i - DREAM DRILLS

YA1A SERIES
YA2C SERIES

i-DREAM DRILL INSERTS & HOLDERS

i-DREAM DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

- Features of *i-Dream Drill* Inserts-
Merkmale des i-Dream Drill Einsätze

- ▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
  Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.

i-Dream Drill General / i-Dream Drill allgemeinen

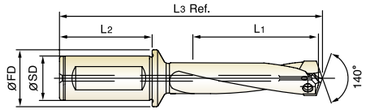
- ▶ For most steels materials / In den meisten Stahlsorten

i-Dream Drill INOX / i-Dream Drill INOX

- ▶ For tough, ductile materials and stainless steels
  Für zähe, verformbare Werkstoffe und rostfreie Stähle.
- ▶ Light, sharp cutting edge / Scharfe Schneidkante
- ▶ Soft cutting action / Weicher Schnitt
- ▶ Minimize cutting forces / Minimaler Schneidendruck
- ▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

- ▶ Special Alloy Steels maintain its hardness and toughness under high temperatures.
  Speziell legierter Stahl, der seine Härte und Zähigkeit auch bei hohen Temperaturen behält.
- ▶ Innovative surface treatment improves wear resistance and reduces corrosion.
  Innovative Oberflächenbehandlung, die die Verschleissfestigkeit erhöht und die Korrosion vermindert.
- ▶ High Performance flute design allows maximum chip evacuation and minimum interference.
  Optimierte Nutenform für maximale Spanabfuhr.



CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246	-	-
ER COLLET CHUCK	D73 - 115		

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	frac.	mm		SD	L2	FD	L1	L3 Ref.	
A Ø12.00 to Ø13.99	YA1A1200	YA2C1200	.4724	-	12.00	ZH12003020	20	50	25	3D	36	112.4	TX1213T08
	YA1A1210	YA2C1210	.4764	-	12.10	ZH12005020				5D	60	136.4	
	YA1A1220	YA2C1220	.4803	-	12.20	ZH12007020				7D	84	160.4	
	YA1A1230	YA2C1230	.4844	31/64	12.30								
	YA1A1250	YA2C1250	.4921	-	12.50	ZH12503020	20	50	25	3D	37.5	113.4	
	YA1A1260	YA2C1260	.4961	-	12.60	ZH12505020				5D	62.5	138.4	
	YA1A1270	YA2C1270	.5000	1/2	12.70	ZH12507020				7D	87.5	163.4	
	YA1A1280	YA2C1280	.5039	-	12.80								
	YA1A1290	YA2C1290	.5079	-	12.90								
	YA1A1300	YA2C1300	.5118	-	13.00	ZH13003020	20	50	25	3D	39	115.4	TX1314T08
	YA1A1310	YA2C1310	.5156	33/64	13.10	ZH13005020				5D	65	141.4	
	YA1A1320	YA2C1320	.5197	-	13.20	ZH13007020				7D	91	167.4	
	YA1A1349	YA2C1349	.5312	17/32	13.49								
	YA1A1350	YA2C1350	.5315	-	13.50	ZH13503020	20	50	25	3D	40.5	116.4	
	YA1A1360	YA2C1360	.5354	-	13.60	ZH13505020				5D	67.5	143.4	
	YA1A1370	YA2C1370	.5394	-	13.70	ZH13507020				7D	94.5	170.4	
	YA1A1380	YA2C1380	.5433	-	13.80								
	YA1A1389	YA2C1389	.5469	35/64	13.89								

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P																			M			K						
Material Description	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	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									
YA1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎									
YA2C	○	○	○	○		○	○			○		◎	◎	◎															

ISO	N										S							H		
Material Description	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
YA1A																					
YA2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YB1A SERIES
YB2C SERIES

i-DREAM DRILL INSERTS & HOLDERS

i-DREAM DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

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Merkmale des i-Dream Drill Einsätze

- ▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
  Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.

i-Dream Drill General / i-Dream Drill allgemeinen

- ▶ For most steels materials / In den meisten Stahlsorten

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- ▶ Soft cutting action / Weicher Schnitt
- ▶ Minimize cutting forces / Minimaler Schneidendruck
- ▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

