



MULTI-1 Drill

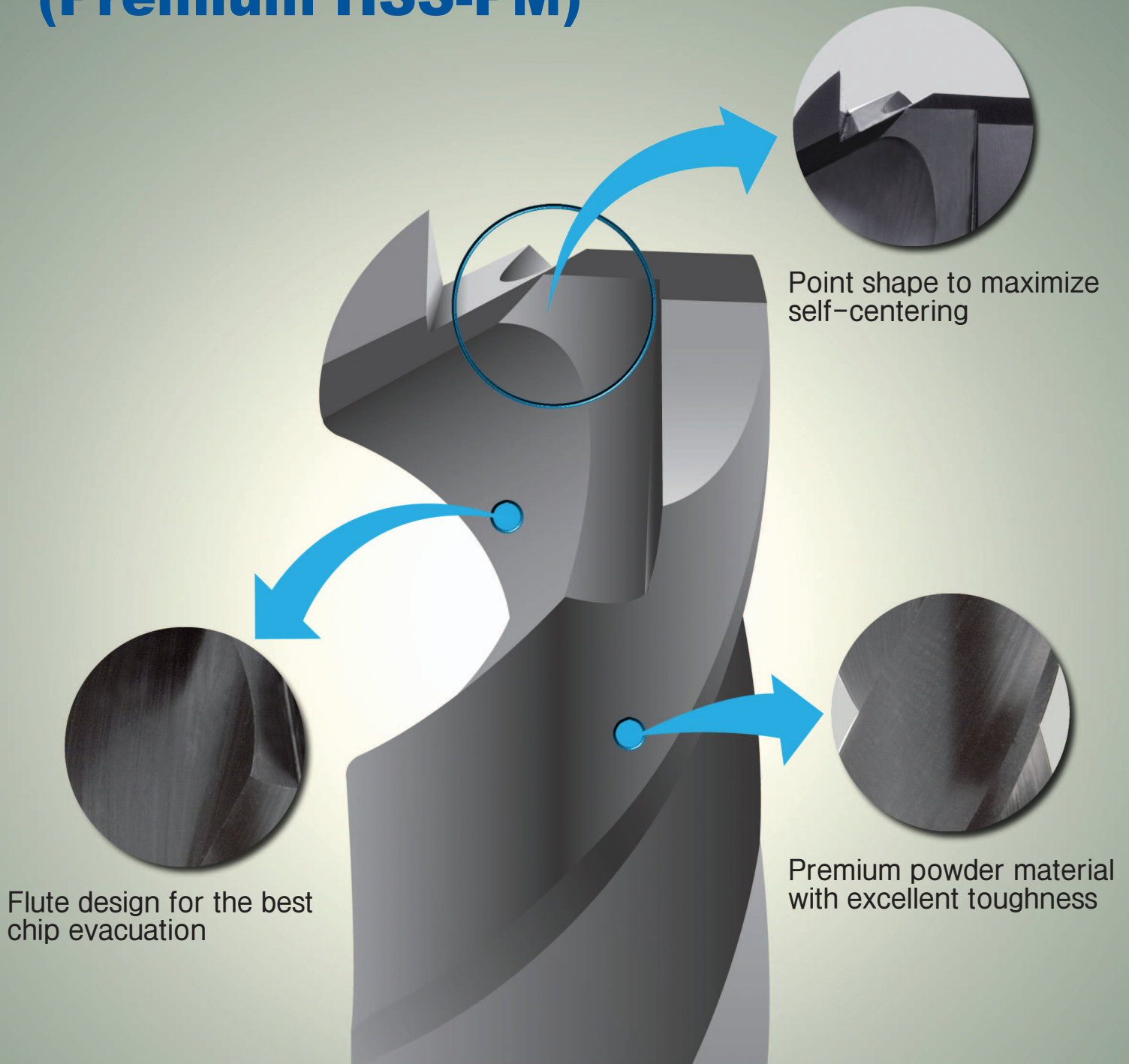
(Premium HSS-PM)



YG YG-1 CO., LTD.

