

SELECTION GUIDE



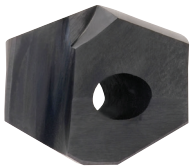
SERIES
TYPE
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SURFACE TREATMENT

YH1A	YH2C
H	
26.00	
27.78	
A51	
TiAIN	TiCN

CARBIDE INSERTS & HOLDERS

i-DREAM
DRILLS

For General Steels and Stainless Steels



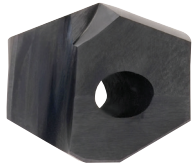
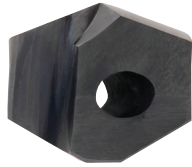
Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A54

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc		
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	○
	2		About 0.45% C	Annealed	190	13	◎	○
	3		About 0.45% C	Quenched & Tempered	250	25	◎	○
	4		About 0.75% C	Annealed	270	28	◎	○
	5		About 0.75% C	Quenched & Tempered	300	32	◎	
	6	Low alloy steel		Annealed	180	10	◎	○
	7			Quenched & Tempered	275	29	◎	○
	8			Quenched & Tempered	300	32	◎	
	9			Quenched & Tempered	350	38	◎	
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	○
	11			Quenched & Tempered	325	35	◎	
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15		◎
	13		Martensitic	Quenched & Tempered	240	23		◎
	14		Austenitic		180	10		◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	
	16		Pearlitic (Martensitic)		260	26	◎	
	17	Nodular cast iron	Ferritic		160	3	◎	
	18		Pearlitic		250	25	◎	
	19	Malleable cast iron	Ferritic		130		◎	
	20		Pearlitic		230	21	◎	
N	21	Aluminum-wrought alloy	Not Curable		60			○
	22		Curable	Hardened	100			○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75			○
	24		≤ 12% Si, Curable	Hardened	90			○
	25		> 12% Si, Not Curable		130			○
	26	Copper and Copper Alloys	Cutting Alloys, PB>1%		110			○
	27		CuZn, CuSnZn (Brass)		90			○
	28		CuSn, lead-free copper and electrolytic copper		100			○
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic					
	30		Rubber, Wood, etc.					
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15		
	32			Cured	280	30		
	33			Annealed	250	25		
	34		Ni or Co Based	Cured	350	38		
	35			Cast	320	34		
	36	Titanium Alloys	Pure Titanium		400 Rm			
	37		Alpha + Beta Alloys	Hardened	1050 Rm			
H	38	Hardened steel		Hardened	550	55		
	39			Hardened	630	60		
	40	Chilled Cast Iron		Cast	400	42		
	41	Hardened Cast Iron		Hardened	550	55		

YI1A	YI2C	YJ1A	YJ2C	ZH*3	ZH*5	ZH*7
I		J				
28.00		30.00				
29.77		31.75				
A52		A53				
TiAIN	TiCN	TiAIN	TiCN	3XD	5XD	7XD



◎	○	◎	○				1
◎	○	◎	○				2
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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 Schneidedruck
 - 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.



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				SD	L2	FD	L1	L3 Ref.	
			dec.	frac.	mm							

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	ZH13003020	20	50	25	3D	39	115.4	
	YA1A1300	YA2C1300	.5118	-	13.00	ZH13005020				5D	65	141.4	
	YA1A1310	YA2C1310	.5156	33/64	13.10	ZH13007020				7D	91	167.4	
	YA1A1320	YA2C1320	.5197	-	13.20								
	YA1A1349	YA2C1349	.5312	17/32	13.49	ZH13503020	20	50	25	3D	40.5	116.4	
	YA1A1350	YA2C1350	.5315	-	13.50	ZH13505020				5D	67.5	143.4	
	YA1A1360	YA2C1360	.5354	-	13.60	ZH13507020				7D	94.5	170.4	
	YA1A1370	YA2C1370	.5394	-	13.70								
	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.

