

METRIC & INCH  
D3041

2004/2005



# Gold-P Drills



*Gold-P Drills*

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YG-1 CO., LTD.  
[www.yg1.co.kr](http://www.yg1.co.kr)

# Wonders

**Price** | *Why pay more for coated drill?*

**Performance** | *Higher productivity  
same quality with general full TiN coating*



**【Gold-P Drill】**








**【Uncoated Drill】**










Which will you **choose?**

*Gold-P Drill?* or *Uncoated Drill?*

	SERIES NO.	DESCRIPTION	page
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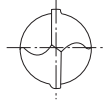
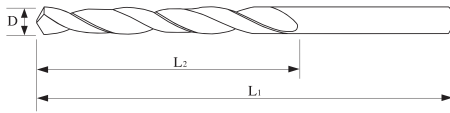
DIN 338 JOBBER LENGTH Gold-p coated drills			
	D1GP125	HSS Straight Shank, Normal point	4
	D1GP165	HSS Straight Shank, Split point	5
	DLGP195	HSSCo5 Straight Shank, Split point	6
	DLGP506	HSSCo5 Straight Shank, Split point, <b>DH100</b> for deep hole	7

JIS REGULAR LENGTH Gold-p coated drills			
	D1GP103	HSS Straight Shank, Normal point	8
	D2GP191	HSSCo8 Straight Shank, Split point	9

ANSI JOBBER LENGTH Gold-p coated drills			
	D1GP113	HSS Straight Shank, <b>Fractional size</b> , normal point	10
	D1GP136	HSS Straight Shank, <b>Letter size</b> , Normal point	10
	D1GP134	HSS Straight Shank, <b>Wire gauge size</b> , Normal point	11
	D2GP185	HSSCo8 Straight Shank, <b>Fractional size</b> , Split point	12
	D2GP186	HSSCo8 Straight Shank, <b>Letter size</b> , Split point	12
	D2GP187	HSSCo8 Straight Shank, <b>Wire gauge size</b> , Split point	13
	DLGP511	HSSCo5 Straight Shank, <b>Fractional size</b> , Split point <b>DH100</b> for deep hole	14
	DLGP513	HSSCo5 Straight Shank, <b>Letter size</b> , Split point, <b>DH100</b> for deep hole	14
	DLGP512	HSSCo5 Straight Shank, <b>Wire gauge size</b> , Split point, <b>DH100</b> for deep hole	15

DRILL SET Gold-p coated drills			
	1.0mm TO 10.0mm × 0.5mm STEP  SET1(19PCS)		1.0mm TO 13.0mm × 0.5mm STEP  SET2(25PCS)
			1.0mm TO 10.5mm × 0.5mm STEP +3.3 +4.2 +6.8 +10.2 SET3(24PCS)

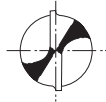
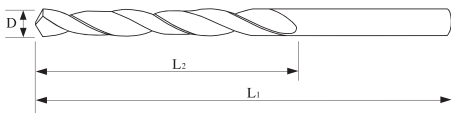
RECOMMENDED CUTTING CONDITIONS	17~20
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**Flute Geometry :** Right hand spiral  
**Point Angle :** 118°, Normal point  
**Surface treatment :** Bright body TiN coating on working part  
**Application :** Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron

unit:mm

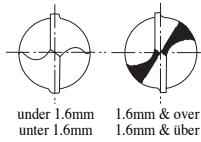
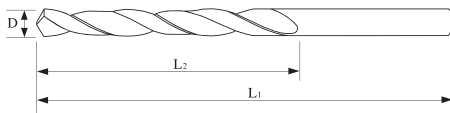
EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1
D1GP125010	1.0	12	34	D1GP125051	5.1	52	86	D1GP125092	9.2	81	125
D1GP125011	1.1	14	36	D1GP125052	5.2	52	86	D1GP125093	9.3	81	125
D1GP125012	1.2	16	38	D1GP125053	5.3	52	86	D1GP125094	9.4	81	125
D1GP125013	1.3	16	38	D1GP125054	5.4	57	93	D1GP125095	9.5	81	125
D1GP125014	1.4	18	40	D1GP125055	5.5	57	93	D1GP125096	9.6	87	133
D1GP125015	1.5	18	40	D1GP125056	5.6	57	93	D1GP125097	9.7	87	133
D1GP125016	1.6	20	43	D1GP125057	5.7	57	93	D1GP125098	9.8	87	133
D1GP125017	1.7	20	43	D1GP125058	5.8	57	93	D1GP125099	9.9	87	133
D1GP125018	1.8	22	46	D1GP125059	5.9	57	93	D1GP125100	10.0	87	133
D1GP125019	1.9	22	46	D1GP125060	6.0	57	93	D1GP125101	10.1	87	133
D1GP125020	2.0	24	49	D1GP125061	6.1	63	101	D1GP125102	10.2	87	133
D1GP125021	2.1	24	49	D1GP125062	6.2	63	101	D1GP125103	10.3	87	133
D1GP125022	2.2	27	53	D1GP125063	6.3	63	101	D1GP125104	10.4	87	133
D1GP125023	2.3	27	53	D1GP125064	6.4	63	101	D1GP125105	10.5	87	133
D1GP125024	2.4	30	57	D1GP125065	6.5	63	101	D1GP125106	10.6	87	133
D1GP125025	2.5	30	57	D1GP125066	6.6	63	101	D1GP125107	10.7	94	142
D1GP125026	2.6	30	57	D1GP125067	6.7	63	101	D1GP125108	10.8	94	142
D1GP125027	2.7	33	61	D1GP125068	6.8	69	109	D1GP125109	10.9	94	142
D1GP125028	2.8	33	61	D1GP125069	6.9	69	109	D1GP125110	11.0	94	142
D1GP125029	2.9	33	61	D1GP125070	7.0	69	109	D1GP125111	11.1	94	142
D1GP125030	3.0	33	61	D1GP125071	7.1	69	109	D1GP125112	11.2	94	142
D1GP125031	3.1	36	65	D1GP125072	7.2	69	109	D1GP125113	11.3	94	142
D1GP125032	3.2	36	65	D1GP125073	7.3	69	109	D1GP125114	11.4	94	142
D1GP125033	3.3	36	65	D1GP125074	7.4	69	109	D1GP125115	11.5	94	142
D1GP125034	3.4	39	70	D1GP125075	7.5	69	109	D1GP125116	11.6	94	142
D1GP125035	3.5	39	70	D1GP125076	7.6	75	117	D1GP125117	11.7	94	142
D1GP125036	3.6	39	70	D1GP125077	7.7	75	117	D1GP125118	11.8	94	142
D1GP125037	3.7	39	70	D1GP125078	7.8	75	117	D1GP125119	11.9	101	151
D1GP125038	3.8	43	75	D1GP125079	7.9	75	117	D1GP125120	12.0	101	151
D1GP125039	3.9	43	75	D1GP125080	8.0	75	117	D1GP125121	12.1	101	151
D1GP125040	4.0	43	75	D1GP125081	8.1	75	117	D1GP125122	12.2	101	151
D1GP125041	4.1	43	75	D1GP125082	8.2	75	117	D1GP125123	12.3	101	151
D1GP125042	4.2	43	75	D1GP125083	8.3	75	117	D1GP125124	12.4	101	151
D1GP125043	4.3	47	80	D1GP125084	8.4	75	117	D1GP125125	12.5	101	151
D1GP125044	4.4	47	80	D1GP125085	8.5	75	117	D1GP125126	12.6	101	151
D1GP125045	4.5	47	80	D1GP125086	8.6	81	125	D1GP125127	12.7	101	151
D1GP125046	4.6	47	80	D1GP125087	8.7	81	125	D1GP125128	12.8	101	151
D1GP125047	4.7	47	80	D1GP125088	8.8	81	125	D1GP125129	12.9	101	151
D1GP125048	4.8	52	86	D1GP125089	8.9	81	125	D1GP125130	13.0	101	151
D1GP125049	4.9	52	86	D1GP125090	9.0	81	125				
D1GP125050	5.0	52	86	D1GP125091	9.1	81	125				



