YG HOLEMAKING TOOLS

HSS & HSS-E
GOLD-P DRILLS

Same Performance as Full TiN-coated Drills

◎ : Excellent ○ : Good

Recommended cutting conditions : P.219

SERIES	D1GP125	D1GP165	DLGP195	DLGP506
STANDARD	DIN338	DIN338	DIN338	DIN338
LENGTH	JOBBER	JOBBER	JOBBER	JOBBER
SIZE MIN	D1.0	D1.6	D1.0	D2.0
SIZE MAX	D13.0	D13.0	D13.0	D13.0
PAGE	206	209	212	215
SURFACE TREATMENT	TiN		TiN	







ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	D1GP125	D1GP165	DLGP195	DLGP506	
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎	1
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	2
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎	3
	4		About 0.75% C	Annealed	270	28	○	○	○	○	4
	5		About 0.75% C	Quenched & Tempered	300	32					5
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎	6
	7			Quenched & Tempered	275	29	○	○	○	○	7
	8			Quenched & Tempered	300	32	○	○	○	○	8
	9			Quenched & Tempered	350	38					9
	10	High alloyed steel, and tool steel		Annealed	200	15	○	○	○	○	10
	11			Quenched & Tempered	325	35					11
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	◎	◎	◎		12
	13		Martensitic	Quenched & Tempered	240	23	○	○	○		13
	14		Austenitic		180	10	○	○	○		14
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○	○	15
	16		Pearlitic (Martensitic)		260	26	○	○	○	○	16
	17	Nodular cast iron	Ferritic		160	3	○	○	○	○	17
	18		Pearlitic		250	25				○	18
	19	Malleable cast iron	Ferritic		130		○	○	○	○	19
	20		Pearlitic		230	21				○	20
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○		21
	22		Curable	Hardened	100		○	○	○		22
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○		23
	24		≤ 12% Si, Curable	Hardened	90						24
	25		> 12% Si, Not Curable		130						25
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110						26
	27		CuZn, CuSnZn (Brass)		90						27
	28		CuSn, lead-free copper and electrolytic copper		100						28
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				○	○	○		29
	30		Rubber, Wood, etc.								30
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15					31
	32			Cured	280	30					32
	33		Ni or Co Based	Annealed	250	25					33
	34			Cured	350	38					34
	35			Cast	320	34					35
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○		36
	37		Alpha + Beta Alloys	Hardened	1050 Rm						37
H	38	Hardened steel		Hardened	550	55					38
	39			Hardened	630	60					39
	40	Chilled Cast Iron		Cast	400	42					40
	41	Hardened Cast Iron		Hardened	550	55					41

GOLD-P DRILL SETS

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









HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

HSS SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS queue cylindrique revêtus, série courte

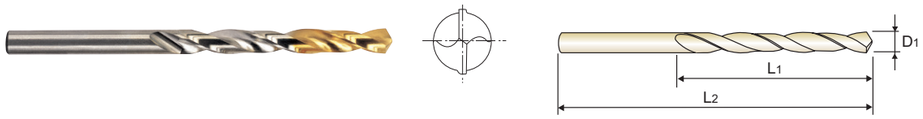
COURTE

PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

CORTA

- ▶**Flute Geometry** : Right hand helix
- ▶**Point Angle** : 118˚, Normal point
- ▶**Surface treatment** : Bright body, TiN coating on working area
- ▶**Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶**Nutenform** : Rechtsspirale
- ▶**Spitzenwinkel** : 118° Normalanschliff
- ▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶**Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125010	1.0	12	34
D1GP125011	1.1	14	36
D1GP125012	1.2	16	38
D1GP125013	1.3	16	38
D1GP125014	1.4	18	40
D1GP125015	1.5	18	40
D1GP125016	1.6	20	43
D1GP125017	1.7	20	43
D1GP125018	1.8	22	46
D1GP125019	1.9	22	46
D1GP125020	2.0	24	49
D1GP125021	2.1	24	49
D1GP125022	2.2	27	53
D1GP125023	2.3	27	53
D1GP125024	2.4	30	57
D1GP125025	2.5	30	57
D1GP125026	2.6	30	57
D1GP125027	2.7	33	61
D1GP125028	2.8	33	61
D1GP125029	2.9	33	61
D1GP125030	3.0	33	61
D1GP125031	3.1	36	65
D1GP125032	3.2	36	65
D1GP125033	3.3	36	65
D1GP125034	3.4	39	70
D1GP125035	3.5	39	70