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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	38	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
HRc																				
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400
YA1A																				
YA2C	○	○	○	○	○	○	○	○												



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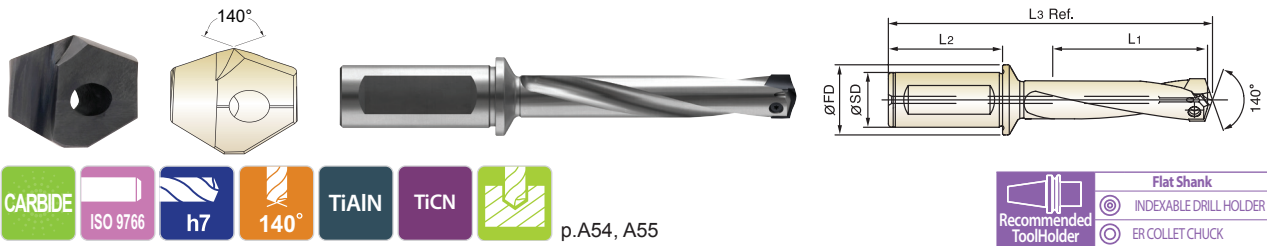
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Unit : mm												
Series Range	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Screw No.
(mm)	General (TiAlN)	INOX (TiCN)	h7				SD	L2	FD	L1	L3 Ref.	
			dec.	frac.	mm							

B Ø14.00 to Ø15.99	YB1A1400	YB2C1400	.5512	-	14.00	ZH14003020				3D	42	118.9	TX1415T08
	YB1A1410	YB2C1410	.5551	-	14.10	ZH14005020	20	50	25	5D	70	146.9	
	YB1A1420	YB2C1420	.5591	-	14.20								
	YB1A1429	YB2C1429	.5625	9/16	14.29	ZH14007020				7D	98	174.9	
	YB1A1430	YB2C1430	.5630	-	14.30								
	YB1A1440	YB2C1440	.5669	-	14.40								
	YB1A1450	YB2C1450	.5709	-	14.50	ZH14503020				3D	43.5	120.9	TX1516T08
	YB1A1460	YB2C1460	.5748	-	14.60	ZH14505020	20	50	25	5D	72.5	149.9	
	YB1A1468	YB2C1468	.5781	37/64	14.68								
	YB1A1480	YB2C1480	.5827	-	14.80								
	YB1A1500	YB2C1500	.5906	-	15.00	ZH15003020				3D	45	122.9	
	YB1A1508	YB2C1508	.5938	19/32	15.08	ZH15005020	20	50	25	5D	75	152.9	
	YB1A1510	YB2C1510	.5945	-	15.10								
	YB1A1520	YB2C1520	.5984	-	15.20								
	YB1A1530	YB2C1530	.6024	-	15.30	ZH15007020				7D	105	182.9	
	YB1A1548	YB2C1548	.6094	39/64	15.48								
	YB1A1550	YB2C1550	.6102	-	15.50	ZH15503020				3D	46.5	123.9	
	YB1A1560	YB2C1560	.6142	-	15.60	ZH15505020	20	50	25	5D	77.5	154.9	
YB1A1570	YB2C1570	.6181	-	15.70									
YB1A1580	YB2C1580	.6220	-	15.80									
YB1A1587	YB2C1587	.6250	5/8	15.87	ZH15507020								

► 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	○	○	○	○	○	○	○	○																				



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- INSERTI & PORTAINSERTI i-DREAM DRILL

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Merkmale des i-Dream Drill Einsätze

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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 (TiAIN)	INOX (TiCN)	h7				SD	L2	FD	L1		L3 Ref.	
			dec.	frac.	mm								
C Ø16.00 to Ø17.99	YC1A1600	YC2C1600	.6299	-	16.00	ZH16003020				3D	48	125.0	TX1617T08
	YC1A1609	YC2C1609	.6335	-	16.09								
	YC1A1620	YC2C1620	.6378	-	16.20	ZH16005020	20	50	25	5D	80	157.0	
	YC1A1627	YC2C1627	.6406	41/64	16.27								
	YC1A1630	YC2C1630	.6417	-	16.30	ZH16007020				7D	112	189.0	
	YC1A1650	YC2C1650	.6496	-	16.50	ZH16503020				3D	49.5	127.0	
	YC1A1667	YC2C1667	.6562	21/32	16.67	ZH16505020	20	50	25	5D	82.5	160.0	TX1718T08
	YC1A1680	YC2C1680	.6614	-	16.80	ZH16507020				7D	115.5	193.0	
	YC1A1700	YC2C1700	.6693	-	17.00	ZH17003020				3D	51	128.0	
	YC1A1707	YC2C1707	.6719	43/64	17.07	ZH17005020	20	50	25	5D	85	162.0	
	YC1A1746	YC2C1746	.6875	11/16	17.46	ZH17007020				7D	119	196.0	
	YC1A1750	YC2C1750	.6890	-	17.50	ZH17503020				3D	52.5	130.0	
	YC1A1780	YC2C1780	.7008	-	17.80	ZH17505020	20	50	25	5D	87.5	165.0	
	YC1A1786	YC2C1786	.7031	45/64	17.86	ZH17507020				7D	122.5	200.0	