- ▶ Special Alloy Steels maintain its hardness and toughness under high temperatures.
  Speziell legierter Stahl, der seine Härte und Zähigkeit auch bei hohen Temperaturen behält.
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CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246	-	-
ER COLLET CHUCK	D73 - 115		

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	frac.	mm		SD	L2	FD	L1	L3 Ref.	
B Ø14.00 to Ø15.99	YB1A1400	YB2C1400	.5512	-	14.00	ZH14003020	20	50	25	3D	42	118.9	TX1415T08
	YB1A1410	YB2C1410	.5551	-	14.10	ZH14005020				5D	70	146.9	
	YB1A1420	YB2C1420	.5591	-	14.20	ZH14007020				7D	98	174.9	
	YB1A1429	YB2C1429	.5625	9/16	14.29								
	YB1A1430	YB2C1430	.5630	-	14.30								
	YB1A1440	YB2C1440	.5669	-	14.40								
	YB1A1450	YB2C1450	.5709	-	14.50	ZH14503020	20	50	25	3D	43.5	120.9	TX1516T08
	YB1A1460	YB2C1460	.5748	-	14.60	ZH14505020				5D	72.5	149.9	
	YB1A1468	YB2C1468	.5781	37/64	14.68	ZH14507020				7D	101.5	178.9	
	YB1A1480	YB2C1480	.5827	-	14.80								
	YB1A1500	YB2C1500	.5906	-	15.00	ZH15003020	20	50	25	3D	45	122.9	
	YB1A1508	YB2C1508	.5938	19/32	15.08	ZH15005020				5D	75	152.9	
	YB1A1510	YB2C1510	.5945	-	15.10	ZH15007020				7D	105	182.9	
	YB1A1520	YB2C1520	.5984	-	15.20								
	YB1A1530	YB2C1530	.6024	-	15.30								
	YB1A1548	YB2C1548	.6094	39/64	15.48								
	YB1A1550	YB2C1550	.6102	-	15.50	ZH15503020	20	50	25	3D	46.5	123.9	
	YB1A1560	YB2C1560	.6142	-	15.60	ZH15505020				5D	77.5	154.9	
	YB1A1570	YB2C1570	.6181	-	15.70	ZH15507020				7D	108.5	185.9	
	YB1A1580	YB2C1580	.6220	-	15.80								
	YB1A1587	YB2C1587	.6250	5/8	15.87								

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P																			M			K						
Material Description	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	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									
YB1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎									
YB2C	○	○	○	○		○	○			○		◎	◎	◎															

ISO	N										S							H		
Material Description	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
YB1A																					
YB2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YC1A SERIES
YC2C SERIES

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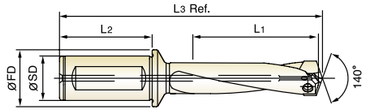

CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
C Ø16.00 to Ø17.99	YC1A1600	YC2C1600	.6299	-	16.00	ZH16003020	20	50	25	3D	48	125.0	TX1617T08
	YC1A1609	YC2C1609	.6335	-	16.09							
	YC1A1620	YC2C1620	.6378	-	16.20	ZH16005020				5D	80	157.0	
	YC1A1627	YC2C1627	.6406	41/64	16.27	ZH16007020				7D	112	189.0	
	YC1A1630	YC2C1630	.6417	-	16.30								
	YC1A1650	YC2C1650	.6496	-	16.50	ZH16503020	20	50	25	3D	49.5	127.0	
	YC1A1667	YC2C1667	.6562	21/32	16.67	ZH16505020				5D	82.5	160.0	
	YC1A1680	YC2C1680	.6614	-	16.80	ZH16507020				7D	115.5	193.0	
	YC1A1700	YC2C1700	.6693	-	17.00	ZH17003020	20	50	25	3D	51	128.0	TX1718T08
	YC1A1707	YC2C1707	.6719	43/64	17.07	ZH17005020				5D	85	162.0	
	YC1A1746	YC2C1746	.6875	11/16	17.46	ZH17007020				7D	119	196.0	
	YC1A1750	YC2C1750	.6890	-	17.50	ZH17503020	20	50	25	3D	52.5	130.0	
	YC1A1780	YC2C1780	.7008	-	17.80	ZH17505020				5D	87.5	165.0	
	YC1A1786	YC2C1786	.7031	45/64	17.86	ZH17507020				7D	122.5	200.0	