MULTI-1 Drill

(Premium HSS-PM)



MULTI-1 DRILL APPLICATION RANGE :

Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, stainless steels, Hardened steels(HRc30~45), Cast irons, Aluminum alloys, Nonferrous alloys

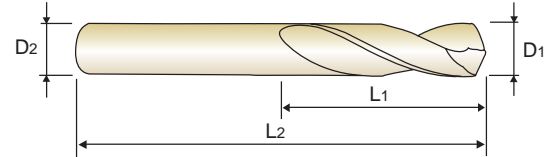
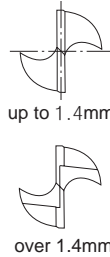


Premium HSS-PM

MULTI-1 Drill (STUB)

- **Features** :
- Excellent wear resistance by using Premium powder metallurgy materials.
 - With special point geometry, no centering required.
 - Minimal drill wandering and improved hole tolerances.
 - Better tool life with excellent coating.

- **Application** : - Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.











up to 1.9mm over 1.9mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA03010	1.0	3	6	38
CDRA03011	1.1	3	7	39
CDRA03012	1.2	3	8	40
CDRA03013	1.3	3	8	40
CDRA03014	1.4	3	9	41
CDRA03015	1.5	3	9	41
CDRA03016	1.6	3	10	42
CDRA03017	1.7	3	10	42
CDRA03018	1.8	3	11	43
CDRA03019	1.9	3	11	43
CDRA03020	2.0	3	12	44
CDRA03021	2.1	3	12	44
CDRA03022	2.2	3	13	45
CDRA03023	2.3	3	13	45
CDRA03024	2.4	3	14	46
CDRA03025	2.5	3	14	46
CDRA03026	2.6	3	14	46
CDRA03027	2.7	3	16	48
CDRA03028	2.8	3	16	48
CDRA03029	2.9	3	16	48
CDRA03030	3.0	3	16	48
CDRA03031	3.1	4	18	50
CDRA03032	3.2	4	18	50
CDRA03033	3.3	4	18	50
CDRA03034	3.4	4	20	52
CDRA03035	3.5	4	20	52
CDRA03036	3.6	4	20	52
CDRA03037	3.7	4	20	52
CDRA03038	3.8	4	22	54
CDRA03039	3.9	4	22	54

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA03040	4.0	4	22	54
CDRA03041	4.1	6	22	66
CDRA03042	4.2	6	22	66
CDRA03043	4.3	6	24	68
CDRA03044	4.4	6	24	68
CDRA03045	4.5	6	24	68
CDRA03046	4.6	6	24	68
CDRA03047	4.7	6	24	68
CDRA03048	4.8	6	26	70
CDRA03049	4.9	6	26	70
CDRA03050	5.0	6	26	70
CDRA03051	5.1	6	26	70
CDRA03052	5.2	6	26	70
CDRA03053	5.3	6	26	70
CDRA03054	5.4	6	28	72
CDRA03055	5.5	6	28	72
CDRA03056	5.6	6	28	72
CDRA03057	5.7	6	28	72
CDRA03058	5.8	6	28	72
CDRA03059	5.9	6	28	72
CDRA03060	6.0	6	28	72
CDRA03061	6.1	8	31	75
CDRA03062	6.2	8	31	75
CDRA03063	6.3	8	31	75
CDRA03064	6.4	8	31	75
CDRA03065	6.5	8	31	75
CDRA03066	6.6	8	31	75
CDRA03067	6.7	8	31	75
CDRA03068	6.8	8	34	78
CDRA03069	6.9	8	34	78

