2105044	4.4	47	80		
D2105045	4.5	47	80		
D2105046	4.6	47	80		
D2105047	4.7	47	80		
D2105947	4.75	47	80		
D2105048	4.8	52	86		
D2105049	4.9	52	86		
D2105050	5.0	52	86		
D2105051	5.1	52	86		
D2105052	5.2	52	86		
D2105952	5.25	52	86		

Unit : mm

► TiN(D4105), TiCN(D7105) and TiAlN(DQ105) are available on your request.

► 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	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	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	○	○	○								○	○	○	○	○	○	○	○	○	○	○

◎ : 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	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	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	○	○	○								○	○	○	○	○	○	○	○	○	○	○

# YGG STRAIGHT SHANK DRILLS

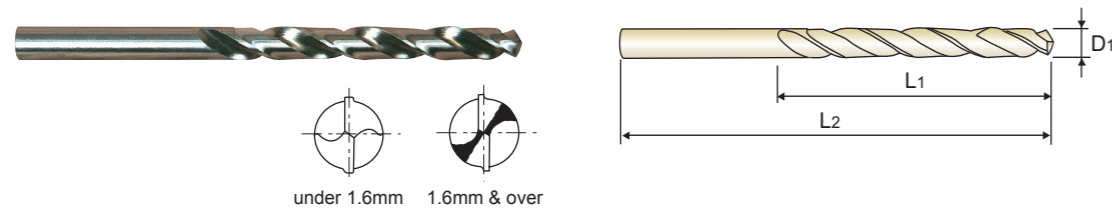
**D2105** SERIES

## HSS Co8, STRAIGHT SHANK TWIST DRILLS

**JOBBER**  
KURZ  
COURTE  
CORTA

- HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

► **Surface treatment** : Coloring(Gold color)    ► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
 ► **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.    ► **Verwendung** : Zum Bohren von rostfreien und austenitischen. Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.



DIN 338
HSS Co8
33°
h8
135°
Gold Coloring
p.A262
ER COLLET CHUCK
Plain Shank
Recommended ToolHolder

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2105053	5.3	52	86	D2105075	7.5	69	109
D2105054	5.4	57	93	D2105076	7.6	75	117
D2105055	5.5	57	93	D2105077	7.7	75	117
D2105056	5.6	57	93	D2105977	7.75	75	117
D2105057	5.7	57	93	D2105078	7.8	75	117
D2105957	5.75	57	93	D2105079	7.9	75	117
D2105058	5.8	57	93	D2105080	8.0	75	117
D2105059	5.9	57	93	D2105081	8.1	75	117
D2105060	6.0	57	93	D2105082	8.2	75	117
D2105061	6.1	63	101	D2105982	8.25	75	117
D2105062	6.2	63	101	D2105083	8.3	75	117
D2105962	6.25	63	101	D2105084	8.4	75	117
D2105063	6.3	63	101	D2105085	8.5	75	117
D2105064	6.4	63	101	D2105086	8.6	81	125
D2105065	6.5	63	101	D2105087	8.7	81	125
D2105066	6.6	63	101	D2105987	8.75	81	125
D2105067	6.7	63	101	D2105088	8.8	81	125
D2105967	6.75	69	109	D2105089	8.9	81	125
D2105068	6.8	69	109	D2105090	9.0	81	125
D2105069	6.9	69	109	D2105091	9.1	81	125
D2105070	7.0	69	109	D2105092	9.2	81	125
D2105071	7.1	69	109	D2105992	9.25	81	125
D2105072	7.2	69	109	D2105093	9.3	81	125
D2105972	7.25	69	109	D2105094	9.4	81	125
D2105073	7.3	69	109	D2105095	9.5	81	125
D2105074	7.4	69	109	D2105096	9.6	87	133

► TiN(D4105), TiCN(D7105) and TiAlN(DQ105) are available on your request.    ► 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 HRc	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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 HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HB	60	100	75	90	130	110	90	100				15	30	25	38	34	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○						○													

# YGG STRAIGHT SHANK DRILLS

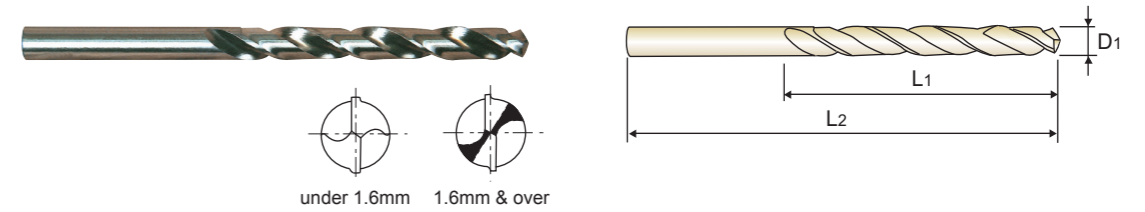
**D2105** SERIES

## HSS Co8, STRAIGHT SHANK TWIST DRILLS

**JOBBER**  
KURZ  
COURTE  
CORTA

- HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

► **Surface treatment** : Coloring(Gold color)    ► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
 ► **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.    ► **Verwendung** : Zum Bohren von rostfreien und austenitischen. Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.



DIN 338
HSS Co8
33°
h8
135°
Gold Coloring
p.A262
ER COLLET CHUCK
Plain Shank
Recommended ToolHolder

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2105097	9.7	87	133	D2105145	14.5	114	169
D2105997	9.75	87	133	D2105150	15.0	114	169
D2105098	9.8	87	133	D2105155	15.5	120	178
D2105099	9.9	87	133	D2105160	16.0	120	178
D2105100	10.0	87	133	D2105165	16.5	125	184
D2105102	10.2	87	133	D2105170	17.0	125	184
D2105105	10.5	87	133	D2105175	17.5	130	191
D2105110	11.0	94	142	D2105180	18.0	130	191
D2105115	11.5	94	142	D2105185	18.5	135	198
D2105120	12.0	101	151	D2105190	19.0	135	198
D2105125	12.5	101	151	D2105195	19.5	140	205
D2105130	13.0	101	151	D2105200	20.0	140	205
D2105135	13.5	108	160				
D2105140	14.0	108	160				

► TiN(D4105), TiCN(D7105) and TiAlN(DQ105) are available on your request.

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





# STRAIGHT SHANK DRILLS

## DL105 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS

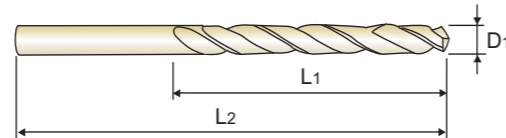
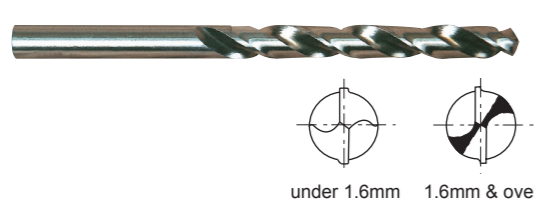
**JOBBER**

- **HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT**
- **Forets HSS-E, queue cylindrique, Forme C, série courte**
- **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS - E**

**KURZ**  
**COURTE**  
**CORTA**

► **Surface treatment** : Coloring(Gold color)  
► **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
► **Verwendung** : Zum Bohren von rostfreien und austenitischen. Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.



**DIN 338** **HSS-E** **33°** **h8** **135°** **Gold Coloring** **p.A262**

**Plain Shank**  
**Recommended Toolholder** **ER COLLET CHUCK**

Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DL105010	1.0	12	34	DL105032	3.2	36	65
DL105011	1.1	14	36	DL105932	3.25	36	65
DL105012	1.2	16	38	DL105033	3.3	36	65
DL105912	1.25	16	38	DL105034	3.4	39	70
DL105013	1.3	16	38	DL105035	3.5	39	70
DL105014	1.4	18	40	DL105036	3.6	39	70
DL105015	1.5	18	40	DL105037	3.7	39	70
DL105016	1.6	20	43	DL105937	3.75	39	70
DL105017	1.7	20	43	DL105038	3.8	43	75
DL105917	1.75	22	46	DL105039	3.9	43	75
DL105018	1.8	22	46	DL105040	4.0	43	75
DL105019	1.9	22	46	DL105041	4.1	43	75
DL105020	2.0	24	49	DL105042	4.2	43	75
DL105021	2.1	24	49	DL105942	4.25	43	75
DL105022	2.2	27	53	DL105043	4.3	47	80
DL105922	2.25	27	53	DL105044	4.4	47	80
DL105023	2.3	27	53	DL105045	4.5	47	80
DL105024	2.4	30	57	DL105046	4.6	47	80
DL105025	2.5	30	57	DL105047	4.7	47	80
DL105026	2.6	30	57	DL105947	4.75	47	80
DL105027	2.7	33	61	DL105048	4.8	52	86
DL105927	2.75	33	61	DL105049	4.9	52	86
DL105028	2.8	33	61	DL105050	5.0	52	86
DL105029	2.9	33	61	DL105051	5.1	52	86
DL105030	3.0	33	61	DL105052	5.2	52	86
DL105031	3.1	36	65	DL105952	5.25	52	86

► TiN(DN105), TiCN(DX105) and TiAlN(DT105) 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	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	○	○	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	
ISO	N				S					H											
	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	60	100	75	90	130	110	90	100			15	30	25	38	34	40	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	○	○	○						○							○					



# STRAIGHT SHANK DRILLS

## DL105 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS

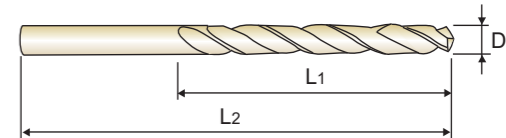
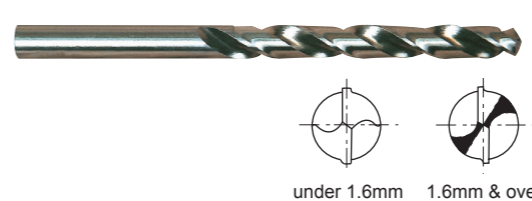
**JOBBER**

- **HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT**
- **Forets HSS-E, queue cylindrique, Forme C, série courte**
- **PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS - E**

**KURZ**  
**COURTE**  
**CORTA**

► **Surface treatment** : Coloring(Gold color)  
► **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
► **Verwendung** : Zum Bohren von rostfreien und austenitischen. Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.