**Flute Geometry** : Right hand spiral  
**Point Angle** : 118°, Split point  
**Surface treatment** : Bright body TiN coating on working part  
**Application** : Drilling in steel, cast steel alloyed and  
 Non-alloyed, grey cast iron, graphite,  
 malleable cast iron

unit:mm

EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1
D1GP165016	1.6	20	43	D1GP165055	5.5	57	93	D1GP165094	9.4	81	125
D1GP165017	1.7	20	43	D1GP165056	5.6	57	93	D1GP165095	9.5	81	125
D1GP165018	1.8	22	46	D1GP165057	5.7	57	93	D1GP165096	9.6	87	133
D1GP165019	1.9	22	46	D1GP165058	5.8	57	93	D1GP165097	9.7	87	133
D1GP165020	2.0	24	49	D1GP165059	5.9	57	93	D1GP165098	9.8	87	133
D1GP165021	2.1	24	49	D1GP165060	6.0	57	93	D1GP165099	9.9	87	133
D1GP165022	2.2	27	53	D1GP165061	6.1	63	101	D1GP165100	10.0	87	133
D1GP165023	2.3	27	53	D1GP165062	6.2	63	101	D1GP165101	10.1	87	133
D1GP165024	2.4	30	57	D1GP165063	6.3	63	101	D1GP165102	10.2	87	133
D1GP165025	2.5	30	57	D1GP165064	6.4	63	101	D1GP165103	10.3	87	133
D1GP165026	2.6	30	57	D1GP165065	6.5	63	101	D1GP165104	10.4	87	133
D1GP165027	2.7	33	61	D1GP165066	6.6	63	101	D1GP165105	10.5	87	133
D1GP165028	2.8	33	61	D1GP165067	6.7	63	101	D1GP165106	10.6	87	133
D1GP165029	2.9	33	61	D1GP165068	6.8	69	109	D1GP165107	10.7	94	142
D1GP165030	3.0	33	61	D1GP165069	6.9	69	109	D1GP165108	10.8	94	142
D1GP165031	3.1	36	65	D1GP165070	7.0	69	109	D1GP165109	10.9	94	142
D1GP165032	3.2	36	65	D1GP165071	7.1	69	109	D1GP165110	11.0	94	142
D1GP165033	3.3	36	65	D1GP165072	7.2	69	109	D1GP165111	11.1	94	142
D1GP165034	3.4	39	70	D1GP165073	7.3	69	109	D1GP165112	11.2	94	142
D1GP165035	3.5	39	70	D1GP165074	7.4	69	109	D1GP165113	11.3	94	142
D1GP165036	3.6	39	70	D1GP165075	7.5	69	109	D1GP165114	11.4	94	142
D1GP165037	3.7	39	70	D1GP165076	7.6	75	117	D1GP165115	11.5	94	142
D1GP165038	3.8	43	75	D1GP165077	7.7	75	117	D1GP165116	11.6	94	142
D1GP165039	3.9	43	75	D1GP165078	7.8	75	117	D1GP165117	11.7	94	142
D1GP165040	4.0	43	75	D1GP165079	7.9	75	117	D1GP165118	11.8	94	142
D1GP165041	4.1	43	75	D1GP165080	8.0	75	117	D1GP165119	11.9	101	151
D1GP165042	4.2	43	75	D1GP165081	8.1	75	117	D1GP165120	12.0	101	151
D1GP165043	4.3	47	80	D1GP165082	8.2	75	117	D1GP165121	12.1	101	151
D1GP165044	4.4	47	80	D1GP165083	8.3	75	117	D1GP165122	12.2	101	151
D1GP165045	4.5	47	80	D1GP165084	8.4	75	117	D1GP165123	12.3	101	151
D1GP165046	4.6	47	80	D1GP165085	8.5	75	117	D1GP165124	12.4	101	151
D1GP165047	4.7	47	80	D1GP165086	8.6	81	125	D1GP165125	12.5	101	151
D1GP165048	4.8	52	86	D1GP165087	8.7	81	125	D1GP165126	12.6	101	151
D1GP165049	4.9	52	86	D1GP165088	8.8	81	125	D1GP165127	12.7	101	151
D1GP165050	5.0	52	86	D1GP165089	8.9	81	125	D1GP165128	12.8	101	151
D1GP165051	5.1	52	86	D1GP165090	9.0	81	125	D1GP165129	12.9	101	151
D1GP165052	5.2	52	86	D1GP165091	9.1	81	125	D1GP165130	13.0	101	151
D1GP165053	5.3	52	86	D1GP165092	9.2	81	125				
D1GP165054	5.4	57	93	D1GP165093	9.3	81	125				



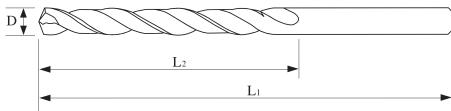
**Flute Geometry** : Right hand spiral  
**Point Angle** : 135°, under 1.6mm : Normal point  
 from 1.6mm : Split point  
**Surface treatment** : Bright body TiN coating on working part  
**Application** : Drilling in stainless steels, materials of difficult machinability such as titanium alloy and inconel.

unit:mm

EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1
DLGP195010	1.0	12	34	DLGP195051	5.1	52	86	DLGP195092	9.2	81	125
DLGP195011	1.1	14	36	DLGP195052	5.2	52	86	DLGP195093	9.3	81	125
DLGP195012	1.2	16	38	DLGP195053	5.3	52	86	DLGP195094	9.4	81	125
DLGP195013	1.3	16	38	DLGP195054	5.4	57	93	DLGP195095	9.5	81	125
DLGP195014	1.4	18	40	DLGP195055	5.5	57	93	DLGP195096	9.6	87	133
DLGP195015	1.5	18	40	DLGP195056	5.6	57	93	DLGP195097	9.7	87	133
DLGP195016	1.6	20	43	DLGP195057	5.7	57	93	DLGP195098	9.8	87	133
DLGP195017	1.7	20	43	DLGP195058	5.8	57	93	DLGP195099	9.9	87	133
DLGP195018	1.8	22	46	DLGP195059	5.9	57	93	DLGP195100	10.0	87	133
DLGP195019	1.9	22	46	DLGP195060	6.0	57	93	DLGP195101	10.1	87	133
DLGP195020	2.0	24	49	DLGP195061	6.1	63	101	DLGP195102	10.2	87	133
DLGP195021	2.1	24	49	DLGP195062	6.2	63	101	DLGP195103	10.3	87	133
DLGP195022	2.2	27	53	DLGP195063	6.3	63	101	DLGP195104	10.4	87	133
DLGP195023	2.3	27	53	DLGP195064	6.4	63	101	DLGP195105	10.5	87	133
DLGP195024	2.4	30	57	DLGP195065	6.5	63	101	DLGP195106	10.6	87	133
DLGP195025	2.5	30	57	DLGP195066	6.6	63	101	DLGP195107	10.7	94	142
DLGP195026	2.6	30	57	DLGP195067	6.7	63	101	DLGP195108	10.8	94	142
DLGP195027	2.7	33	61	DLGP195068	6.8	69	109	DLGP195109	10.9	94	142
DLGP195028	2.8	33	61	DLGP195069	6.9	69	109	DLGP195110	11.0	94	142
DLGP195029	2.9	33	61	DLGP195070	7.0	69	109	DLGP195111	11.1	94	142
DLGP195030	3.0	33	61	DLGP195071	7.1	69	109	DLGP195112	11.2	94	142
DLGP195031	3.1	36	65	DLGP195072	7.2	69	109	DLGP195113	11.3	94	142
DLGP195032	3.2	36	65	DLGP195073	7.3	69	109	DLGP195114	11.4	94	142
DLGP195033	3.3	36	65	DLGP195074	7.4	69	109	DLGP195115	11.5	94	142
DLGP195034	3.4	39	70	DLGP195075	7.5	69	109	DLGP195116	11.6	94	142
DLGP195035	3.5	39	70	DLGP195076	7.6	75	117	DLGP195117	11.7	94	142
DLGP195036	3.6	39	70	DLGP195077	7.7	75	117	DLGP195118	11.8	94	142
DLGP195037	3.7	39	70	DLGP195078	7.8	75	117	DLGP195119	11.9	101	151
DLGP195038	3.8	43	75	DLGP195079	7.9	75	117	DLGP195120	12.0	101	151
DLGP195039	3.9	43	75	DLGP195080	8.0	75	117	DLGP195121	12.1	101	151
DLGP195040	4.0	43	75	DLGP195081	8.1	75	117	DLGP195122	12.2	101	151
DLGP195041	4.1	43	75	DLGP195082	8.2	75	117	DLGP195123	12.3	101	151
DLGP195042	4.2	43	75	DLGP195083	8.3	75	117	DLGP195124	12.4	101	151
DLGP195043	4.3	47	80	DLGP195084	8.4	75	117	DLGP195125	12.5	101	151
DLGP195044	4.4	47	80	DLGP195085	8.5	75	117	DLGP195126	12.6	101	151
DLGP195045	4.5	47	80	DLGP195086	8.6	81	125	DLGP195127	12.7	101	151
DLGP195046	4.6	47	80	DLGP195087	8.7	81	125	DLGP195128	12.8	101	151
DLGP195047	4.7	47	80	DLGP195088	8.8	81	125	DLGP195129	12.9	101	151
DLGP195048	4.8	52	86	DLGP195089	8.9	81	125	DLGP195130	13.0	101	151
DLGP195049	4.9	52	86	DLGP195090	9.0	81	125				
DLGP195050	5.0	52	86	DLGP195091	9.1	81	125				

# GOLD-P DRILLS

## HSSCo5 Straight shank jobber length DH100 Type Gold-P coated Drills for deep hole(DIN338)



**Flute Geometry :** Right hand spiral, 38° helix, DH100 worm pattern type.

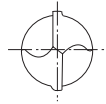
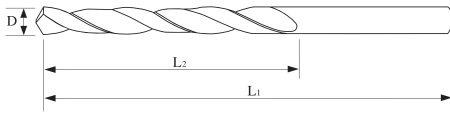
**Point Angle :** 130°, Split point giving higher chip removal.