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◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YC1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YC2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YC1A																					
YC2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YD1A SERIES
YD2C SERIES

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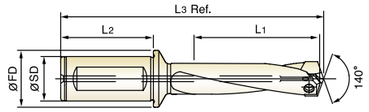

CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
D Ø18.00 to Ø19.99	YD1A1800	YD2C1800	.7087	-	18.00	ZH18003025	25	56	32	3D	54	140.3	TX1819T15
	YD1A1826	YD2C1826	.7188	23/32	18.26	ZH18005025				5D	90	176.3	
						ZH18007025				7D	126	212.3	
	YD1A1850	YD2C1850	.7283	-	18.50	ZH18503025	25	56	32	3D	55.5	141.3	
	YD1A1865	YD2C1865	.7344	47/64	18.65	ZH18505025				5D	92.5	178.3	
	YD1A1880	YD2C1880	.7402	-	18.80	ZH18507025				7D	129.5	215.3	
	YD1A1900	YD2C1900	.7480	-	19.00	ZH19003025	25	56	32	3D	57	144.3	TX1920T15
	YD1A1905	YD2C1905	.7500	3/4	19.05	ZH19005025				5D	95	182.3	
	YD1A1927	YD2C1927	.7587	-	19.27								
	YD1A1945	YD2C1945	.7656	49/64	19.45	ZH19007025				7D	133	220.3	
	YD1A1950	YD2C1950	.7677	-	19.50	ZH19503025	25	56	32	3D	58.5	145.3	
	YD1A1980	YD2C1980	.7795	-	19.80	ZH19505025				5D	97.5	184.3	
	YD1A1984	YD2C1984	.7812	25/32	19.84	ZH19507025				7D	136.5	223.3	

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◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YD1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YD2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YD1A																					
YD2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YE1A SERIES
YE2C SERIES

i-DREAM DRILL INSERTS & HOLDERS

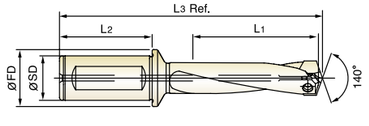
i-DREAM DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

- Features of *i-Dream Drill* Inserts-
Merkmale des i-Dream Drill Einsätze

▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.
i-Dream Drill General* / *i-Dream Drill allgemeinen
▶ For most steels materials / In den meisten Stahlsorten
i-Dream Drill INOX* / *i-Dream Drill INOX
▶ For tough, ductile materials and stainless steels
Für zähe, verformbare Werkstoffe und rostfreie Stähle.
▶ Light, sharp cutting edge / Scharfe Schneidkante
▶ Soft cutting action / Weicher Schnitt
▶ Minimize cutting forces / Minimaler Schneidendruck
▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

▶ Special Alloy Steels maintain its hardness and toughness under high temperatures.
Speziell legierter Stahl, der seine Härte und Zähigkeit auch bei hohen Temperaturen behält.
▶ Innovative surface treatment improves wear resistance and reduces corrosion.
Innovative Oberflächenbehandlung, die die Verschleissfestigkeit erhöht und die Korrosion vermindert.
▶ High Performance flute design allows maximum chip evacuation and minimum interference.
Optimierte Nutenform für maximale Spanabfuhr.



CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

p.A54, 55

Recommended ToolHolder	Flat Shank	Page	Plain Shank	Page
	INDEXABLE DRILL HOLDER	D245 - 246	-	-
	ER COLLET CHUCK		D73 - 115	

Unit : mm

Series Range	Insert EDP No.		Insert O.D.		
			h7		
(mm)	General (TiAlN)	INOX (TiCN)	dec.	frac.	mm
E Ø20.00 to Ø21.99	YE1A2000	YE2C2000	.7874		20.00
	YE1A2024	YE2C2024	.7969	51/64	20.24
	YE1A2050	YE2C2050	.8071		20.50
	YE1A2064	YE2C2064	.8125	13/16	20.64
	YE1A2070	YE2C2070	.8150		20.70
	YE1A2100	YE2C2100	.8268		21.00
	YE1A2103	YE2C2103	.8281	53/64	21.03
	YE1A2143	YE2C2143	.8438	27/32	21.43
	YE1A2150	YE2C2150	.8465		21.50
	YE1A2170	YE2C2170	.8543		21.70
	YE1A2183	YE2C2183	.8594	55/64	21.83

