

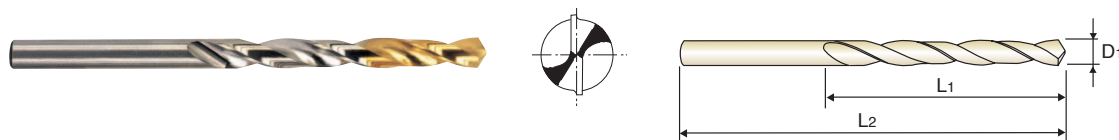
**HSS STRAIGHT SHANK DRILLS, GOLD-P COATED**  
**HSS SPIRALBOHRER, GOLD-P BESCHICHTET**

**JOBBER**

**KURZ**

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 118°, Split point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Drilling steels, Cast steels alloyed and Non-alloyed, Grey cast iron, Graphite, Malleable cast iron

- ▶ **Nutenform** : Rechtsspirale
- ▶ **Spitzenwinkel** : 118° Kreuzanschliff
- ▶ **Oberfläche** : Blank mit TiN-Beschichtung im Arbeitsbereich
- ▶ **Anwendung** : Stahl, legierter und unlegierter Stahlguss, Grauguss, Graphit, Temperguss



Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP165016	1.6	20	43	D1GP165046	4.6	47	80
D1GP165017	1.7	20	43	D1GP165047	4.7	47	80
D1GP165018	1.8	22	46	D1GP165048	4.8	52	86
D1GP165019	1.9	22	46	D1GP165049	4.9	52	86
D1GP165020	2.0	24	49	D1GP165050	5.0	52	86
D1GP165021	2.1	24	49	D1GP165051	5.1	52	86
D1GP165022	2.2	27	53	D1GP165052	5.2	52	86
D1GP165023	2.3	27	53	D1GP165053	5.3	52	86
D1GP165024	2.4	30	57	D1GP165054	5.4	57	93
D1GP165025	2.5	30	57	D1GP165055	5.5	57	93
D1GP165026	2.6	30	57	D1GP165056	5.6	57	93
D1GP165027	2.7	33	61	D1GP165057	5.7	57	93
D1GP165028	2.8	33	61	D1GP165058	5.8	57	93
D1GP165029	2.9	33	61	D1GP165059	5.9	57	93
D1GP165030	3.0	33	61	D1GP165060	6.0	57	93
D1GP165031	3.1	36	65	D1GP165061	6.1	63	101
D1GP165032	3.2	36	65	D1GP165062	6.2	63	101
D1GP165033	3.3	36	65	D1GP165063	6.3	63	101
D1GP165034	3.4	39	70	D1GP165064	6.4	63	101
D1GP165035	3.5	39	70	D1GP165065	6.5	63	101
D1GP165036	3.6	39	70	D1GP165066	6.6	63	101
D1GP165037	3.7	39	70	D1GP165067	6.7	63	101
D1GP165038	3.8	43	75	D1GP165068	6.8	69	109
D1GP165039	3.9	43	75	D1GP165069	6.9	69	109
D1GP165040	4.0	43	75	D1GP165070	7.0	69	109
D1GP165041	4.1	43	75	D1GP165071	7.1	69	109
D1GP165042	4.2	43	75	D1GP165072	7.2	69	109
D1GP165043	4.3	47	80	D1GP165073	7.3	69	109
D1GP165044	4.4	47	80	D1GP165074	7.4	69	109
D1GP165045	4.5	47	80	D1GP165075	7.5	69	109

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○	○			



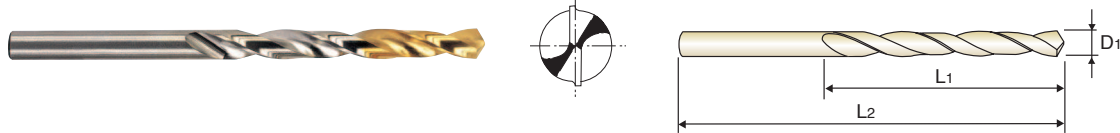
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Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1GP165076	7.6	75	117	D1GP165104	10.4	87	133
D1GP165077	7.7	75	117	D1GP165105	10.5	87	133
D1GP165078	7.8	75	117	D1GP165106	10.6	87	133
D1GP165079	7.9	75	117	D1GP165107	10.7	94	142
D1GP165080	8.0	75	117	D1GP165108	10.8	94	142
D1GP165081	8.1	75	117	D1GP165109	10.9	94	142
D1GP165082	8.2	75	117	D1GP165110	11.0	94	142
D1GP165083	8.3	75	117	D1GP165111	11.1	94	142
D1GP165084	8.4	75	117	D1GP165112	11.2	94	142
D1GP165085	8.5	75	117	D1GP165113	11.3	94	142
D1GP165086	8.6	81	125	D1GP165114	11.4	94	142
D1GP165087	8.7	81	125	D1GP165115	11.5	94	142
D1GP165088	8.8	81	125	D1GP165116	11.6	94	142
D1GP165089	8.9	81	125	D1GP165117	11.7	94	142
D1GP165090	9.0	81	125	D1GP165118	11.8	94	142
D1GP165091	9.1	81	125	D1GP165119	11.9	101	151
D1GP165092	9.2	81	125	D1GP165120	12.0	101	151
D1GP165093	9.3	81	125	D1GP165121	12.1	101	151
D1GP165094	9.4	81	125	D1GP165122	12.2	101	151
D1GP165095	9.5	81	125	D1GP165123	12.3	101	151
D1GP165096	9.6	87	133	D1GP165124	12.4	101	151
D1GP165097	9.7	87	133	D1GP165125	12.5	101	151
D1GP165098	9.8	87	133	D1GP165126	12.6	101	151
D1GP165099	9.9	87	133	D1GP165127	12.7	101	151
D1GP165100	10.0	87	133	D1GP165128	12.8	101	151
D1GP165101	10.1	87	133	D1GP165129	12.9	101	151
D1GP165102	10.2	87	133	D1GP165130	13.0	101	151
D1GP165103	10.3	87	133				

