

**Burgije sa Izmjenjivim  
Segmentima**



**SELECTION GUIDE**



**HOLEMAKING TOOLS**

<b>COUNTERBORES</b>	
SERIES	EL950
TYPE	MEDIUM FINE
PILOT DIA.	3.4-140
CUTTER DIA.	3.2-130 6.0-200
PAGE	443
SURFACE TREATMENT	
	Bright



Please visit [www.yg1.com/next](http://www.yg1.com/next) for material search. Excellent Good

ISO	VDI	Material Description	HB	HRC
	1		125	
	2		190	13
	3	Non-alloy steel	250	25
	4		270	28
	5		300	32
	6		180	10
	7		275	29
	8	Low alloy steel	300	32
	9		350	38
	10	High alloyed steel, and tool steel	200	15
	11		325	35
	12		200	15
	13	Stainless steel	240	23
	14		180	10
	15	Grey cast iron	180	10
	16		260	26
	17	Nodular cast iron	160	3
	18		250	25
	19	Malleable cast iron	130	
	20		230	21
	21	Aluminum-wrought alloy	60	
	22		100	
	23	Aluminum-cast alloyed	75	
	24		90	
	25	Copper and Copper Alloys (Bronze / Brass)	130	
	26		110	
	27	Non Metallic Materials	90	
	28		100	
	29			
	30			
	31		200	15
	32	Heat Resistant Super Alloys	280	30
	33		250	25
	34		350	38
	35		320	34
	36	Titanium Alloys	400 Rm	
	37		1050 Rm	
	38	Hardened steel	550	55
	39	Chilled Cast Iron	630	60
	40	Hardened Cast Iron	400	42
	41		550	55

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**CARBIDE INSERTS & HOLDERS**

**i - ONE DRILLS**  
**i-One Drills**

- High Performance Exchangeable for General Steels and Cast Iron
- Leistungsstarke, austauschbare Bohrwerkzeuge für allgemeine Stähle und Gusseisen





**CENTER DRILLS**

**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**HSS & HSS-E, CENTER DRILLS**

**DV303, DV333, DV334, D1303, D1343, D1313, D1353, D1363, D1373, DV383 SERIES**

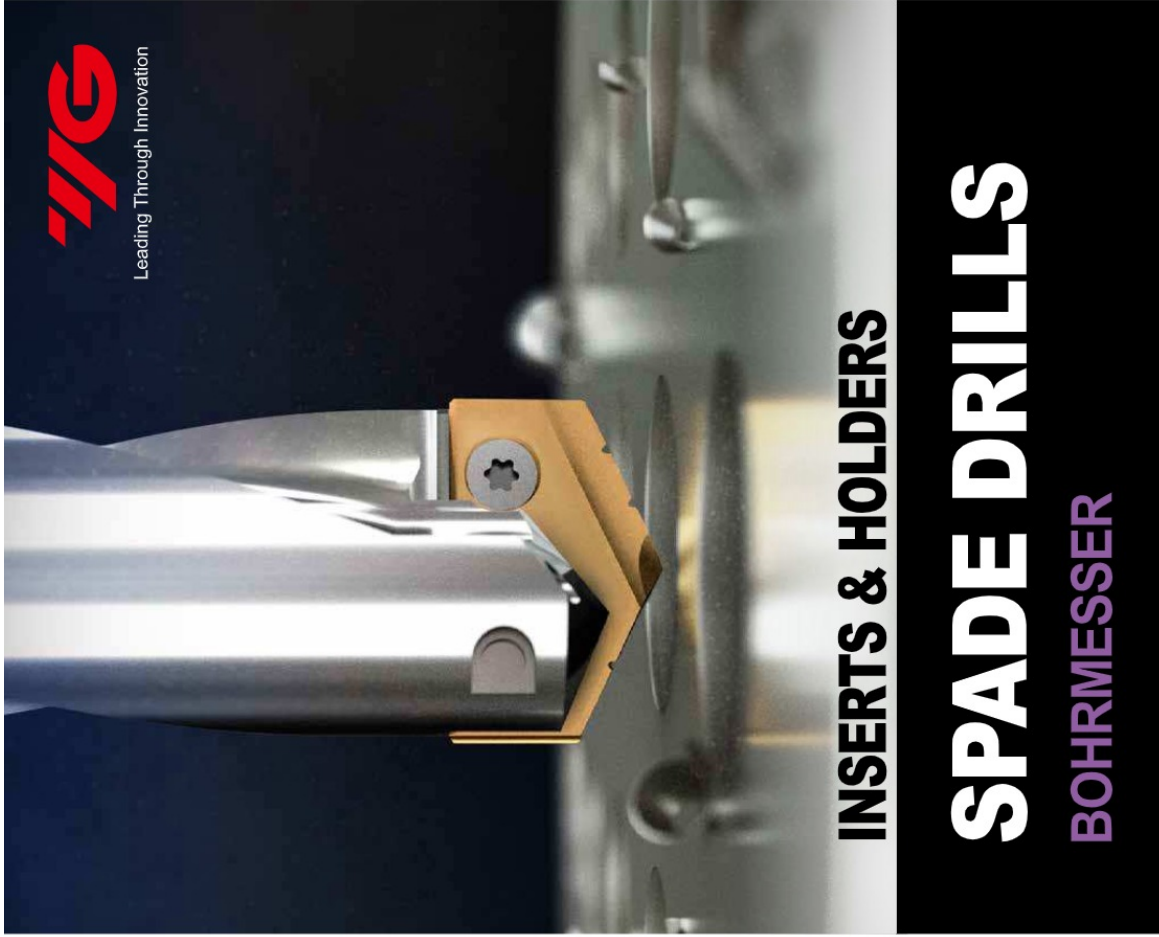
RPM = rev./min.  
FEED = mm/rev.