Holder EDP No.	Shank Dia. SD	Shank Length L2	Flange Dia. FD	Drilling Depth	L1	Overall Length L3 Ref.	Screw No.
ZH20003025	25	56	32	3D	60	145.5	TX2021T20
ZH20005025				5D	100	185.5	
ZH20007025				7D	140	225.5	
ZH20503025	25	56	32	3D	61.5	147.5	
ZH20505025				5D	102.5	188.5	
ZH20507025				7D	143.5	229.5	
ZH21003025	25	56	32	3D	63	149.5	TX2122T20
ZH21005025				5D	105	191.5	
ZH21007025				7D	147	233.5	
ZH21503025	25	56	32	3D	64.5	150.5	
ZH21505025				5D	107.5	193.5	
ZH21507025				7D	150.5	236.5	

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YE1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YE2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YE1A																					
YE2C	○	○	○	○	○	○	○	○													

CARBIDE
HSS
i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
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
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TECHNICAL DATA

i - DREAM DRILLS

YF1A SERIES
YF2C SERIES

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PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

- Features of *i-Dream Drill* Inserts-
Merkmale des i-Dream Drill Einsätze

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▶ Minimize cutting forces / Minimaler Schneidendruck
▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

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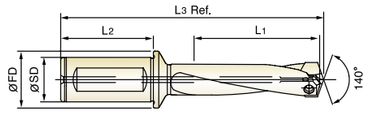
Optimierte Nutenform für maximale Spanabfuhr.



CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder	Flat Shank	Page	Plain Shank	Page
	INDEXABLE DRILL HOLDER	D245 - 246	-	-
	ER COLLET CHUCK		D73 - 115	

Unit : mm

Series Range	Insert EDP No.		Insert O.D.		
			h7		
(mm)	General (TiAlN)	INOX (TiCN)	dec.	frac.	mm
F Ø22.00 to Ø23.99	YF1A2200	YF2C2200	.8661		22.00
	YF1A2223	YF2C2223	.8750	7/8	22.23
	YF1A2250	YF2C2250	.8858		22.50
	YF1A2262	YF2C2262	.8906	57/64	22.62
	YF1A2270	YF2C2270	.8937		22.70
	YF1A2300	YF2C2300	.9055		23.00
	YF1A2302	YF2C2302	.9062	29/32	23.02
	YF1A2342	YF2C2342	.9219	59/64	23.42
	YF1A2350	YF2C2350	.9252		23.50
	YF1A2370	YF2C2370	.9331		23.70
	YF1A2381	YF2C2381	.9375	15/16	23.81

Holder EDP No.	Shank Dia. SD	Shank Length L2	Flange Dia. FD	Drilling Depth	L1	Overall Length L3 Ref.	Screw No.
ZH22003025	25	56	32	3D	66	152.4	TX2223T20
ZH22005025				5D	110	196.4	
ZH22007025				7D	154	240.4	
ZH22503025	25	56	32	3D	67.5	153.4	
ZH22505025				5D	112.5	198.4	
ZH22507025				7D	157.5	243.4	
ZH23003025	25	56	32	3D	69	155.4	TX2324T20
ZH23005025				5D	115	201.4	
ZH23007025				7D	161	247.4	
ZH23503025	25	56	32	3D	70.5	157.4	
ZH23505025				5D	117.5	204.4	
ZH23507025				7D	164.5	251.4	

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YF1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YF2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YF1A																					
YF2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YG1A SERIES
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Merkmale des i-Dream Drill Einsätze

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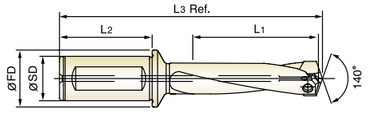

CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
G Ø24.00 to Ø25.99	YG1A2400	YG2C2400	.9449	-	24.00	ZH24003032	32	60	37	3D	72	164.8	TX2425T20
	YG1A2421	YG2C2421	.9531	61/64	24.21	ZH24005032				5D	120	212.8	
						ZH24007032				7D	168	260.8	
	YG1A2450	YG2C2450	.9646	-	24.50	ZH24503032	32	60	37	3D	73.5	165.8	
	YG1A2461	YG2C2461	.9688	31/32	24.61	ZH24505032				5D	122.5	214.8	
	YG1A2470	YG2C2470	.9724	-	24.70	ZH24507032				7D	171.5	263.8	
	YG1A2500	YG2C2500	.9843	63/64	25.00	ZH25003032	32	60	37	3D	75	167.8	TX2526T20
	YG1A2540	YG2C2540	1.0000	1	25.40	ZH25005032				5D	125	217.8	
						ZH25007032				7D	175	267.8	
	YG1A2550	YG2C2550	1.0039	-	25.50	ZH25503032	32	60	37	3D	76.5	170.8	
	YG1A2567	YG2C2567	1.0106	-	25.67	ZH25505032				5D	127.5	221.8	
	YG1A2570	YG2C2570	1.0118	-	25.70	ZH25507032				7D	178.5	272.8	
	YG1A2580	YG2C2580	1.0156	1-1/64	25.80								

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YG1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YG2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YG1A																					
YG2C	○	○	○	○	○	○	○	○													

CARBIDE
HSS
i-ONE DRILLS
i-DREAM DRILLS
DREAM DRILLS -PRO
DREAM DRILLS -GENERAL
DREAM DRILLS -HIGH FEED
DREAM DRILLS -FLAT BOTTOM
DREAM DRILLS -INOX
DREAM DRILLS -ALU
DREAM DRILLS -MQL
DREAM DRILLS for HIGH HARDENED STEELS
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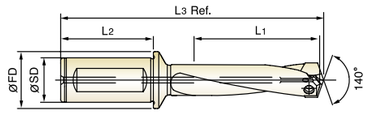

CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
H Ø26.00 to Ø27.99	YH1A2600	YH2C2600	1.0236	-	26.00	ZH26003032	32	60	37	3D	78	171.2	TX2627T25
	YH1A2619	YH2C2619	1.0312	1-1/32	26.19	ZH26005032				5D	130	223.2	
						ZH26007032				7D	182	275.2	
	YH1A2650	YH2C2650	1.0433		26.50	ZH26503032	32	60	37	3D	79.5	172.2	
	YH1A2659	YH2C2659	1.0469	1-3/64	26.59	ZH26505032				5D	132.5	225.2	
	YH1A2699	YH2C2699	1.0625	1-1/16	26.99	ZH26507032				7D	185.5	278.2	
	YH1A2700	YH2C2700	1.0630	-	27.00	ZH27003032	32	60	37	3D	81	174.2	TX2728T25
						ZH27005032				5D	135	228.2	
						ZH27007032				7D	189	282.2	
	YH1A2750	YH2C2750	1.0827	-	27.50	ZH27503032	32	60	37	3D	82.5	175.2	
	YH1A2778	YH2C2778	1.0938	1-3/32	27.78	ZH27505032				5D	137.5	230.2	
						ZH27507032				7D	192.5	285.2	

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◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YH1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YH2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YH1A																					
YH2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YI1A SERIES
YI2C SERIES

i-DREAM DRILL INSERTS & HOLDERS

i-DREAM DRILL EINSÄTZE UND HALTER
PLAQUETTES ET PORTE-PLAQUETTE I-DREAM DRILL - USAGE GÉNÉRAL / INOX
INSERTI & PORTAINSERTI i-DREAM DRILL

- Features of *i-Dream Drill* Inserts-
Merkmale des i-Dream Drill Einsätze

▶ Secure and accurate seating resulting in accurate repeatability and concentricity.
Der sichere und genaue Sitz der Platte garantiert genaue Wiederholbarkeit beim Einsatz und beim Rundlauf.

i-Dream Drill General / i-Dream Drill allgemeinen

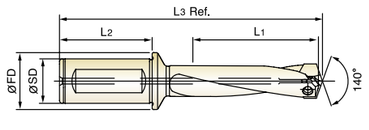
▶ For most steels materials / In den meisten Stahlsorten

i-Dream Drill INOX / i-Dream Drill INOX

▶ For tough, ductile materials and stainless steels
Für zähe, verformbare Werkstoffe und rostfreie Stähle.
▶ Light, sharp cutting edge / Scharfe Schneidkante
▶ Soft cutting action / Weicher Schnitt
▶ Minimize cutting forces / Minimaler Schneidendruck
▶ Reduce built-up edge / Reduzierte Gratbildung