**DIN 338** **HSS-E** **33°** **h8** **135°** **Gold Coloring** **p.A262**

**Plain Shank**  
**Recommended Toolholder** **ER COLLET CHUCK**

Unit : mm				Unit : mm			
EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DL105053	5.3	52	86	DL105075	7.5	69	109
DL105054	5.4	57	93	DL105076	7.6	75	117
DL105055	5.5	57	93	DL105077	7.7	75	117
DL105056	5.6	57	93	DL105977	7.75	75	117
DL105057	5.7	57	93	DL105078	7.8	75	117
DL105957	5.75	57	93	DL105079	7.9	75	117
DL105058	5.8	57	93	DL105080	8.0	75	117
DL105059	5.9	57	93	DL105081	8.1	75	117
DL105060	6.0	57	93	DL105082	8.2	75	117
DL105061	6.1	63	101	DL105982	8.25	75	117
DL105062	6.2	63	101	DL105083	8.3	75	117
DL105962	6.25	63	101	DL105084	8.4	75	117
DL105063	6.3	63	101	DL105085	8.5	75	117
DL105064	6.4	63	101	DL105086	8.6	81	125
DL105065	6.5	63	101	DL105087	8.7	81	125
DL105066	6.6	63	101	DL105987	8.75	81	125
DL105067	6.7	63	101	DL105088	8.8	81	125
DL105967	6.75	69	109	DL105089	8.9	81	125
DL105068	6.8	69	109	DL105090	9.0	81	125
DL105069	6.9	69	109	DL105091	9.1	81	125
DL105070	7.0	69	109	DL105092	9.2	81	125
DL105071	7.1	69	109	DL105992	9.25	81	125
DL105072	7.2	69	109	DL105093	9.3	81	125
DL105972	7.25	69	109	DL105094	9.4	81	125
DL105073	7.3	69	109	DL105095	9.5	81	125
DL105074	7.4	69	109	DL105096	9.6	87	133

► TiN(DN105), TiCN(DX105) and TiAlN(DT105) 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	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	○	○	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	
ISO	N				S					H											
	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	60	100	75	90	130	110	90	100			15	30	25	38	34	40	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	○	○	○						○							○					

# YG STRAIGHT SHANK DRILLS

## DL105 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS

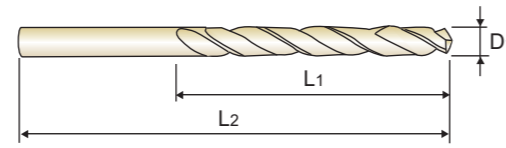
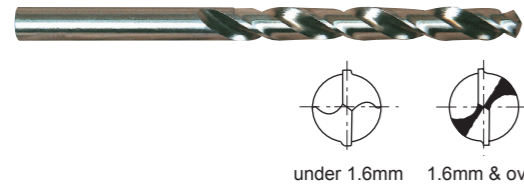
JOBBER

- HSS-E, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS-E, queue cylindrique, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS - E

KURZ  
COURTE  
CORTA

▶ **Surface treatment** : Coloring(Gold color)  
▶ **Application** : Drilling stainless steels and difficult - to - cut materials such as titanium and inconel.

▶ **Oberflächenbehandlung** : Coloring(Goldfarbe)  
▶ **Verwendung** : Zum Bohren von rostfreien und austenitischen. Stählen, schwererspanbaren Werkstoffen wie Titan und Inconel.



DIN 338 HSS-E 33° h8 135° Gold Coloring p.A262

Plain Shank  
Recommended ToolHolder ER COLLET CHUCK

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
DL105097	9.7	87	133	DL105145	14.5	114	169
DL105098	9.75	87	133	DL105150	15.0	114	169
DL105099	9.8	87	133	DL105155	15.5	120	178
DL105100	9.9	87	133	DL105160	16.0	120	178
DL105102	10.0	87	133	DL105165	16.5	125	184
DL105105	10.2	87	133	DL105170	17.0	125	184
DL105110	10.5	87	133	DL105175	17.5	130	191
DL105115	11.0	94	142	DL105180	18.0	130	191
DL105120	11.5	94	142	DL105185	18.5	135	198
DL105125	12.0	101	151	DL105190	19.0	135	198
DL105130	12.5	101	151	DL105195	19.5	140	205
DL105135	13.0	101	151	DL105200	20.0	140	205
DL105140	13.5	108	160				
DL105140	14.0	108	160				

▶ TiN(DN105), TiCN(DX105) and TiAlN(DT105) are available on your request.

◎ : 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	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								
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	400 Rm	1050 Rm	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	○	○	○						○							○					

# YG STRAIGHT SHANK DRILLS

## D1105 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS

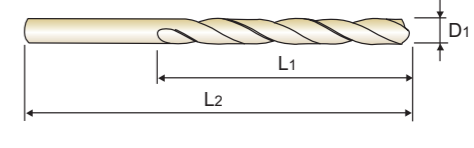
JOBBER

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

KURZ  
COURTE  
CORTA

▶ **Surface treatment** : Steam Tempered(Black Oxide Finish)  
▶ **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

▶ **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
▶ **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphärguß, Sintereisen, Graphite.



DIN 338 HSS 20~30° h8 118° Vap p.A262

Plain Shank  
Recommended ToolHolder ER COLLET CHUCK

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
D1105003	0.3	3	19	D1105919	1.95	24	49
D1105004	0.4	5	20	D1105020	2.0	24	49
D1105005	0.5	6	22	D1105920	2.05	24	49
D1105006	0.6	7	24	D1105021	2.1	24	49
D1105007	0.7	9	28	D1105921	2.15	27	53
D1105008	0.8	10	30	D1105022	2.2	27	53
D1105009	0.9	11	32	D1105922	2.25	27	53
D1105010	1.0	12	34	D1105023	2.3	27	53
D1105011	1.1	14	36	D1105923	2.35	27	53
D1105012	1.15	14	36	D1105024	2.4	30	57
D1105013	1.2	16	38	D1105924	2.45	30	57
D1105014	1.25	16	38	D1105025	2.5	30	57
D1105015	1.3	16	38	D1105925	2.55	30	57
D1105016	1.35	18	40	D1105026	2.6	30	57
D1105017	1.4	18	40	D1105926	2.65	30	57
D1105018	1.45	18	40	D1105027	2.7	33	61
D1105019	1.5	18	40	D1105927	2.75	33	61
D1105020	1.55	20	43	D1105028	2.8	33	61
D1105021	1.6	20	43	D1105928	2.85	33	61
D1105022	1.65	20	43	D1105029	2.9	33	61
D1105023	1.7	20	43	D1105929	2.95	33	61
D1105024	1.75	22	46	D1105030	3.0	33	61
D1105025	1.8	22	46	D1105930	3.05	36	65
D1105026	1.85	22	46	D1105031	3.1	36	65
D1105027	1.9	22	46	D1105931	3.15	36	65
D1105028				D1105032	3.2	36	65
D1105029							
D1105030							
D1105031							
D1105032							

▶ 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	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								
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	400 Rm	1050 Rm	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	○	○	○						○							○					

**YG STRAIGHT SHANK DRILLS**

**D1105 SERIES**

**HSS, STRAIGHT SHANK TWIST DRILLS**

**JOBBER**

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

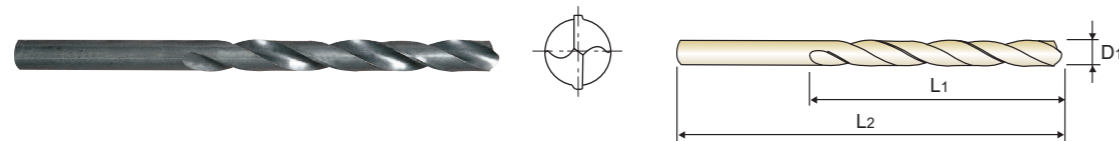
- KURZ
- COURTE
- CORTA

**Surface treatment** : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm

**Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

**Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm

**Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphite.



DIN 338 HSS 20~30° h8 118° Vap p.A262

Plain Shank  
Recommended ToolHolder ER COLLET CHUCK

Unit : mm				Unit : mm			
EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1105932	3.25	36	65	D1105945	4.55	47	80
D1105033	3.3	36	65	D1105046	4.6	47	80
D1105933	3.35	36	65	D1105946	4.65	47	80
D1105034	3.4	39	70	D1105047	4.7	47	80
D1105934	3.45	39	70	D1105947	4.75	47	80
D1105035	3.5	39	70	D1105048	4.8	52	86
D1105935	3.55	39	70	D1105948	4.85	52	86
D1105036	3.6	39	70	D1105049	4.9	52	86
D1105936	3.65	39	70	D1105949	4.95	52	86
D1105037	3.7	39	70	D1105050	5.0	52	86
D1105937	3.75	39	70	D1105950	5.05	52	86
D1105038	3.8	43	75	D1105051	5.1	52	86
D1105938	3.85	43	75	D1105951	5.15	52	86
D1105039	3.9	43	75	D1105052	5.2	52	86
D1105939	3.95	43	75	D1105952	5.25	52	86
D1105040	4.0	43	75	D1105053	5.3	52	86
D1105940	4.05	43	75	D1105953	5.35	57	93
D1105041	4.1	43	75	D1105054	5.4	57	93
D1105941	4.15	43	75	D1105954	5.45	57	93
D1105042	4.2	43	75	D1105055	5.5	57	93
D1105942	4.25	43	75	D1105955	5.55	57	93
D1105043	4.3	47	80	D1105056	5.6	57	93
D1105943	4.35	47	80	D1105956	5.65	57	93
D1105044	4.4	47	80	D1105057	5.7	57	93
D1105944	4.45	47	80	D1105957	5.75	57	93
D1105045	4.5	47	80	D1105058	5.8	57	93

▶ 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	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO 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	40	55	60	42	55	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**YG STRAIGHT SHANK DRILLS**

