

# YG STRAIGHT SHANK DRILLS

## D1106 SERIES

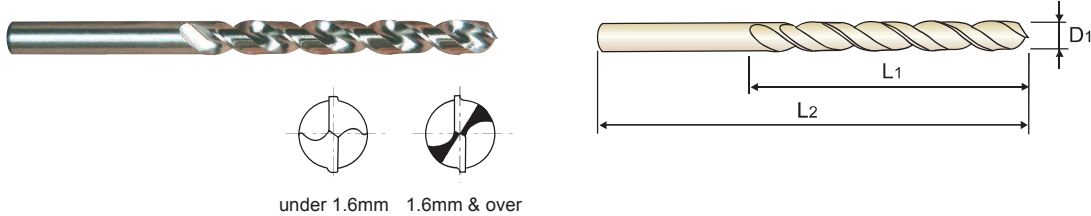
### HSS, STRAIGHT SHANK TWIST DRILLS for ALUMINUM

**JOBBER**  
**KURZ**  
**COURTE**  
**CORTA**

- HSS, SPIRALBOHRER für ALUMINIUM mit ZYLINDERSCHAFT
- Forets HSS, queue cylindrique pour ALU, Forme C, série courte
- PUNTE ELICOIDALI, GAMBO CILINDRICO, PER ALLUMINIO (HSS)

► **Application** : Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze aluminum and magnesium alloys.

► **Verwendung** : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



DIN 338
HSS
38°
h8
135°
P.279

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1106015	1.5	18	40
D1106016	1.6	20	43
D1106017	1.7	20	43
D1106018	1.8	22	46
D1106019	1.9	22	46
D1106020	2.0	24	49
D1106021	2.1	24	49
D1106022	2.2	27	53
D1106023	2.3	27	53
D1106024	2.4	30	57
D1106025	2.5	30	57
D1106026	2.6	30	57
D1106027	2.7	33	61
D1106028	2.8	33	61
D1106029	2.9	33	61
D1106030	3.0	33	61
D1106031	3.1	36	65
D1106032	3.2	36	65
D1106033	3.3	36	65
D1106034	3.4	39	70
D1106035	3.5	39	70
D1106036	3.6	39	70
D1106037	3.7	39	70
D1106038	3.8	43	75
D1106039	3.9	43	75
D1106040	4.0	43	75

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D1106041	4.1	43	75
D1106042	4.2	43	75
D1106043	4.3	47	80
D1106044	4.4	47	80
D1106045	4.5	47	80
D1106046	4.6	47	80
D1106047	4.7	47	80
D1106048	4.8	52	86
D1106049	4.9	52	86
D1106050	5.0	52	86
D1106051	5.1	52	86
D1106052	5.2	52	86
D1106053	5.3	52	86
D1106054	5.4	57	93
D1106055	5.5	57	93
D1106056	5.6	57	93
D1106057	5.7	57	93
D1106058	5.8	57	93
D1106059	5.9	57	93
D1106060	6.0	57	93
D1106061	6.1	63	101
D1106062	6.2	63	101
D1106063	6.3	63	101
D1106064	6.4	63	101
D1106065	6.5	63	101
D1106066	6.6	63	101

► NEXT PAGE

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		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	23	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	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	◎	◎		◎																	



# STRAIGHT SHANK DRILLS

**D1106** SERIES

## HSS, STRAIGHT SHANK TWIST DRILLS for ALUMINUM

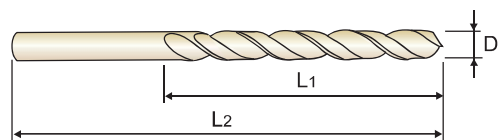
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► **Verwendung** : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.



under 1.6mm 1.6mm & over

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1106067	6.7	63	101
D1106068	6.8	69	109
D1106069	6.9	69	109
D1106070	7.0	69	109
D1106071	7.1	69	109
D1106072	7.2	69	109
D1106073	7.3	69	109
D1106074	7.4	69	109
D1106075	7.5	69	109
D1106076	7.6	75	117
D1106077	7.7	75	117
D1106078	7.8	75	117
D1106079	7.9	75	117
D1106080	8.0	75	117
D1106081	8.1	75	117
D1106082	8.2	75	117
D1106083	8.3	75	117
D1106084	8.4	75	117
D1106085	8.5	75	117
D1106086	8.6	81	125

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1106087	8.7	81	125
D1106088	8.8	81	125
D1106089	8.9	81	125
D1106090	9.0	81	125
D1106091	9.1	81	125
D1106092	9.2	81	125
D1106093	9.3	81	125
D1106094	9.4	81	125
D1106095	9.5	81	125
D1106096	9.6	87	133
D1106097	9.7	87	133
D1106098	9.8	87	133
D1106099	9.9	87	133
D1106100	10.0	87	133
D1106105	10.5	87	133
D1106110	11.0	94	142
D1106115	11.5	94	142
D1106120	12.0	101	151
D1106125	12.5	101	151
D1106130	13.0	101	151

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	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	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	◎	◎	◎	◎																	

◎ : Excellent ○ : Good



# STRAIGHT SHANK DRILLS

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

CARBIDE

HSS

### D1106 SERIES

### HSS, TWIST DRILLS for ALUMINUM

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)							
					2.0	3.0	4.0	5.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel										
	2											
	3											
	4											
	5											
	6	Low alloy steel										
	7											
	8											
	9											
	10		High alloyed steel, and tool steel									
	11											
M	12	Stainless steel										
	13											
	14											
K	15	Grey cast iron										
	16											
	17	Nodular cast iron										
	18											
	19	Malleable cast iron										
	20											
N	21	Aluminum-wrought alloy	50	RPM	7960	5310	3980	3180	2650	1990	1590	1220
	22		FEED	0.05~0.08	0.06~0.10	0.08~0.12	0.10~0.14	0.14~0.18	0.14~0.20	0.19~0.25	0.25~0.35	
	23	Aluminum-cast, alloyed	40	RPM	6370	4240	3180	2550	2120	1590	1270	980
	24		FEED	0.05~0.08	0.06~0.10	0.08~0.12	0.10~0.14	0.14~0.18	0.14~0.20	0.19~0.25	0.25~0.35	
	25		30	RPM	4770	3180	2390	1910	1590	1190	950	730
	26		FEED	0.03~0.06	0.03~0.07	0.04~0.08	0.05~0.09	0.04~0.10	0.06~0.12	0.10~0.16	0.12~0.22	
	27	Copper and Copper Alloys (Bronze / Brass)										
	28											
	29	Non Metallic Materials										
	30											
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										

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA