SERIES	D4541	D4542	DJ543	DJ544
LENGTH	STUB	JOBBER	STUB	JOBBER
SIZE MIN	D2.0	D2.0	D2.0	D2.0
SIZE MAX	D13.0	D32.0	D13.0	D20.0
PAGE	A173	A177	A183	A186
SURFACE TREATMENT	TiN			

HSS Co8 & HSS-E
HPD STRAIGHT SHANK DRILLS

High Precision Drilling for General Steels & Stainless Steels



Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A189

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	D4541	D4542	DJ543	DJ544
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	○	○
	2		About 0.45% C	Annealed	190	13	◎	◎		
	3		About 0.45% C	Quenched & Tempered	250	25	○	○		
	4		About 0.75% C	Annealed	270	28				
	5		About 0.75% C	Quenched & Tempered	300	32				
	6	Low alloy steel		Annealed	180	10	◎	◎		
	7			Quenched & Tempered	275	29	○	○		
	8			Quenched & Tempered	300	32				
	9			Quenched & Tempered	350	38				
	10	High alloyed steel, and tool steel		Annealed	200	15	○	○		
	11			Quenched & Tempered	325	35				
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15			◎	◎
	13		Martensitic	Quenched & Tempered	240	23			○	○
	14		Austenitic		180	10			◎	◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	◎		
	16		Pearlitic (Martensitic)		260	26				
	17	Nodular cast iron	Ferritic		160	3				
	18		Pearlitic		250	25				
	19	Malleable cast iron	Ferritic		130					
	20		Pearlitic		230	21				
N	21	Aluminum-wrought alloy	Not Curable		60				◎	◎
	22		Curable	Hardened	100				◎	◎
	23	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		Ni or Co Based	Annealed	250	25				
	34			Cured	350	38				
	35			Cast	320	34				
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm					
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				

HSS Co8, HPD TWIST DRILLS for STEELS

STUB

PREMIUM HSS KOBALT, HPD SPIRALBOHRER für STÄHLE
Forets HPD HSSCo Premium pour Aciers, série extra-courte
PUNTE ELICOIDALI HPD IN PREMIUM HSS Co, PER ACCIAI

EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

▶**Application** : Designed for accurate drilling on NC/CNC machines. Drilling hard and tough materials, alloyed tool steels, inconel, nimonic, cast iron, aluminum die casting, etc.

▶**Advantage** : Helical thinning - good chip removal, self-centering, reducing thrust and improving accuracy.
Reinforced web and stub length - increasing rigidity, reducing vibration and deflection.
Premium Cobalt HSS with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity

▶**Anwendung** : Für präzises Bohren mit NC/CNC Maschinen, geeignet zum Bearbeiten von harten und zähen Werkstücken, Legierungen, Werkzeugstahl, Nimonic, Inconel, Gusseisen, Aluminium-Guss usw.

▶**Vorteile** : Durch Kreuzanschliff gute Spanentfernung, reduzierter Druck, verbesserte Genauigkeit, selbstzentriert, extra kurze Ausführung, verbesserte Stabilität, weniger Vibrationen und Abdrängung, Premium Kobalt HSS mit hochwertiger TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Oberflächengüte und Produktivität.

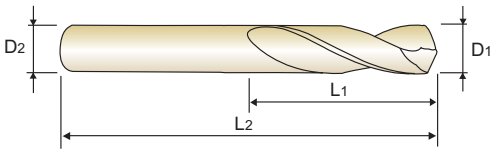




under 4mm



4mm & over



D1=D2

HSS Co8 | 25° | h7 | h8 | 130° | TiN

p.A189

Recommended ToolHolder: Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4541020	2.00	12	44
D4541920	2.05	12	44
D4541021	2.10	12	44
D4541921	2.15	13	45
D4541022	2.20	13	45
D4541922	2.25	13	45
D4541023	2.30	13	45
D4541923	2.35	13	45
D4541024	2.40	14	46
D4541924	2.45	14	46
D4541025	2.50	14	46
D4541925	2.55	14	46
D4541026	2.60	14	46
D4541926	2.65	14	46
D4541027	2.70	16	48
D4541927	2.75	16	48
D4541028	2.80	16	48
D4541928	2.85	16	48
D4541029	2.90	16	48
D4541929	2.95	16	48
D4541030	3.00	16	48
D4541930	3.05	18	50