**D1105 SERIES**

**HSS, STRAIGHT SHANK TWIST DRILLS**

**JOBBER**

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

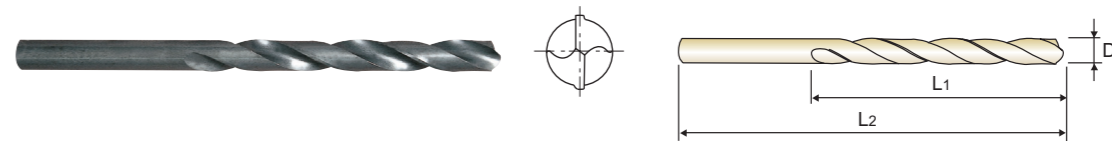
- KURZ
- COURTE
- CORTA

**Surface treatment** : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm

**Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

**Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm

**Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphite.



DIN 338 HSS 20~30° h8 118° Vap p.A262

Plain Shank  
Recommended ToolHolder ER COLLET CHUCK

Unit : mm				Unit : mm			
EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1105958	5.85	57	93	D1105971	7.15	69	109
D1105059	5.9	57	93	D1105072	7.2	69	109
D1105959	5.95	57	93	D1105972	7.25	69	109
D1105060	6.0	57	93	D1105073	7.3	69	109
D1105960	6.05	63	101	D1105973	7.35	69	109
D1105061	6.1	63	101	D1105074	7.4	69	109
D1105961	6.15	63	101	D1105974	7.45	69	109
D1105062	6.2	63	101	D1105075	7.5	69	109
D1105962	6.25	63	101	D1105975	7.55	75	117
D1105063	6.3	63	101	D1105076	7.6	75	117
D1105963	6.35	63	101	D1105976	7.65	75	117
D1105064	6.4	63	101	D1105077	7.7	75	117
D1105964	6.45	63	101	D1105977	7.75	75	117
D1105065	6.5	63	101	D1105078	7.8	75	117
D1105965	6.55	63	101	D1105978	7.85	75	117
D1105066	6.6	63	101	D1105079	7.9	75	117
D1105966	6.65	63	101	D1105979	7.95	75	117
D1105067	6.7	63	101	D1105080	8.0	75	117
D1105967	6.75	69	109	D1105081	8.1	75	117
D1105068	6.8	69	109	D1105082	8.2	75	117
D1105968	6.85	69	109	D1105982	8.25	75	117
D1105069	6.9	69	109	D1105083	8.3	75	117
D1105969	6.95	69	109	D1105084	8.4	75	117
D1105070	7.0	69	109	D1105085	8.5	75	117
D1105970	7.05	69	109	D1105086	8.6	81	125
D1105071	7.1	69	109	D1105087	8.7	81	125

▶ 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	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO 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	40	55	60	42	55	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	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

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

# YG STRAIGHT SHANK DRILLS

## D1105 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

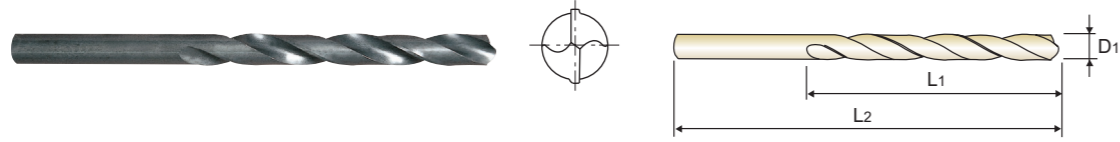
- KURZ
- COURTE
- CORTA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm

► **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinterisen, Graphite.



DIN 338 HSS 20~30° h8 118° Vap p.A262

Plain Shank Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
D1105987	8.75	81	125	D1105109	10.9	94	142
D1105088	8.8	81	125	D1105110	11.0	94	142
D1105089	8.9	81	125	D1105111	11.1	94	142
D1105090	9.0	81	125	D1105112	11.2	94	142
D1105091	9.1	81	125	D1105812	11.25	94	142
D1105092	9.2	81	125	D1105113	11.3	94	142
D1105992	9.25	81	125	D1105114	11.4	94	142
D1105093	9.3	81	125	D1105115	11.5	94	142
D1105094	9.4	81	125	D1105116	11.6	94	142
D1105095	9.5	81	125	D1105117	11.7	94	142
D1105096	9.6	87	133	D1105817	11.75	94	142
D1105097	9.7	87	133	D1105118	11.8	94	142
D1105997	9.75	87	133	D1105119	11.9	101	151
D1105098	9.8	87	133	D1105120	12.0	101	151
D1105099	9.9	87	133	D1105121	12.1	101	151
D1105100	10.0	87	133	D1105122	12.2	101	151
D1105101	10.1	87	133	D1105822	12.25	101	151
D1105102	10.2	87	133	D1105123	12.3	101	151
D1105802	10.25	87	133	D1105124	12.4	101	151
D1105103	10.3	87	133	D1105125	12.5	101	151
D1105104	10.4	87	133	D1105126	12.6	101	151
D1105105	10.5	87	133	D1105127	12.7	101	151
D1105106	10.6	87	133	D1105827	12.75	101	151
D1105107	10.7	94	142	D1105128	12.8	101	151
D1105807	10.75	94	142	D1105129	12.9	101	151
D1105108	10.8	94	142	D1105130	13.0	101	151

► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N							S						H							
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials	Heat Resistant Super Alloys			Titanium Alloys			Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	40	41	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

# YG STRAIGHT SHANK DRILLS

## D1105 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS

JOBBER

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

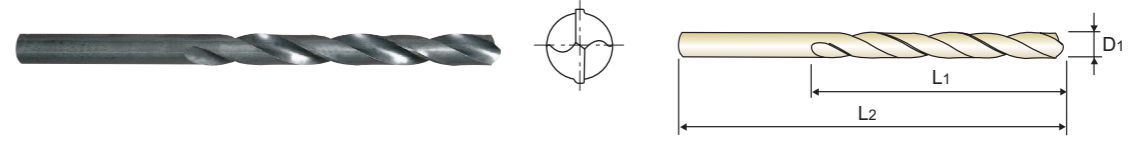
- KURZ
- COURTE
- CORTA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
Bright Finish under 2mm

► **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
Helle Beschaffenheit unter 2mm

► **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinterisen, Graphite.



DIN 338 HSS 20~30° h8 118° Vap p.A262

Plain Shank Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
D1105832	13.25	108	160	D1105867	16.75	125	184
D1105135	13.5	108	160	D1105170	17.0	125	184
D1105837	13.75	108	160	D1105872	17.25	130	191
D1105140	14.0	108	160	D1105175	17.5	130	191
D1105842	14.25	114	169	D1105877	17.75	130	191
D1105145	14.5	114	169	D1105180	18.0	130	191
D1105847	14.75	114	169	D1105882	18.25	135	198
D1105150	15.0	114	169	D1105185	18.5	135	198
D1105155	15.5	120	178	D1105887	18.75	135	198
D1105157	15.75	120	178	D1105190	19.0	135	198
D1105160	16.0	120	178	D1105892	19.25	140	205
D1105862	16.25	125	184	D1105195	19.5	140	205
D1105165	16.5	125	184	D1105897	19.75	140	205
				D1105200	20.0	140	205

◎ : Excellent ○ : Good

ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N							S						H							
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials	Heat Resistant Super Alloys			Titanium Alloys			Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	40	41	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

**YG** STRAIGHT SHANK DRILLS

D1125 SERIES

**HSS, STRAIGHT SHANK TWIST DRILLS**

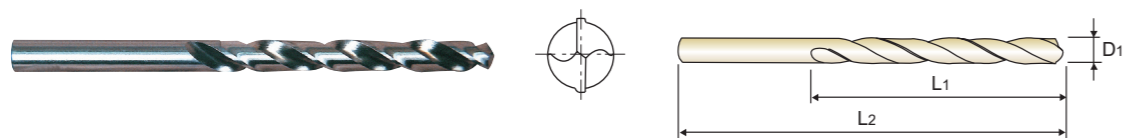
**JOBBER**

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

- KURZ
- COURTE
- CORTA

**Surface treatment** : Bright Finish  
**Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

**Oberflächenbehandlung** : Helle Beschaffenheit  
**Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphärguß, Sintereisen, Graphite.



DIN 338 HSS 20~30° h8 118° Bright p.A262

Plain Shank Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
D1125020	2.0	24	49	D1125046	4.6	47	80
D1125021	2.1	24	49	D1125047	4.7	47	80
D1125022	2.2	27	53	D1125048	4.8	52	86
D1125023	2.3	27	53	D1125049	4.9	52	86
D1125024	2.4	30	57	D1125050	5.0	52	86
D1125025	2.5	30	57	D1125051	5.1	52	86
D1125026	2.6	30	57	D1125052	5.3	52	86
D1125027	2.7	33	61	D1125053	5.3	52	86
D1125028	2.8	33	61	D1125054	5.4	57	93
D1125029	2.9	33	61	D1125055	5.5	57	93
D1125030	3.0	33	61	D1125056	5.6	57	93
D1125031	3.1	36	65	D1125057	5.7	57	93
D1125032	3.2	36	65	D1125058	5.8	57	93
D1125033	3.3	36	65	D1125059	5.9	57	93
D1125034	3.4	39	70	D1125060	6.0	57	93
D1125035	3.5	39	70	D1125061	6.1	63	101
D1125036	3.6	39	70	D1125062	6.2	63	101
D1125037	3.7	39	70	D1125063	6.3	63	101
D1125038	3.8	43	75	D1125064	6.4	63	101
D1125039	3.9	43	75	D1125065	6.5	63	101
D1125040	4.0	43	75	D1125066	6.6	63	101
D1125041	4.1	43	75	D1125067	6.7	63	101
D1125042	4.2	43	75	D1125068	6.8	69	109
D1125043	4.3	47	80	D1125069	6.9	69	109
D1125044	4.4	47	80	D1125070	7.0	69	109
D1125045	4.5	47	80	D1125071	7.1	69	109

▶ NEXT PAGE

**YG** STRAIGHT SHANK DRILLS

D1125 SERIES

**HSS, STRAIGHT SHANK TWIST DRILLS**

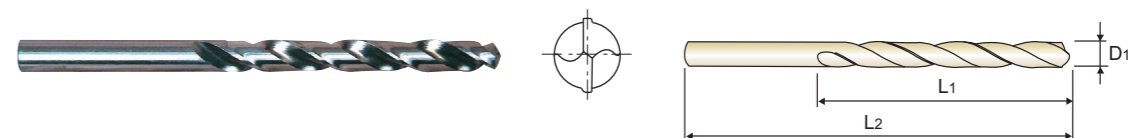
**JOBBER**

- HSS, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

- KURZ
- COURTE
- CORTA

**Surface treatment** : Bright Finish  
**Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

**Oberflächenbehandlung** : Helle Beschaffenheit  
**Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphärguß, Sintereisen, Graphite.



