



## 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 (Ø1.0 & Ø1.5 : NORMAL point)   | 1.0-10.0x0.5mm step                         | 19 pcs |
| <b>D1GP165SET2</b> | HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)   | 1.0-13.0x0.5mm step                         | 25 pcs |
| <b>D1GP165SET3</b> | HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)   | 1.0-10.5x0.5mm step<br>+3.3 +4.2 +6.8 +10.2 | 24 pcs |
| <b>DLGP195SET1</b> | HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point) | 1.0-10.0x0.5mm step                         | 19 pcs |
| <b>DLGP195SET2</b> | HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point) | 1.0-13.0x0.5mm step                         | 25 pcs |
| <b>DLGP195SET3</b> | HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point) | 1.0-10.5x0.5mm step<br>+3.3 +4.2 +6.8 +10.2 | 24 pcs |

**GOLD-P COATED DRILLS**  
**GOLD-P BESCHICHTET BOHRER**
**D1GP125, D1GP165, DLGP195 SERIES**

Unit : mm

| WORK MATERIAL | CARBON STEELS           |      | CARBON STEELS           |      | ALLOY STEELS                 |      | STAINLESS STEELS        |      | TITANIUM ALLOYS         |      | ALUMINUM ALLOYS, ZINC ALLOYS |      | MAGNESIUM ALLOYS |      |
|---------------|-------------------------|------|-------------------------|------|------------------------------|------|-------------------------|------|-------------------------|------|------------------------------|------|------------------|------|
| 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> |      |                              |      |                  |      |
| DIAMETER      | N                       | S    | N                       | S    | N                            | S    | N                       | S    | N                       | S    | N                            | S    | N                | S    |
| 1             | 14000                   | 0.02 | 12500                   | 0.02 | 7700                         | 0.02 | 7000                    | 0.02 | 8050                    | 0.02 | 30000                        | 0.02 | 11500            | 0.03 |
| 2             | 7000                    | 0.06 | 6100                    | 0.06 | 3850                         | 0.06 | 3500                    | 0.06 | 4050                    | 0.06 | 15000                        | 0.06 | 5800             | 0.09 |
| 3             | 4650                    | 0.10 | 4100                    | 0.08 | 2550                         | 0.08 | 2350                    | 0.08 | 2700                    | 0.08 | 9900                         | 0.10 | 3850             | 0.13 |
| 4             | 3500                    | 0.11 | 3050                    | 0.11 | 1950                         | 0.10 | 1750                    | 0.10 | 2000                    | 0.09 | 7450                         | 0.11 | 2900             | 0.15 |
| 5             | 2800                    | 0.12 | 2450                    | 0.11 | 1550                         | 0.10 | 1400                    | 0.10 | 1600                    | 0.10 | 5950                         | 0.12 | 2300             | 0.17 |
| 6             | 2350                    | 0.14 | 2050                    | 0.13 | 1300                         | 0.12 | 1150                    | 0.12 | 1350                    | 0.12 | 4950                         | 0.14 | 1950             | 0.19 |
| 7             | 2000                    | 0.16 | 1750                    | 0.15 | 1100                         | 0.14 | 1000                    | 0.14 | 1150                    | 0.14 | 4250                         | 0.16 | 1650             | 0.22 |
| 8             | 1750                    | 0.18 | 1550                    | 0.18 | 960                          | 0.15 | 875                     | 0.15 | 1000                    | 0.15 | 3700                         | 0.18 | 1450             | 0.24 |
| 9             | 1550                    | 0.20 | 1350                    | 0.22 | 855                          | 0.18 | 780                     | 0.18 | 895                     | 0.17 | 3300                         | 0.20 | 1280             | 0.27 |
| 10            | 1400                    | 0.21 | 1250                    | 0.22 | 770                          | 0.18 | 700                     | 0.18 | 805                     | 0.18 | 3000                         | 0.23 | 1150             | 0.29 |
| 11            | 1250                    | 0.22 | 1100                    | 0.22 | 700                          | 0.18 | 650                     | 0.18 | 730                     | 0.18 | 2700                         | 0.23 | 1050             | 0.30 |
| 12            | 1150                    | 0.23 | 1000                    | 0.22 | 650                          | 0.20 | 585                     | 0.20 | 670                     | 0.20 | 2480                         | 0.23 | 960              | 0.31 |
| 13            | 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**

Unit : mm

| WORK MATERIAL | CARBON STEELS<br>ALLOY STEELS |      | TOOL STEELS<br>HARDENED STEELS |      | SOFT GREY CAST IRON |      | HARD GREY CAST IRON |      |
|---------------|-------------------------------|------|--------------------------------|------|---------------------|------|---------------------|------|
| HARDNESS      | HRC15 ~ 30                    |      | HRC20 ~ 40                     |      |                     |      |                     |      |
| STRENGTH      | 700 ~ 1000 N/mm <sup>2</sup>  |      | 800 ~ 1200 N/mm <sup>2</sup>   |      |                     |      |                     |      |
| DIAMETER      | N                             | S    | N                              | S    | N                   | S    | N                   | S    |
| 1             | 8750                          | 0.02 | 6300                           | 0.02 | 16000               | 0.02 | 9800                | 0.02 |
| 2             | 4400                          | 0.06 | 3150                           | 0.06 | 7900                | 0.07 | 4900                | 0.07 |
| 3             | 2900                          | 0.08 | 2100                           | 0.08 | 5250                | 0.11 | 3250                | 0.11 |
| 4             | 2200                          | 0.09 | 1600                           | 0.09 | 3950                | 0.14 | 2450                | 0.14 |
| 5             | 1750                          | 0.10 | 1250                           | 0.10 | 3150                | 0.14 | 1950                | 0.14 |
| 6             | 1450                          | 0.12 | 1050                           | 0.12 | 2650                | 0.18 | 1650                | 0.18 |
| 7             | 1250                          | 0.14 | 900                            | 0.14 | 2250                | 0.20 | 1400                | 0.20 |
| 8             | 1100                          | 0.15 | 790                            | 0.15 | 1950                | 0.22 | 1250                | 0.22 |
| 9             | 975                           | 0.17 | 700                            | 0.17 | 1750                | 0.24 | 1100                | 0.24 |
| 10            | 875                           | 0.18 | 630                            | 0.18 | 1600                | 0.28 | 980                 | 0.28 |
| 11            | 800                           | 0.20 | 575                            | 0.20 | 1450                | 0.28 | 890                 | 0.28 |
| 12            | 730                           | 0.20 | 525                            | 0.20 | 1300                | 0.28 | 815                 | 0.28 |
| 13            | 675                           | 0.20 | 485                            | 0.20 | 1200                | 0.28 | 755                 | 0.28 |

N = R.P.M

S = Feed per Revolution (mm/rev.)