



DREAM DRILLS - FLAT BOTTOM

DPP447 SERIES

CARBIDE, DREAM DRILLS - FLAT BOTTOM

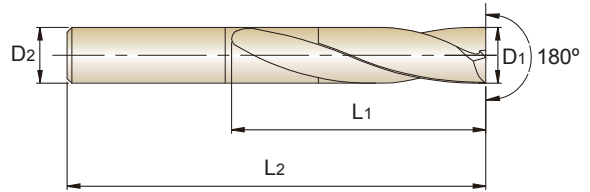
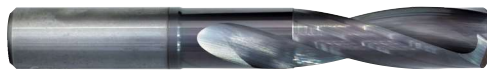
SHORT

- 🇩🇪 **VHM, DREAM DRILLS - FLACHBOHRER**
- 🇫🇷 **DREAM DRILLS - FOND PLAT, FORET CARBURE MONOBLOC**
- 🇮🇹 **PUNTE IN MD DREAM DRILLS, TESTA PIANA**

**KURZ
COURTE
CORTA**

- ▶ For holes on various angled surfaces.
- ▶ 180 degree point angle enables drilling of flat, inclined and curved surfaces.
- ▶ Optimized flute shape for excellent chip evacuation.
- ▶ High strength cutting edge to improve tool life and versatility drilling.
- ▶ For through holes, minimized burrs at entrance and exit when drilling thin plate.

- ▶ Für Bohrungen auf verschiedenen abgewinkelten Flächen.
- ▶ Der 180-Grad-Spitzenwinkel ermöglicht das Bohren von flachen, geneigten und gekrümmten Oberflächen.
- ▶ Optimierte Nutenform für hervorragende Spanabfuhr.
- ▶ Hochfeste Schneide zur Verbesserung der Standzeit und Vielseitigkeit beim Bohren.
- ▶ Für Durchgangsbohrungen, minimierter Grat am Ein- und Austritt beim Bohren von dünnen Blechen.



2 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447030	3.0	6	16	50
DPP447031	3.1	6	16	50
DPP447032	3.2	6	16	50
DPP447033	3.3	6	16	50
DPP447034	3.4	6	18	50
DPP447035	3.5	6	18	50
DPP447036	3.6	6	18	50
DPP447037	3.7	6	18	50
DPP447038	3.8	6	18	50
DPP447039	3.9	6	18	50
DPP447040	4.0	6	18	50
DPP447041	4.1	6	20	60
DPP447042	4.2	6	20	60
DPP447043	4.3	6	20	60
DPP447044	4.4	6	20	60
DPP447045	4.5	6	22	60
DPP447046	4.6	6	22	60
DPP447047	4.7	6	22	60
DPP447048	4.8	6	22	60
DPP447049	4.9	6	22	60
DPP447050	5.0	6	22	60
DPP447051	5.1	6	24	60
DPP447052	5.2	6	24	60
DPP447053	5.3	6	24	60

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447054	5.4	6	24	60
DPP447055	5.5	6	24	60
DPP447056	5.6	6	24	60
DPP447057	5.7	6	26	60
DPP447058	5.8	6	26	60
DPP447059	5.9	6	26	60
DPP447060	6.0	6	26	60
DPP447061	6.1	8	28	70
DPP447062	6.2	8	28	70
DPP447063	6.3	8	28	70
DPP447064	6.4	8	30	70
DPP447065	6.5	8	30	70
DPP447066	6.6	8	30	70
DPP447067	6.7	8	30	70
DPP447068	6.8	8	30	70
DPP447069	6.9	8	30	70
DPP447070	7.0	8	30	70
DPP447071	7.1	8	34	70
DPP447072	7.2	8	34	70
DPP447073	7.3	8	34	70
DPP447074	7.4	8	34	70
DPP447075	7.5	8	34	70
DPP447076	7.6	8	34	70
DPP447077	7.7	8	34	70

▶ Other diameters and shank types are available upon request.