DIN 338 HSS 20~30° h8 118° Bright p.A262

Plain Shank Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
D1125072	7.2	69	109	D1125098	9.8	87	133
D1125073	7.3	69	109	D1125099	9.9	87	133
D1125074	7.4	69	109	D1125100	10.0	87	133
D1125075	7.5	69	109	D1125101	10.1	87	133
D1125076	7.6	75	117	D1125102	10.2	87	133
D1125077	7.7	75	117	D1125103	10.3	87	133
D1125078	7.8	75	117	D1125104	10.4	87	133
D1125079	7.9	75	117	D1125105	10.5	87	133
D1125080	8.0	75	117	D1125106	10.6	87	133
D1125081	8.1	75	117	D1125107	10.7	94	142
D1125082	8.2	75	117	D1125108	10.8	94	142
D1125083	8.3	75	117	D1125109	10.9	94	142
D1125084	8.4	75	117	D1125110	11.0	94	142
D1125085	8.5	75	117	D1125111	11.1	94	142
D1125086	8.6	81	125	D1125112	11.2	94	142
D1125087	8.7	81	125	D1125113	11.3	94	142
D1125088	8.8	81	125	D1125114	11.4	94	142
D1125089	8.9	81	125	D1125115	11.5	94	142
D1125090	9.0	81	125	D1125116	11.6	94	142
D1125091	9.1	81	125	D1125117	11.7	94	142
D1125092	9.2	81	125	D1125118	11.8	94	142
D1125093	9.3	81	125	D1125119	11.9	101	151
D1125094	9.4	81	125	D1125120	12.0	101	151
D1125095	9.5	81	125	D1125121	12.1	101	151
D1125096	9.6	87	133	D1125122	12.2	101	151
D1125097	9.7	87	133	D1125123	12.3	101	151

▶ 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	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		
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	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	400 Rm	1050 Rm	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



# YMG STRAIGHT SHANK DRILLS

## D2104 SERIES

### HSS Co8, STRAIGHT SHANK TWIST DRILLS

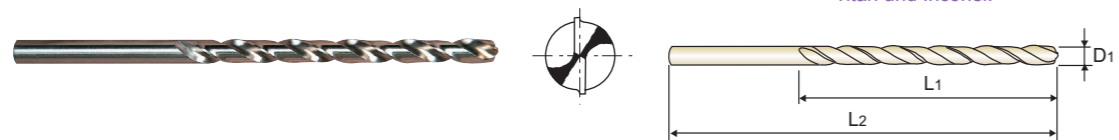
LONG

- HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
- Forets HSS Co8, queue cylindrique, série longue
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

LANG  
LONGUE  
LUNGA

► **Surface treatment** : Coloring(Gold color)  
► **Application** : Drilling deep holes in stainless steels and difficult - to - cut materials such as titanium and inconel.

► **Oberflächenbehandlung** : Coloring(Goldfarbe)  
► **Verwendung** : Für Bohrarbeiten mit Bohrbuchsen oder an tief liegenden Stellen. Zum Bohren von rostfreien und austenitischen. Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.



Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104073	7.3	102	156
D2104074	7.4	102	156
D2104075	7.5	102	156
D2104076	7.6	109	165
D2104077	7.7	109	165
D2104078	7.8	109	165
D2104079	7.9	109	165
D2104080	8.0	109	165
D2104081	8.1	109	165
D2104082	8.2	109	165
D2104083	8.3	109	165
D2104084	8.4	109	165
D2104085	8.5	109	165
D2104086	8.6	115	175
D2104087	8.7	115	175
D2104088	8.8	115	175
D2104089	8.9	115	175
D2104090	9.0	115	175
D2104091	9.1	115	175

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104093	9.3	115	175
D2104094	9.4	115	175
D2104095	9.5	115	175
D2104096	9.6	121	184
D2104097	9.7	121	184
D2104098	9.8	121	184
D2104099	9.9	121	184
D2104100	10.0	121	184
D2104102	10.2	121	184
D2104105	10.5	121	184
D2104108	10.8	128	195
D2104110	11.0	128	195
D2104112	11.2	128	195
D2104115	11.5	128	195
D2104118	11.8	128	195
D2104120	12.0	134	205

► HSS-E(DL104) is available on your request.  
► TiN(D4104), TiCN(D7104) and TiAlN(DQ104) are available on your request.

◎ : 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	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	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	○	○	○								○					○					

# YMG STRAIGHT SHANK DRILLS

## D1121 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS

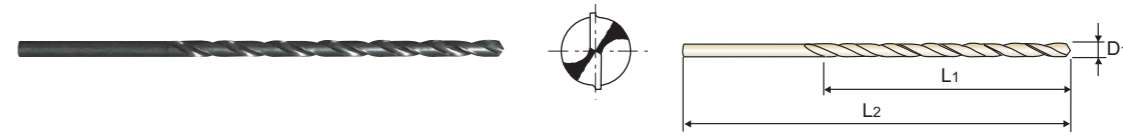
EXTRA LONG

- HSS, SPIRALBOHRER MIT ZYLINDERSCHAFT
- Forets HSS, queue cylindrique, série extra-longue
- PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS

ÜBERLANG  
EXTRA-LONGUE  
EXTRA LUNGA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
► **Application** : Designed for drilling deep holes or deeply located holes. Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
► **Verwendung** : Standardbohrer zum Bohren extrem tiefer Löcher, zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinterisen, Graphit.



Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1121025	2.5	95	140
D1121030	3.0	100	150
D1121035	3.5	115	165
D1121040	4.0	120	175
D1121045	4.5	125	185
D1121050	5.0	135	195
D1121055	5.5	140	205
D1121060	6.0	140	205
D1121065	6.5	150	215
D1121070	7.0	155	225
D1121075	7.5	155	225

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1121085	8.5	165	240
D1121090	9.0	175	250
D1121095	9.5	175	250
D1121100	10.0	185	265
D1121105	10.5	185	265
D1121110	11.0	195	280
D1121115	11.5	195	280
D1121120	12.0	205	295
D1121125	12.5	205	295
D1121130	13.0	205	295

◎ : 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	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	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	○	○	○								○					○					

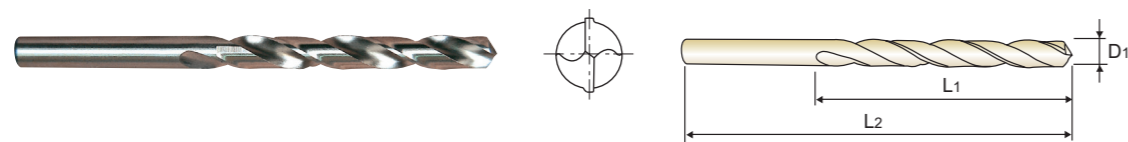
YG STRAIGHT SHANK DRILLS

DL109 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for HEAVY DUTY JOBBER

HSS-E, SPIRALBOHRER für HOHE LEISTUNGEN mit ZYLINDERSCHAFT
Forets HSS-E, queue cylindrique pour matériaux durs, série courte
PUNTE ELICOIDALI PER IMPIEGHI GRAVOSI, GAMBO CILINDRICO, HSS - E

Application: Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.
Verwendung: Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinterisen, Graphit.



Product icons including DIN 338, HSS-E, 20~30°, h8, 118°, Bright, and ER COLLET CHUCK.

Table of drill specifications for DL109 series, listing EDP No., Drill Diameter, Flute Length, and Overall Length.

TiN(DN109), TiCN(DX109) and TiAlN(DT109) are available on your request.

© : Excellent ○ : Good

Material compatibility chart showing ISO standards for various materials like Non-alloy steel, Low alloy steel, Stainless steel, Titanium Alloys, etc.

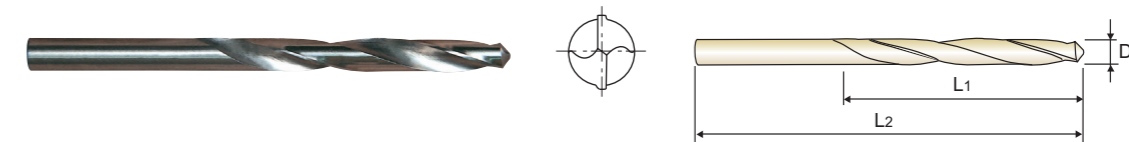
YG STRAIGHT SHANK DRILLS

D1100 SERIES

HSS, STRAIGHT SHANK TWIST DRILLS for BRASS/BRONZE JOBBER

HSS, SPIRALBOHRER für MESSING/BRONZE mit ZYLINDERSCHAFT
Forets HSS, queue cylindrique pour Laiton/Bronze, série courte
PUNTE ELICOIDALI, GAMBO CILINDRICO PER OTTONE (HSS)

Application: Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze and magnesium alloys.
Verwendung: Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



Product icons including DIN 338, HSS, 15~20°, h8, 118°, Bright, and ER COLLET CHUCK.

Table of drill specifications for D1100 series, listing EDP No., Drill Diameter, Flute Length, and Overall Length.

NEXT PAGE

© : Excellent ○ : Good

Material compatibility chart showing ISO standards for various materials like Non-alloy steel, Low alloy steel, Stainless steel, Titanium Alloys, etc.



