

HM Burgije



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -GENERAL

DREAM DRILLS - UNIVERSAL

- For General Purpose (HRc30 to HRc45)
- Für allgemeine Anwendungen (HRc30 bis HRc45)



Global Cutting Tool Leader **YG-1**



HOLEMAKING

YG1 - Dream Drills General

CARBIDE



**DREAM DRILLS
- INOX**

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**

DH451, DH452, DH453 SERIES with COOLANT HOLES

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

ISO	VCI 3523	Material Description	K _r (mm)	Drill Diameter (mm)									
				Parameter	8.0	10.0	12.0	14.0	16.0	18.0	20.0		
P	1	Non-alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590		
	FEED			0.16-0.22	0.20-0.26	0.18-0.28	0.20-0.30	0.22-0.32	0.26-0.36	0.28-0.38			
	RPM			3980	3180	2650	2270	1990	1770	1590			
	FEED			0.16-0.22	0.20-0.26	0.18-0.28	0.20-0.30	0.22-0.32	0.26-0.36	0.28-0.38			
M	12	Stainless steel	50	RPM	1990	1590	1330	1140	990	880	800		
	FEED			0.09-0.13	0.12-0.15	0.10-0.16	0.12-0.17	0.14-0.19	0.16-0.20				
	RPM			1990	1590	1330	1140	990	880	800			
	FEED			0.09-0.13	0.12-0.15	0.10-0.16	0.12-0.17	0.14-0.19	0.16-0.20				
K	13	Grey cast iron	40	RPM	2390	1910	1590	1360	1190	1060	950		
	FEED			0.10-0.14	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.15-0.20	0.16-0.21			
	RPM			2390	1910	1590	1360	1190	1060	950			
	FEED			0.10-0.14	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.15-0.20	0.16-0.21			
N	21	Aluminum- wrought alloy	180	RPM	7160	5730	4770	4090	3590	3190	2860		
	FEED			0.24-0.30	0.25-0.35	0.24-0.35	0.30-0.40	0.30-0.40	0.33-0.48	0.35-0.45			
	RPM			7160	5730	4770	4090	3590	3190	2860			
	FEED			0.24-0.30	0.25-0.35	0.24-0.35	0.30-0.40	0.30-0.40	0.33-0.48	0.35-0.45			
S	31	Titanium Alloys	40	RPM	1590	1270	1060	910	800	710	640		
	FEED			0.08-0.12	0.09-0.14	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19			
	RPM			1590	1270	1060	910	800	710	640			
	FEED			0.08-0.12	0.09-0.14	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19			

► Recommend to reduce the feed rate as following
Feed 100% : DH451(3xD), DH452(5xD) **Feed 85%** : DH453(8xD)
 phone+82-52-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr



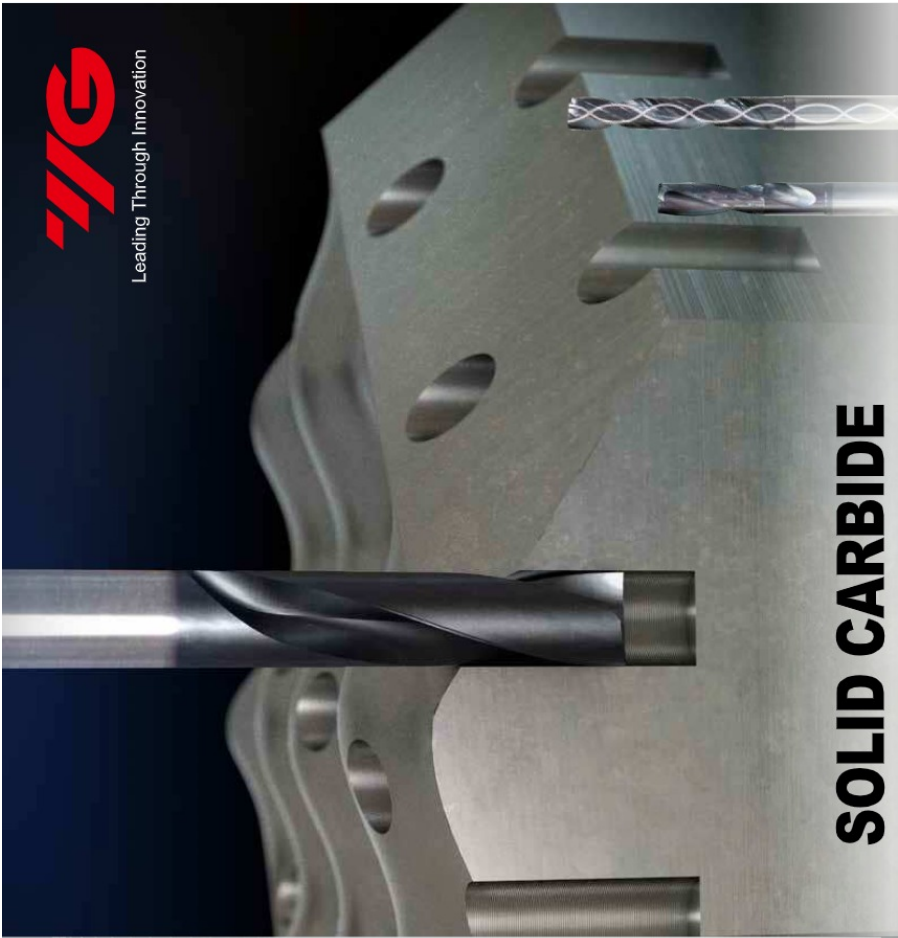
SOLID CARBIDE

**DREAM DRILLS
-ALU
DREAM DRILLS - ALU**

- For Aluminum and Aluminum Alloys
- Für Aluminium und Aluminiumlegierungen



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SOLID CARBIDE

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS - FLACHBOHRER

- For Holes on Various Angled Surfaces
- Für Bohrungen auf verschiedenen abgewinkelten Oberflächen



Global Cutting Tool Leader **YG-1**



HOLEMAKING

YG1 - Dream Drills Flat Bottom



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS **-HIGH FEED** **DREAM DRILLS - HIGH FEED**

- 1.5 to 2 Times Faster Feeding Speed than 2-Flute Drill For Carbon Steels, Alloy Steels(up to HRC35) and Cast Iron
- 1.5 bis 2 mal höhere Vorschubgeschwindigkeit als Bohrer mit 2 Schneiden, für Kohlenstoffstähle, legierte Stähle (bis HRC35) und Grauguss



Global Cutting Tool Leader **YG-1**



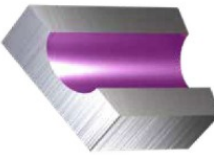
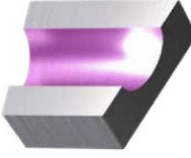
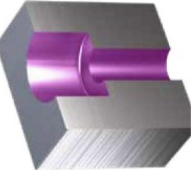
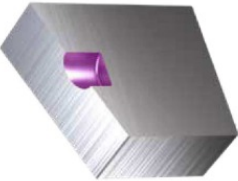


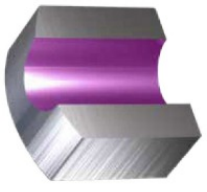
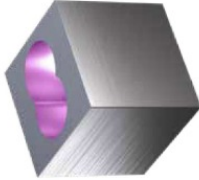
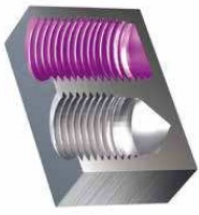
HOLEMAKING

YG1 - Dream Drills HIGH FEED

CARBIDE	HSS	LONG DRILLS	FOREAM DRILLS	DREAM DRILLS -GENERAL	DREAM DRILLS -HIGH FEED	DREAM DRILLS -FLAT BOTTOM	DREAM DRILLS -INOX	DREAM DRILLS -ALU	DREAM DRILLS -CFRP	DREAM DRILLS -HSL	DREAM DRILLS -HARDENED STEELS	GENERAL CARBIDE DRILLS	MULTI DRILLS	HPD DRILLS	GOLD-P DRILLS	SUPER-OP DRILLS	STRAIGHT SHANK DRILLS	TAPERSHANK DRILLS	NC-SPOTTING DRILLS	CENTER DRILLS	SPADE DRILLS	REAMERS	COUNTER SINCS	COUNTER BONES	TECHNICAL DATA
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RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER


VARIETY OF DRILLING
Arten von Bohrungen

		
Inclined Entry	Inclined Exit	Counter Boring
		
Guide Drilling	Cross Drilling	Thin Plate
		
Curved Surface	Chained Hole	Blind Hole for Threading



SOLID CARBIDE
DREAM DRILLS
-INOX
DREAM DRILLS - INOX

- For Tough Materials like Stainless Steels, Nickel Alloys and Titanium.
 - Für schwierig zerspanbare Materialien wie Edelstahl, Nickellegierungen und Titan.