- Features of *i-Dream Drill* Holders-
- Merkmale des i-Dresm Drill Halters-

▶ Special Alloy Steels maintain its hardness and toughness under high temperatures.
Speziell legierter Stahl, der seine Härte und Zähigkeit auch bei hohen Temperaturen behält.
▶ Innovative surface treatment improves wear resistance and reduces corrosion.
Innovative Oberflächenbehandlung, die die Verschleissfestigkeit erhöht und die Korrosion vermindert.
▶ High Performance flute design allows maximum chip evacuation and minimum interference.
Optimierte Nutenform für maximale Spanabfuhr.



CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

p.A54, 55

Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
I Ø28.00 to Ø29.99	YI1A2800	YI2C2800	1.1024	-	28.00	ZH28003032	32	60	37	3D	84	178.2	TX2829T25
	YI1A2818	YI2C2818	1.1094	1-7/64	28.18	ZH28005032				5D	140	234.2	
						ZH28007032				7D	196	290.2	
	YI1A2850	YI2C2850	1.1220	-	28.50	ZH28503032	32	60	37	3D	85.5	179.2	
	YI1A2858	YI2C2858	1.1250	1-1/8	28.58	ZH28505032				5D	142.5	236.2	
						ZH28507032				7D	199.5	293.2	
	YI1A2900	YI2C2900	1.1417	-	29.00	ZH29003032	32	60	37	3D	87	182.2	TX2930T25
	YI1A2937	YI2C2937	1.1562	1-5/32	29.37	ZH29005032				5D	145	240.2	
						ZH29007032				7D	203	298.2	
	YI1A2950	YI2C2950	1.1614	-	29.50	ZH29503032	32	60	37	3D	88.5	183.2	
	YI1A2977	YI2C2977	1.1719	1-11/64	29.77	ZH29505032				5D	147.5	242.2	
						ZH29507032				7D	206.5	301.2	

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	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
YI1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YI2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
YI1A																					
YI2C	○	○	○	○	○	○	○	○													

i - DREAM DRILLS

YJ1A SERIES
YJ2C SERIES

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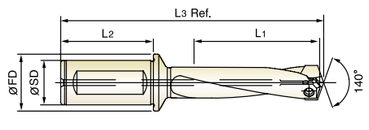

CARBIDE | ISO 9766 | h7 | 140° | TiAlN | TiCN

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Recommended ToolHolder

	Flat Shank	Page	Plain Shank	Page
INDEXABLE DRILL HOLDER	D245 - 246		-	-
ER COLLET CHUCK	D73 - 115			

Unit : mm

Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7 dec.	h7 frac.	h7 mm		SD	L2	FD	L1	L3 Ref.	
J Ø30.00 to Ø31.99	YJ1A3000	YJ2C3000	1.1811		30.00	ZH30003032	32	60	37	3D	90	186.0	TX3031T25
	YJ1A3016	YJ2C3016	1.1875	1-3/16	30.16	ZH30005032				5D	150	246.0	
						ZH30007032				7D	210	306.0	
	YJ1A3050	YJ2C3050	1.2008		30.50	ZH30503032	32	60	37	3D	91.5	187.0	
	YJ1A3056	YJ2C3056	1.2031	1-13/64	30.56	ZH30505032				5D	152.5	248.0	
	YJ1A3096	YJ2C3096	1.2188	1-7/32	30.96	ZH30507032				7D	213.5	309.0	
	YJ1A3100	YJ2C3100	1.2205		31.00	ZH31003032	32	60	37	3D	93	188.0	TX3132T25
						ZH31005032				5D	155	250.0	
						ZH31007032				7D	217	312.0	
	YJ1A3150	YJ2C3150	1.2402		31.50	ZH31503032	32	60	37	3D	94.5	191.0	
	YJ1A3175	YJ2C3175	1.2500	1-1/4	31.75	ZH31505032				5D	157.5	254.0	
						ZH31507032				7D	220.5	317.0	

▶ Other diameters of insert and shank types of holder are available upon request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
YJ1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎
YJ2C	○	○	○	○		○	○			○		◎	◎	◎						

ISO	N										S							H		
Material Description	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
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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
YJ1A																					
YJ2C	○	○	○	○	○	○	○	○													