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○	○			



### GOLD-P COATED DRILLS GOLD-P BESCHICHTET BOHRER

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

### D1GP125, D1GP165, DLGP195 SERIES

WORK MATERIAL	CARBON STEELS		CARBON STEELS		ALLOY STEELS		STAINLESS STEELS		TITANIUM ALLOYS		ALUMINUM ALLOYS, ZINC ALLOYS		MAGNESIUM ALLOYS	
	N	S	N	S	N	S	N	S	N	S	N	S	N	S
HARDNESS			~ HRC23		~ HRC23 ~ 34		HRC23							
STRENGTH	~ 570 N/mm <sup>2</sup>		~ 830 N/mm <sup>2</sup>		810 ~ 1110 N/mm <sup>2</sup>		~ 830 N/mm <sup>2</sup>		~ 410 N/mm <sup>2</sup>					
DRILLING SPEED	35 ~ 45 m/min		30 ~ 40 m/min		20 ~ 25 m/min		20 ~ 25 m/min		20 ~ 25 m/min		85 ~ 95 m/min		30 ~ 35 m/min	
D1GP125	14000	0.02	12500	0.02	7700	0.02	7000	0.02	8050	0.02	30000	0.02	11500	0.03
D1GP165	7000	0.06	6100	0.06	3850	0.06	3500	0.06	4050	0.06	15000	0.06	5800	0.09
DLGP195	4650	0.10	4100	0.08	2550	0.08	2350	0.08	2700	0.08	9900	0.10	3850	0.13
	3500	0.11	3050	0.11	1950	0.10	1750	0.10	2000	0.09	7450	0.11	2900	0.15
	2800	0.12	2450	0.11	1550	0.10	1400	0.10	1600	0.10	5950	0.12	2300	0.17
	2350	0.14	2050	0.13	1300	0.12	1150	0.12	1350	0.12	4950	0.14	1950	0.19
	2000	0.16	1750	0.15	1100	0.14	1000	0.14	1150	0.14	4250	0.16	1650	0.22
	1750	0.18	1550	0.18	960	0.15	875	0.15	1000	0.15	3700	0.18	1450	0.24
	1550	0.20	1350	0.22	855	0.18	780	0.18	895	0.17	3300	0.20	1280	0.27
	1400	0.21	1250	0.22	770	0.18	700	0.18	805	0.18	3000	0.23	1150	0.29
	1250	0.22	1100	0.22	700	0.18	650	0.18	730	0.18	2700	0.23	1050	0.30
	1150	0.23	1000	0.22	650	0.20	585	0.20	670	0.20	2480	0.23	960	0.31
	1050	0.23	950	0.22	595	0.20	540	0.20	620	0.20	2300	0.23	890	0.31

N = R.P.M

S = Feed per Revolution (mm/rev.)

### GOLD-P COATED DRILLS for DEEP HOLES GOLD-P BESCHICHTET BOHRER für TIEFLOCH MIT ZYLINDERSCHAFT

### DLGP506 SERIES

WORK MATERIAL	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
	N	S	N	S	N	S	N	S
HARDNESS	HRC15 ~ 30		HRC20 ~ 40					
STRENGTH	700 ~ 1000 N/mm <sup>2</sup>		800 ~ 1200 N/mm <sup>2</sup>					
DRILLING SPEED	23 ~ 28 m/min		15 ~ 20 m/min		40 ~ 50 m/min		25 ~ 30 m/min	
D1GP506	8750	0.02	6300	0.02	16000	0.02	9800	0.02
	4400	0.06	3150	0.06	7900	0.07	4900	0.07
	2900	0.08	2100	0.08	5250	0.11	3250	0.11
	2200	0.09	1600	0.09	3950	0.14	2450	0.14
	1750	0.10	1250	0.10	3150	0.14	1950	0.14
	1450	0.12	1050	0.12	2650	0.18	1650	0.18
	1250	0.14	900	0.14	2250	0.20	1400	0.20
	1100	0.15	790	0.15	1950	0.22	1250	0.22
	975	0.17	700	0.17	1750	0.24	1100	0.24
	875	0.18	630	0.18	1600	0.28	980	0.28
	800	0.20	575	0.20	1450	0.28	890	0.28
	730	0.20	525	0.20	1300	0.28	815	0.28
	675	0.20	485	0.20	1200	0.28	755	0.28

N = R.P.M

S = Feed per Revolution (mm/rev.)