# YG STRAIGHT SHANK DRILLS

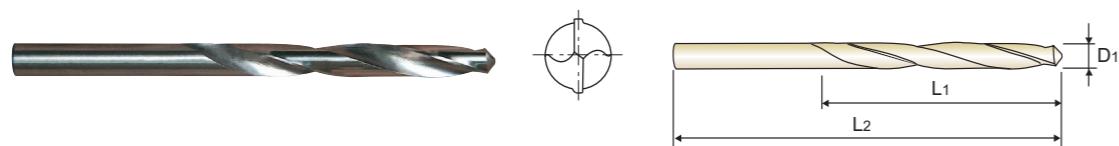
## D1100 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS for BRASS/BRONZE JOBBER

- HSS, SPIRALBOHRER für MESSING/BRONZE mit ZYLINDERSCHAFT KURZ
- Forets HSS, queue cylindrique pour Laiton/Bronze, série courte COURTE
- PUNTE ELICOIDALI, GAMBO CILINDRICO PER OTTONE (HSS) CORTA

► **Application :** Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze and magnesium alloys.

► **Verwendung :** Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



**DIN 338** **HSS**  $15 \sim 20^\circ$  **h8** **118°** **Bright** p.A263

**Plain Shank**  
Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1100067	6.7	63	101	D1100087	8.7	81	125
D1100068	6.8	69	109	D1100088	8.8	81	125
D1100069	6.9	69	109	D1100089	8.9	81	125
D1100070	7.0	69	109	D1100090	9.0	81	125
D1100071	7.1	69	109	D1100091	9.1	81	125
D1100072	7.2	69	109	D1100092	9.2	81	125
D1100073	7.3	69	109	D1100093	9.3	81	125
D1100074	7.4	69	109	D1100094	9.4	81	125
D1100075	7.5	69	109	D1100095	9.5	81	125
D1100076	7.6	75	117	D1100096	9.6	87	133
D1100077	7.7	75	117	D1100097	9.7	87	133
D1100078	7.8	75	117	D1100098	9.8	87	133
D1100079	7.9	75	117	D1100099	9.9	87	133
D1100080	8.0	75	117	D1100100	10.0	87	133
D1100081	8.1	75	117	D1100105	10.5	87	133
D1100082	8.2	75	117	D1100110	11.0	94	142
D1100083	8.3	75	117	D1100115	11.5	94	142
D1100084	8.4	75	117	D1100120	12.0	101	151
D1100085	8.5	75	117	D1100125	12.5	101	151
D1100086	8.6	81	125	D1100130	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	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	40	55	60	42	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																					

# YG STRAIGHT SHANK DRILLS

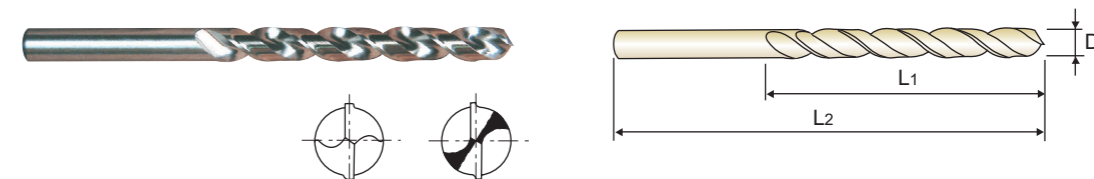
## D1106 SERIES

### HSS, STRAIGHT SHANK TWIST DRILLS for ALUMINUM JOBBER

- HSS, SPIRALBOHRER für ALUMINIUM mit ZYLINDERSCHAFT KURZ
- Forets HSS, queue cylindrique pour ALU, Forme C, série courte COURTE
- PUNTE ELICOIDALI, GAMBO CILINDRICO, PER ALLUMINIO (HSS) CORTA

► **Application :** Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze aluminum and magnesium alloys.

► **Verwendung :** Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



**DIN 338** **HSS**  $38^\circ$  **h8** **135°** **Bright** p.A263

**Plain Shank**  
Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1106015	1.5	18	40	D1106041	4.1	43	75
D1106016	1.6	20	43	D1106042	4.2	43	75
D1106017	1.7	20	43	D1106043	4.3	47	80
D1106018	1.8	22	46	D1106044	4.4	47	80
D1106019	1.9	22	46	D1106045	4.5	47	80
D1106020	2.0	24	49	D1106046	4.6	47	80
D1106021	2.1	24	49	D1106047	4.7	47	80
D1106022	2.2	27	53	D1106048	4.8	52	86
D1106023	2.3	27	53	D1106049	4.9	52	86
D1106024	2.4	30	57	D1106050	5.0	52	86
D1106025	2.5	30	57	D1106051	5.1	52	86
D1106026	2.6	30	57	D1106052	5.2	52	86
D1106027	2.7	33	61	D1106053	5.3	52	86
D1106028	2.8	33	61	D1106054	5.4	57	93
D1106029	2.9	33	61	D1106055	5.5	57	93
D1106030	3.0	33	61	D1106056	5.6	57	93
D1106031	3.1	36	65	D1106057	5.7	57	93
D1106032	3.2	36	65	D1106058	5.8	57	93
D1106033	3.3	36	65	D1106059	5.9	57	93
D1106034	3.4	39	70	D1106060	6.0	57	93
D1106035	3.5	39	70	D1106061	6.1	63	101
D1106036	3.6	39	70	D1106062	6.2	63	101
D1106037	3.7	39	70	D1106063	6.3	63	101
D1106038	3.8	43	75	D1106064	6.4	63	101
D1106039	3.9	43	75	D1106065	6.5	63	101
D1106040	4.0	43	75	D1106066	6.6	63	101

◎ : 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	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	40	55	60	42	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																					

# YG STRAIGHT SHANK DRILLS

D1106 SERIES

## HSS, STRAIGHT SHANK TWIST DRILLS for ALUMINUM

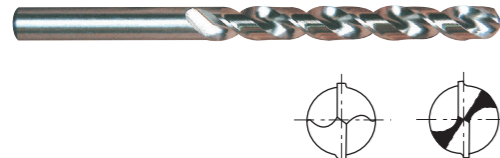
JOBBER

- HSS, SPIRALBOHRER für ALUMINIUM mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique pour ALU, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, PER ALLUMINIO (HSS)

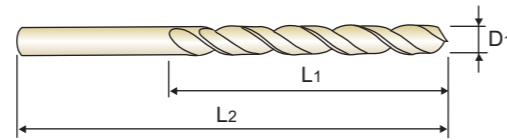
KURZ  
COURTE  
CORTA

►Application : Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze aluminum and magnesium alloys.

►Verwendung : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



under 1.6mm 1.6mm & over



DIN 338 HSS 38° h8 135° Bright p.A263

Plain Shank Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1106067	6.7	63	101	D1106087	8.7	81	125
D1106068	6.8	69	109	D1106088	8.8	81	125
D1106069	6.9	69	109	D1106089	8.9	81	125
D1106070	7.0	69	109	D1106090	9.0	81	125
D1106071	7.1	69	109	D1106091	9.1	81	125
D1106072	7.2	69	109	D1106092	9.2	81	125
D1106073	7.3	69	109	D1106093	9.3	81	125
D1106074	7.4	69	109	D1106094	9.4	81	125
D1106075	7.5	69	109	D1106095	9.5	81	125
D1106076	7.6	75	117	D1106096	9.6	87	133
D1106077	7.7	75	117	D1106097	9.7	87	133
D1106078	7.8	75	117	D1106098	9.8	87	133
D1106079	7.9	75	117	D1106099	9.9	87	133
D1106080	8.0	75	117	D1106100	10.0	87	133
D1106081	8.1	75	117	D1106105	10.5	87	133
D1106082	8.2	75	117	D1106110	11.0	94	142
D1106083	8.3	75	117	D1106115	11.5	94	142
D1106084	8.4	75	117	D1106120	12.0	101	151
D1106085	8.5	75	117	D1106125	12.5	101	151
D1106086	8.6	81	125	D1106130	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																				
HB	125	190	250	270	300	180	290	320	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																						
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42	55	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

# YG STRAIGHT SHANK DRILLS

DL510 SERIES

## HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

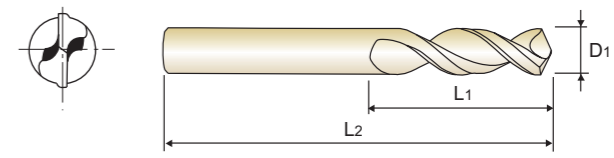
STUB

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
- Forets HSS-E, queue cylindrique pour perçage profond, série extra-courte
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

EXTRA KURZ  
EXTRA-COURTE  
EXTRA CORTA

►Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

►Verwendung : Zum Bohren von legiertem und unlegiertem Stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DIN 1897 HSS-E 42° h8 130° Bright p.A264

Plain Shank Recommended Toolholder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
DL510020	2.0	12	38	DL510046	4.6	24	58
DL510021	2.1	12	38	DL510047	4.7	24	58
DL510022	2.2	13	40	DL510048	4.8	26	62
DL510023	2.3	13	40	DL510049	4.9	26	62
DL510024	2.4	14	43	DL510050	5.0	26	62
DL510025	2.5	14	43	DL510051	5.1	26	62
DL510026	2.6	14	43	DL510052	5.2	26	62
DL510027	2.7	16	46	DL510053	5.3	26	66
DL510028	2.8	16	46	DL510054	5.4	28	66
DL510029	2.9	16	46	DL510055	5.5	28	66
DL510030	3.0	16	46	DL510056	5.6	28	66
DL510031	3.1	18	49	DL510057	5.7	28	66
DL510032	3.2	18	49	DL510058	5.8	28	66
DL510033	3.3	18	49	DL510059	5.9	28	66
DL510034	3.4	20	52	DL510060	6.0	28	66
DL510035	3.5	20	52	DL510061	6.1	31	70
DL510036	3.6	20	52	DL510062	6.2	31	70
DL510037	3.7	20	52	DL510063	6.3	31	70
DL510038	3.8	22	55	DL510064	6.4	31	70
DL510039	3.9	22	55	DL510065	6.5	31	70
DL510040	4.0	22	55	DL510066	6.6	31	70
DL510041	4.1	22	55	DL510067	6.7	31	70
DL510042	4.2	22	55	DL510068	6.8	34	74
DL510043	4.3	24	58	DL510069	6.9	34	74
DL510044	4.4	24	58	DL510070	7.0	34	74
DL510045	4.5	24	58	DL510071	7.1	34	74