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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			
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	
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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		
YC1A																							
YC2C	○	○	○	○	○	○	○	○															



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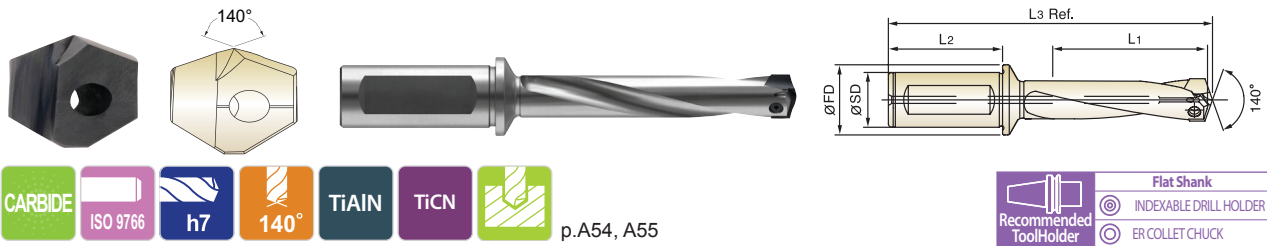
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Unit : mm

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 (TiAIN)	INOX (TiCN)	h7				SD	L2	FD	L1		L3 Ref.	
			dec.	frac.	mm								
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	
	YD1A1850	YD2C1850	.7283	-	18.50	ZH18007025				7D	126	212.3	
	YD1A1865	YD2C1865	.7344	47/64	18.65	ZH18503025	25	56	32	3D	55.5	141.3	
	YD1A1880	YD2C1880	.7402	-	18.80	ZH18505025				5D	92.5	178.3	
	YD1A1900	YD2C1900	.7480	-	19.00	ZH18507025				7D	129.5	215.3	
	YD1A1905	YD2C1905	.7500	3/4	19.05	ZH19003025	25	56	32	3D	57	144.3	TX1920T15
	YD1A1927	YD2C1927	.7587	-	19.27	ZH19005025				5D	95	182.3	
	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	

▶ 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		
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 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.

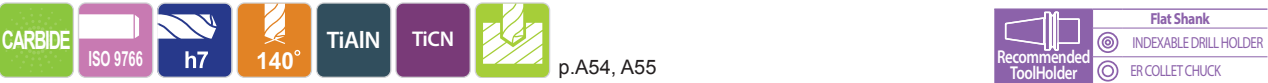
i-Dream Drill General / i-Dream Drill allgemeinen

 - ▶ 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 Schneidedruck
 - ▶ 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.



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)	dec.	frac.	mm		SD	L2	FD	L1		L3 Ref.	
E Ø20.00 to Ø21.99	YE1A2000	YE2C2000	.7874	-	20.00	ZH20003025	25	56	32	3D	60	145.5	TX2021T20
	YE1A2024	YE2C2024	.7969	51/64	20.24	ZH20005025				5D	100	185.5	
						ZH20007025				7D	140	225.5	
	YE1A2050	YE2C2050	.8071	-	20.50	ZH20503025	25	56	32	3D	61.5	147.5	
	YE1A2064	YE2C2064	.8125	13/16	20.64	ZH20505025				5D	102.5	188.5	
	YE1A2070	YE2C2070	.8150	-	20.70	ZH20507025				7D	143.5	229.5	
	YE1A2100	YE2C2100	.8268	-	21.00	ZH21003025	25	56	32	3D	63	149.5	TX2122T20
	YE1A2103	YE2C2103	.8281	53/64	21.03	ZH21005025				5D	105	191.5	
	YE1A2143	YE2C2143	.8438	27/32	21.43	ZH21007025				7D	147	233.5	
	YE1A2150	YE2C2150	.8465	-	21.50	ZH21503025	25	56	32	3D	64.5	150.5	
	YE1A2170	YE2C2170	.8543	-	21.70	ZH21505025				5D	107.5	193.5	
	YE1A2183	YE2C2183	.8594	55/64	21.83	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	○	○	○	○	○	○	○	○													