ISO	VDI	Material Description	K (min)	Parameter	1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0
1	3323		40	RPM FEED	12730 0.02-0.04	6370 0.03-0.06	4240 0.04-0.08	3180 0.05-0.09	2550 0.06-0.10	2120 0.07-0.12	1590 0.09-0.15	1270 0.12-0.18
2			30	RPM FEED	9530 0.02-0.04	4770 0.03-0.06	3180 0.04-0.08	2390 0.05-0.09	1910 0.06-0.10	1590 0.07-0.12	1190 0.09-0.15	950 0.12-0.18
3		Non-alloy steel	25	RPM FEED	7960 0.01-0.03	3980 0.01-0.035	2650 0.015-0.05	1990 0.02-0.06	1590 0.03-0.07	1330 0.04-0.08	990 0.06-0.12	800 0.08-0.14
5												
6			30	RPM FEED	9530 0.02-0.04	4770 0.03-0.06	3180 0.04-0.08	2390 0.05-0.09	1910 0.06-0.10	1590 0.07-0.12	1190 0.09-0.15	950 0.12-0.18
7		Low alloy steel	20	RPM FEED	7960 0.01-0.03	3980 0.01-0.035	2650 0.015-0.05	1990 0.02-0.06	1590 0.03-0.07	1330 0.04-0.08	990 0.06-0.12	800 0.08-0.14
9												
10		High alloyed steel, and tool steel										
11												
12			10	RPM FEED	3180 0.01-0.03	1590 0.01-0.035	1060 0.015-0.05	800 0.02-0.06	640 0.03-0.07	530 0.04-0.08	400 0.06-0.12	320 0.08-0.14
13		Stainless steel										
14												
15		Grey cast iron	40	RPM FEED	12730 0.02-0.04	6370 0.03-0.06	4240 0.04-0.08	3180 0.05-0.09	2550 0.06-0.10	2120 0.07-0.12	1590 0.09-0.15	1270 0.12-0.18
16												
17		Hardened steels	30	RPM FEED	9530 0.02-0.04	4770 0.03-0.06	3180 0.04-0.08	2390 0.05-0.09	1910 0.06-0.10	1590 0.07-0.12	1190 0.09-0.15	950 0.12-0.18
18		General carbide	40	RPM FEED	12730 0.02-0.04	6370 0.03-0.06	4240 0.04-0.08	3180 0.05-0.09	2550 0.06-0.10	2120 0.07-0.12	1590 0.09-0.15	1270 0.12-0.18
19		Malleable cast iron	25	RPM FEED	7960 0.01-0.03	3980 0.01-0.035	2650 0.015-0.05	1990 0.02-0.06	1590 0.03-0.07	1330 0.04-0.08	990 0.06-0.12	800 0.08-0.14
20												
21		Aluminum-wrought alloy										
22												
23												
24		Aluminum-cast, alloyed										
25												
26		Copper and Copper Alloys										
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**INSERTS & HOLDERS**

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