▶ NEXT PAGE

⊙ : Excellent ○ : Good

ISO Material Description	P										M				K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	⊙	⊙	⊙	○	○	⊙	○	○	○		○				⊙	○						

ISO Material Description	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○																			

YG DREAM DRILLS - FLAT BOTTOM

DPP447 SERIES

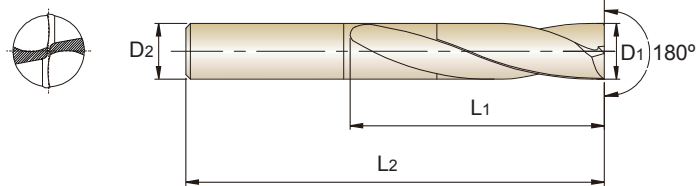
CARBIDE, DREAM DRILLS - FLAT BOTTOM

SHORT
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CORTA

- VHM, DREAM DRILLS - FLACHBOHRER
- DREAM DRILLS - FOND PLAT, FORET CARBURE MONOBLOC
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- ▶ Optimierte Nutenform für hervorragende Spanabfuhr.
- ▶ Hochfeste Schneide zur Verbesserung der Standzeit und Vielseitigkeit beim Bohren.
- ▶ Für Durchgangsbohrungen, minimierter Grat am Ein- und Austritt beim Bohren von dünnen Blechen.



2 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447078	7.8	8	34	70
DPP447079	7.9	8	34	70
DPP447080	8.0	8	34	70
DPP447081	8.1	10	38	80
DPP447082	8.2	10	38	80
DPP447083	8.3	10	38	80
DPP447084	8.4	10	38	80
DPP447085	8.5	10	38	80
DPP447086	8.6	10	38	80
DPP447087	8.7	10	40	80
DPP447088	8.8	10	40	80
DPP447089	8.9	10	40	80
DPP447090	9.0	10	40	80
DPP447091	9.1	10	42	80
DPP447092	9.2	10	42	80
DPP447093	9.3	10	42	80
DPP447094	9.4	10	42	80
DPP447095	9.5	10	42	80
DPP447096	9.6	10	42	80
DPP447097	9.7	10	45	80
DPP447098	9.8	10	45	80
DPP447099	9.9	10	45	80
DPP447100	10.0	10	45	80
DPP447101	10.1	12	46	90

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447102	10.2	12	46	90
DPP447103	10.3	12	46	90
DPP447104	10.4	12	48	90
DPP447105	10.5	12	48	90
DPP447106	10.6	12	48	90
DPP447107	10.7	12	48	90
DPP447108	10.8	12	48	90
DPP447109	10.9	12	48	90
DPP447110	11.0	12	48	90
DPP447111	11.1	12	50	90
DPP447112	11.2	12	50	90
DPP447113	11.3	12	50	90
DPP447114	11.4	12	50	90
DPP447115	11.5	12	50	90
DPP447116	11.6	12	50	90
DPP447117	11.7	12	52	90
DPP447118	11.8	12	52	90
DPP447119	11.9	12	52	90
DPP447120	12.0	12	52	90
DPP447125	12.5	14	54	100
DPP447130	13.0	14	56	100
DPP447135	13.5	14	58	100
DPP447140	14.0	14	58	100
DPP447145	14.5	16	62	105

▶ Other diameters and shank types are available upon request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	○	○	○		○				◎	○				

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○																			



DREAM DRILLS - FLAT BOTTOM

DPP447 SERIES

CARBIDE, DREAM DRILLS - FLAT BOTTOM

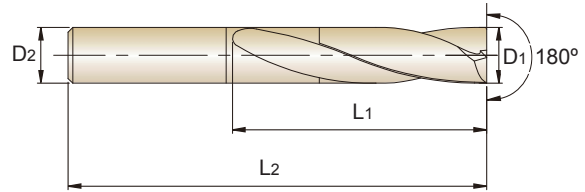
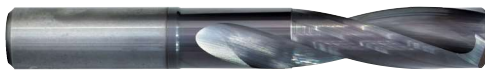
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CARBIDE 20° h6 h7 180° P.116

2 x D

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447150	15.0	16	62	105
DPP447155	15.5	16	64	115
DPP447160	16.0	16	64	115
DPP447165	16.5	18	70	125
DPP447170	17.0	18	70	125
DPP447175	17.5	18	70	125

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
X-Coating	D1	D2	L1	L2
DPP447180	18.0	18	70	125
DPP447185	18.5	20	75	135
DPP447190	19.0	20	75	135
DPP447195	19.5	20	75	145
DPP447200	20.0	20	75	145

▶ Other diameters and shank types are available upon request.