i-DREAM DRILL INSERTS & HOLDERS

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- 🇮🇹 INSERTI & PORTAINSERTI i-DREAM DRILL

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Merkmale des i-Dream Drill Einsätze

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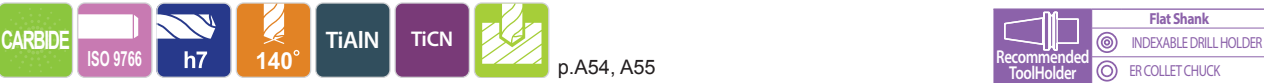
i-Dream Drill General / i-Dream Drill allgemeinen

 - ▶ For most steels materials / In den meisten Stahlsorten

i-Dream Drill INOX / i-Dream Drill INOX

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 - ▶ Minimize cutting forces / Minimaler Schneidedruck
 - ▶ 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.
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Optimierte Nutenform für maximale Spanabfuhr.



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)	dec.	frac.	mm		SD	L2	FD	L1		L3 Ref.		
F Ø22.00 to Ø23.99	YF1A2200	YF2C2200	.8661	-	22.00	ZH22003025	25	56	32	3D	66	152.4	TX2223T20	
	YF1A2223	YF2C2223	.8750	7/8	22.23	ZH22005025				5D	110	196.4		
						ZH22007025				7D	154	240.4		
	YF1A2250	YF2C2250	.8858	-	22.50	ZH22503025	25	56	32	3D	67.5	153.4		TX2324T20
	YF1A2262	YF2C2262	.8906	57/64	22.62	ZH22505025				5D	112.5	198.4		
	YF1A2270	YF2C2270	.8937	-	22.70	ZH22507025				7D	157.5	243.4		
	YF1A2300	YF2C2300	.9055	-	23.00	ZH23003025	25	56	32	3D	69	155.4	TX2324T20	
	YF1A2302	YF2C2302	.9062	29/32	23.02	ZH23005025				5D	115	201.4		
	YF1A2342	YF2C2342	.9219	59/64	23.42	ZH23007025				7D	161	247.4		
	YF1A2350	YF2C2350	.9252	-	23.50	ZH23503025	25	56	32	3D	70.5	157.4		
	YF1A2370	YF2C2370	.9331	-	23.70	ZH23505025				5D	117.5	204.4		
	YF1A2381	YF2C2381	.9375	15/16	23.81	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 DRILL INSERTS & HOLDERS

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Merkmale des i-Dream Drill Einsätze

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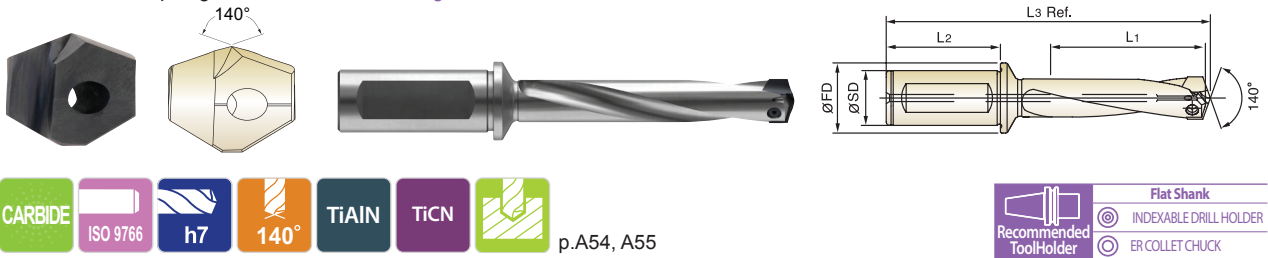
i-Dream Drill General / i-Dream Drill allgemeinen

 - ▶ For most steels materials / In den meisten Stahlsorten

i-Dream Drill INOX / i-Dream Drill INOX

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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.



