i - DREAM DRILLS

YA1A SERIES
YA2C SERIES

i-DREAM DRILL INSERTS & HOLDERS

i-DREAM DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

- Features of *i-Dream Drill* Inserts-
Merkmale des i-Dream Drill Einsätze

▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.

i-Dream Drill ***General*** */ i-Dream Drill* ***allgemeinen***

▶ For most steels materials / In den meisten Stahlsorten

i-Dream Drill ***INOX*** */ i-Dream Drill* ***INOX***

▶ For tough, ductile materials and stainless steels
Für zähe, verformbare Werkstoffe und rostfreie Stähle.
▶ Light, sharp cutting edge / Scharfe Schneidkante
▶ Soft cutting action / Weicher Schnitt
▶ Minimize cutting forces / Minimaler Schneidendruck
▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

▶ Special Alloy Steels maintain its hardness and toughness under high temperatures.
Speziell legierter Stahl, der seine Härte und Zähigkeit auch bei hohen Temperaturen behält.
▶ Innovative surface treatment improves wear resistance and reduces corrosion.
Innovative Oberflächenbehandlung, die die Verschleissfestigkeit erhöht und die Korrosion vermindert.
▶ High Performance flute design allows maximum chip evacuation and minimum interference.
Optimierte Nutenform für maximale Spanabfuhr.



CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

p.A54, A55

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

Unit : mm

Series Range (mm)	Insert EDP No. General (TiAlN)	Insert EDP No. INOX (TiCN)	Insert O.D. h7 dec.	Insert O.D. h7 frac.	Insert O.D. h7 mm	Holder EDP No.	Shank Dia. SD	Shank Length L2	Flange Dia. FD	Drilling Depth	L1	Overall Length L3 Ref.	Screw No.
A Ø12.00 to Ø13.99	YA1A1200	YA2C1200	.4724	-	12.00	ZH12003020	20	50	25	3D	36	112.4	TX1213T08
	YA1A1210	YA2C1210	.4764	-	12.10								
	YA1A1220	YA2C1220	.4803	-	12.20	ZH12005020				5D	60	136.4	
	YA1A1230	YA2C1230	.4844	31/64	12.30	ZH12007020				7D	84	160.4	
	YA1A1250	YA2C1250	.4921	-	12.50	ZH12503020	20	50	25	3D	37.5	113.4	
	YA1A1260	YA2C1260	.4961	-	12.60								
	YA1A1270	YA2C1270	.5000	1/2	12.70	ZH12505020				5D	62.5	138.4	
	YA1A1280	YA2C1280	.5039	-	12.80								
	YA1A1290	YA2C1290	.5079	-	12.90	ZH12507020				7D	87.5	163.4	
	YA1A1300	YA2C1300	.5118	-	13.00	ZH13003020	20	50	25	3D	39	115.4	TX1314T08
	YA1A1310	YA2C1310	.5156	33/64	13.10								
	YA1A1320	YA2C1320	.5197	-	13.20	ZH13005020				5D	65	141.4	
	YA1A1349	YA2C1349	.5312	17/32	13.49	ZH13007020				7D	91	167.4	
	YA1A1350	YA2C1350	.5315	-	13.50	ZH13503020	20	50	25	3D	40.5	116.4	
	YA1A1360	YA2C1360	.5354	-	13.60								
	YA1A1370	YA2C1370	.5394	-	13.70	ZH13505020				5D	67.5	143.4	
	YA1A1380	YA2C1380	.5433	-	13.80								
	YA1A1389	YA2C1389	.5469	35/64	13.89	ZH13507020				7D	94.5	170.4	

▶ 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			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
YA1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YA2C	○	○	○	○		○	○			○		◎	◎	◎						

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
YA1A																					
YA2C	○	○	○	○	○	○	○	○													