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4541031	3.10	18	50
D4541931	3.15	18	50
D4541032	3.20	18	50
D4541932	3.25	18	50
D4541033	3.30	18	50
D4541933	3.35	18	50
D4541034	3.40	20	52
D4541934	3.45	20	52
D4541035	3.50	20	52
D4541935	3.55	20	52
D4541036	3.60	20	52
D4541936	3.65	20	52
D4541037	3.70	20	52
D4541937	3.75	20	52
D4541038	3.80	22	54
D4541938	3.85	22	54
D4541039	3.90	22	54
D4541939	3.95	22	54
D4541040	4.00	22	54
D4541940	4.05	22	66
D4541041	4.10	22	66
D4541941	4.15	22	66

▶ TiCN(D7541), TiAlN(DQ541) are available on your request.

▶ 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																					

HPD DRILLS

D4541 SERIES

HSS Co8, HPD TWIST DRILLS for STEELS

STUB

PREMIUM HSS KOBALT, HPD SPIRALBOHRER für STÄHLE — EXTRA KURZ
Forets HPD HSSCo Premium pour Aciers, série extra-courte — EXTRA-COURTE
PUNTE ELICOIDALI HPD IN PREMIUM HSS Co, PER ACCIAI — EXTRA CORTA

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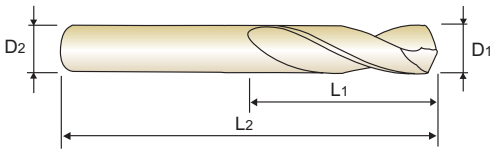

$D_1=D_2$

HSS Co8 | 25° | h7 | h8 | 130° | TiN

p.A189

Recommended ToolHolder: Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
D4541042	4.20	22	66
D4541942	4.25	22	66
D4541043	4.30	24	68
D4541943	4.35	24	68
D4541044	4.40	24	68
D4541944	4.45	24	68
D4541045	4.50	24	68
D4541945	4.55	24	68
D4541046	4.60	24	68
D4541946	4.65	24	68
D4541047	4.70	24	68
D4541947	4.75	24	68
D4541048	4.80	26	70
D4541948	4.85	26	70
D4541049	4.90	26	70
D4541949	4.95	26	70
D4541050	5.00	26	70
D4541950	5.05	26	70
D4541051	5.10	26	70
D4541951	5.15	26	70
D4541052	5.20	26	70
D4541952	5.25	26	70

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
D4541053	5.30	26	70
D4541953	5.35	28	72
D4541054	5.40	28	72
D4541954	5.45	28	72
D4541055	5.50	28	72
D4541955	5.55	28	72
D4541056	5.60	28	72
D4541956	5.65	28	72
D4541057	5.70	28	72
D4541957	5.75	28	72
D4541058	5.80	28	72
D4541958	5.85	28	72
D4541059	5.90	28	72
D4541959	5.95	28	72
D4541060	6.00	28	72
D4541061	6.10	31	75
D4541062	6.20	31	75
D4541063	6.30	31	75
D4541064	6.40	31	75
D4541065	6.50	31	75
D4541965	6.55	31	75
D4541066	6.60	31	75

▶ TiCN(D7541), TiAlN(DQ541) are available on your request.

▶ 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																					

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YG-1 CO., LTD.