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)	dec.	frac.	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	TX2425T20
	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	TX2526T20
	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	○	○	○	○	○	○	○	○													



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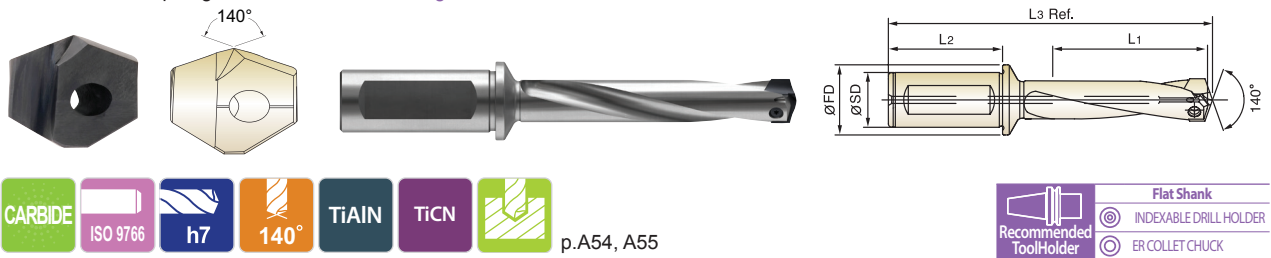
i-Dream Drill General / i-Dream Drill allgemeinen

 - ▶ 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.
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 - ▶ Soft cutting action / Weicher Schnitt
 - ▶ Minimize cutting forces / Minimaler Schneidendruck
 - ▶ Reduce built-up edge / Reduzierte Gratbildung
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Merkmale des i-Dresm Drill Halters-

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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)	dec.	frac.	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	TX2627T25
	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	TX2728T25
						ZH27505032				5D	137.5	230.2	
	YH1A2778	YH2C2778	1.0938	1-3/32	27.78	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 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.



Unit : mm

Series Range (mm)	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth		Overall Length	Screw No.
	General (TiAIN)	INOX (TiCN)	h7				SD	L2	FD	L1	L3 Ref.		
			dec.	frac.	mm								
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.



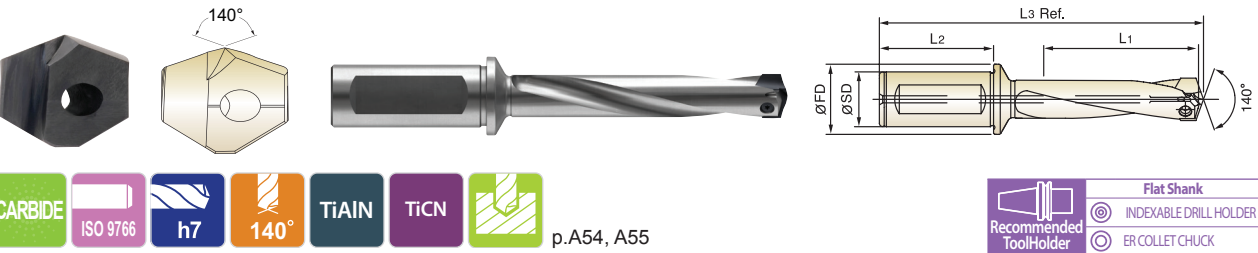
i-DREAM DRILL INSERTS & HOLDERS

- 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

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 - i-Dream Drill General / i-Dream Drill allgemeinen*
 - ▶ For most steels materials / In den meisten Stahlsorten
 - i-Dream Drill INOX / i-Dream Drill INOX*
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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.
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 - ▶ High Performance flute design allows maximum chip evacuation and minimum interference.
Optimierte Nutenform für maximale Spanabfuhr.



Unit : mm

Series Range (mm)	Insert EDP No.		Insert O.D.			Holder EDP No.	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth		Overall Length	Screw No.
	General (TAIN)	INOX (TiCN)	h7				SD	L2	FD	L1	L3 Ref.		
			dec.	frac.	mm								
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	
						ZH31003032	32	60	37	3D	93	188.0	TX3132T25
	YJ1A3100	YJ2C3100	1.2205	-	31.00	ZH31005032				5D	155	250.0	
						ZH31007032				7D	217	312.0	
						ZH31503032	32	60	37	3D	94.5	191.0	
	YJ1A3150	YJ2C3150	1.2402	-	31.50	ZH31505032				5D	157.5	254.0	
	YJ1A3175	YJ2C3175	1.2500	1-1/4	31.75	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		
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	
Y1A	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎	◎	◎	◎	
Y1A	○	○	○	○		○	○					◎	◎	◎							
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
Y1A																					
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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	
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	
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
YJ1A																					
YJ2C	○	○	○	○	○	○	○	○													

YA1A, YB1A, YC1A, YD1A, YE1A,
YF1A, YG1A, YH1A, YI1A, YJ1A SERIES

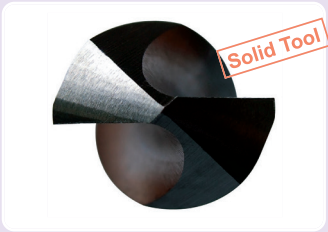
i-DREAM DRILLS - GENERAL

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

ISO	VDI 3323	Material Description	Vc	Feed				
				Ø12.00-14.99	Ø15.00-17.99	Ø18.00-21.99	Ø22.00-26.99	Ø27.00-31.99
P	1	Non-alloy steel	95-120	0.16-0.28	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	2		80-105	0.14-0.24	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	3		60-80	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.33-0.49
	4		55-70	0.10-0.16	0.15-0.25	0.21-0.30	0.25-0.38	0.29-0.43
	5		55-70	0.10-0.16	0.15-0.25	0.21-0.30	0.25-0.38	0.29-0.43
	6	Low alloy steel	70-90	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.34-0.50
	7		60-80	0.12-0.20	0.15-0.25	0.22-0.32	0.30-0.46	0.34-0.50
	8		55-70	0.10-0.16	0.13-0.21	0.21-0.30	0.25-0.38	0.29-0.43
	9		45-60	0.08-0.12	0.13-0.21	0.21-0.30	0.25-0.38	0.29-0.43
	10	High alloyed steel, and tool steel	50-65	0.10-0.16	0.13-0.21	0.18-0.26	0.20-0.31	0.24-0.35
	11		40-55	0.10-0.16	0.11-0.18	0.21-0.30	0.20-0.31	0.24-0.35
K	15	Grey cast iron	100-125	0.15-0.26	0.20-0.37	0.27-0.42	0.36-0.51	0.40-0.55
	16		75-95	0.11-0.20	0.16-0.29	0.20-0.30	0.25-0.35	0.29-0.40
	17	Nodular cast iron	95-120	0.13-0.22	0.17-0.31	0.21-0.32	0.28-0.40	0.32-0.44
	18		75-95	0.11-0.20	0.14-0.26	0.19-0.29	0.25-0.35	0.29-0.40
	19	Malleable cast iron	100-125	0.13-0.22	0.17-0.31	0.21-0.32	0.28-0.40	0.32-0.44
	20		75-95	0.11-0.18	0.14-0.26	0.19-0.29	0.25-0.35	0.29-0.40

- The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.
Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.
- Recommend you to reduce the feed rate to 85%, 70% when you use 5xD, 7xD holders.
- For use of 7xD holder, we recommend to use a pilot drill with equal to or larger than 140° point angle (0.5xD - 1.5xD).
The use of the centering pre-hole improves hole location, roundness and surface finish.