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	○	○	○			○			◎	○				

ISO	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys							Titanium Alloys		Hardened steel	Chilled Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○																			

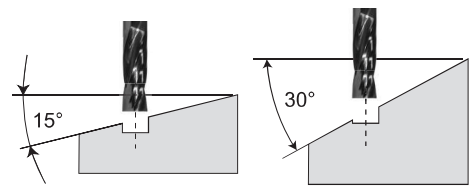
DPP447 SERIES

without COOLANT HOLES (2XD)

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1	Non-alloy steel	80	RPM FEED	8490 0.02-0.05	6370 0.03-0.07	5090 0.03-0.08	4240 0.04-0.10	3180 0.08-0.14	2550 0.11-0.17	2120 0.11-0.21	1590 0.18-0.28	1270 0.28-0.38
	2		80	RPM FEED	8490 0.02-0.05	6370 0.03-0.07	5090 0.03-0.08	4240 0.04-0.10	3180 0.08-0.14	2550 0.11-0.17	2120 0.11-0.21	1590 0.18-0.28	1270 0.28-0.38
	3		70	RPM FEED	7430 0.02-0.05	5570 0.03-0.07	4460 0.03-0.08	3710 0.04-0.10	2790 0.07-0.13	2230 0.11-0.17	1860 0.11-0.21	1390 0.18-0.28	1110 0.24-0.34
	4		40	RPM FEED	4240 0.02-0.05	3180 0.03-0.07	2550 0.03-0.08	2120 0.04-0.10	1590 0.07-0.13	1270 0.11-0.17	1060 0.11-0.21	800 0.18-0.28	640 0.24-0.34
	5		38	RPM FEED	4030 0.02-0.05	3020 0.02-0.06	2420 0.03-0.08	2020 0.03-0.09	1510 0.06-0.12	1210 0.09-0.15	1010 0.08-0.18	760 0.14-0.24	600 0.21-0.31
	6	Low alloy steel	45	RPM FEED	4770 0.02-0.05	3580 0.03-0.07	2860 0.03-0.08	2390 0.04-0.10	1790 0.07-0.13	1430 0.11-0.17	1190 0.11-0.21	900 0.18-0.28	720 0.24-0.34
	7		40	RPM FEED	4240 0.02-0.05	3180 0.03-0.07	2550 0.03-0.08	2120 0.04-0.10	1590 0.07-0.13	1270 0.11-0.17	1060 0.11-0.21	800 0.18-0.28	640 0.24-0.34
	8		38	RPM FEED	4030 0.02-0.05	3020 0.02-0.06	2420 0.03-0.08	2020 0.03-0.09	1510 0.06-0.12	1210 0.09-0.15	1010 0.08-0.18	760 0.14-0.24	600 0.21-0.31
	9		25	RPM FEED	2650 0.01-0.03	1990 0.02-0.04	1590 0.02-0.05	1330 0.03-0.06	990 0.03-0.08	800 0.05-0.10	660 0.06-0.12	500 0.06-0.16	400 0.10-0.20
	10		High alloyed steel, and tool steel										
	11												
M	12	Stainless steel	30	RPM FEED	3180 0.01-0.03	2390 0.01-0.03	1910 0.02-0.04	1590 0.02-0.05	1190 0.03-0.06	950 0.03-0.08	800 0.05-0.10	600 0.06-0.12	480 0.09-0.15
	13												
	14												
K	15	Grey cast iron	70	RPM FEED	7430 0.02-0.05	5570 0.02-0.06	4460 0.03-0.08	3710 0.03-0.09	2790 0.06-0.12	2230 0.09-0.15	1860 0.08-0.18	1390 0.14-0.24	1110 0.20-0.30
	16		60	RPM FEED	6370 0.02-0.05	4770 0.02-0.05	3820 0.03-0.06	3180 0.03-0.07	2390 0.04-0.10	1910 0.07-0.13	1590 0.06-0.16	1190 0.11-0.21	950 0.15-0.25
	17	Nodular cast iron											
	18	Malleable cast iron											
	19												
20													
N	21	Aluminum- wrought alloy	165	RPM FEED	17510 0.02-0.05	13130 0.04-0.08	10500 0.04-0.10	8750 0.06-0.12	6570 0.10-0.16	5250 0.14-0.20	4380 0.14-0.24	3280 0.22-0.32	2630 0.30-0.40
	22		165	RPM FEED	17510 0.02-0.05	13130 0.04-0.08	10500 0.04-0.10	8750 0.06-0.12	6570 0.10-0.16	5250 0.14-0.20	4380 0.14-0.24	3280 0.22-0.32	2630 0.30-0.40
	23	Aluminum-cast, alloyed											
	24												
	25												
	26												
	27	Copper and Copper Alloys (Bronze / Brass)											
	28												
	29												
	30	Non Metallic Materials											
S	31	Heat Resistant Super Alloys											
	32												
	33												
	34												
	35	Titanium Alloys											
	36												
	37												
H	38	Hardened steel											
	39												
	40		Chilled Cast Iron										
41	Hardened Cast Iron												