**Surface treatment :** Bright body TiN coating on working part.

**Application :** Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, Special aluminum or magnesium alloys.

unit:mm

EDP No.	D h8	L <sub>2</sub>	L <sub>1</sub>	EDP No.	D h8	L <sub>2</sub>	L <sub>1</sub>	EDP No.	D h8	L <sub>2</sub>	L <sub>1</sub>
DLGP506020	2.0	24	49	DLGP506057	5.7	57	93	DLGP506094	9.4	81	125
DLGP506021	2.1	24	49	DLGP506058	5.8	57	93	DLGP506095	9.5	81	125
DLGP506022	2.2	27	53	DLGP506059	5.9	57	93	DLGP506096	9.6	87	133
DLGP506023	2.3	27	53	DLGP506060	6.0	57	93	DLGP506097	9.7	87	133
DLGP506024	2.4	30	57	DLGP506061	6.1	63	101	DLGP506098	9.8	87	133
DLGP506025	2.5	30	57	DLGP506062	6.2	63	101	DLGP506099	9.9	87	133
DLGP506026	2.6	30	57	DLGP506063	6.3	63	101	DLGP506100	10.0	87	133
DLGP506027	2.7	33	61	DLGP506064	6.4	63	101	DLGP506101	10.1	87	133
DLGP506028	2.8	33	61	DLGP506065	6.5	63	101	DLGP506102	10.2	87	133
DLGP506029	2.9	33	61	DLGP506066	6.6	63	101	DLGP506103	10.3	87	133
DLGP506030	3.0	33	61	DLGP506067	6.7	63	101	DLGP506104	10.4	87	133
DLGP506031	3.1	36	65	DLGP506068	6.8	69	109	DLGP506105	10.5	87	133
DLGP506032	3.2	36	65	DLGP506069	6.9	69	109	DLGP506106	10.6	87	133
DLGP506033	3.3	36	65	DLGP506070	7.0	69	109	DLGP506107	10.7	94	142
DLGP506034	3.4	39	70	DLGP506071	7.1	69	109	DLGP506108	10.8	94	142
DLGP506035	3.5	39	70	DLGP506072	7.2	69	109	DLGP506109	10.9	94	142
DLGP506036	3.6	39	70	DLGP506073	7.3	69	109	DLGP506110	11.0	94	142
DLGP506037	3.7	39	70	DLGP506074	7.4	69	109	DLGP506111	11.1	94	142
DLGP506038	3.8	43	75	DLGP506075	7.5	69	109	DLGP506112	11.2	94	142
DLGP506039	3.9	43	75	DLGP506076	7.6	75	117	DLGP506113	11.3	94	142
DLGP506040	4.0	43	75	DLGP506077	7.7	75	117	DLGP506114	11.4	94	142
DLGP506041	4.1	43	75	DLGP506078	7.8	75	117	DLGP506115	11.5	94	142
DLGP506042	4.2	43	75	DLGP506079	7.9	75	117	DLGP506116	11.6	94	142
DLGP506043	4.3	47	80	DLGP506080	8.0	75	117	DLGP506117	11.7	94	142
DLGP506044	4.4	47	80	DLGP506081	8.1	75	117	DLGP506118	11.8	94	142
DLGP506045	4.5	47	80	DLGP506082	8.2	75	117	DLGP506119	11.9	101	151
DLGP506046	4.6	47	80	DLGP506083	8.3	75	117	DLGP506120	12.0	101	151
DLGP506047	4.7	47	80	DLGP506084	8.4	75	117	DLGP506121	12.1	101	151
DLGP506048	4.8	52	86	DLGP506085	8.5	75	117	DLGP506122	12.2	101	151
DLGP506049	4.9	52	86	DLGP506086	8.6	81	125	DLGP506123	12.3	101	151
DLGP506050	5.0	52	86	DLGP506087	8.7	81	125	DLGP506124	12.4	101	151
DLGP506051	5.1	52	86	DLGP506088	8.8	81	125	DLGP506125	12.5	101	151
DLGP506052	5.2	52	86	DLGP506089	8.9	81	125	DLGP506126	12.6	101	151
DLGP506053	5.3	52	86	DLGP506090	9.0	81	125	DLGP506127	12.7	101	151
DLGP506054	5.4	57	93	DLGP506091	9.1	81	125	DLGP506128	12.8	101	151
DLGP506055	5.5	57	93	DLGP506092	9.2	81	125	DLGP506129	12.9	101	151
DLGP506056	5.6	57	93	DLGP506093	9.3	81	125	DLGP506130	13.0	101	151



**Flute Geometry :** Right hand spiral

**Point Angle :** 118°, Normal point

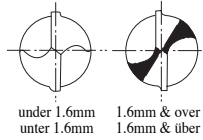
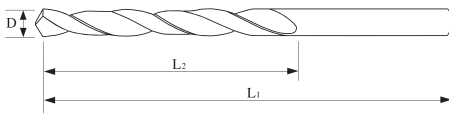
**Surface treatment :** Bright body TiN coating on working part

**Application :** Drilling in steel, cast steel alloyed and  
Non-alloyed, grey cast iron, graphite, malleable  
cast iron

unit:mm

EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1
D1GP103010	1.0	18	40	D1GP103051	5.1	62	92	D1GP103092	9.2	92	127
D1GP103011	1.1	20	42	D1GP103052	5.2	64	95	D1GP103093	9.3	92	127
D1GP103012	1.2	20	42	D1GP103053	5.3	64	95	D1GP103094	9.4	92	127
D1GP103013	1.3	22	45	D1GP103054	5.4	64	95	D1GP103095	9.5	92	127
D1GP103014	1.4	23	48	D1GP103055	5.5	64	95	D1GP103096	9.6	95	130
D1GP103015	1.5	23	48	D1GP103056	5.6	67	98	D1GP103097	9.7	95	130
D1GP103016	1.6	25	50	D1GP103057	5.7	67	98	D1GP103098	9.8	95	130
D1GP103017	1.7	25	50	D1GP103058	5.8	67	98	D1GP103099	9.9	95	130
D1GP103018	1.8	28	52	D1GP103059	5.9	67	98	D1GP103100	10.0	95	130
D1GP103019	1.9	28	52	D1GP103060	6.0	70	102	D1GP103101	10.1	98	133
D1GP103020	2.0	29	55	D1GP103061	6.1	70	102	D1GP103102	10.2	98	133
D1GP103021	2.1	29	55	D1GP103062	6.2	70	102	D1GP103103	10.3	98	133
D1GP103022	2.2	33	58	D1GP103063	6.3	70	102	D1GP103104	10.4	98	133
D1GP103023	2.3	33	58	D1GP103064	6.4	73	105	D1GP103105	10.5	100	137
D1GP103024	2.4	35	61	D1GP103065	6.5	73	105	D1GP103106	10.6	100	137
D1GP103025	2.5	35	61	D1GP103066	6.6	73	105	D1GP103107	10.7	100	137
D1GP103026	2.6	37	64	D1GP103067	6.7	73	105	D1GP103108	10.8	103	140
D1GP103027	2.7	37	64	D1GP103068	6.8	73	105	D1GP103109	10.9	103	140
D1GP103028	2.8	39	67	D1GP103069	6.9	73	105	D1GP103110	11.0	103	140
D1GP103029	2.9	42	71	D1GP103070	7.0	73	105	D1GP103111	11.1	103	140
D1GP103030	3.0	42	71	D1GP103071	7.1	75	108	D1GP103112	11.2	106	143
D1GP103031	3.1	42	71	D1GP103072	7.2	75	108	D1GP103113	11.3	106	143
D1GP103032	3.2	42	71	D1GP103073	7.3	75	108	D1GP103114	11.4	106	143
D1GP103033	3.3	45	73	D1GP103074	7.4	78	111	D1GP103115	11.5	106	143
D1GP103034	3.4	45	73	D1GP103075	7.5	78	111	D1GP103116	11.6	109	146
D1GP103035	3.5	45	73	D1GP103076	7.6	78	111	D1GP103117	11.7	109	146
D1GP103036	3.6	48	76	D1GP103077	7.7	81	114	D1GP103118	11.8	109	146
D1GP103037	3.7	48	76	D1GP103078	7.8	81	114	D1GP103119	11.9	109	146
D1GP103038	3.8	48	76	D1GP103079	7.9	81	114	D1GP103120	12.0	111	149
D1GP103039	3.9	51	79	D1GP103080	8.0	81	114	D1GP103121	12.1	111	149
D1GP103040	4.0	54	83	D1GP103081	8.1	84	117	D1GP103122	12.2	111	149
D1GP103041	4.1	54	83	D1GP103082	8.2	84	117	D1GP103123	12.3	111	149
D1GP103042	4.2	54	83	D1GP103083	8.3	84	117	D1GP103124	12.4	114	152
D1GP103043	4.3	54	83	D1GP103084	8.4	87	121	D1GP103125	12.5	114	152
D1GP103044	4.4	56	86	D1GP103085	8.5	87	121	D1GP103126	12.6	114	152
D1GP103045	4.5	56	86	D1GP103086	8.6	87	121	D1GP103127	12.7	114	152
D1GP103046	4.6	56	86	D1GP103087	8.7	87	121	D1GP103128	12.8	114	152
D1GP103047	4.7	59	89	D1GP103088	8.8	89	124	D1GP103129	12.9	114	152
D1GP103048	4.8	59	89	D1GP103089	8.9	89	124	D1GP103130	13.0	114	152
D1GP103049	4.9	62	92	D1GP103090	9.0	89	124				
D1GP103050	5.0	62	92	D1GP103091	9.1	89	124				