► 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																				
HB	125	190	250	270	300	180	290	320	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																						
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42	55	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

# YG STRAIGHT SHANK DRILLS

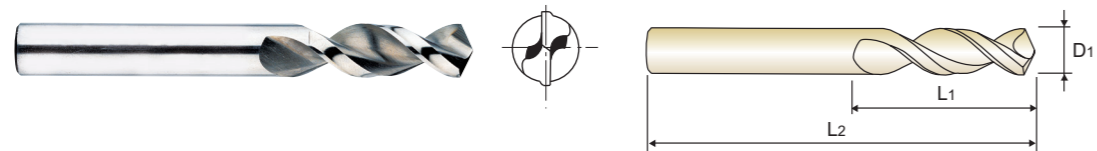
## DL510 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES *STUB*

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT *EXTRA KURZ*
- Forets HSS-E, queue cylindrique pour perçage profond, série extra-courte *EXTRA-COURTE*
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP *EXTRA CORTA*

► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



#### ► DH100 worm pattern drills



EDP No.	Drill Diameter		Overall Length	EDP No.	Drill Diameter		Overall Length
	D <sub>1</sub>	L <sub>1</sub>			D <sub>1</sub>	L <sub>1</sub>	
DL510072	7.2	34	74	DL510100	10.0	43	89
DL510073	7.3	34	74	DL510102	10.2	43	89
DL510074	7.4	34	74	DL510105	10.5	43	89
DL510075	7.5	34	74	DL510108	10.8	47	95
DL510076	7.6	37	79	DL510110	11.0	47	95
DL510077	7.7	37	79	DL510112	11.2	47	95
DL510078	7.8	37	79	DL510115	11.5	47	95
DL510079	7.9	37	79	DL510118	11.8	47	95
DL510080	8.0	37	79	DL510120	12.0	51	102
DL510081	8.1	37	79	DL510125	12.5	51	102
DL510082	8.2	37	79	DL510130	13.0	51	102
DL510083	8.3	37	79	DL510135	13.5	54	107
DL510084	8.4	37	79	DL510140	14.0	54	107
DL510085	8.5	37	79	DL510145	14.5	56	111
DL510086	8.6	40	84	DL510150	15.0	56	111
DL510087	8.7	40	84	DL510155	15.5	58	115
DL510088	8.8	40	84	DL510160	16.0	58	115
DL510089	8.9	40	84	DL510165	16.5	60	119
DL510090	9.0	40	84	DL510170	17.0	60	119
DL510091	9.1	40	84	DL510175	17.5	62	123
DL510092	9.2	40	84	DL510180	18.0	62	123
DL510093	9.3	40	84	DL510185	18.5	64	127
DL510094	9.4	40	84	DL510190	19.0	64	127
DL510095	9.5	40	84	DL510195	19.5	66	131
DL510096	9.6	43	89	DL510200	20.0	66	131
DL510097	9.7	43	89				
DL510098	9.8	43	89				
DL510099	9.9	43	89				

◎ : 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	38	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	◎	◎	◎	○	○	◎	○	○	○	○					○	○	○	○	○	○

# YG STRAIGHT SHANK DRILLS

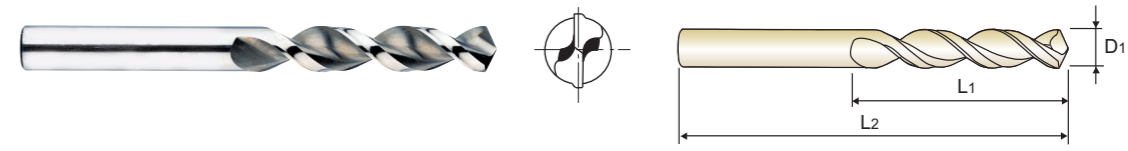
## DL508 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES *JOBBER*

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT *KURZ*
- Forets HSS-E, queue cylindrique pour perçage profond, série courte *COURTE*
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP *CORTA*

► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



#### ► DH100 worm pattern drills



EDP No.	Drill Diameter		Overall Length	EDP No.	Drill Diameter		Overall Length
	D <sub>1</sub>	L <sub>1</sub>			D <sub>1</sub>	L <sub>1</sub>	
DL508020	2.0	24	49	DL508046	4.6	47	80
DL508021	2.1	24	49	DL508047	4.7	47	80
DL508022	2.2	27	53	DL508048	4.8	52	86
DL508023	2.3	27	53	DL508049	4.9	52	86
DL508024	2.4	30	57	DL508050	5.0	52	86
DL508025	2.5	30	57	DL508051	5.1	52	86
DL508026	2.6	30	57	DL508052	5.2	52	86
DL508027	2.7	33	61	DL508053	5.3	52	86
DL508028	2.8	33	61	DL508054	5.4	57	93
DL508029	2.9	33	61	DL508055	5.5	57	93
DL508030	3.0	33	61	DL508056	5.6	57	93
DL508031	3.1	36	65	DL508057	5.7	57	93
DL508032	3.2	36	65	DL508058	5.8	57	93
DL508033	3.3	36	65	DL508059	5.9	57	93
DL508034	3.4	39	70	DL508060	6.0	57	93
DL508035	3.5	39	70	DL508061	6.1	63	101
DL508036	3.6	39	70	DL508062	6.2	63	101
DL508037	3.7	39	70	DL508063	6.3	63	101
DL508038	3.8	43	75	DL508064	6.4	63	101
DL508039	3.9	43	75	DL508065	6.5	63	101
DL508040	4.0	43	75	DL508066	6.6	63	101
DL508041	4.1	43	75	DL508067	6.7	63	101
DL508042	4.2	43	75	DL508068	6.8	69	109
DL508043	4.3	47	80	DL508069	6.9	69	109
DL508044	4.4	47	80	DL508070	7.0	69	109
DL508045	4.5	47	80	DL508071	7.1	69	109

◎ : 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	38	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	◎	◎	◎	○	○	◎	○	○	○	○					○	○	○	○	○	○

YTG STRAIGHT SHANK DRILLS

DL508 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS

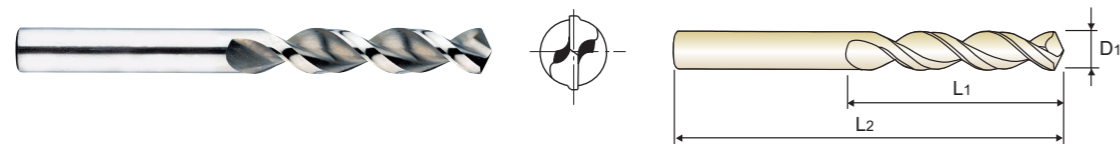
JOBBER

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
Forets HSS-E, queue cylindrique pour perçage profond, série courte
PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

KURZ
COURTE
CORTA

Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

Verwendung : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DH100 worm pattern drills



Unit : mm

Table with 7 columns: EDP No., Drill Diameter (D1), Flute Length (L1), Overall Length (L2), EDP No., Drill Diameter (D1), Flute Length (L1), Overall Length (L2). Lists 20 drill models with their specifications.

© : Excellent ○ : Good

Material compatibility table showing ISO material descriptions and hardness values for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, Aluminum-wrought alloy, Aluminum-cast, alloyed, Copper and Copper Alloys, Non Metallic Materials, Heat Resistant Super Alloys, Titanium Alloys, Hardened steel, Chilled Cast Iron, Hardened Cast Iron.

YTG STRAIGHT SHANK DRILLS

DL509 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

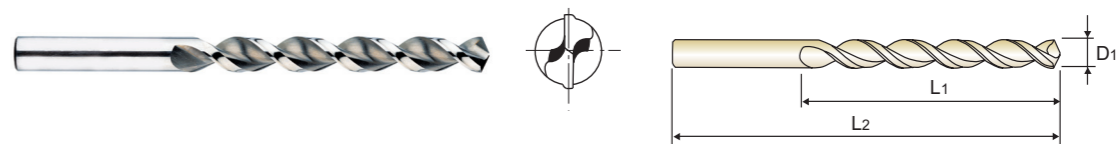
LONG

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
Forets HSS-E, queue cylindrique pour perçage profond, série longue
PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

LANG
LONGUE
LUNGA

Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

Verwendung : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DH100 worm pattern drills



Unit : mm

Table with 7 columns: EDP No., Drill Diameter (D1), Flute Length (L1), Overall Length (L2), EDP No., Drill Diameter (D1), Flute Length (L1), Overall Length (L2). Lists 20 drill models with their specifications.

▶ NEXT PAGE

© : Excellent ○ : Good

Material compatibility table showing ISO material descriptions and hardness values for various materials like Non-alloy steel, Low alloy steel, High alloyed steel, Stainless steel, Grey cast iron, Nodular cast iron, Malleable cast iron, Aluminum-wrought alloy, Aluminum-cast, alloyed, Copper and Copper Alloys, Non Metallic Materials, Heat Resistant Super Alloys, Titanium Alloys, Hardened steel, Chilled Cast Iron, Hardened Cast Iron.