Surface Angle	Cutting Conditions	
	RPM	FEED
0° ~ 15°	100%	100%
15° ~ 30°	100%	50%
30° ~	70%	30%



- ▶ The cutting conditions are for 2xD.
- ▶ A rigid and precise machine and holder are required.
- ▶ The recommended depth of hole is measured from the highest point of the hole on drilling in inclined and angled surfaces.
- ▶ The recommended cutting conditions are those for drilling on flat and horizontal surfaces.
- ▶ Please adjust feed rate according to the above surface angle when drilling on an inclined surface.
 - The recommended feed rate 50% or lower, in case of 15°~30° of the incline angle.
 - The recommended feed rate 30% or lower and RPM 70%, in case of 30° ~ of the incline angle.
- ▶ Please decrease cutting speed as material hardness increases.
- ▶ Only use drilling tools. Side milling, traversing, helical milling are not usable.



DREAM DRILLS - FLAT BOTTOM

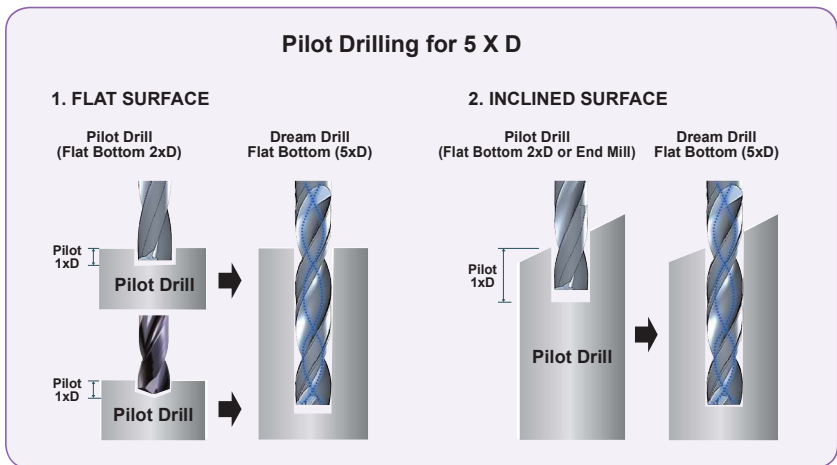
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

DH450 SERIES

with COOLANT HOLES (5XD)

