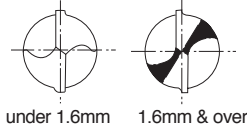


**GOLD-P  
DRILL  
D1GP165SET2**

**HSS STRAIGHT SHANK, DIN 338, SPLIT POINT - General Purpose**

HSS-Spiralbohrer, DIN 338, Kreuzanschliff - Universeller Einsatzbereich  
 FORET HSS QUEUE LISSE, DIN 338, AFFUTAGE EN CROIX - Usage Général  
 PUNTA HSS CODOLO CILINDRICO, DIN 338, AUTOCENTRANTE, PARZIAL - Impieghi generali  
 HSS MANGO CILINDRICO, DIN 338, SPLIT POINT - Operaciones estándar

Coated

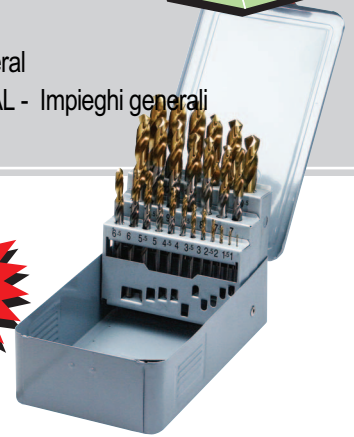


under 1.6mm 1.6mm & over

unit:mm

EDP No.	SIZE	Pcs
D1GP165SET2	1.0 - 13.0 X 0.5mm step	25

**25  
PCS**



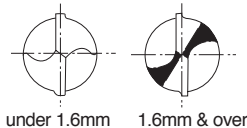
**DRILL  
SET**

**GOLD-P  
DRILL  
DLGP195SET2**

**HSS Co5 STRAIGHT SHANK, DIN 338, SPLIT POINT - General Purpose**

HSS Co5 Spiralbohrer, DIN 338, Kreuzanschliff - Universeller Einsatzbereich  
 FORET HSS Co5 QUEUE LISSE, DIN 338, AFFUTAGE EN CROIX - Usage Général  
 PUNTA HSS Co5, CODOLO CILINDRICO, DIN 338, AUTOCENTRANTE, PARZIAL - Impieghi generali  
 HSS Co5 MANGO CILINDRICO, DIN 338, SPLIT POINT - Operaciones estándar

Coated



under 1.6mm 1.6mm & over

unit:mm

EDP No.	SIZE	Pcs
DLGP195SET2	1.0 - 13.0 X 0.5mm step	25

**25  
PCS**



**TAP  
SET**

**COMBO TAP  
TC804SET7**

**HSS-E, DIN 371/376 SPIRAL FLUTE - Multi-Purpose**

HSS-E, DIN 371/376 spiralisierte Ausführung - Universeller Einsatzbereich  
 HSS-E, DIN 371/376 TARAUD HELICOÏDAL - Multi-Usage  
 HSS-E, DIN 371/376, ELICOIDALE - Impieghi generali  
 HSS-E, DIN 371/376 HELICOIDAL - Multioperaciones



unit:mm

EDP No.	SIZE PITCH	LIMIT	OVERALL LENGTH	THREAD LENGTH	SHANK DIAMETER	SQUARE SIZE	Pcs
TC804206	M3 x 0.5	6H	56	6	3.5	2.7	1
TC804246	M4 x 0.7	6H	63	7	4.5	3.4	1
TC804286	M5 x 0.8	6H	70	8	6	4.9	1
TC804316	M6 x 1.0	6H	80	10	6	4.9	1
TC804366	M8 x 1.25	6H	90	13	8	6.2	1
TC804426	M10 x 1.5	6H	100	15	10	8	1
TC804506	M12 x 1.75	6H	110	18	9	7	1