Comparison with Split Point Drill, Spade Drill & Dream Drill



Solid Tool

Normal Split Point Drill



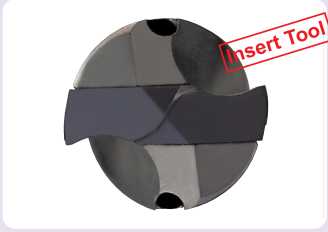
Solid Tool

Dream Drill



Insert Tool

Spade Drill



Insert Tool

i-Dream Drill

YA2C, YB2C, YC2C, YD2C, YE2C,
YF2C, YG2C, YH2C, YI2C, YJ2C SERIES

i-DREAM DRILLS - INOX

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

ISO	VDI 3323	Material Description	Vc	Feed				
				Ø12.00-14.99	Ø15.00-17.99	Ø18.00-21.90	Ø22.00-26.99	Ø27.00-31.99
P	1	Non-alloy steel	95-120	0.16-0.28	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	2		80-105	0.14-0.24	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	3		60-80	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.33-0.49
	4		55-70	0.10-0.16	0.15-0.25	0.21-0.30	0.25-0.38	0.29-0.43
	6	Low alloy steel	70-90	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.34-0.50
	7		60-80	0.12-0.20	0.15-0.25	0.22-0.32	0.30-0.46	0.34-0.50
	10	High alloyed steel, and tool steel	50-65	0.10-0.16	0.13-0.21	0.18-0.26	0.20-0.31	0.24-0.35
M	12	Stainless steel	30-45	0.08-0.14	0.09-0.15	0.10-0.16	0.12-0.20	0.14-0.22
	13		30-45	0.08-0.14	0.09-0.15	0.10-0.16	0.12-0.20	0.14-0.22
	14		45-60	0.10-0.16	0.12-0.18	0.14-0.20	0.15-0.26	0.18-0.28
N	21	Aluminum-wrought alloy	250-330	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55	0.50-0.60
	22		200-250	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55	0.50-0.60
	23	Aluminum-cast, alloyed	200-250	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55
	24		150-220	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55
	25		100-200	0.20-0.30	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50
	26	Copper and Copper Alloys (Bronze / Brass)	115-145	0.16-0.28	0.23-0.36	0.29-0.36	0.37-0.45	0.41-0.48
	27		145-185	0.17-0.29	0.24-0.37	0.30-0.38	0.38-0.46	0.42-0.49
	28		95-120	0.06-0.09	0.09-0.13	0.11-0.13	0.15-0.18	0.19-0.22

- The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.
Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.
- Recommend you to reduce the feed rate to 85%, 70% when you use 5xD, 7xD holders.
- For use of 7xD holder, we recommend to use a pilot drill with equal to or larger than 140° point angle (0.5xD - 1.5xD).
The use of the centering pre-hole improves hole location, roundness and surface finish.

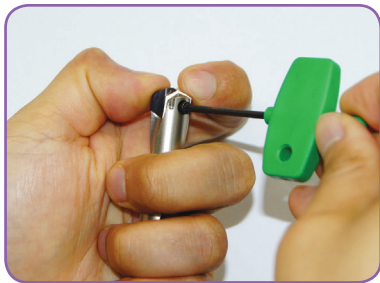
ASSEMBLY OF i-DREAM DRILLS MONTAGE DES i-DREAM DRILLS



Make sure to clean the insert and insert seat.
Schneideinsatz und Haltersitz sorgfältig reinigen.



Slide the drill insert into the slot of the holder and press down the insert to touch the bottom of the slot.
Schneideinsatz in den Haltersitz einführen und den Schneideinsatz fest auf den Grund des Haltersitzes pressen.

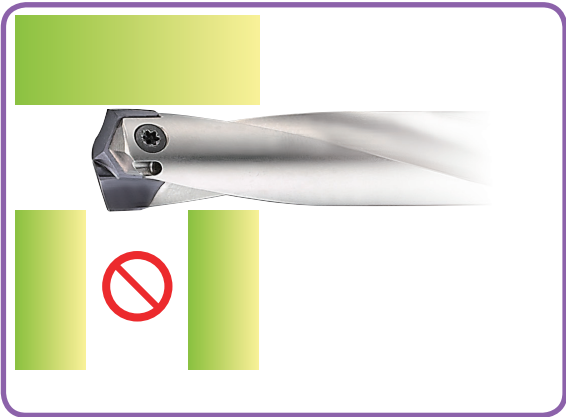


After confirming the insert is pressed down to the bottom of the slot, tighten the screw using anti-seize compound.
Wenn der Schneideinsatz fest auf den Grund des Haltersitzes gepresst ist, die Schraube fest anziehen und dabei Spezialfett verwenden.