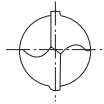
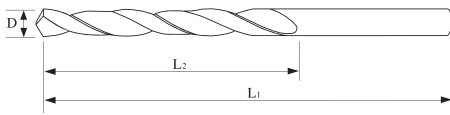
**Flute Geometry :** Right hand spiral  
**Point Angle :** 135°, under 1.6mm:Normal point  
 from 1.6mm:Split point  
**Surface treatment :** Bright body TiN coating on working part  
**Application :** Drilling in stainless steels, materials of difficult  
 machinability such as titanium alloy and inconel.

unit:mm

EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1	EDP No.	D h8	L2	L1
D2GP191010	1.0	18	40	D2GP191051	5.1	62	92	D2GP191092	9.2	92	127
D2GP191011	1.1	20	42	D2GP191052	5.2	64	95	D2GP191093	9.3	92	127
D2GP191012	1.2	20	42	D2GP191053	5.3	64	95	D2GP191094	9.4	92	127
D2GP191013	1.3	22	45	D2GP191054	5.4	64	95	D2GP191095	9.5	92	127
D2GP191014	1.4	23	48	D2GP191055	5.5	64	95	D2GP191096	9.6	95	130
D2GP191015	1.5	23	48	D2GP191056	5.6	67	98	D2GP191097	9.7	95	130
D2GP191016	1.6	25	50	D2GP191057	5.7	67	98	D2GP191098	9.8	95	130
D2GP191017	1.7	25	50	D2GP191058	5.8	67	98	D2GP191099	9.9	95	130
D2GP191018	1.8	28	52	D2GP191059	5.9	67	98	D2GP191100	10.0	95	130
D2GP191019	1.9	28	52	D2GP191060	6.0	70	102	D2GP191101	10.1	98	133
D2GP191020	2.0	29	55	D2GP191061	6.1	70	102	D2GP191102	10.2	98	133
D2GP191021	2.1	29	55	D2GP191062	6.2	70	102	D2GP191103	10.3	98	133
D2GP191022	2.2	33	58	D2GP191063	6.3	70	102	D2GP191104	10.4	98	133
D2GP191023	2.3	33	58	D2GP191064	6.4	73	105	D2GP191105	10.5	100	137
D2GP191024	2.4	35	61	D2GP191065	6.5	73	105	D2GP191106	10.6	100	137
D2GP191025	2.5	35	61	D2GP191066	6.6	73	105	D2GP191107	10.7	100	137
D2GP191026	2.6	37	64	D2GP191067	6.7	73	105	D2GP191108	10.8	103	140
D2GP191027	2.7	37	64	D2GP191068	6.8	73	105	D2GP191109	10.9	103	140
D2GP191028	2.8	39	67	D2GP191069	6.9	73	105	D2GP191110	11.0	103	140
D2GP191029	2.9	42	71	D2GP191070	7.0	73	105	D2GP191111	11.1	103	140
D2GP191030	3.0	42	71	D2GP191071	7.1	75	108	D2GP191112	11.2	106	143
D2GP191031	3.1	42	71	D2GP191072	7.2	75	108	D2GP191113	11.3	106	143
D2GP191032	3.2	42	71	D2GP191073	7.3	75	108	D2GP191114	11.4	106	143
D2GP191033	3.3	45	73	D2GP191074	7.4	78	111	D2GP191115	11.5	106	143
D2GP191034	3.4	45	73	D2GP191075	7.5	78	111	D2GP191116	11.6	109	146
D2GP191035	3.5	45	73	D2GP191076	7.6	78	111	D2GP191117	11.7	109	146
D2GP191036	3.6	48	76	D2GP191077	7.7	81	114	D2GP191118	11.8	109	146
D2GP191037	3.7	48	76	D2GP191078	7.8	81	114	D2GP191119	11.9	109	146
D2GP191038	3.8	48	76	D2GP191079	7.9	81	114	D2GP191120	12.0	111	149
D2GP191039	3.9	51	79	D2GP191080	8.0	81	114	D2GP191121	12.1	111	149
D2GP191040	4.0	54	83	D2GP191081	8.1	84	117	D2GP191122	12.2	111	149
D2GP191041	4.1	54	83	D2GP191082	8.2	84	117	D2GP191123	12.3	111	149
D2GP191042	4.2	54	83	D2GP191083	8.3	84	117	D2GP191124	12.4	114	152
D2GP191043	4.3	54	83	D2GP191084	8.4	87	121	D2GP191125	12.5	114	152
D2GP191044	4.4	56	86	D2GP191085	8.5	87	121	D2GP191126	12.6	114	152
D2GP191045	4.5	56	86	D2GP191086	8.6	87	121	D2GP191127	12.7	114	152
D2GP191046	4.6	56	86	D2GP191087	8.7	87	121	D2GP191128	12.8	114	152
D2GP191047	4.7	59	89	D2GP191088	8.8	89	124	D2GP191129	12.9	114	152
D2GP191048	4.8	59	89	D2GP191089	8.9	89	124	D2GP191130	13.0	114	152
D2GP191049	4.9	62	92	D2GP191090	9.0	89	124				
D2GP191050	5.0	62	92	D2GP191091	9.1	89	124				

# GOLD-P DRILLS

## HSS Straight shank jobber length Gold-P coated Drills(ANSI)



**Flute Geometry** : Right hand spiral

**Point Angle** : 118°, Normal point

**Surface treatment** : Bright body TiN coating on working part

**Application** : Drilling in steel, cast steel alloyed and  
Non-alloyed, grey cast iron, graphite, malleable  
cast iron

### ► Fractional sizes

unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D1GP113003	3/64	.0469	3/4	1-3/4
D1GP113004	1/16	.0625	7/8	1-7/8
D1GP113005	5/64	.0781	1	2
D1GP113006	3/32	.0938	1-1/4	2-1/4
D1GP113007	7/64	.1094	1-1/2	2-5/8
D1GP113008	1/8	.1250	1-5/8	2-3/4
D1GP113009	9/64	.1406	1-3/4	2-7/8
D1GP113010	5/32	.1563	2	3-1/8
D1GP113011	11/64	.1719	2-1/8	3-1/4
D1GP113012	3/16	.1875	2-5/16	3-1/2
D1GP113013	13/64	.2031	2-7/16	3-5/8
D1GP113014	7/32	.2188	2-1/2	3-3/4
D1GP113015	15/64	.2344	2-5/8	3-7/8
D1GP113016	1/4	.2500	2-3/4	4
D1GP113017	17/64	.2656	2-7/8	4-1/8
D1GP113018	9/32	.2813	2-15/16	4-1/4
D1GP113019	19/64	.2969	3-1/16	4-3/8
D1GP113020	5/16	.3125	3-3/16	4-1/2
D1GP113021	21/64	.3281	3-5/16	4-5/8
D1GP113022	11/32	.3438	3-7/16	4-3/4
D1GP113023	23/64	.3594	3-1/2	4-7/8
D1GP113024	3/8	.3750	3-5/8	5
D1GP113025	25/64	.3906	3-3/4	5-1/8
D1GP113026	13/32	.4063	3-7/8	5-1/4
D1GP113027	27/64	.4219	3-15/16	5-3/8
D1GP113028	7/16	.4375	4-1/16	5-1/2
D1GP113029	29/64	.4531	4-3/16	5-5/8
D1GP113030	15/32	.4688	4-5/16	5-3/4
D1GP113031	31/64	.4844	4-3/8	5-7/8
D1GP113032	1/2	.5000	4-1/2	6