HSS Co8, HPD TWIST DRILLS for STEELS

STUB

PREMIUM HSS KOBALT, HPD SPIRALBOHRER für STÄHLE
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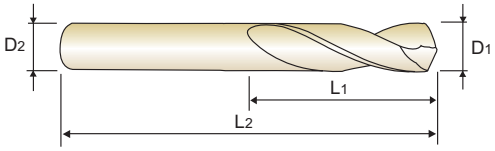

D1=D2

HSS Co8 | 25° | h7 | h8 | 130° | TiN

p.A189

Recommended ToolHolder: Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4541966	6.65	31	75
D4541067	6.70	31	75
D4541068	6.80	34	78
D4541069	6.90	34	78
D4541070	7.00	34	78
D4541071	7.10	34	78
D4541072	7.20	34	78
D4541073	7.30	34	78
D4541973	7.35	34	78
D4541074	7.40	34	78
D4541075	7.50	34	78
D4541975	7.55	37	81
D4541076	7.60	37	81
D4541976	7.65	37	81
D4541077	7.70	37	81
D4541078	7.80	37	81
D4541079	7.90	37	81
D4541080	8.00	37	81
D4541081	8.10	37	87
D4541082	8.20	37	87
D4541083	8.30	37	87
D4541983	8.35	37	87

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
D4541084	8.40	37	87
D4541085	8.50	37	87
D4541985	8.55	40	90
D4541086	8.60	40	90
D4541986	8.65	40	90
D4541087	8.70	40	90
D4541088	8.80	40	90
D4541089	8.90	40	90
D4541090	9.00	40	90
D4541091	9.10	40	90
D4541092	9.20	40	90
D4541992	9.25	40	90
D4541093	9.30	40	90
D4541993	9.35	40	90
D4541094	9.40	40	90
D4541994	9.45	40	90
D4541095	9.50	40	90
D4541995	9.55	43	93
D4541096	9.60	43	93
D4541996	9.65	43	93
D4541097	9.70	43	93
D4541098	9.80	43	93

▶ TiCN(D7541), TiAlN(DQ541) are available on your request.

▶ 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																					

HPD DRILLS

D4541 SERIES

HSS Co8, HPD TWIST DRILLS for STEELS

STUB

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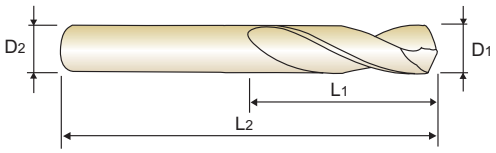

$D_1=D_2$

HSS Co8 | 25° | h7 | h8 | 130° | TiN

p.A189

Recommended ToolHolder: Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
D4541099	9.90	43	93
D4541999	9.95	43	93
D4541100	10.00	43	93
D4541101	10.10	43	100
D4541102	10.20	43	100
D4541802	10.25	43	100
D4541103	10.30	43	100
D4541803	10.35	43	100
D4541104	10.40	43	100
D4541105	10.50	43	100
D4541805	10.55	43	100
D4541106	10.60	43	100
D4541806	10.65	47	104
D4541107	10.70	47	104
D4541108	10.80	47	104
D4541109	10.90	47	104
D4541809	10.95	47	104
D4541110	11.00	47	104
D4541111	11.10	47	104
D4541112	11.20	47	104
D4541812	11.25	47	104
D4541113	11.30	47	104

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
D4541813	11.35	47	104
D4541114	11.40	47	104
D4541115	11.50	47	104
D4541815	11.55	47	104
D4541116	11.60	47	104
D4541117	11.70	47	104
D4541118	11.80	47	104
D4541119	11.90	51	108
D4541120	12.00	51	108
D4541121	12.10	51	108
D4541122	12.20	51	108
D4541123	12.30	51	108
D4541124	12.40	51	108
D4541125	12.50	51	108
D4541126	12.60	51	108
D4541127	12.70	51	108
D4541128	12.80	51	108
D4541129	12.90	51	108
D4541130	13.00	51	108

▶ TiCN(D7541), TiAlN(DQ541) are available on your request.

◎ : 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																					

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