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125036	3.6	39	70
D1GP125037	3.7	39	70
D1GP125038	3.8	43	75
D1GP125039	3.9	43	75
D1GP125040	4.0	43	75
D1GP125041	4.1	43	75
D1GP125042	4.2	43	75
D1GP125043	4.3	47	80
D1GP125044	4.4	47	80
D1GP125045	4.5	47	80
D1GP125046	4.6	47	80
D1GP125047	4.7	47	80
D1GP125048	4.8	52	86
D1GP125049	4.9	52	86
D1GP125050	5.0	52	86
D1GP125051	5.1	52	86
D1GP125052	5.2	52	86
D1GP125053	5.3	52	86
D1GP125054	5.4	57	93
D1GP125055	5.5	57	93
D1GP125056	5.6	57	93
D1GP125057	5.7	57	93
D1GP125058	5.8	57	93
D1GP125059	5.9	57	93
D1GP125060	6.0	57	93
D1GP125061	6.1	63	101

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

GOLD-P DRILLS

D1GP125 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

HSS SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS queue cylindrique revêtus, série courte

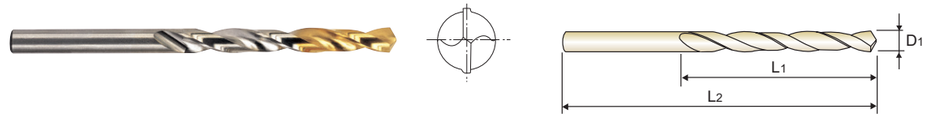
COURTE

PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

CORTA

▶Flute Geometry : Right hand helix
▶Point Angle : 118˚, Normal point
▶Surface treatment : Bright body, TiN coating on working area
▶Application : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

▶Nutenform : Rechtsspirale
▶Spitzenwinkel : 118° Normalanschliff
▶Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich
▶Anwendung : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125062	6.2	63	101
D1GP125063	6.3	63	101
D1GP125064	6.4	63	101
D1GP125065	6.5	63	101
D1GP125066	6.6	63	101
D1GP125067	6.7	63	101
D1GP125068	6.8	69	109
D1GP125069	6.9	69	109
D1GP125070	7.0	69	109
D1GP125071	7.1	69	109
D1GP125072	7.2	69	109
D1GP125073	7.3	69	109
D1GP125074	7.4	69	109
D1GP125075	7.5	69	109
D1GP125076	7.6	75	117
D1GP125077	7.7	75	117
D1GP125078	7.8	75	117
D1GP125079	7.9	75	117
D1GP125080	8.0	75	117
D1GP125081	8.1	75	117
D1GP125082	8.2	75	117
D1GP125083	8.3	75	117
D1GP125084	8.4	75	117
D1GP125085	8.5	75	117
D1GP125086	8.6	81	125
D1GP125087	8.7	81	125

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125088	8.8	81	125
D1GP125089	8.9	81	125
D1GP125090	9.0	81	125
D1GP125091	9.1	81	125
D1GP125092	9.2	81	125
D1GP125093	9.3	81	125
D1GP125094	9.4	81	125
D1GP125095	9.5	81	125
D1GP125096	9.6	87	133
D1GP125097	9.7	87	133
D1GP125098	9.8	87	133
D1GP125099	9.9	87	133
D1GP125100	10.0	87	133
D1GP125101	10.1	87	133
D1GP125102	10.2	87	133
D1GP125103	10.3	87	133
D1GP125104	10.4	87	133
D1GP125105	10.5	87	133
D1GP125106	10.6	87	133
D1GP125107	10.7	94	142
D1GP125108	10.8	94	142
D1GP125109	10.9	94	142
D1GP125110	11.0	94	142
D1GP125111	11.1	94	142
D1GP125112	11.2	94	142
D1GP125113	11.3	94	142