### ► Letter sizes

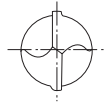
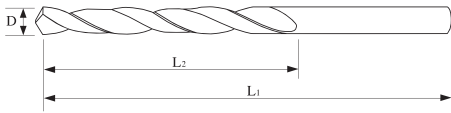
unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D1GP136101	A	.2340	2-5/8	3-7/8
D1GP136102	B	.2380	2-3/4	4
D1GP136103	C	.2420	2-3/4	4
D1GP136104	D	.2460	2-3/4	4
D1GP113016	E	.2500	2-3/4	4
D1GP136106	F	.2570	2-7/8	4-1/8
D1GP136107	G	.2610	2-7/8	4-1/8
D1GP136108	H	.2660	2-7/8	4-1/8
D1GP136109	I	.2720	2-7/8	4-1/8
D1GP136110	J	.2770	2-7/8	4-1/8
D1GP136111	K	.2810	2-15/16	4-1/4
D1GP136112	L	.2900	2-15/16	4-1/4
D1GP136136	M	.2950	3-1/16	4-3/8
D1GP136114	N	.3020	3-1/16	4-3/8
D1GP136115	O	.3160	3-3/16	4-1/2
D1GP136116	P	.3230	3-5/16	4-5/8
D1GP136117	Q	.3320	3-7/16	4-3/4
D1GP136118	R	.3390	3-7/16	4-3/4
D1GP136119	S	.3480	3-1/2	4-7/8
D1GP136120	T	.3580	3-1/2	4-7/8
D1GP136121	U	.3680	3-5/8	5
D1GP136122	V	.3770	3-5/8	5
D1GP136123	W	.3860	3-3/4	5-1/8
D1GP136124	X	.3970	3-3/4	5-1/8
D1GP136125	Y	.4040	3-7/8	5-1/4
D1GP136126	Z	.4130	3-7/8	5-1/4

**Tolerance of D** /  $\frac{\text{upto } 1/8(.1250)}{0 \sim -.0005}$   
 $\frac{\text{over } 1/8(.1250) \sim \text{upto } 1/4(.2500)}{0 \sim -.0007}$   
 $\frac{\text{over } 1/4(.2500) \sim \text{upto } 1/2(.5000)}{0 \sim -.0010}$

# GOLD-P DRILLS

## HSS Straight shank jobber length Gold-P coated Drills(ANSI)



**Flute Geometry** : Right hand spiral  
**Point Angle** : 118°, Normal point  
**Surface treatment** : Bright body TiN coating on working part  
**Application** : Drilling in steel, cast steel alloyed and  
 Non-alloyed, grey cast iron, graphite, malleable cast iron

### ► Wire gage sizes

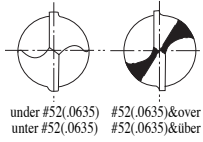
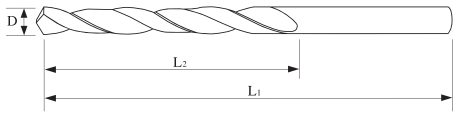
unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>	EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D1GP134256	1	.2280	2-5/8	3-7/8	D1GP134228	29	.1360	1-3/4	2-7/8
D1GP134255	2	.2210	2-5/8	3-7/8	D1GP134227	30	.1285	1-5/8	2-3/4
D1GP134254	3	.2130	2-1/2	3-3/4	D1GP134226	31	.1200	1-5/8	2-3/4
D1GP134253	4	.2090	2-1/2	3-3/4	D1GP134225	32	.1160	1-5/8	2-3/4
D1GP134252	5	.2055	2-1/2	3-3/4	D1GP134224	33	.1130	1-1/2	2-5/8
D1GP134251	6	.2040	2-1/2	3-3/4	D1GP134223	34	.1110	1-1/2	2-5/8
D1GP134250	7	.2010	2-7/16	3-5/8	D1GP134222	35	.1100	1-1/2	2-5/8
D1GP134249	8	.1990	2-7/16	3-5/8	D1GP134221	36	.1065	1-7/16	2-1/2
D1GP134248	9	.1960	2-7/16	3-5/8	D1GP134220	37	.1040	1-7/16	2-1/2
D1GP134247	10	.1935	2-7/16	3-5/8	D1GP134219	38	.1015	1-7/16	2-1/2
D1GP134246	11	.1910	2-5/16	3-1/2	D1GP134218	39	.0995	1-3/8	2-3/8
D1GP134245	12	.1890	2-5/16	3-1/2	D1GP134217	40	.0980	1-3/8	2-3/8
D1GP134244	13	.1850	2-5/16	3-1/2	D1GP134216	41	.0960	1-3/8	2-3/8
D1GP134243	14	.1820	2-3/16	3-3/8	D1GP134215	42	.0935	1-1/4	2-1/4
D1GP134242	15	.1800	2-3/16	3-3/8	D1GP134214	43	.0890	1-1/4	2-1/4
D1GP134241	16	.1770	2-3/16	3-3/8	D1GP134213	44	.0860	1-1/8	2-1/8
D1GP134240	17	.1730	2-3/16	3-3/8	D1GP134212	45	.0820	1-1/8	2-1/8
D1GP134239	18	.1695	2-1/8	3-1/4	D1GP134211	46	.0810	1-1/8	2-1/8
D1GP134238	19	.1660	2-1/8	3-1/4	D1GP134210	47	.0785	1	2
D1GP134237	20	.1610	2-1/8	3-1/4	D1GP134209	48	.0760	1	2
D1GP134236	21	.1590	2-1/8	3-1/4	D1GP134208	49	.0730	1	2
D1GP134235	22	.1570	2	3-1/8	D1GP134207	50	.0700	1	2
D1GP134234	23	.1540	2	3-1/8	D1GP134206	51	.0670	1	2
D1GP134233	24	.1520	2	3-1/8	D1GP134205	52	.0635	7/8	1-7/8
D1GP134232	25	.1495	1-7/8	3	D1GP134204	53	.0595	7/8	1-7/8
D1GP134231	26	.1470	1-7/8	3	D1GP134203	54	.0550	7/8	1-7/8
D1GP134230	27	.1440	1-7/8	3	D1GP134202	55	.0520	7/8	1-7/8
D1GP134229	28	.1405	1-3/4	2-7/8	D1GP134201	56	.0465	3/4	1-3/4

Tolerance of D /  $\begin{cases} \text{upto } 1/8(.1250) \\ 0 \sim -.0005 \end{cases}$   
 $\begin{cases} \text{over } 1/8(.1250) \sim \text{upto } 1/4(.2500) \\ 0 \sim -.0007 \end{cases}$   
 $\begin{cases} \text{over } 1/4(.2500) \sim \text{upto } 1/2(.5000) \\ 0 \sim -.0010 \end{cases}$

# GOLD-P DRILLS

## HSSCo8 Straight shank jobber length Gold-P coated Drills(ANSI)



**Flute Geometry** : Right hand spiral  
**Point Angle** : 135°, Fractional size #3/64:Normal point  
 Wire gage size #53~#56:Normal point  
 over Fractional size # 1/16(including): Split point  
 Wire gage size #1~#52:Split point  
**Surface treatment** : Bright body TiN coating on working part  
**Application** : Drilling in stainless steels, materials of difficult  
 machinability such as titanium alloy and inconel.