**7  
PCS**



**GOLD-P COATED DRILL SETS**  
**GOLD-P BESCHICHTET BOHRER SATS**



**DIN338 DRILL SETS JOBBER LENGTH Gold-P coated Drills**

SET NO.	DESCRIPTON	SIZE	Q'TY
<b>D1GP165SET1</b>	HSS Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
<b>D1GP165SET2</b>	HSS Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
<b>D1GP165SET3</b>	HSS Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
<b>DLGP195SET1</b>	HSS-E Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
<b>DLGP195SET2</b>	HSS-E Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
<b>DLGP195SET3</b>	HSS-E Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
<b>DLGPSET982</b>	HSS-E Straight Shank, Split Point (∅1.0 & ∅1.5 : NORMAL point)	1.0-10.0x0.1mm step	91 pcs

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



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

#### 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
<b>HARDNESS</b>			~ HRC23		~ HRC23 ~ 34		HRC23							
<b>STRENGTH</b>	~ 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>					
<b>DRILLING SPEED</b>	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	
<b>DIAMETER</b>	N	S	N	S	N	S	N	S	N	S	N	S	N	S
1.0	14000	0.02	12500	0.02	7700	0.02	7000	0.02	8050	0.02	30000	0.02	11500	0.03
2.0	7000	0.06	6100	0.06	3850	0.06	3500	0.06	4050	0.06	15000	0.06	5800	0.09
3.0	4650	0.10	4100	0.08	2550	0.08	2350	0.08	2700	0.08	9900	0.10	3850	0.13
4.0	3500	0.11	3050	0.11	1950	0.10	1750	0.10	2000	0.09	7450	0.11	2900	0.15
5.0	2800	0.12	2450	0.11	1550	0.10	1400	0.10	1600	0.10	5950	0.12	2300	0.17
6.0	2350	0.14	2050	0.13	1300	0.12	1150	0.12	1350	0.12	4950	0.14	1950	0.19
7.0	2000	0.16	1750	0.15	1100	0.14	1000	0.14	1150	0.14	4250	0.16	1650	0.22
8.0	1750	0.18	1550	0.18	960	0.15	875	0.15	1000	0.15	3700	0.18	1450	0.24
9.0	1550	0.20	1350	0.22	855	0.18	780	0.18	895	0.17	3300	0.20	1280	0.27
10.0	1400	0.21	1250	0.22	770	0.18	700	0.18	805	0.18	3000	0.23	1150	0.29
11.0	1250	0.22	1100	0.22	700	0.18	650	0.18	730	0.18	2700	0.23	1050	0.30
12.0	1150	0.23	1000	0.22	650	0.20	585	0.20	670	0.20	2480	0.23	960	0.31
13.0	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
<b>HARDNESS</b>	HRC15 ~ 30		HRC20 ~ 40					
<b>STRENGTH</b>	700 ~ 1000 N/mm <sup>2</sup>		800 ~ 1200 N/mm <sup>2</sup>					
<b>DRILLING SPEED</b>	23 ~ 28 m/min		15 ~ 20 m/min		40 ~ 50 m/min		25 ~ 30 m/min	
<b>DIAMETER</b>	N	S	N	S	N	S	N	S
1.0	8750	0.02	6300	0.02	16000	0.02	9800	0.02
2.0	4400	0.06	3150	0.06	7900	0.07	4900	0.07
3.0	2900	0.08	2100	0.08	5250	0.11	3250	0.11
4.0	2200	0.09	1600	0.09	3950	0.14	2450	0.14
5.0	1750	0.10	1250	0.10	3150	0.14	1950	0.14
6.0	1450	0.12	1050	0.12	2650	0.18	1650	0.18
7.0	1250	0.14	900	0.14	2250	0.20	1400	0.20
8.0	1100	0.15	790	0.15	1950	0.22	1250	0.22
9.0	975	0.17	700	0.17	1750	0.24	1100	0.24
10.0	875	0.18	630	0.18	1600	0.28	980	0.28
11.0	800	0.20	575	0.20	1450	0.28	890	0.28
12.0	730	0.20	525	0.20	1300	0.28	815	0.28
13.0	675	0.20	485	0.20	1200	0.28	755	0.28

N = R.P.M

S = Feed per Revolution (mm/rev.)