▶ 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	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											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	○	○	○						○							○					

D1GP125 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

HSS SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS queue cylindrique revêtus, série courte

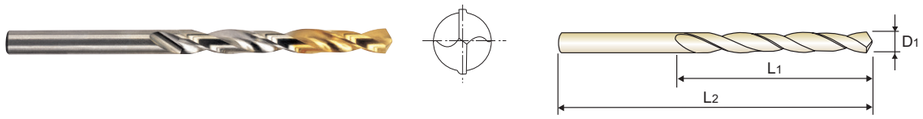
COURTE

PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

CORTA

- ▶**Flute Geometry** : Right hand helix
- ▶**Point Angle** : 118˚, Normal point
- ▶**Surface treatment** : Bright body, TiN coating on working area
- ▶**Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶**Nutenform** : Rechtsspirale
- ▶**Spitzenwinkel** : 118° Normalanschliff
- ▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶**Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

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

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP125123	12.3	101	151
D1GP125124	12.4	101	151
D1GP125125	12.5	101	151
D1GP125126	12.6	101	151
D1GP125127	12.7	101	151
D1GP125128	12.8	101	151
D1GP125129	12.9	101	151
D1GP125130	13.0	101	151

◎ : Excellent ○ : Good

ISO	P																			
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	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											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	○	○	○						○							○					

D1GP165 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

HSS SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS queue cylindrique revêtus, série courte

COURTE

PUNTE IN HSS, GAMBO CILINDRICO, GOLD-P

CORTA

- ▶**Flute Geometry** : Right hand helix
- ▶**Point Angle** : 118˚, Split point
- ▶**Surface treatment** : Bright body, TiN coating on working area
- ▶**Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶**Nutenform** : Rechtsspirale
- ▶**Spitzenwinkel** : 118° Kreuzanschliff
- ▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶**Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

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

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

▶ NEXT PAGE

◎ : Excellent ○ : Good

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

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

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

KURZ
COURTE
CORTA

- ▶**Flute Geometry** : Right hand helix
- ▶**Point Angle** : 118˚, Split point
- ▶**Surface treatment** : Bright body, TiN coating on working area
- ▶**Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶**Nutenform** : Rechtsspirale
- ▶**Spitzenwinkel** : 118° Kreuzanschliff
- ▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶**Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

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

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

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

GOLD-P DRILLS

D1GP165 SERIES

HSS, STRAIGHT SHANK DRILLS, GOLD-P COATED

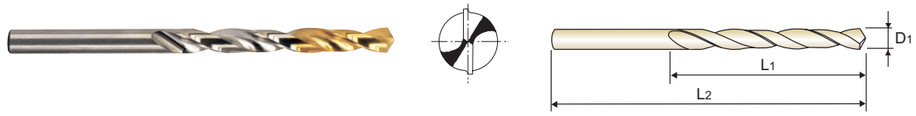
JOBBER

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

KURZ
COURTE
CORTA

▶Flute Geometry : Right hand helix
▶Point Angle : 118˚, Split point
▶Surface treatment : Bright body, TiN coating on working area
▶Application : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

▶Nutenform : Rechtsspirale
▶Spitzenwinkel : 118° Kreuzanschliff
▶Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich
▶Anwendung : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



DIN 338 | HSS | N ≈ 30° | h8 | 118° | P.219

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP165120	12.0	101	151
D1GP165121	12.1	101	151
D1GP165122	12.2	101	151
D1GP165123	12.3	101	151
D1GP165124	12.4	101	151
D1GP165125	12.5	101	151

