# i - DREAM DRILLS

**YI1A SERIES**
**YI2C 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**

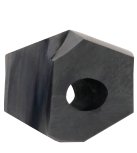
▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.

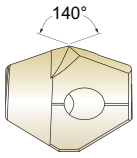
*i-Dream Drill* ***General*** */ i-Dream Drill* ***allgemeinen***
▶ For most steels materials / In den meisten Stahlsorten

*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

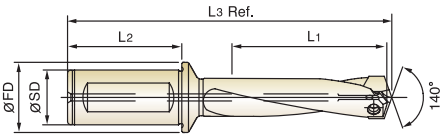
**- Features of *i-Dream Drill* Holders-**
**- Merkmale des i-Dresm Drill Halters-**

▶ 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 |
|---|---|---|---|---|---|
| I Ø28.00 to Ø29.99 | YI1A2800 | YI2C2800 | 1.1024 | - | 28.00 |
| | YI1A2818 | YI2C2818 | 1.1094 | 1-7/64 | 28.18 |
| | YI1A2850 | YI2C2850 | 1.1220 | - | 28.50 |
| | YI1A2858 | YI2C2858 | 1.1250 | 1-1/8 | 28.58 |
| | YI1A2900 | YI2C2900 | 1.1417 | - | 29.00 |
| | YI1A2937 | YI2C2937 | 1.1562 | 1-5/32 | 29.37 |
| | YI1A2950 | YI2C2950 | 1.1614 | - | 29.50 |
| | YI1A2977 | YI2C2977 | 1.1719 | 1-11/64 | 29.77 |

| Holder EDP No. | Shank Dia. SD | Shank Length L2 | Flange Dia. FD | Drilling Depth L1 | | Overall Length L3 Ref. | Screw No. |
|---|---|---|---|---|---|---|---|
| ZH28003032 | 32 | 60 | 37 | 3D | 84 | 178.2 | TX2829T25 |
| ZH28005032 | | | | 5D | 140 | 234.2 | |
| ZH28007032 | | | | 7D | 196 | 290.2 | |
| ZH28503032 | 32 | 60 | 37 | 3D | 85.5 | 179.2 | |
| ZH28505032 | | | | 5D | 142.5 | 236.2 | |
| ZH28507032 | | | | 7D | 199.5 | 293.2 | |
| ZH29003032 | 32 | 60 | 37 | 3D | 87 | 182.2 | TX2930T25 |
| ZH29005032 | | | | 5D | 145 | 240.2 | |
| ZH29007032 | | | | 7D | 203 | 298.2 | |
| ZH29503032 | 32 | 60 | 37 | 3D | 88.5 | 183.2 | |
| ZH29505032 | | | | 5D | 147.5 | 242.2 | |
| ZH29507032 | | | | 7D | 206.5 | 301.2 | |

▶ 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 |
| YI1A | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ |
| YI2C | ○ | ○ | ○ | ○ | | ○ | ○ | | | ○ | | ◎ | ◎ | ◎ | | | | | | |

| 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 |
| YI1A | | | | | | | | | | | | | | | | | | | | | |
| YI2C | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | | | | | | | | | | | |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