



GOLD-P COATED DRILL SETS

- GOLD-P BESCHICHTET BOHRER SATS
- Coffrets de Forets GOLD-P revêtus
- SET DI PUNTE GOLD-P



DIN338 DRILL SETS JOBBER LENGTH Gold-P coated Drills

EDP No.	DESCRIPTION	SIZE	Q'TY
D1GP165SET1	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
D1GP165SET2	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
D1GP165SET3	HSS Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGP195SET1	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
DLGP195SET2	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
DLGP195SET3	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGPSET982	HSS-E Straight Shank, Split Point (Ø1.0 & Ø1.5 : NORMAL point)	1.0-10.0x0.1mm step	91 pcs



D1GP125, D1GP165, DLGP195, DLGP506 SERIES

HSS & HSS-E GOLD-P DRILLS

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

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)						
					2.0	3.0	4.0	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	40	RPM FEED	6370 0.04-0.08	4240 0.06-0.10	3180 0.08-0.12	2120 0.12-0.16	1590 0.12-0.18	1270 0.16-0.22	980 0.18-0.24
	2		35	RPM FEED	5570 0.04-0.08	3710 0.06-0.10	2790 0.08-0.12	1860 0.12-0.16	1390 0.12-0.18	1110 0.16-0.22	860 0.18-0.24
	3		30	RPM FEED	4770 0.04-0.08	3180 0.06-0.10	2390 0.08-0.12	1590 0.12-0.16	1190 0.12-0.18	950 0.16-0.22	730 0.18-0.24
	4		20	RPM FEED	3180 0.02-0.05	2120 0.02-0.06	1590 0.04-0.08	1060 0.04-0.10	800 0.06-0.12	640 0.08-0.14	490 0.12-0.18
	5										
	6	Low alloy steel	35	RPM FEED	5570 0.04-0.08	3710 0.06-0.10	2790 0.08-0.12	1860 0.12-0.16	1390 0.12-0.18	1110 0.16-0.22	860 0.18-0.24
	7		30	RPM FEED	4770 0.04-0.08	3180 0.06-0.10	2390 0.08-0.12	1590 0.12-0.16	1190 0.12-0.18	950 0.16-0.22	730 0.18-0.24
	8		30	RPM FEED	4770 0.02-0.05	3180 0.02-0.06	2390 0.04-0.08	1590 0.04-0.10	1190 0.06-0.12	950 0.08-0.14	730 0.12-0.18
	9										
	10	High alloyed steel, and tool steel	20	RPM FEED	3180 0.04-0.08	2120 0.06-0.10	1590 0.08-0.12	1060 0.12-0.16	800 0.12-0.18	640 0.16-0.22	490 0.18-0.24
	11										
M	12	Stainless steel	25	RPM FEED	3980 0.04-0.08	2650 0.06-0.10	1990 0.08-0.12	1330 0.12-0.16	990 0.12-0.18	800 0.16-0.22	610 0.18-0.24
	13		20	RPM FEED	3180 0.04-0.08	2120 0.06-0.10	1590 0.08-0.12	1060 0.12-0.16	800 0.12-0.18	640 0.16-0.22	490 0.18-0.24
	14		15	RPM FEED	2390 0.02-0.05	1590 0.02-0.06	1190 0.04-0.08	800 0.04-0.10	600 0.06-0.12	480 0.08-0.14	370 0.12-0.18
K	15	Grey cast iron	40	RPM FEED	6370 0.04-0.08	4240 0.06-0.10	3180 0.08-0.12	2120 0.12-0.16	1590 0.12-0.18	1270 0.16-0.22	980 0.18-0.24
	16		35	RPM FEED	5570 0.02-0.05	3710 0.02-0.06	2790 0.04-0.08	1860 0.04-0.10	1390 0.06-0.12	1110 0.08-0.14	860 0.12-0.18
	17	Nodular cast iron	40	RPM FEED	6370 0.04-0.08	4240 0.06-0.10	3180 0.08-0.12	2120 0.12-0.16	1590 0.12-0.18	1270 0.16-0.22	980 0.18-0.24
	18		30	RPM FEED	4770 0.02-0.05	3180 0.02-0.06	2390 0.04-0.08	1590 0.04-0.10	1190 0.06-0.12	950 0.08-0.14	730 0.12-0.18
	19	Malleable cast iron	35	RPM FEED	5570 0.04-0.08	3710 0.06-0.10	2790 0.08-0.12	1860 0.12-0.16	1390 0.12-0.18	1110 0.16-0.22	860 0.18-0.24
	20		30	RPM FEED	4770 0.02-0.05	3180 0.02-0.06	2390 0.04-0.08	1590 0.04-0.10	1190 0.06-0.12	950 0.08-0.14	730 0.12-0.18
N	21	Aluminum-wrought alloy	65	RPM FEED	10350 0.05-0.09	6900 0.07-0.11	5170 0.12-0.16	3450 0.12-0.18	2590 0.14-0.20	2070 0.16-0.22	1590 0.22-0.28
	22		65	RPM FEED	10350 0.05-0.09	6900 0.07-0.11	5170 0.12-0.16	3450 0.12-0.18	2590 0.14-0.20	2070 0.16-0.22	1590 0.22-0.28
	23	Aluminum-cast, alloyed	50	RPM FEED	7960 0.05-0.09	5310 0.07-0.11	3980 0.12-0.16	2650 0.12-0.18	1990 0.14-0.20	1590 0.16-0.22	1220 0.22-0.28
	24										
	25										
	26										
	27	Copper and Copper Alloys (Bronze / Brass)									
	28										
	29	Non Metallic Materials	30	RPM FEED	4770 0.04-0.08	3180 0.06-0.10	2390 0.08-0.12	1590 0.12-0.16	1190 0.12-0.18	950 0.16-0.22	730 0.18-0.24
	30										
S	31	Heat Resistant Super Alloys									
	32										
	33										
	34										
	35										
	36	Titanium Alloys	20	RPM FEED	3180 0.02-0.05	2120 0.02-0.06	1590 0.04-0.08	1060 0.05-0.09	800 0.06-0.10	640 0.07-0.13	490 0.08-0.14
	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