CDRA03 SERIES

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA03070	7.0	8	34	78
CDRA03071	7.1	8	34	78
CDRA03072	7.2	8	34	78
CDRA03073	7.3	8	34	78
CDRA03074	7.4	8	34	78
CDRA03075	7.5	8	34	78
CDRA03076	7.6	8	37	81
CDRA03077	7.7	8	37	81
CDRA03078	7.8	8	37	81
CDRA03079	7.9	8	37	81
CDRA03080	8.0	8	37	81
CDRA03081	8.1	10	37	87
CDRA03082	8.2	10	37	87
CDRA03083	8.3	10	37	87
CDRA03084	8.4	10	37	87
CDRA03085	8.5	10	37	87
CDRA03086	8.6	10	40	90
CDRA03087	8.7	10	40	90
CDRA03088	8.8	10	40	90
CDRA03089	8.9	10	40	90
CDRA03090	9.0	10	40	90
CDRA03091	9.1	10	40	90
CDRA03092	9.2	10	40	90
CDRA03093	9.3	10	40	90
CDRA03094	9.4	10	40	90
CDRA03095	9.5	10	40	90
CDRA03096	9.6	10	43	93
CDRA03097	9.7	10	43	93
CDRA03098	9.8	10	43	93
CDRA03099	9.9	10	43	93
CDRA03100	10.0	10	43	93

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA03101	10.1	12	43	100
CDRA03102	10.2	12	43	100
CDRA03103	10.3	12	43	100
CDRA03104	10.4	12	43	100
CDRA03105	10.5	12	43	100
CDRA03106	10.6	12	43	100
CDRA03107	10.7	12	47	104
CDRA03108	10.8	12	47	104
CDRA03109	10.9	12	47	104
CDRA03110	11.0	12	47	104
CDRA03111	11.1	12	47	104
CDRA03112	11.2	12	47	104
CDRA03113	11.3	12	47	104
CDRA03114	11.4	12	47	104
CDRA03115	11.5	12	47	104
CDRA03116	11.6	12	47	104
CDRA03117	11.7	12	47	104
CDRA03118	11.8	12	47	104
CDRA03119	11.9	12	51	108
CDRA03120	12.0	12	51	108
CDRA03121	12.1	12	51	108
CDRA03122	12.2	12	51	108
CDRA03123	12.3	12	51	108
CDRA03124	12.4	12	51	108
CDRA03125	12.5	12	51	108
CDRA03126	12.6	12	51	108
CDRA03127	12.7	12	51	108
CDRA03128	12.8	12	51	108
CDRA03129	12.9	12	51	108
CDRA03130	13.0	12	51	108

CUTTING CONDITION

Unit : mm

WORK MATERIAL	CARBON STEEL		ALLOY STEELS PRE-HARDENED STEEL		CAST IRON		ALUMINUM ALLOYS NONFERROUS ALLOYS		MOLD STEEL, HARDENED STEELS (HRC30~45) STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)	
	DIAMETER	N	S	N	S	N	S	N	S	N	S	N
2.0	5800	0.06	4700	0.05	6500	0.08	10500	0.17	2600	0.04	3100	0.08
3.0	4300	0.12	3500	0.09	4900	0.14	10500	0.27	1800	0.05	2100	0.09
4.0	3200	0.15	2600	0.13	3600	0.18	8000	0.33	1300	0.07	1600	0.11
5.0	2600	0.18	2100	0.16	2900	0.21	6500	0.39	1050	0.09	1250	0.17
6.0	2100	0.20	1700	0.18	2400	0.25	5200	0.46	900	0.10	1050	0.19
8.0	1600	0.24	1300	0.20	1800	0.29	4200	0.51	650	0.14	800	0.26
10.0	1300	0.27	1000	0.24	1500	0.32	3400	0.61	550	0.17	630	0.33
12.0	1100	0.29	850	0.26	1200	0.36	2700	0.73	450	0.20	530	0.39

N = R.P.M

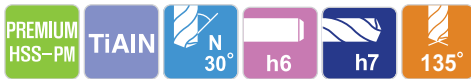
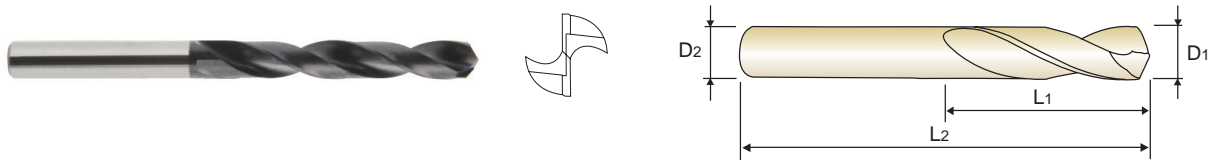
S = Feed per Revolution (mm/rev.)

