i - ONE DRILLS

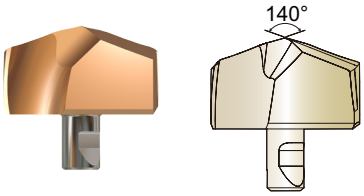
Y181H SERIES

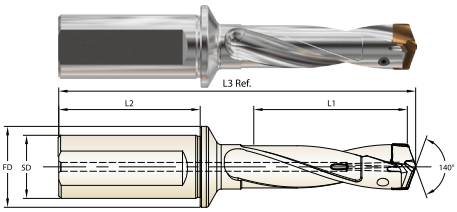
i-ONE DRILL INSERTS & HOLDERS

i-ONE DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE i-ONE DRILL
INSERTI & PORTAINSERTI i-ONE DRILL

- Applications
▶For carbon steels, alloy steels and cast iron.
▶Holder length: 3xD, 5xD, 8xD
- Benefits
▶Secure and quick clamping system.
▶High performance with cost efficiency.
▶Multi-layered coating delivers outstanding productivity and reliability.

- Anwendungen
▶Für Kohlenstoffstähle, legierte Stähle und Gusseisen.
▶Halterlänge: 3xD, 5xD, 8xD
- Vorteile
▶Sicheres und schnelles Spannsystem.
▶Hohe Leistungsfähigkeit bei gleichzeitiger Kosteneffizienz.
▶Mehrschichtige Beschichtung bietet hervorragende Produktivität und Zuverlässigkeit.





FULL-FLAT SHANK

CARBIDE | ISO 9766 | h7 | 140° | H Coating

p.A34

Recommended ToolHolder: Flat Shank — INDEXABLE DRILL HOLDER; ER COLLET CHUCK

Unit : mm

Series Range	Insert EDP No.	Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth		Overall Length	Screw No.
(mm)	H-Coating	h7										
		dec.	frac.	mm		SD	L_2	FD		L_1	L_3 Ref.	
S18 Ø18.00 to Ø19.99	Y181H1800	0.7087	-	18.00	ZD18003025	25	56	32	3D	57.0	141.3	TX1819P9
	Y181H1810	0.7126	-	18.10								
	Y181H1820	0.7165	-	18.20								
	Y181H1826	0.7188	23/32	18.26								
	Y181H1830	0.7205	-	18.30	ZD18005025				5D	95.0	178.3	
	Y181H1840	0.7244	-	18.40								
	Y181H1850	0.7283	-	18.50								
	Y181H1860	0.7323	-	18.60								
	Y181H1865	0.7344	47/64	18.65	ZD18008025				8D	152.0	233.8	
	Y181H1870	0.7362	-	18.70								
	Y181H1880	0.7402	-	18.80								
	Y181H1890	0.7441	-	18.90								
	Y181H1900	0.7480	-	19.00	ZD19003025	25	56	32	3D	60.0	145.3	TX1920P9
	Y181H1905	0.7500	3/4	19.05								
	Y181H1910	0.7520	-	19.10								
	Y181H1920	0.7559	-	19.20								
	Y181H1927	0.7587	-	19.27	ZD19005025				5D	100.0	184.3	
	Y181H1930	0.7598	-	19.30								
	Y181H1940	0.7638	-	19.40								
	Y181H1945	0.7656	49/64	19.45								
	Y181H1950	0.7677	-	19.50								
	Y181H1960	0.7717	-	19.60	ZD19008025				8D	160.0	242.8	
	Y181H1970	0.7756	-	19.70								
	Y181H1980	0.7795	-	19.80								
	Y181H1984	0.7813	25/32	19.84								
	Y181H1990	0.7835	-	19.90								

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Duplex	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	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	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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