# YG STRAIGHT SHANK DRILLS

## DL509 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES LONG

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT LANG
- Forets HSS-E, queue cylindrique pour perçage profond, série longue LONGUE
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP LUNGA

▶Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

▶Verwendung : Zum Bohren von legiertem und unlegiertem Stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



#### ▶ DH100 worm pattern drills

DIN 340 HSS-E 42° h8 130° Bright p.A264

Plain Shank Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
DL509072	7.2	102	156	DL509098	9.8	121	184
DL509073	7.3	102	156	DL509099	9.9	121	184
DL509074	7.4	102	156	DL509100	10.0	121	184
DL509075	7.5	102	156	DL509102	10.2	121	184
DL509076	7.6	109	165	DL509105	10.5	121	184
DL509077	7.7	109	165	DL509110	11.0	128	195
DL509078	7.8	109	165	DL509115	11.5	128	195
DL509079	7.9	109	165	DL509120	12.0	134	205
DL509080	8.0	109	165				
DL509081	8.1	109	165				
DL509082	8.2	109	165				
DL509083	8.3	109	165				
DL509084	8.4	109	165				
DL509085	8.5	109	165				
DL509086	8.6	115	175				
DL509087	8.7	115	175				
DL509088	8.8	115	175				
DL509089	8.9	115	175				
DL509090	9.0	115	175				
DL509091	9.1	115	175				
DL509092	9.2	115	175				
DL509093	9.3	115	175				
DL509094	9.4	115	175				
DL509095	9.5	115	175				
DL509096	9.6	121	184				
DL509097	9.7	121	184				

◎ : 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	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	15	30	25	38	34	15	30	25	38	34	55	60	42	55	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

# YG STRAIGHT SHANK DRILLS

## DL505 SERIES

### HSS-E, STRAIGHT SHANK TWIST DRILLS JOBBER

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT KURZ
- Forets HSS-E, queue cylindrique pour perçage profond, série courte COURTE
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP CORTA

▶Surface treatment : Steam Tempered(Black Oxide Finish)  
▶Application : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

▶Oberflächenbehandlung : Steam Homo(Schwarzoxidation)  
▶Verwendung : Zum Bohren von legiertem und unlegiertem Stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



#### ▶ DH100 worm pattern drills

DIN 338 HSS-E 38° h8 130° Vap p.A264

Plain Shank Recommended ToolHolder ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter		Flute Length		Overall Length		
	D1	L1	L2	D1	L1	L2	
DL505020	2.0	24	49	DL505046	4.6	47	80
DL505021	2.1	24	49	DL505047	4.7	47	80
DL505022	2.2	27	53	DL505048	4.8	52	86
DL505023	2.3	27	53	DL505049	4.9	52	86
DL505024	2.4	30	57	DL505050	5.0	52	86
DL505025	2.5	30	57	DL505051	5.1	52	86
DL505026	2.6	30	57	DL505052	5.2	52	86
DL505027	2.7	33	61	DL505053	5.3	52	86
DL505028	2.8	33	61	DL505054	5.4	57	93
DL505029	2.9	33	61	DL505055	5.5	57	93
DL505030	3.0	33	61	DL505056	5.6	57	93
DL505031	3.1	36	65	DL505057	5.7	57	93
DL505032	3.2	36	65	DL505058	5.8	57	93
DL505033	3.3	36	65	DL505059	5.9	57	93
DL505034	3.4	39	70	DL505060	6.0	57	93
DL505035	3.5	39	70	DL505061	6.1	63	101
DL505036	3.6	39	70	DL505062	6.2	63	101
DL505037	3.7	39	70	DL505063	6.3	63	101
DL505038	3.8	43	75	DL505064	6.4	63	101
DL505039	3.9	43	75	DL505065	6.5	63	101
DL505040	4.0	43	75	DL505066	6.6	63	101
DL505041	4.1	43	75	DL505067	6.7	63	101
DL505042	4.2	43	75	DL505068	6.8	69	109
DL505043	4.3	47	80	DL505069	6.9	69	109
DL505044	4.4	47	80	DL505070	7.0	69	109
DL505045	4.5	47	80	DL505071	7.1	69	109

▶ TiN(DN505), TiCN(DX505) and TiAlN(DT505) are available on your request.

▶ 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	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	15	30	25	38	34	15	30	25	38	34	55	60	42	55	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**YG STRAIGHT SHANK DRILLS**

**DL505 SERIES**

**HSS-E, STRAIGHT SHANK TWIST DRILLS**

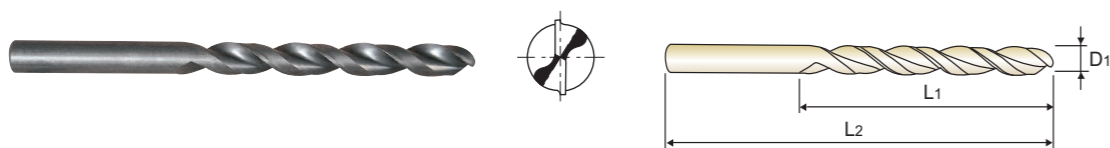
JOBBER

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
- Forets HSS-E, queue cylindrique pour perçage profond, série courte
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

- KURZ
- COURTE
- CORTA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DIN 338 HSS-E 38° h8 130° Vap p.A264

Plain Shank Recommended ToolHolder ER COLLET CHUCK

**► DH100 worm pattern drills**

EDP No.	Drill Diameter		Overall Length
	D <sub>1</sub>	L <sub>1</sub>	
DL505072	7.2	69	109
DL505073	7.3	69	109
DL505074	7.4	69	109
DL505075	7.5	69	109
DL505076	7.6	75	117
DL505077	7.7	75	117
DL505078	7.8	75	117
DL505079	7.9	75	117
DL505080	8.0	75	117
DL505081	8.1	75	117
DL505082	8.2	75	117
DL505083	8.3	75	117
DL505084	8.4	75	117
DL505085	8.5	75	117
DL505086	8.6	81	125
DL505087	8.7	81	125
DL505088	8.8	81	125
DL505089	8.9	81	125
DL505090	9.0	81	125
DL505091	9.1	81	125
DL505092	9.2	81	125
DL505093	9.3	81	125
DL505094	9.4	81	125
DL505095	9.5	81	125
DL505096	9.6	87	133
DL505097	9.7	87	133

EDP No.	Drill Diameter		Overall Length
	D <sub>1</sub>	L <sub>1</sub>	
DL505098	9.8	87	133
DL505099	9.9	87	133
DL505100	10.0	87	133
DL505101	10.1	87	133
DL505102	10.2	87	133
DL505105	10.5	87	133
DL505108	10.8	94	142
DL505110	11.0	94	142
DL505112	11.2	94	142
DL505115	11.5	94	142
DL505118	11.8	94	142
DL505120	12.0	101	151
DL505122	12.2	101	151
DL505125	12.5	101	151
DL505128	12.8	101	151
DL505130	13.0	101	151

Unit : mm

► TiN(DN505), TiCN(DX505) and TiAlN(DT505) are available on your request.

◎ : 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									
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30			
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25															
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230													
Recommended	◎	◎	◎	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
ISO 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										
	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	
HRc											15	30	25	38	34	40	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 STRAIGHT SHANK DRILLS**

**DL504 SERIES**

**HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES**

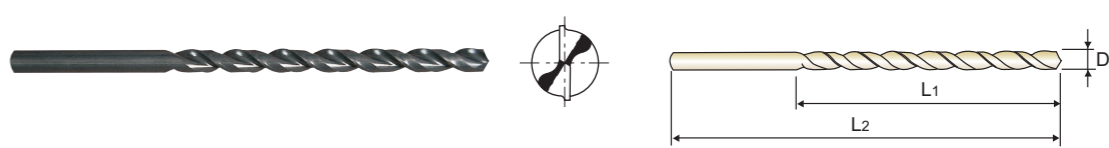
LONG

- HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT
- Forets HSS-E, queue cylindrique pour perçage profond, série longue
- PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

- LANG
- LONGUE
- LUNGA

► **Surface treatment** : Steam Tempered(Black Oxide Finish)  
► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)  
► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DIN 340 HSS-E 38° h8 130° Vap p.A264

Plain Shank Recommended ToolHolder ER COLLET CHUCK

**► DH100 worm pattern drills**

EDP No.	Drill Diameter		Overall Length
	D <sub>1</sub>	L <sub>1</sub>	
DL504020	2.0	56	85
DL504021	2.1	56	85
DL504022	2.2	59	90
DL504023	2.3	59	90
DL504024	2.4	62	95
DL504025	2.5	62	95
DL504026	2.6	62	95
DL504027	2.7	66	100
DL504028	2.8	66	100
DL504029	2.9	66	100
DL504030	3.0	66	100
DL504031	3.1	69	106
DL504032	3.2	69	106
DL504033	3.3	69	106
DL504034	3.4	73	112
DL504035	3.5	73	112
DL504036	3.6	73	112
DL504037	3.7	73	112
DL504038	3.8	78	119
DL504039	3.9	78	119
DL504040	4.0	78	119
DL504042	4.2	78	119
DL504045	4.5	82	126
DL504048	4.8	87	132
DL504050	5.0	87	132
DL504052	5.2	87	132

► TiN(DN504), TiCN(DX504) and TiAlN(DT504) are available on your request.

◎ : 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									
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30			
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25															
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230													
Recommended	◎	◎	◎	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
ISO 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										
	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	
HRc											15	30	25	38	34	40	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																																	

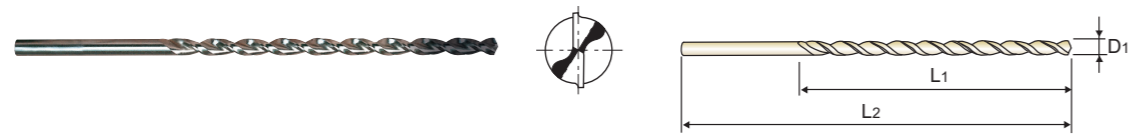
# YIG STRAIGHT SHANK DRILLS

DT600 SERIES DT692 SERIES DT693 SERIES

## HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES EXTRA LONG

🇩🇪 HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT **ÜBERLANG**  
🇫🇷 Forets HSS-E, queue cylindrique pour perçage profond, Forme C, série extra-longue **EXTRA-LONGUE**  
🇮🇹 PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP **EXTRA LUNGA**

**▶ Surface treatment** : TiAlN coating on working area. **▶ Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.  
**▶ Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.