### Fractional sizes

unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D2GP185003	3/64	.0469	3/4	1-3/4
D2GP185004	1/16	.0625	7/8	1-7/8
D2GP185005	5/64	.0781	1	2
D2GP185006	3/32	.0938	1-1/4	2-1/4
D2GP185007	7/64	.1094	1-1/2	2-5/8
D2GP185008	1/8	.1250	1-5/8	2-3/4
D2GP185009	9/64	.1406	1-3/4	2-7/8
D2GP185010	5/32	.1563	2	3-1/8
D2GP185011	11/64	.1719	2-1/8	3-1/4
D2GP185012	3/16	.1875	2-5/16	3-1/2
D2GP185013	13/64	.2031	2-7/16	3-5/8
D2GP185014	7/32	.2188	2-1/2	3-3/4
D2GP185015	15/64	.2344	2-5/8	3-7/8
D2GP185016	1/4	.2500	2-3/4	4
D2GP185017	17/64	.2656	2-7/8	4-1/8
D2GP185018	9/32	.2813	2-15/16	4-1/4
D2GP185019	19/64	.2969	3-1/16	4-3/8
D2GP185020	5/16	.3125	3-3/16	4-1/2
D2GP185021	21/64	.3281	3-5/16	4-5/8
D2GP185022	11/32	.3438	3-7/16	4-3/4
D2GP185023	23/64	.3594	3-1/2	4-7/8
D2GP185024	3/8	.3750	3-5/8	5
D2GP185025	25/64	.3906	3-3/4	5-1/8
D2GP185026	13/32	.4063	3-7/8	5-1/4
D2GP185027	27/64	.4219	3-15/16	5-3/8
D2GP185028	7/16	.4375	4-1/16	5-1/2
D2GP185029	29/64	.4531	4-3/16	5-5/8
D2GP185030	15/32	.4688	4-5/16	5-3/4
D2GP185031	31/64	.4844	4-3/8	5-7/8
D2GP185032	1/2	.5000	4-1/2	6

### Letter sizes

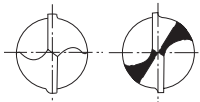
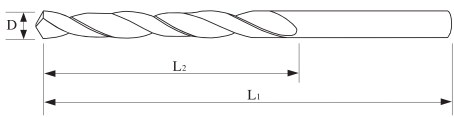
unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D2GP186101	A	.2340	2-5/8	3-7/8
D2GP186102	B	.2380	2-3/4	4
D2GP186103	C	.2420	2-3/4	4
D2GP186104	D	.2460	2-3/4	4
D2GP185016	E	.2500	2-3/4	4
D2GP186106	F	.2570	2-7/8	4-1/8
D2GP186107	G	.2610	2-7/8	4-1/8
D2GP186108	H	.2660	2-7/8	4-1/8
D2GP186109	I	.2720	2-7/8	4-1/8
D2GP186110	J	.2770	2-7/8	4-1/8
D2GP186111	K	.2810	2-15/16	4-1/4
D2GP186112	L	.2900	2-15/16	4-1/4
D2GP186113	M	.2950	3-1/16	4-3/8
D2GP186114	N	.3020	3-1/16	4-3/8
D2GP186115	O	.3160	3-3/16	4-1/2
D2GP186116	P	.3230	3-5/16	4-5/8
D2GP186117	Q	.3320	3-7/16	4-3/4
D2GP186118	R	.3390	3-7/16	4-3/4
D2GP186119	S	.3480	3-1/2	4-7/8
D2GP186120	T	.3580	3-1/2	4-7/8
D2GP186121	U	.3680	3-5/8	5
D2GP186122	V	.3770	3-5/8	5
D2GP186123	W	.3860	3-3/4	5-1/8
D2GP186124	X	.3970	3-3/4	5-1/8
D2GP186125	Y	.4040	3-7/8	5-1/4
D2GP186126	Z	.4130	3-7/8	5-1/4

Tolerance of D /  $\frac{\text{upto } 1/8(.1250)}{0 \sim -.0005}$   
 $\frac{\text{over } 1/8(.1250) \sim \text{upto } 1/4(.2500)}{0 \sim -.0007}$   
 $\frac{\text{over } 1/4(.2500) \sim \text{upto } 1/2(.5000)}{0 \sim -.0010}$

# GOLD-P DRILLS

## HSSCo8 Straight shank jobber length Gold-P coated Drills(ANSI)



under #52(.0635) #52(.0635)&over  
unter #52(.0635) #52(.0635)&über

**Flute Geometry** : Right hand spiral

**Point Angle** : 135°, Fractional size  $\neq$  3/64 Normal point

Wire gage size #53-#56: Normal point

over Fractional size  $\neq$  1/16(including): Split point

Wire gage size #1-#52: Split point

**Surface treatment** : Bright body TiN coating on working part

**Application** : Drilling in stainless steels, materials of difficult machinability such as titanium alloy and inconel.

### ► Wire gage sizes

unit inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>	EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
D2GP187256	1	.2280	2-5/8	3-7/8	D2GP187228	29	.1360	1-3/4	2-7/8
D2GP187255	2	.2210	2-5/8	3-7/8	D2GP187227	30	.1285	1-5/8	2-3/4
D2GP187254	3	.2130	2-1/2	3-3/4	D2GP187226	31	.1200	1-5/8	2-3/4
D2GP187253	4	.2090	2-1/2	3-3/4	D2GP187225	32	.1160	1-5/8	2-3/4
D2GP187252	5	.2055	2-1/2	3-3/4	D2GP187224	33	.1130	1-1/2	2-5/8
D2GP187251	6	.2040	2-1/2	3-3/4	D2GP187223	34	.1110	1-1/2	2-5/8
D2GP187250	7	.2010	2-7/16	3-5/8	D2GP187222	35	.1100	1-1/2	2-5/8
D2GP187249	8	.1990	2-7/16	3-5/8	D2GP187221	36	.1065	1-7/16	2-1/2
D2GP187248	9	.1960	2-7/16	3-5/8	D2GP187220	37	.1040	1-7/16	2-1/2
D2GP187247	10	.1935	2-7/16	3-5/8	D2GP187219	38	.1015	1-7/16	2-1/2
D2GP187246	11	.1910	2-5/16	3-1/2	D2GP187218	39	.0995	1-3/8	2-3/8
D2GP187245	12	.1890	2-5/16	3-1/2	D2GP187217	40	.0980	1-3/8	2-3/8
D2GP187244	13	.1850	2-5/16	3-1/2	D2GP187216	41	.0960	1-3/8	2-3/8
D2GP187243	14	.1820	2-3/16	3-3/8	D2GP187215	42	.0935	1-1/4	2-1/4
D2GP187242	15	.1800	2-3/16	3-3/8	D2GP187214	43	.0890	1-1/4	2-1/4
D2GP187241	16	.1770	2-3/16	3-3/8	D2GP187213	44	.0860	1-1/8	2-1/8
D2GP187240	17	.1730	2-3/16	3-3/8	D2GP187212	45	.0820	1-1/8	2-1/8
D2GP187239	18	.1695	2-1/8	3-1/4	D2GP187211	46	.0810	1-1/8	2-1/8
D2GP187238	19	.1660	2-1/8	3-1/4	D2GP187210	47	.0785	1	2
D2GP187237	20	.1610	2-1/8	3-1/4	D2GP187209	48	.0760	1	2
D2GP187236	21	.1590	2-1/8	3-1/4	D2GP187208	49	.0730	1	2
D2GP187235	22	.1570	2	3-1/8	D2GP187207	50	.0700	1	2
D2GP187234	23	.1540	2	3-1/8	D2GP187206	51	.0670	1	2
D2GP187233	24	.1520	2	3-1/8	D2GP187205	52	.0635	7/8	1-7/8
D2GP187232	25	.1495	1-7/8	3	D2GP187204	53	.0595	7/8	1-7/8
D2GP187231	26	.1470	1-7/8	3	D2GP187203	54	.0550	7/8	1-7/8
D2GP187230	27	.1440	1-7/8	3	D2GP187202	55	.0520	7/8	1-7/8
D2GP187229	28	.1405	1-3/4	2-7/8	D2GP187201	56	.0465	3/4	1-3/4

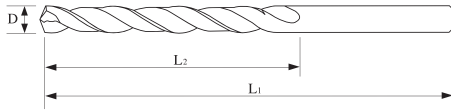
Tolerance of D /  $\frac{\text{upto } 1/8(.1250)}{0 \sim -.0005}$

/over 1/8(.1250) ~ upto 1/4(.2500)  
0 ~ -.0007

/over 1/4(.2500) ~ upto 1/2(.5000)  
0 ~ -.0010

# GOLD-P DRILLS

## HSSCo5 Straight shank jobber length DH100 Type Gold-P coated Drills(ANSI)



**Flute Geometry** : Right hand spiral, 38° helix, DH100 worm pattern type.

**Point Angle** : 130°, split point giving higher chip removal.

**Surface treatment** : Bright body TiN coating on working part

**Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, Special aluminum or magnesium alloys

### ► Fractional sizes

unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
DLGP511005	5/64	.0781	1	2
DLGP511006	3/32	.0938	1-1/4	2-1/4
DLGP511007	7/64	.1094	1-1/2	2-5/8
DLGP511008	1/8	.1250	1-5/8	2-3/4
DLGP511009	9/64	.1406	1-3/4	2-7/8
DLGP511010	5/32	.1563	2	3-1/8
DLGP511011	11/64	.1719	2-1/8	3-1/4
DLGP511012	3/16	.1875	2-5/16	3-1/2
DLGP511013	13/64	.2031	2-7/16	3-5/8
DLGP511014	7/32	.2188	2-1/2	3-3/4
DLGP511015	15/64	.2344	2-5/8	3-7/8
DLGP511016	1/4	.2500	2-3/4	4
DLGP511017	17/64	.2656	2-7/8	4-1/8
DLGP511018	9/32	.2813	2-15/16	4-1/4
DLGP511019	19/64	.2969	3-1/16	4-3/8
DLGP511020	5/16	.3125	3-3/16	4-1/2
DLGP511021	21/64	.3281	3-5/16	4-5/8
DLGP511022	11/32	.3438	3-7/16	4-3/4
DLGP511023	23/64	.3594	3-1/2	4-7/8
DLGP511024	3/8	.3750	3-5/8	5
DLGP511025	25/64	.3906	3-3/4	5-1/8
DLGP511026	13/32	.4063	3-7/8	5-1/4
DLGP511027	27/64	.4219	3-15/16	5-3/8
DLGP511028	7/16	.4375	4-1/16	5-1/2
DLGP511029	29/64	.4531	4-3/16	5-5/8
DLGP511030	15/32	.4688	5-3/4	
DLGP511031	31/64	.4844	5-7/8	
DLGP511032	1/2	.5000	6	