Premium HSS-PM

MULTI-1 Drill (JOBBER)

- **Features** :
- Excellent wear resistance by using Premium powder metallurgy materials.
 - With special point geometry, no centering required.
 - Minimal drill wandering and improved hole tolerances.
 - Better tool life with excellent coating.

- **Application** : - Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.



EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA04020	2.0	3	24	56
CDRA04021	2.1	3	24	56
CDRA04022	2.2	3	25	56
CDRA04023	2.3	3	25	56
CDRA04024	2.4	3	30	61
CDRA04025	2.5	3	30	61
CDRA04026	2.6	3	30	61
CDRA04027	2.7	3	33	64
CDRA04028	2.8	3	33	64
CDRA04029	2.9	3	33	64
CDRA04030	3.0	3	33	64
CDRA04031	3.1	4	36	68
CDRA04032	3.2	4	36	68
CDRA04033	3.3	4	36	68
CDRA04034	3.4	4	39	71
CDRA04035	3.5	4	39	71
CDRA04036	3.6	4	39	71
CDRA04037	3.7	4	39	71
CDRA04038	3.8	4	43	75
CDRA04039	3.9	4	43	75
CDRA04040	4.0	4	43	75
CDRA04041	4.1	6	43	85
CDRA04042	4.2	6	43	85
CDRA04043	4.3	6	47	89
CDRA04044	4.4	6	47	89
CDRA04045	4.5	6	47	89
CDRA04046	4.6	6	47	89
CDRA04047	4.7	6	47	89
CDRA04048	4.8	6	52	94
CDRA04049	4.9	6	52	94

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA04050	5.0	6	52	94
CDRA04051	5.1	6	52	94
CDRA04052	5.2	6	52	94
CDRA04053	5.3	6	52	94
CDRA04054	5.4	6	57	99
CDRA04055	5.5	6	57	99
CDRA04056	5.6	6	57	99
CDRA04057	5.7	6	57	99
CDRA04058	5.8	6	57	99
CDRA04059	5.9	6	57	99
CDRA04060	6.0	6	57	99
CDRA04061	6.1	8	63	107
CDRA04062	6.2	8	63	107
CDRA04063	6.3	8	63	107
CDRA04064	6.4	8	63	107
CDRA04065	6.5	8	63	107
CDRA04066	6.6	8	63	107
CDRA04067	6.7	8	63	107
CDRA04068	6.8	8	69	113
CDRA04069	6.9	8	69	113
CDRA04070	7.0	8	69	113
CDRA04071	7.1	8	69	113
CDRA04072	7.2	8	69	113
CDRA04073	7.3	8	69	113
CDRA04074	7.4	8	69	113
CDRA04075	7.5	8	69	113
CDRA04076	7.6	8	75	119
CDRA04077	7.7	8	75	119
CDRA04078	7.8	8	75	119
CDRA04079	7.9	8	75	119

CDRA04 SERIES

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA04080	8.0	8	75	119
CDRA04081	8.1	10	75	125
CDRA04082	8.2	10	75	125
CDRA04083	8.3	10	75	125
CDRA04084	8.4	10	75	125
CDRA04085	8.5	10	75	125
CDRA04086	8.6	10	81	131
CDRA04087	8.7	10	81	131
CDRA04088	8.8	10	81	131
CDRA04089	8.9	10	81	131
CDRA04090	9.0	10	81	131
CDRA04091	9.1	10	81	131
CDRA04092	9.2	10	81	131
CDRA04093	9.3	10	81	131
CDRA04094	9.4	10	81	131
CDRA04095	9.5	10	81	131
CDRA04096	9.6	10	87	137
CDRA04097	9.7	10	87	137
CDRA04098	9.8	10	87	137
CDRA04099	9.9	10	87	137
CDRA04100	10.0	10	87	137
CDRA04101	10.1	12	87	144
CDRA04102	10.2	12	87	144
CDRA04103	10.3	12	87	144
CDRA04104	10.4	12	87	144
CDRA04105	10.5	12	87	144