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1GP165126	12.6	101	151
D1GP165127	12.7	101	151
D1GP165128	12.8	101	151
D1GP165129	12.9	101	151
D1GP165130	13.0	101	151

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

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

JOBBER

HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, série courte

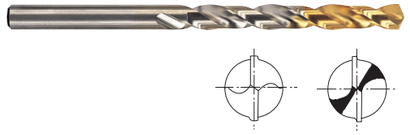
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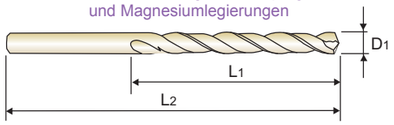
PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

CORTA

▶**Flute Geometry** : Right hand helix
▶**Point Angle** : 135˚, under 1.6mm : Normal point
1.6mm & over : Split point
▶**Surface treatment** : Bright body, TiN coating on working area
▶**Application** : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

▶**Nutenform** : Rechtsspirale
▶**Spitzenwinkel** : 135°, unter 1.6mm : Normalanschliff
1.6mm & über : Kreuzanschliff
▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
▶**Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen





DIN 338 | HSS-E | 33° | h8 | 135° | P.219

Unit : mm

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

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

▶ NEXT PAGE

◎ : Excellent ○ : Good

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

GOLD-P DRILLS

DLGP195 SERIES

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

JOBBER

HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, série courte

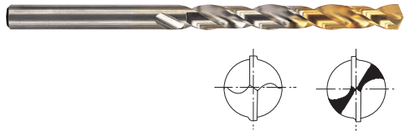
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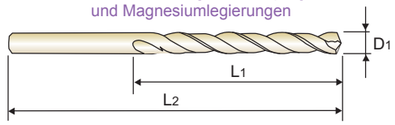
PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

CORTA

▶Flute Geometry : Right hand helix
▶Point Angle : 135˚, under 1.6mm : Normal point
1.6mm & over : Split point
▶Surface treatment : Bright body, TiN coating on working area
▶Application : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

▶Nutenform : Rechtsspirale
▶Spitzenwinkel : 135°, unter 1.6mm : Normalanschliff
1.6mm & über : Kreuzanschliff
▶Oberfläche : Blank mit TiN-Beschichtung im Arbeitsbereich
▶Anwendung : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen





DIN 338 | HSS-E | 33° | h8 | 135° | P.219

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195062	6.2	63	101
DLGP195063	6.3	63	101
DLGP195064	6.4	63	101
DLGP195065	6.5	63	101
DLGP195066	6.6	63	101
DLGP195067	6.7	63	101
DLGP195068	6.8	69	109
DLGP195069	6.9	69	109
DLGP195070	7.0	69	109
DLGP195071	7.1	69	109
DLGP195072	7.2	69	109
DLGP195073	7.3	69	109
DLGP195074	7.4	69	109
DLGP195075	7.5	69	109
DLGP195076	7.6	75	117
DLGP195077	7.7	75	117
DLGP195078	7.8	75	117
DLGP195079	7.9	75	117
DLGP195080	8.0	75	117
DLGP195081	8.1	75	117
DLGP195082	8.2	75	117
DLGP195083	8.3	75	117
DLGP195084	8.4	75	117
DLGP195085	8.5	75	117
DLGP195086	8.6	81	125
DLGP195087	8.7	81	125

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195088	8.8	81	125
DLGP195089	8.9	81	125
DLGP195090	9.0	81	125
DLGP195091	9.1	81	125
DLGP195092	9.2	81	125
DLGP195093	9.3	81	125
DLGP195094	9.4	81	125
DLGP195095	9.5	81	125
DLGP195096	9.6	87	133
DLGP195097	9.7	87	133
DLGP195098	9.8	87	133
DLGP195099	9.9	87	133
DLGP195100	10.0	87	133
DLGP195101	10.1	87	133
DLGP195102	10.2	87	133
DLGP195103	10.3	87	133
DLGP195104	10.4	87	133
DLGP195105	10.5	87	133
DLGP195106	10.6	87	133
DLGP195107	10.7	94	142
DLGP195108	10.8	94	142
DLGP195109	10.9	94	142
DLGP195110	11.0	94	142
DLGP195111	11.1	94	142
DLGP195112	11.2	94	142
DLGP195113	11.3	94	142

