HPD DRILLS

DJ544 SERIES

HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

JOBBER

HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE — **KURZ**
Forets HPD-SUS HSS-E pour INOX, série courte — **COURTE**
PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX — **CORTA**

▶**Application** : Designed for 4D~5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.

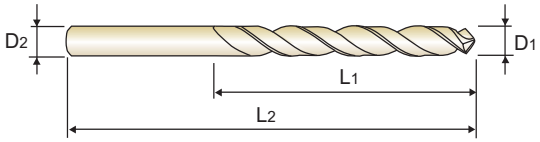
▶**Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D~5D drilling.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.

▶**Anwendung** : Für 4D~5D Bohrtiefe, geeignet für rostfreier stähle, Stahl, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierung usw.

▶**Vorteile** : Helixwinkel, durch scharfe Hauptschneide wird Spanstau vermieden, geeignet zum Hochleistungsbohren, verstärkte Kerndicke, kurze Ausführung, Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Stabilität, Oberflächengüte und Produktivität.



up to 13mm over 13mm



for STAINLESS STEELS
für rostfreier Stäle

$D_1=D_2$

HSS-E | 38° | h7 | h8 | 130° | 120° | TiN

up to 4mm over 4mm

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Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544020	2.00	24	56
DJ544021	2.10	24	56
DJ544022	2.20	27	59
DJ544023	2.30	27	59
DJ544024	2.40	30	62
DJ544025	2.50	30	62
DJ544026	2.60	30	62
DJ544027	2.70	33	65
DJ544028	2.80	33	65
DJ544029	2.90	33	65
DJ544030	3.00	33	65
DJ544031	3.10	36	68
DJ544032	3.20	36	68
DJ544033	3.30	36	68
DJ544034	3.40	39	71
DJ544035	3.50	39	71
DJ544036	3.60	39	71
DJ544037	3.70	39	71
DJ544038	3.80	43	75
DJ544039	3.90	43	75
DJ544040	4.00	43	75
DJ544041	4.10	43	87

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544042	4.20	43	87
DJ544043	4.30	47	91
DJ544044	4.40	47	91
DJ544045	4.50	47	91
DJ544046	4.60	47	91
DJ544047	4.70	47	91
DJ544048	4.80	52	96
DJ544049	4.90	52	96
DJ544050	5.00	52	96
DJ544051	5.10	52	96
DJ544052	5.20	52	96
DJ544053	5.30	52	96
DJ544054	5.40	57	101
DJ544055	5.50	57	101
DJ544056	5.60	57	101
DJ544057	5.70	57	101
DJ544058	5.80	57	101
DJ544059	5.90	57	101
DJ544060	6.00	57	101
DJ544061	6.10	63	107
DJ544062	6.20	63	107
DJ544063	6.30	63	107

▶ TiCN(DW544), TiAlN(DY544) 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	◎	◎				○															

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

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COURTE

PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX

CORTA

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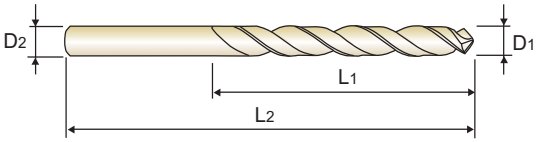
up to 13mm over 13mm



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für rostfreier Stäle

HSS-E | 38° | h7 | h8 | 130° | 120° | TiN

up to 4mm over 4mm

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$D_1=D_2$

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Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544064	6.40	63	107
DJ544065	6.50	63	107
DJ544066	6.60	63	107
DJ544067	6.70	63	107
DJ544068	6.80	69	113
DJ544069	6.90	69	113
DJ544070	7.00	69	113
DJ544071	7.10	69	113
DJ544072	7.20	69	113
DJ544073	7.30	69	113
DJ544074	7.40	69	113
DJ544075	7.50	69	113
DJ544076	7.60	75	119
DJ544077	7.70	75	119
DJ544078	7.80	75	119
DJ544079	7.90	75	119
DJ544080	8.00	75	119
DJ544081	8.10	75	125
DJ544082	8.20	75	125
DJ544083	8.30	75	125
DJ544084	8.40	75	125
DJ544085	8.50	75	125

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544086	8.60	81	131
DJ544087	8.70	81	131
DJ544088	8.80	81	131
DJ544089	8.90	81	131
DJ544090	9.00	81	131
DJ544091	9.10	81	131
DJ544092	9.20	81	131
DJ544093	9.30	81	131
DJ544094	9.40	81	131
DJ544095	9.50	81	131
DJ544096	9.60	87	137
DJ544097	9.70	87	137
DJ544098	9.80	87	137
DJ544099	9.90	87	137
DJ544100	10.00	87	137
DJ544101	10.10	87	144
DJ544102	10.20	87	144
DJ544103	10.30	87	144
DJ544104	10.40	87	144
DJ544105	10.50	87	144
DJ544106	10.60	87	144
DJ544107	10.70	94	151

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▶ NEXT PAGE

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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	
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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			
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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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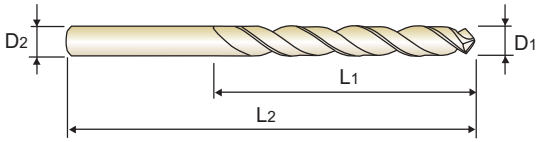

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Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544108	10.80	94	151
DJ544109	10.90	94	151
DJ544110	11.00	94	151
DJ544111	11.10	94	151
DJ544112	11.20	94	151
DJ544113	11.30	94	151
DJ544114	11.40	94	151
DJ544115	11.50	94	151
DJ544116	11.60	94	151
DJ544117	11.70	94	151
DJ544118	11.80	94	151
DJ544119	11.90	101	158
DJ544120	12.00	101	158
DJ544121	12.10	101	158
DJ544122	12.20	101	158
DJ544123	12.30	101	158
DJ544124	12.40	101	158
DJ544125	12.50	101	158
DJ544126	12.60	101	158
DJ544127	12.70	101	158
DJ544128	12.80	101	158
DJ544129	12.90	101	158

EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D_1	L_1	L_2
DJ544130	13.00	101	158
DJ544135	13.50	106	166
DJ544140	14.00	106	166
DJ544141	14.10	109	169
DJ544145	14.50	109	169
DJ544150	15.00	109	169
DJ544155	15.50	112	172
DJ544156	15.60	112	172
DJ544160	16.00	112	172
DJ544165	16.50	115	181
DJ544170	17.00	115	181
DJ544175	17.50	118	184
DJ544176	17.60	118	184
DJ544180	18.00	118	184
DJ544185	18.50	122	188
DJ544190	19.00	122	188
DJ544195	19.50	125	191
DJ544196	19.60	125	191
DJ544200	20.00	125	191

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