### ► Letter sizes

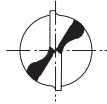
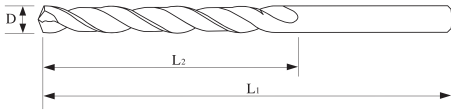
unit:inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
DLGP513101	A	.2340	2-5/8	3-7/8
DLGP513102	B	.2380	2-3/4	4
DLGP513103	C	.2420	2-3/4	4
DLGP513104	D	.2460	2-3/4	4
DLGP511016	E	.2500	2-3/4	4
DLGP513106	F	.2570	2-7/8	4-1/8
DLGP513107	G	.2610	2-7/8	4-1/8
DLGP513108	H	.2660	2-7/8	4-1/8
DLGP513109	I	.2720	2-7/8	4-1/8
DLGP513110	J	.2770	2-7/8	4-1/8
DLGP513111	K	.2810	2-15/16	4-1/4
DLGP513112	L	.2900	2-15/16	4-1/4
DLGP513113	M	.2950	3-1/16	4-3/8
DLGP513114	N	.3020	3-1/16	4-3/8
DLGP513115	O	.3160	3-3/16	4-1/2
DLGP513116	P	.3230	3-5/16	4-5/8
DLGP513117	Q	.3320	3-7/16	4-3/4
DLGP513118	R	.3390	3-7/16	4-3/4
DLGP513119	S	.3480	3-1/2	4-7/8
DLGP513120	T	.3580	3-1/2	4-7/8
DLGP513121	U	.3680	3-5/8	5
DLGP513122	V	.3770	3-5/8	5
DLGP513123	W	.3860	3-3/4	5-1/8
DLGP513124	X	.3970	3-3/4	5-1/8
DLGP513125	Y	.4040	3-7/8	5-1/4
DLGP513126	Z	.4130	3-7/8	5-1/4

Tolerance of D /  $\frac{\text{upto } 1/8(.1250)}{0 \sim -.0005}$   
 $\frac{\text{over } 1/8(.1250) \sim \text{upto } 1/4(.2500)}{0 \sim -.0007}$   
 $\frac{\text{over } 1/4(.2500) \sim \text{upto } 1/2(.5000)}{0 \sim -.0010}$

# GOLD-P DRILLS

## HSSCo5 Straight shank jobber length DH100 Type Gold-P coated Drills(ANSI)



**Flute Geometry** : Right hand spiral, 38° helix, DH100 worm pattern type.

**Point Angle** : 130°, split point giving higher chip removal.

**Surface treatment** : Bright body TiN coating on working part

**Application** : Drilling deep holes in non alloy steels, alloy steels, gray cast iron, malleable cast iron, Special aluminum or magnesium alloys

### ► Wire gage sizes

unit inch

EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>	EDP No.	SIZE	D	L <sub>2</sub>	L <sub>1</sub>
DLGP512247	1	.2280	2-5/8	3-7/8	DLGP512223	25	.1495	1-7/8	3
DLGP512246	2	.2210	2-5/8	3-7/8	DLGP512222	26	.1470	1-7/8	3
DLGP512245	3	.2130	2-1/2	3-3/4	DLGP512221	27	.1440	1-7/8	3
DLGP512244	4	.2090	2-1/2	3-3/4	DLGP512220	28	.1405	1-3/4	2-7/8
DLGP512243	5	.2055	2-1/2	3-3/4	DLGP512219	29	.1360	1-3/4	2-7/8
DLGP512242	6	.2040	2-1/2	3-3/4	DLGP512218	30	.1285	1-5/8	2-3/4
DLGP512241	7	.2010	2-7/16	3-5/8	DLGP512217	31	.1200	1-5/8	2-3/4
DLGP512240	8	.1990	2-7/16	3-5/8	DLGP512216	32	.1160	1-5/8	2-3/4
DLGP512239	9	.1960	2-7/16	3-5/8	DLGP512215	33	.1130	1-1/2	2-5/8
DLGP512238	10	.1935	2-7/16	3-5/8	DLGP512214	34	.1110	1-1/2	2-5/8
DLGP512237	11	.1910	2-5/16	3-1/2	DLGP512213	35	.1100	1-1/2	2-5/8
DLGP512236	12	.1890	2-5/16	3-1/2	DLGP512212	36	.1065	1-7/16	2-1/2
DLGP512235	13	.1850	2-5/16	3-1/2	DLGP512211	37	.1040	1-7/16	2-1/2
DLGP512234	14	.1820	2-3/16	3-3/8	DLGP512210	38	.1015	1-7/16	2-1/2
DLGP512233	15	.1800	2-3/16	3-3/8	DLGP512209	39	.0995	1-3/8	2-3/8
DLGP512232	16	.1770	2-3/16	3-3/8	DLGP512208	40	.0980	1-3/8	2-3/8
DLGP512231	17	.1730	2-3/16	3-3/8	DLGP512207	41	.0960	1-3/8	2-3/8
DLGP512230	18	.1695	2-1/8	3-1/4	DLGP512206	42	.0935	1-1/4	2-1/4
DLGP512229	19	.1660	2-1/8	3-1/4	DLGP512205	43	.0890	1-1/4	2-1/4
DLGP512228	20	.1610	2-1/8	3-1/4	DLGP512204	44	.0860	1-1/8	2-1/8
DLGP512227	21	.1590	2-1/8	3-1/4	DLGP512203	45	.0820	1-1/8	2-1/8
DLGP512226	22	.1570	2	3-1/8	DLGP512202	46	.0810	1-1/8	2-1/8
DLGP512225	23	.1540	2	3-1/8	DLGP512201	47	.0785	1	2
DLGP512224	24	.1520	2	3-1/8					

Tolerance of D /  $\frac{\text{upto } 1/8(.1250)}{0 \sim -.0005}$

/over 1/8(.1250) ~ upto 1/4(.2500)  
0 ~ -.0007

/over 1/4(.2500) ~ upto 1/2(.5000)  
0 ~ -.0010



## DIN338 DRILL SET JOBBER LENGTH Gold-P coated Drills

SET NO.	DESCRIPTON	SIZE	Q'TY
D1GP165SET1	HSS Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
D1GP165SET2	HSS Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-13.0X0.5mm step	25 pcs
DLGP165SET3	HSS Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs
DLGP195SET1	HSSCo5 Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
DLGP195SET2	HSSCo5 Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs
DLGP195SET3	HSSCo5 Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-10.5x0.5mm step +3.3 +4.2 +6.8 +10.2	24 pcs

## JIS DRILL SET REGULAR LENGTH Gold-P coated Drills

SET NO.	DESCRIPTON	SIZE	Q'TY
D1GP103SET1	HSS Straight Shank, Normal Point	1.0-10.0x0.5mm step	19 pcs
D1GP103SET2	HSS Straight Shank, Normal Point	1.0-13.0X0.5mm step	25 pcs
D2GP191SET1	HSSCo8 Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-10.0x0.5mm step	19 pcs
D2GP191SET2	HSSCo8 Straight Shank, Split Point ( $\phi$ 1.0 & $\phi$ 1.5 : NORMAL point)	1.0-13.0x0.5mm step	25 pcs



**[ D1GP125, D1GP165, DLGP195, D1GP103, D2GP191 Series ]**

Work Material Werkstück	Carbon Steels Stähle		Carbon Steels Stähle		Alloy Steels Stahl-Legierungen		Stainless Steels Edelstähle	
Hardness			~ HRC23		HRC23 ~ 34		~ HRC23	
Strength	~ 570N/mm <sup>2</sup>		~ 830N/mm <sup>2</sup>		830~1110N/mm <sup>2</sup>		~ 830N/mm <sup>2</sup>	
Diameter(mm)	N	S	N	S	N	S	N	S
1	14000	0.02	12500	0.02	7700	0.02	7000	0.02
2	7000	0.06	6100	0.06	3850	0.06	3500	0.06
3	4650	0.10	4100	0.08	2550	0.08	2350	0.08
4	3500	0.11	3050	0.11	1950	0.10	1750	0.10
5	2800	0.12	2450	0.11	1550	0.10	1400	0.10
6	2350	0.14	2050	0.13	1300	0.12	1150	0.12
7	2000	0.16	1750	0.15	1100	0.14	1000	0.14
8	1750	0.18	1550	0.18	960	0.15	875	0.15
9	1550	0.20	1350	0.22	855	0.18	780	0.18
10	1400	0.21	1250	0.22	770	0.18	700	0.18
11	1250	0.22	1100	0.22	700	0.18	650	0.18
12	1150	0.23	1000	0.22	650	0.20	585	0.20
13	1050	0.23	950	0.22	595	0.20	540	0.20