DREAM DRILLS - CFRP

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

DI473 SERIES
DREAM DRILLS - CFRP

ISO	VDI 3223	Material Description	N _{max} (in/min)	Parameter	Drill Diameter (mm)						RPM = v_{cut}/D FEED = f_{min}/N		
					3.0	4.0	5.0	6.0	8.0	10.0		20.0	
	1	Non-alloy steel											
	2	Non-alloy steel											
	3	Non-alloy steel											
	4	Non-alloy steel											
	5	Non-alloy steel											
	6	Low alloy steel											
	7	Low alloy steel											
	8	Low alloy steel											
	9	Low alloy steel											
	10	High alloyed steel, and tool steel											
	11	High alloyed steel, and tool steel											
	12	Stainless steel											
	13	Stainless steel											
	14	Stainless steel											
	15	Grey cast iron											
	16	Grey cast iron											
	17	Nodular cast iron											
	18	Nodular cast iron											
	19	Nodular cast iron											
	20	Malleable cast iron											
	21	Aluminum-wrought alloy											
	22	Aluminum-wrought alloy											
	23	Aluminum-cast, alloyed											
	24	Aluminum-cast, alloyed											
	25	Aluminum-cast, alloyed											
	26	Copper and Copper Alloys (Bronze / Brass)											
	27	Copper and Copper Alloys (Bronze / Brass)											
	28	Copper and Copper Alloys (Bronze / Brass)											
	29	Non Metallic Materials											
	30	Non Metallic Materials											
	31	Non Metallic Materials	120	12790 0.05-0.07	9550 0.05-0.07	7640 0.03-0.07	6370 0.05-0.07	4770 0.05-0.07	3620 0.03-0.07	3180 0.05-0.07			
	32	Heat Resistant Super Alloys											
	33	Heat Resistant Super Alloys											
	34	Heat Resistant Super Alloys											
	35	Heat Resistant Super Alloys											
	36	Titanium Alloys											
	37	Titanium Alloys											
	38	Hardened steel											
	39	Hardened steel											
	40	Chilled Cast Iron											
	41	Hardened Cast Iron											




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DREAM DRILLS
-MQL TYPE
DREAM DRILLS - MQL TYPE

- Minimum Quantity Lubrication Drilling Deep Holes (10xD ~ 30xD)
- Minimalmengenschmierung Tieflochbohren (10xD ~ 30xD)

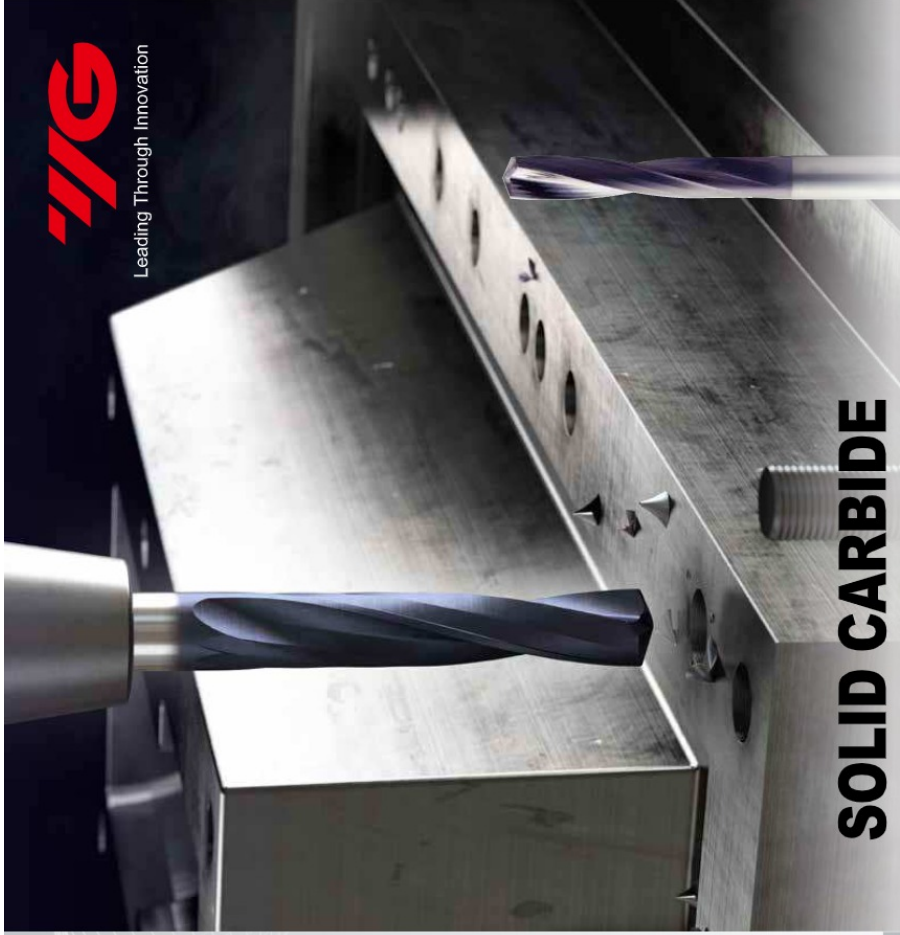


YG

Global Cutting Tool Leader **YG-1**



HOLEMAKING



YG
Leading Through Innovation

SOLID CARBIDE

DREAM DRILLS
- for HIGH HARDENED STEELS
DREAM DRILLS - FÜR HOCHGEHÄRTETE STÄHLE

- For High Hardened Steels (HRc50 to HRc70)

- Für hochgehartete Stähle (HRc50 bis HRc70)