▶ 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	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											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	○	○	○						○							○					

DLGP195 SERIES

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

JOBBER

HSS-E SPIRALBOHRER, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, série courte

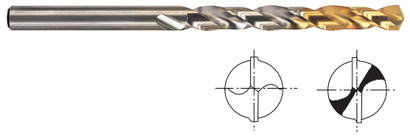
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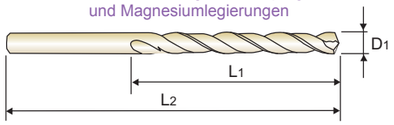
PUNTE IN HSS-E, GAMBO CILINDRICO, GOLD-P

CORTA

▶**Flute Geometry** : Right hand helix
▶**Point Angle** : 135˚, under 1.6mm : Normal point
1.6mm & over : Split point
▶**Surface treatment** : Bright body, TiN coating on working area
▶**Application** : Drilling stainless steels, difficult to cut materials such as titanium alloys and inconel.

▶**Nutenform** : Rechtsspirale
▶**Spitzenwinkel** : 135°, unter 1.6mm : Normalanschliff
1.6mm & über : Kreuzanschliff
▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
▶**Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen





DIN 338 | HSS-E | 33˚ | h8 | 135˚ | P.219

Unit : mm

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

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP195123	12.3	101	151
DLGP195124	12.4	101	151
DLGP195125	12.5	101	151
DLGP195126	12.6	101	151
DLGP195127	12.7	101	151
DLGP195128	12.8	101	151
DLGP195129	12.9	101	151
DLGP195130	13.0	101	151

◎ : Excellent ○ : Good

ISO	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	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											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	○	○	○						○							○					

DLGP506 SERIES

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

JOBBER

HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte

COURTE

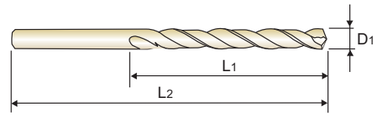
PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

CORTA

▶**Flute Geometry** : Right hand, 38˚ helix,
DH100 worm pattern type.
▶**Point Angle** : 130˚, Split point giving higher chip removal.
▶**Surface treatment** : Bright body, TiN coating on working area.
▶**Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, or magnesium alloys.

▶**Nutenform** : 38° Rechtsspirale, DH 100 Flachnut
▶**Spitzenwinkel** : Durch 130° Kreuzanschliff Gute Spanabfuhr
▶**Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
▶**Anwendung** : Tiefe Bohrungen in unlegierten und legierten Stählen, Grauguss, Temperguss, Aluminium- und Magnesiumlegierungen





DIN 338 | HSS-E | 38˚ | h8 | 130˚ | P.219

▶DH100 worm pattern drills

Unit : mm

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

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

▶ NEXT PAGE

◎ : Excellent ○ : Good

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

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

JOBBER

HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte

COURTE

PUNTE GAMBO CILINDRICO DH100 IN HSS-E, PER FORI PROFONDI, GOLD-P

CORTA

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DIN 338 | HSS-E | 38° | h8 | 130° | P.219

▶DH100 worm pattern drills

Unit : mm

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

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506098	9.8	87	133
DLGP506099	9.9	87	133
DLGP506100	10.0	87	133
DLGP506101	10.1	87	133
DLGP506102	10.2	87	133
DLGP506103	10.3	87	133
DLGP506104	10.4	87	133
DLGP506105	10.5	87	133
DLGP506106	10.6	87	133
DLGP506107	10.7	94	142
DLGP506108	10.8	94	142
DLGP506109	10.9	94	142
DLGP506110	11.0	94	142
DLGP506111	11.1	94	142
DLGP506112	11.2	94	142
DLGP506113	11.3	94	142
DLGP506114	11.4	94	142
DLGP506115	11.5	94	142
DLGP506116	11.6	94	142
DLGP506117	11.7	94	142
DLGP506118	11.8	94	142
DLGP506119	11.9	101	151
DLGP506120	12.0	101	151
DLGP506121	12.1	101	151
DLGP506122	12.2	101	151
DLGP506123	12.3	101	151