**N=rev/min, S=mm/rev**
**[ D1GP125, D1GP165, DLGP195, D1GP103, D2GP191 Series ]**

Work Material Werkstück	Titanium Alloys Titan-Legierungen		Aluminum Alloys, Zinc Alloys Aluminium-Legierungen, Zink-Legierungen		Magnesium Alloys Magnesium-Legierungen	
Hardness						
Strength	~410N/mm <sup>2</sup>					
Diameter(mm)	N	S	N	S	N	S
1	8050	0.02	30000	0.02	11500	0.03
2	4050	0.06	15000	0.06	5800	0.09
3	2700	0.08	9900	0.10	3850	0.13
4	2000	0.09	7450	0.11	2900	0.15
5	1600	0.10	5950	0.12	2300	0.17
6	1350	0.12	4950	0.14	1950	0.19
7	1150	0.14	4250	0.16	1650	0.22
8	1000	0.15	3700	0.18	1450	0.24
9	895	0.17	3300	0.20	1280	0.27
10	805	0.18	3000	0.23	1150	0.29
11	730	0.18	2700	0.23	1050	0.30
12	670	0.20	2480	0.23	960	0.31
13	620	0.20	2300	0.23	890	0.31

**N=rev/min, S=mm/rev**

**[ DLGP506 Series ]**

Work Material Werkstück	Carbon Steels Alloy Steels Stähle Stahl-Legierungen		Tool Steels Hardened Steels Werkzeugstähle Gehärtete Stähle		Soft Grey Cast Iron Weicher Grauguss		Hard Grey Cast Iron Harter Grauguss	
Hardness	HRc15 ~ 30		HRc20 ~ 40					
Strength	700 ~ 1000N/mm <sup>2</sup>		800~1200N/mm <sup>2</sup>					
Diameter(mm)	N	S	N	S	N	S	N	S
1	8750	0.02	6300	0.02	16000	0.02	9800	0.02
2	4400	0.06	3150	0.06	7900	0.07	4900	0.07
3	2900	0.08	2100	0.08	5250	0.11	3250	0.11
4	2200	0.09	1600	0.09	3950	0.14	2450	0.14
5	1750	0.10	1250	0.10	3150	0.14	1950	0.14
6	1450	0.12	1050	0.12	2650	0.18	1650	0.18
7	1250	0.14	900	0.14	2250	0.20	1400	0.20
8	1100	0.15	790	0.15	1950	0.22	1250	0.22
9	975	0.17	700	0.17	1750	0.24	1100	0.24
10	875	0.18	630	0.18	1600	0.28	980	0.28
11	800	0.20	575	0.20	1450	0.28	890	0.28
12	730	0.20	525	0.20	1300	0.28	815	0.28
13	675	0.20	485	0.20	1200	0.28	755	0.28

**N=rev/min, S=mm/rev**
**[ DLGP511, DLGP512, DLGP513 Series ]**

Work Material Werkstück	Carbon Steels Alloy Steels Stähle Stahl-Legierungen		Tool Steels Hardened Steels Werkzeugstähle Gehärtete Stähle		Soft Grey Cast Iron Weicher Grauguss		Hard Grey Cast Iron Harter Grauguss	
Hardness	HRc15 ~ 30		HRc20 ~ 40					
Strength	700 ~ 1000N/mm <sup>2</sup>		800~1200N/mm <sup>2</sup>					
Diameter(inch)	N	S	N	S	N	S	N	S
3/64 (.0469)	8750	0.0008	6300	0.0008	16000	0.0008	9800	0.0008
#47 (.0785)	4400	0.0022	3150	0.0022	7900	0.0027	4900	0.0027
#32 (.1160)	2900	0.0032	2100	0.0032	5250	0.0043	3250	0.0043
#22 (.1570)	2200	0.0036	1600	0.0036	3950	0.0054	2450	0.0054
#9 (.1960)	1750	0.0041	1250	0.0041	3150	0.0054	1950	0.0054
B (.2380)	1450	0.0047	1050	0.0047	2650	0.0069	1650	0.0069
J (.2770)	1250	0.0054	900	0.0054	2250	0.0078	1400	0.0078
O (.3160)	1100	0.0060	790	0.0060	1950	0.0087	1250	0.0087
T (.3580)	975	0.0066	700	0.0066	1750	0.0095	1100	0.0095
X (.3970)	875	0.0071	630	0.0071	1600	0.0108	980	0.0108
7/16 (.4375)	800	0.0077	575	0.0077	1450	0.0108	890	0.0108
15/32 (.4688)	730	0.0077	525	0.0077	1300	0.0108	815	0.0108
1/2 (.5000)	675	0.0077	485	0.0077	1200	0.0108	755	0.0108

**N=rev/min, S=inch/rev**

**[ D1GP113, D1GP134, D1GP136, D2GP185, D2GP186, D2GP187 Series ]**

Work Material Werkstück	Carbon Steels Stähle		Carbon Steels Stähle		Alloy Steels Stahl-Legierungen		Stainless Steels Edelstähle	
Hardness			~ HRC23		HRC23 ~ 34		~ HRC23	
Strength	~ 570N/mm <sup>2</sup>		~ 830N/mm <sup>2</sup>		830~1110N/mm <sup>2</sup>		~ 830N/mm <sup>2</sup>	
Diameter <sup>(inch)</sup>	N	S	N	S	N	S	N	S
3/64(.0469)	14000	0.0008	12500	0.0008	7700	0.0008	7000	0.0008
#47(.0785)	7000	0.0023	6100	0.0024	3850	0.0024	3500	0.0024
#32(.1160)	4650	0.0038	4100	0.0031	2550	0.0031	2350	0.0031
#22(.1570)	3500	0.0044	3050	0.0043	1950	0.0039	1750	0.0039
#9(.1960)	2800	0.0049	2450	0.0043	1550	0.0039	1400	0.0039
B(.2380)	2350	0.0056	2050	0.0051	1300	0.0047	1150	0.0047
J(.2770)	2000	0.0064	1750	0.0059	1100	0.0055	1000	0.0055
O(.3160)	1750	0.0072	1550	0.0071	960	0.0059	875	0.0059
T(.3580)	1550	0.0077	1350	0.0087	855	0.0071	780	0.0071
X(.3970)	1400	0.0084	1250	0.0087	770	0.0071	700	0.0071
7/16(.4375)	1250	0.0087	1100	0.0087	700	0.0071	650	0.0071
15/32(.4688)	1150	0.0090	1000	0.0087	650	0.0079	585	0.0079
1/2(.5000)	1050	0.0090	950	0.0087	595	0.0079	540	0.0079

**N=rev/min, S=inch/rev**
**[ D1GP113, D1GP134, D1GP136, D2GP185, D2GP186, D2GP187 Series ]**

Work Material Werkstück	Titanium Alloys Titan-Legierungen		Aluminum Alloys, Zinc Alloys Aluminium-Legierungen, Zink-Legierungen		Magnesium Alloys Magnesium-Legierungen	
Hardness						
Strength	~410N/mm <sup>2</sup>					
Diameter <sup>(inch)</sup>	N	S	N	S	N	S
3/64(.0469)	8050	0.0008	30000	0.0008	11500	0.0012
#47(.0785)	4050	0.0024	15000	0.0023	5800	0.0035
#32(.1160)	2700	0.0031	9900	0.0038	3850	0.0051
#22(.1570)	2000	0.0035	7450	0.0044	2900	0.0059
#9(.1960)	1600	0.0039	5950	0.0049	2300	0.0067
B(.2380)	1350	0.0047	4950	0.0056	1950	0.0075
J(.2770)	1150	0.0055	4250	0.0064	1650	0.0087
O(.3160)	1000	0.0059	3700	0.0072	1450	0.0094
T(.3580)	895	0.0067	3300	0.0079	1280	0.0106
X(.3970)	805	0.0071	3000	0.0090	1150	0.0114
7/16(.4375)	730	0.0071	2700	0.0090	1050	0.0118
15/32(.4688)	670	0.0079	2480	0.0090	960	0.0122
1/2(.5000)	620	0.0079	2300	0.0090	890	0.0122

**N=rev/min, S=inch/rev**



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