### ▶ DH100 worm pattern drills

DIN 1869/1 DIN 1869/2 DIN 1869/3 HSS-E 38° h8 130° TiAlN p.A265 Plain Shank ER COLLET CHUCK

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DT600020	2.0	85	125
DT600025	2.5	95	140
DT600030	3.0	100	150
DT600035	3.5	115	165
DT600040	4.0	120	175
DT600045	4.5	125	185
DT600050	5.0	135	195
DT600055	5.5	140	205
DT600060	6.0	140	205
DT600065	6.5	150	215
DT600070	7.0	155	225
DT600075	7.5	155	225
DT600080	8.0	165	240
DT600085	8.5	165	240
DT600090	9.0	175	250
DT600095	9.5	175	250
DT600100	10.0	185	265
DT600105	10.5	185	265

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DT692030	3.0	130	190
DT692035	3.5	145	210
DT692040	4.0	150	220
DT692045	4.5	160	235
DT692050	5.0	170	245
DT692055	5.5	180	260
DT692060	6.0	180	260
DT692065	6.5	190	275
DT692070	7.0	200	290
DT692075	7.5	200	290
DT692080	8.0	210	305
DT692085	8.5	210	305
DT692090	9.0	220	320
DT692095	9.5	220	320
DT692100	10.0	235	340
DT692102	10.2	235	340

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DT693040	4.0	190	280
DT693050	5.0	210	315
DT693060	6.0	225	330
DT693080	8.0	265	390
DT693100	10.0	295	430

▶ TiN(DN600) and TiCN(DX600) are available on your request.

◎ : 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	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

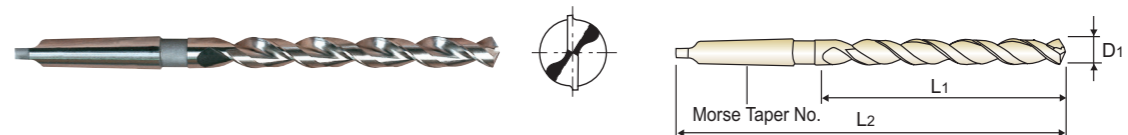
# YIG STRAIGHT SHANK DRILLS

DL608 SERIES

## HSS-E, MORSE TAPER SHANK TWIST DRILLS for DEEP HOLES LONG

🇩🇪 HSS-E, SPIRALBOHRER für TIEFLOCH mit MORSEKEGELSCHAFT **LANG**  
🇫🇷 Forets HSS-E, queue cône morse pour perçage profond, série longue **LONGUE**  
🇮🇹 PUNTE IN HSS - E, ATTACCO CONO MORSE PER FORI NON - STOP **LUNGA**

**▶ Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys. **▶ Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



### ▶ DH100 worm pattern drills

DIN 341 HSS-E 38° 1~3 h8 130° Bright p.A264 Plain Shank ER COLLET CHUCK

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper
DL608130	13.0	134	215	1
DL608135	13.5	142	223	1
DL608140	14.0	142	223	1
DL608145	14.5	147	245	2
DL608150	15.0	147	245	2
DL608155	15.5	153	251	2
DL608160	16.0	153	251	2
DL608165	16.5	159	257	2
DL608170	17.0	159	257	2
DL608175	17.5	165	263	2
DL608180	18.0	165	263	2
DL608185	18.5	171	269	2
DL608190	19.0	171	269	2

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper
DL608195	19.5	177	275	2
DL608200	20.0	177	275	2
DL608210	21.0	184	282	2
DL608220	22.0	191	289	2
DL608230	23.0	198	296	2
DL608240	24.0	206	327	3
DL608250	25.0	206	327	3
DL608260	26.0	214	335	3
DL608270	27.0	222	343	3
DL608280	28.0	222	343	3
DL608290	29.0	230	351	3
DL608300	30.0	230	351	3

◎ : 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	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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

# YG STRAIGHT SHANK DRILLS

DL507 SERIES

## HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES EXTRA LONG

HSS-E, SPIRALBOHRER für ALUMINIUM TIEFLOCH mit ZYLINDERSCHAFT ÜBERLANG  
 Forets HSS-E, queue cylindrique pour ALU, perçage profond, série extra-longue EXTRA-LONGUE  
 PUNTE HSS-E, GAMBO CILINDRICO PER FORATURE NON - STOP SU ALLUMINIO EXTRA LUNGA

**►Application :** Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials. **►Verwendung :** Zum Bohren von weichen und langspanenden Werkstoffen wie Alu-Legierungen, Zink, Kupfer, Kunststoffe und Holz.



### ►DH50 worm pattern drills

Plain Shank  
 ER COLLET CHUCK  
 Recommended ToolHolder

Unit : mm

EDP No.	Drill Diameter		Flute Length	Overall Length	EDP No.	Drill Diameter		Flute Length	Overall Length
	D1	L1				D1	L1		
DL507120	2.0	40	75		DL507430	3.0	100	200	
DL507121	2.1	40	75		DL507433	3.3	100	200	
DL507220	2.0	50	100		DL507435	3.5	100	200	
DL507221	2.1	50	100		DL507440	4.0	100	200	
DL507225	2.5	50	100		DL507442	4.2	100	200	
DL507227	2.7	50	100		DL507445	4.5	100	200	
DL507230	3.0	50	100		DL507450	5.0	100	200	
DL507233	3.3	50	100		DL507453	5.3	100	200	
DL507235	3.5	50	100		DL507455	5.5	100	200	
DL507320	2.0	75	150		DL507460	6.0	100	200	
DL507321	2.1	75	150		DL507465	6.5	100	200	
DL507325	2.5	75	150		DL507468	6.8	100	200	
DL507327	2.7	75	150		DL507470	7.0	100	200	
DL507330	3.0	75	150		DL507475	7.5	100	200	
DL507333	3.3	75	150		DL507480	8.0	100	200	
DL507335	3.5	75	150		DL507485	8.5	100	200	
DL507340	4.0	75	150		DL507488	8.8	100	200	
DL507342	4.2	75	150		DL507490	9.0	100	200	
DL507345	4.5	75	150		DL507495	9.5	100	200	
DL507350	5.0	75	150		DL507700	10.0	100	200	
DL507353	5.3	75	150		DL507540	4.0	150	250	
DL507355	5.5	75	150		DL507542	4.2	150	250	
DL507360	6.0	75	150		DL507545	4.5	150	250	
					DL507550	5.0	150	250	
					DL507553	5.3	150	250	

► 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	◎	◎	○																			

# YG STRAIGHT SHANK DRILLS

DL507 SERIES

## HSS-E, STRAIGHT SHANK TWIST DRILLS for ALUMINUM DEEP HOLES EXTRA LONG

HSS-E, SPIRALBOHRER für ALUMINIUM TIEFLOCH mit ZYLINDERSCHAFT ÜBERLANG  
 Forets HSS-E, queue cylindrique pour ALU, perçage profond, série extra-longue EXTRA-LONGUE  
 PUNTE HSS-E, GAMBO CILINDRICO PER FORATURE NON - STOP SU ALLUMINIO EXTRA LUNGA

**►Application :** Drilling deep holes in aluminum and its alloys, silumin, zinc, refined copper, wood and other soft synthetic materials. **►Verwendung :** Zum Bohren von weichen und langspanenden Werkstoffen wie Alu-Legierungen, Zink, Kupfer, Kunststoffe und Holz.



### ►DH50 worm pattern drills

Plain Shank  
 ER COLLET CHUCK  
 Recommended ToolHolder

Unit : mm

EDP No.	Drill Diameter		Flute Length	Overall Length	EDP No.	Drill Diameter		Flute Length	Overall Length
	D1	L1				D1	L1		
DL507555	5.5	150	250		DL507650	5.0	180	300	
DL507560	6.0	150	250		DL507653	5.3	180	300	
DL507565	6.5	150	250		DL507655	5.5	180	300	
DL507568	6.8	150	250		DL507660	6.0	180	300	
DL507570	7.0	150	250		DL507665	6.5	180	300	
DL507575	7.5	150	250		DL507668	6.8	180	300	
DL507580	8.0	150	250		DL507670	7.0	180	300	
DL507585	8.5	150	250		DL507675	7.5	180	300	
DL507588	8.8	150	250		DL507680	8.0	180	300	
DL507590	9.0	150	250		DL507685	8.5	180	300	
DL507595	9.5	150	250		DL507688	8.8	180	300	
DL507800	10.0	150	250		DL507690	9.0	180	300	
DL507803	10.3	150	250		DL507695	9.5	180	300	
DL507805	10.5	150	250		DL507900	10.0	180	300	
DL507810	11.0	150	250		DL507903	10.3	180	300	
DL507815	11.5	150	250		DL507905	10.5	180	300	
DL507820	12.0	150	250		DL507910	11.0	180	300	
DL507825	12.5	150	250		DL507915	11.5	180	300	
DL507830	13.0	150	250		DL507920	12.0	180	300	
					DL507925	12.5	180	300	
					DL507930	13.0	180	300	

◎ : 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	◎	◎	○																			





RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

D2107, D1107, D2105, DL105, D1105, D1125, D2104, D1121, DL109 SERIES

HSS, HSS-E & HSS Co8 COBALT DRILLS

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

Large table with columns for ISO, VDI, Material Description, Vc, Parameter, and Drill Diameter (mm) for various materials like Non-alloy steel, Low alloy steel, etc.



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

D1100 SERIES

HSS, TWIST DRILLS for BRASS / BRONZE

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

Table for D1100 series with columns for ISO, VDI, Material Description, Vc, Parameter, and Drill Diameter (mm).

D1106 SERIES

HSS, TWIST DRILLS for ALUMINUM

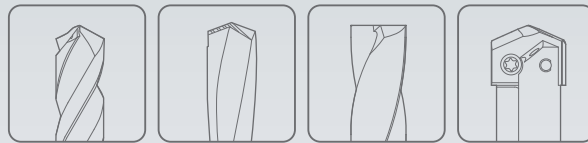
Vc = m/min. RPM = rev./min. FEED = mm/rev.

Table for D1106 series with columns for ISO, VDI, Material Description, Vc, Parameter, and Drill Diameter (mm).





Global Cutting Tool Leader **YG-1**



# HOLEMAKING



Leading Through Innovation



**HSS & HSS-E**

# MORSE TAPER SHANK DRILLS

**BOHRER MIT MK**

- Morse Taper Shank Drills for Wide Applications
- Bohrer mit Morsekegel für breite Anwendungen