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
CDRA04106	10.6	12	87	144
CDRA04107	10.7	12	94	151
CDRA04108	10.8	12	94	151
CDRA04109	10.9	12	94	151
CDRA04110	11.0	12	94	151
CDRA04111	11.1	12	94	151
CDRA04112	11.2	12	94	151
CDRA04113	11.3	12	94	151
CDRA04114	11.4	12	94	151
CDRA04115	11.5	12	94	151
CDRA04116	11.6	12	94	151
CDRA04117	11.7	12	94	151
CDRA04118	11.8	12	94	151
CDRA04119	11.9	12	101	158
CDRA04120	12.0	12	101	158
CDRA04121	12.1	12	101	158
CDRA04122	12.2	12	101	158
CDRA04123	12.3	12	101	158
CDRA04124	12.4	12	101	158
CDRA04125	12.5	12	101	158
CDRA04126	12.6	12	101	158
CDRA04127	12.7	12	101	158
CDRA04128	12.8	12	101	158
CDRA04129	12.9	12	101	158
CDRA04130	13.0	12	101	158

CUTTING CONDITION

Unit : mm

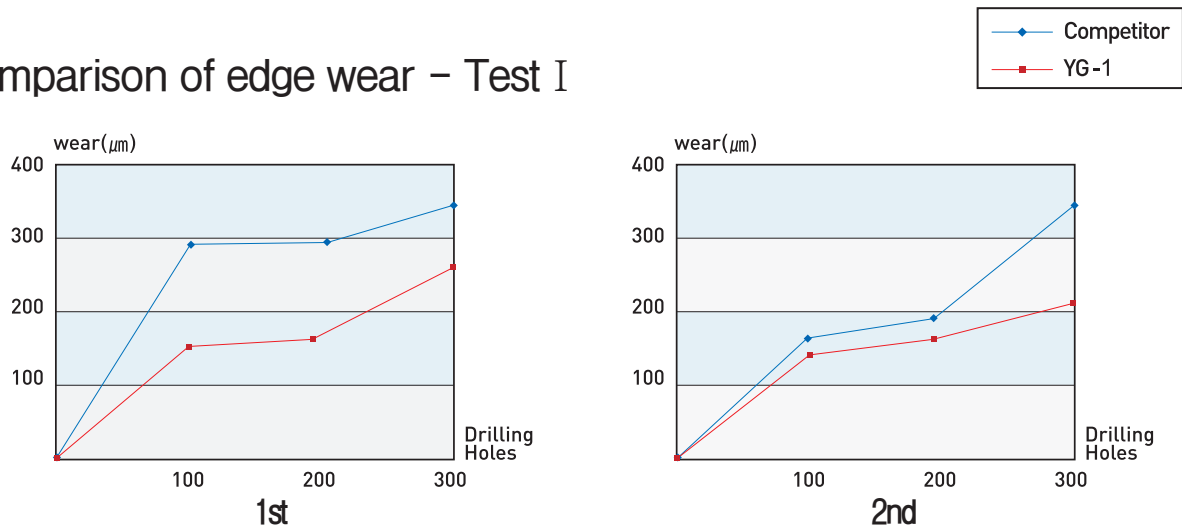
WORK MATERIAL	CARBON STEEL		ALLOY STEELS PRE-HARDENED STEEL		CAST IRON		ALUMINUM ALLOYS NONFERROUS ALLOYS		MOLD STEEL, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)	
	DIAMETER	N	S	N	S	N	S	N	S	N	S	N
2.0	5800	0.05	4700	0.04	6500	0.07	10500	0.14	2600	0.03	3100	0.07
3.0	4300	0.10	3500	0.08	4900	0.12	10500	0.23	1800	0.04	2100	0.08
4.0	3200	0.13	2600	0.11	3600	0.15	8000	0.28	1300	0.06	1600	0.09
5.0	2600	0.15	2100	0.14	2900	0.18	6500	0.33	1050	0.08	1250	0.14
6.0	2100	0.17	1700	0.15	2400	0.21	5200	0.39	900	0.09	1050	0.16
8.0	1600	0.20	1300	0.17	1800	0.25	4200	0.43	650	0.12	800	0.22
10.0	1300	0.23	1000	0.20	1500	0.27	3400	0.52	550	0.14	630	0.28
12.0	1100	0.25	850	0.22	1200	0.31	2700	0.62	450	0.17	530	0.33