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

GOLD-P DRILLS

DLGP506 SERIES

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

JOBBER

HSS-E DH100 SPIRALBOHRER, für TIEFLOCH mit ZYLINDERSCHAFT, GOLD-P BESCHICHTET

KURZ

Forets GOLD-P HSS-E queue cylindrique revêtus, DH100 pour perçage profond, série courte

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DIN 338 | HSS-E | 38° | h8 | 130° | P.219

▶DH100 worm pattern drills

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506124	12.4	101	151
DLGP506125	12.5	101	151
DLGP506126	12.6	101	151
DLGP506127	12.7	101	151

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DLGP506128	12.8	101	151
DLGP506129	12.9	101	151
DLGP506130	13.0	101	151

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

GOLD-P COATED DRILL SETS

GOLD-P BESCHICHTET BOHRER SATS
Coffrets de Forets GOLD-P revêtus
SET DI PUNTE GOLD-P



DIN338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

EDP No.	DESCRIPTON	SIZE	Q'TY
D1GP165SET1	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
D1GP165SET2	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
D1GP165SET3	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGP195SET1	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
DLGP195SET2	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
DLGP195SET3	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGPSET982	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.1mm step	91 pcs

GOLD-P DRILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

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

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm) 2.0	3.0	4.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	2		35	RPM	5570	3710	2790	1860	1390	1110	860
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	3		30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	4		20	RPM	3180	2120	1590	1060	800	640	490
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	5										
	6	Low alloy steel	35	RPM	5570	3710	2790	1860	1390	1110	860
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	7		30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	8		30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	9										
	10	High alloyed steel, and tool steel	20	RPM	3180	2120	1590	1060	800	640	490
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	11										
M	12	Stainless steel	25	RPM	3980	2650	1990	1330	990	800	610
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	13		20	RPM	3180	2120	1590	1060	800	640	490
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	14		15	RPM	2390	1590	1190	800	600	480	370
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
K	15	Grey cast iron	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	16		35	RPM	5570	3710	2790	1860	1390	1110	860
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	17	Nodular cast iron	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	18		30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
	19	Malleable cast iron	35	RPM	5570	3710	2790	1860	1390	1110	860
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	20		30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.12-0.18
N	21	Aluminum-wrought alloy	65	RPM	10350	6900	5170	3450	2590	2070	1590
				FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	22		65	RPM	10350	6900	5170	3450	2590	2070	1590
				FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	23	Aluminum-cast, alloyed	50	RPM	7960	5310	3980	2650	1990	1590	1220
				FEED	0.05-0.09	0.07-0.11	0.12-0.16	0.12-0.18	0.14-0.20	0.16-0.22	0.22-0.28
	24										
	25										
	26	Copper and Copper Alloys (Bronze / Brass)									
	27										
	28										
	29	Non Metallic Materials	30	RPM	4770	3180	2390	1590	1190	950	730
				FEED	0.04-0.08	0.06-0.10	0.08-0.12	0.12-0.16	0.12-0.18	0.16-0.22	0.18-0.24
	30										
S	31	Heat Resistant Super Alloys									
	32										
	33										
	34										
	35										
	36	Titanium Alloys	20	RPM	3180	2120	1590	1060	800	640	490
				FEED	0.02-0.05	0.02-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.13	0.08-0.14
	37										
H	38	Hardened steel									
	39										
	40	Chilled Cast Iron									
	41	Hardened Cast Iron									