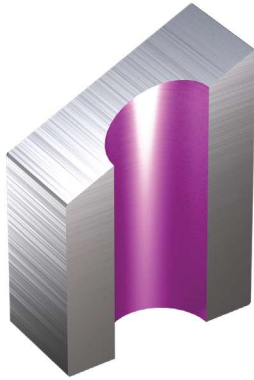
RPM = rev./min.
FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)									
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1	Non-alloy steel	100	RPM FEED	10610 0.05-0.09	7960 0.08-0.12	6370 0.09-0.15	5310 0.12-0.18	3980 0.18-0.24	3180 0.24-0.30	2650 0.26-0.36	1990 0.38-0.48	1590 0.50-0.60	
	2		90	RPM FEED	9550 0.02-0.05	7160 0.04-0.08	5730 0.04-0.10	4770 0.06-0.12	3580 0.10-0.16	2860 0.14-0.20	2390 0.14-0.24	1790 0.22-0.32	1430 0.30-0.40	
	3		90	RPM FEED	9550 0.02-0.05	7160 0.04-0.08	5730 0.04-0.10	4770 0.06-0.12	3580 0.10-0.16	2860 0.14-0.20	2390 0.14-0.24	1790 0.22-0.32	1430 0.30-0.40	
	4		75	RPM FEED	7960 0.02-0.04	5970 0.03-0.06	4770 0.05-0.08	3980 0.05-0.09	2980 0.06-0.12	2390 0.09-0.15	1990 0.08-0.18	1490 0.14-0.24	1190 0.20-0.30	800 0.20-0.30
	5		75	RPM FEED	7960 0.02-0.04	5970 0.03-0.06	4770 0.05-0.08	3980 0.05-0.09	2980 0.06-0.12	2390 0.09-0.15	1990 0.08-0.18	1490 0.14-0.24	1190 0.20-0.30	800 0.20-0.30
	6	Low alloy steel	85	RPM FEED	9020 0.02-0.05	6760 0.04-0.08	5410 0.04-0.10	4510 0.06-0.12	3380 0.10-0.16	2710 0.14-0.20	2250 0.14-0.24	1690 0.22-0.32	1350 0.30-0.40	
	7		75	RPM FEED	7960 0.02-0.05	5970 0.04-0.08	4770 0.04-0.10	3980 0.06-0.12	2980 0.10-0.16	2390 0.14-0.20	1990 0.14-0.24	1490 0.22-0.32	1190 0.30-0.40	
	8		75	RPM FEED	7960 0.02-0.04	5970 0.03-0.06	4770 0.05-0.08	3980 0.05-0.09	2980 0.06-0.12	2390 0.09-0.15	1990 0.08-0.18	1490 0.14-0.24	1190 0.20-0.30	
	9		50	RPM FEED	5310 0.02-0.04	3980 0.03-0.06	3180 0.05-0.08	2650 0.05-0.09	1990 0.06-0.12	1590 0.09-0.15	1330 0.08-0.18	990 0.14-0.24	800 0.20-0.30	
	10		High alloyed steel, and tool steel											
11														
M	12	Stainless steel	60	RPM FEED	6370 0.02-0.05	4770 0.04-0.08	3820 0.04-0.10	3180 0.06-0.12	2390 0.10-0.16	1910 0.14-0.20	1590 0.14-0.24	1190 0.22-0.32	950 0.30-0.40	
	13													
	14													
K	15	Grey cast iron	90	RPM FEED	9550 0.02-0.05	7160 0.03-0.06	5730 0.05-0.08	4770 0.05-0.09	3580 0.06-0.12	2860 0.09-0.15	2390 0.08-0.18	1790 0.14-0.24	1430 0.20-0.30	
	16		75	RPM FEED	7960 0.02-0.05	5970 0.02-0.05	4770 0.03-0.06	3980 0.03-0.07	2980 0.04-0.10	2390 0.07-0.13	1990 0.06-0.16	1490 0.11-0.21	1190 0.15-0.25	
	17	Nodular cast iron												
	18													
	19	Malleable cast iron												
20														
N	21	Aluminum-wrought alloy	160	RPM FEED	16980 0.05-0.09	12730 0.08-0.12	10190 0.09-0.15	8490 0.12-0.18	6370 0.18-0.24	5090 0.24-0.30	4240 0.26-0.36	3180 0.38-0.48	2550 0.50-0.60	
	22		160	RPM FEED	16980 0.05-0.09	12730 0.08-0.12	10190 0.09-0.15	8490 0.12-0.18	6370 0.18-0.24	5090 0.24-0.30	4240 0.26-0.36	3180 0.38-0.48	2550 0.50-0.60	
	23	Aluminum-cast, alloyed												
	24													
	25													
	26													
	27	Copper and Copper Alloys (Bronze / Brass)												
	28													
	29	Non Metallic Materials												
	30													
S	31	Heat Resistant Super Alloys												
	32													
	33													
	34													
	35													
	36	Titanium Alloys												
	37													
H	38	Hardened steel												
	39													
	40	Chilled Cast Iron												
	41	Hardened Cast Iron												