N = R.P.M

S = Feed per Revolution (mm/rev.)

TEST RESULT AGAINST COMPETITOR'S HSS-PM DRILLS

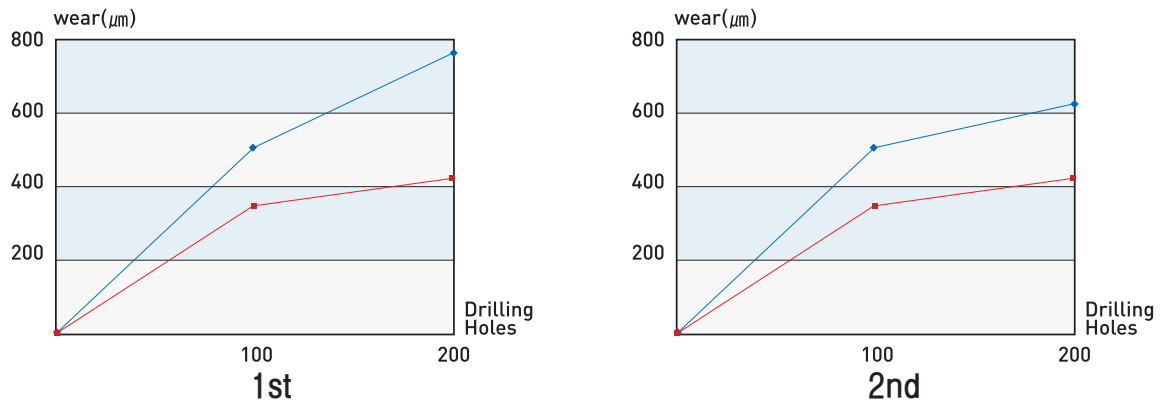
Comparison of edge wear – Test I



Cutting Condition

- Work material : SUS316(X3CrNiMo17-13-3) - R.P.M : 600 rev/min
- Drilling Depth : 24 mm - Feed : 110 mm/min
- Total Drilling(hole) : 300

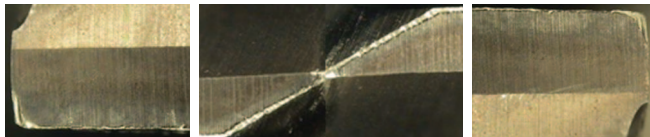
Comparison of edge wear – Test II



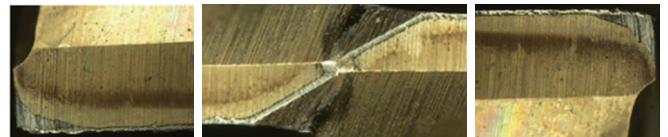
Cutting Condition

- Work material : SKD11(X155CrVMo12-1) - R.P.M : 600 rev/min
- Drilling Depth : 24 mm - Feed : 110 mm/min
- Total Drilling(hole) : 200

YG-1



COMPETITOR



Selection Chart

◎ : Excellent ○ : Good

Work Material							
Structural Steels	Carbon Steels	Pre-Hardened Steels Alloy Steels	Hardened Steels(HRc 30~45)	Stainless Steels	Cast Irons	Aluminum Alloys	Copper Alloys
◎	◎	◎	◎	◎	○	○	○



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