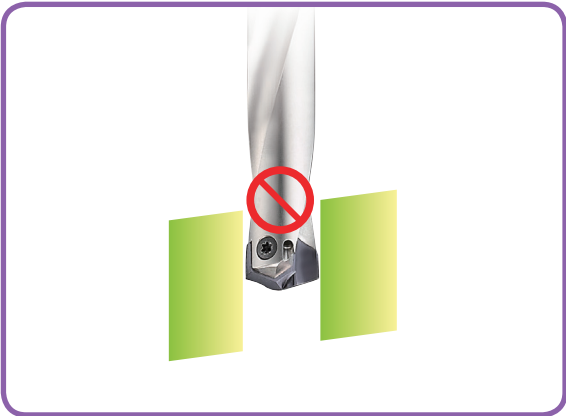
WRENCH TYPE	PRODUCT No.	T-HANDLE No.	SERIES (SIZE)	CLAMPING TORQUE (N·m)
WING TYPE 	TWWT08	—	A (Ø12.00-Ø13.99)	2.4
			B (Ø14.00-Ø15.99)	
			C (Ø16.00-Ø17.99)	
TORX BIT TYPE 	TWBT15	TWH600 	D (Ø18.00-Ø19.99)	6
	TWBT20		E, F, G (Ø20.00-Ø25.99)	10
	TWBT25		H, I, J (Ø26.00-Ø31.99)	13

- Use the wing type or T-type wrench.
Benutzen Sie den Winkeldreher oder T - Schlüsse
- ▶ Need to use appropriate wrenches and screws as indicated.
Unbedingt die angegebenen Schrauben und Dreher verwenden.
 - ▶ It's important to tighten up the screw properly.
Es ist wichtig, die Schraube korrekt und fest anzuziehen.

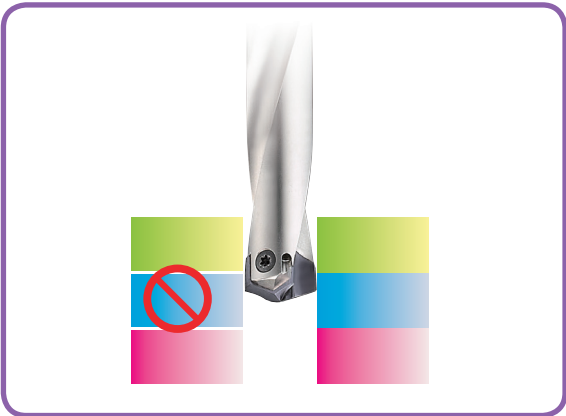
CAUTION-NOT RECOMMENDABLE APPLICATION ACHTUNG - NICHT EMPFOHLENE ANWENDUNG



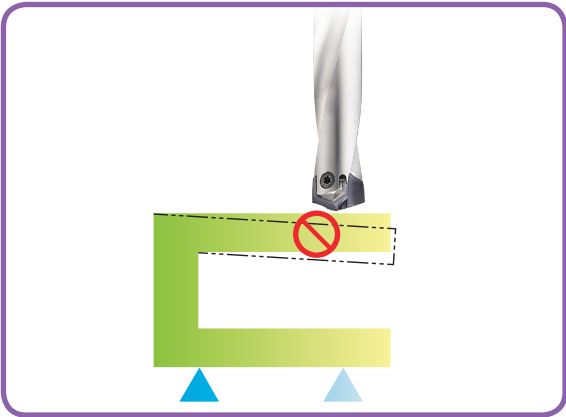
Intersecting cross hole is bigger than the drill insert's Margin Length.
Der Haltersitz ist größer als die Breite des Schneideinsatzes.



Material with slanting entrance and exit over 7 degrees. (If drilling 7 degrees or under slanting surface, reduce the feed about 30-50%)
Werkstücke mit schrägem Anschnitt oder Austritt von über 7°. (Zum Bohren von bis zu 7° Schräge den Vorschub um ca. 30-50% reduzieren).



For drilling stacked plates, minimize the space between the plates.
Beim Bohren von Blechpaketen den Abstand der Bleche minimieren.
The space between stacked plates can cause insert breakage or poor chip control.
Freiraum in Blechpaketen kann den Bruch des Schneideinsatzes oder schlechte Entspannung verursachen.



The material needs to be fixtured securely before drilling.
Das Werkstück muss fest und sicher aufgespannt sein