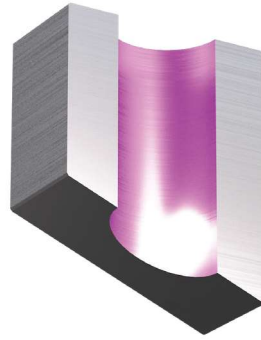


- ▶ For Flat bottom 5xD drilling depth, Slope surface needs Pilot Drilling with YG-1 Flat Bottom Drill (2XD) and Flat surface needs Pilot Drilling with YG-1 Dream Drill General.
- ▶ Pilot Drilling Depth : around 1XD
- ▶ Pilot Drilling Diameter : same size diameter

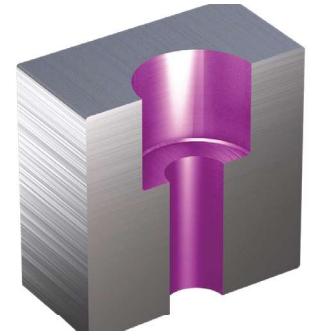
**VARIETY OF DRILLING
Arten von Bohrungen**



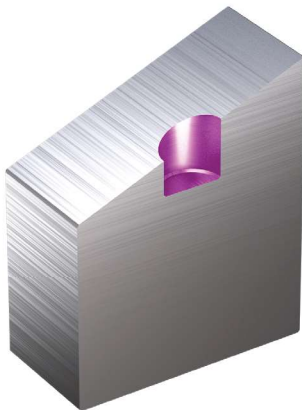
Inclined Entry



Inclined Exit



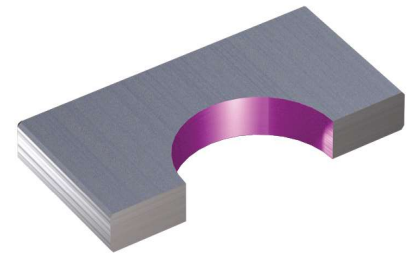
Counter Boring



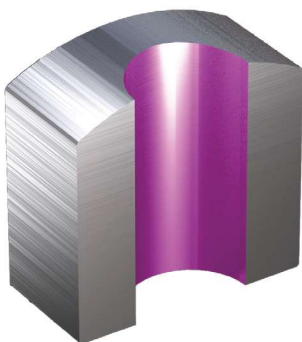
Guide Drilling



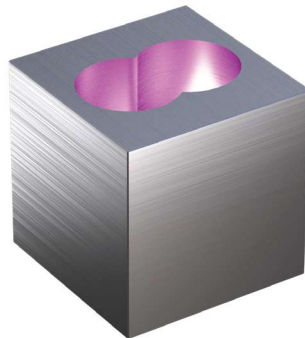
Cross Drilling



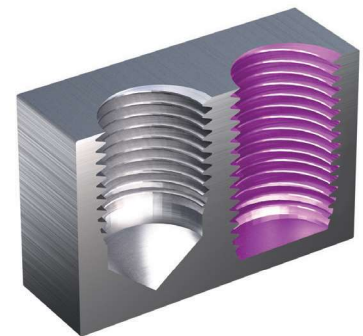
Thin Plate



Curved Surface



Chained Hole



Blind Hole for Threading