

Solid Carbide "Speedy" Reamer

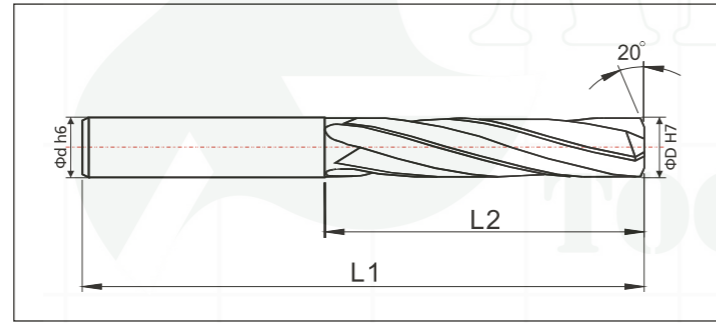


YSR(L)



YSBR Solid Broach Reamer(Order-made)

- ▶ 15° right helix spiral, 20° chamfer(standard) for high speed reaming
- ▶ Standard H7 tolerance, special point & tolerance or corner radius available on demand
- ▶ Speedy reaming Vc = 40~80m/min., f = 0.1mm/rev.per flute, TiN & TiAlN coated.
- ▶ Best combination if use with our standard YSD Solid carbide drill.



YSR Solid Carbide "Speedy" Reamer.

Code No.	D	d	L1	L2	Number of Flute
YSR 030 ~ 035	3.0 ~ 3.5	4.0	54	19	3
YSR 036 ~ 041	3.6 ~ 4.1			24	
YSR 042 ~ 051	4.2 ~ 5.1	5.0	61	31	
YSR 052 ~ 061	5.2 ~ 6.1	6.0	65	35	
YSR 062 ~ 071	6.2 ~ 7.1	7.0	73	41	
YSR 072 ~ 081	7.2 ~ 8.1	8.0	78	45	
YSR 082 ~ 091	8.2 ~ 9.1	9.0	82	48	
YSR 092 ~ 101	9.2 ~ 10.1	10.0	87	51	
YSR 102 ~ 111	10.2 ~ 11.1	11.0	93	53	
YSR 112 ~ 121	11.2 ~ 12.1	12.0	100	60	
YSR 122 ~ 131	12.2 ~ 13.1				13.0
YSR 132 ~ 141	13.2 ~ 14.1	14.0	105	62	
YSR 142 ~ 151	14.2 ~ 15.1	15.0	108	64	
YSR 152 ~ 161	15.2 ~ 16.1	16.0	112	66	
YSR 162 ~ 171	16.2 ~ 17.1	17.0	116	68	
YSR 172 ~ 181	17.2 ~ 18.1	18.0	120	71	
YSR 182 ~ 191	18.2 ~ 19.1	19.0	124	73	
YSR 192 ~ 200	19.2 ~ 20.0	20.0	128	77	

YSRL Solid Carbide Speedy Reamer, Long series

Code No.	D	d	L1	L2	Number of Flute
YSRL 030 ~ 035	3.0 ~ 3.5	4.0	79	44	3
YSRL 036 ~ 041	3.6 ~ 4.1				
YSRL 042 ~ 051	4.2 ~ 5.1	5.0	82	49	
YSRL 052 ~ 061	5.2 ~ 6.1	6.0	84	52	
YSRL 062 ~ 071	6.2 ~ 7.1	7.0	89	57	
YSRL 072 ~ 081	7.2 ~ 8.1	8.0	96	62	
YSRL 082 ~ 091	8.2 ~ 9.1	9.0	103	66	
YSRL 092 ~ 101	9.2 ~ 10.1	10.0	108	71	
YSRL 102 ~ 111	10.2 ~ 11.1	11.0	118	78	
YSRL 112 ~ 121	11.2 ~ 12.1	12.0	135	88	
YSRL 122 ~ 131	12.2 ~ 13.1				145
YSRL 132 ~ 141	13.2 ~ 14.1	14.0	145	94	
YSRL 142 ~ 151	14.2 ~ 15.1	15.0	150	97	
YSRL 152 ~ 161	15.2 ~ 16.1	16.0	157	109	
YSRL 162 ~ 171	16.2 ~ 17.1	17.0			
YSRL 172 ~ 181	17.2 ~ 18.1	18.0	157	109	
YSRL 182 ~ 191	18.2 ~ 19.1	19.0	157	109	
YSRL 192 ~ 200	19.2 ~ 20.0	20.0			

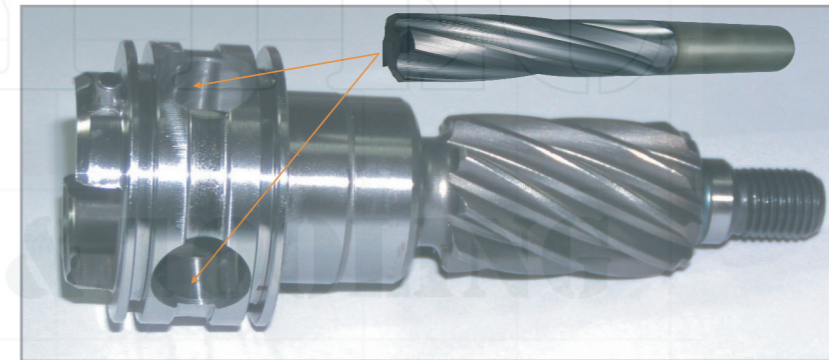
Machining case of YSR

- ▶ Company : "M" Automotive
- ▶ Applied Carbide Speedy Reamer : YSR120-R0.6
- ▶ Kind of machine : Machining center, Vertical spindle
- ▶ Work-piece : SCM420H, EPS Pinion shaft, HRC27~31 (See reamed work-piece photo)
- ▶ Cutting speed : 1200rpm, Vc = 45m/min., f = 0.2mm/rev.
- ▶ Pre-drilling : Φ11.8mm, cut-off : 0.1mm(one side)
- ▶ Coolant : External soluble oil

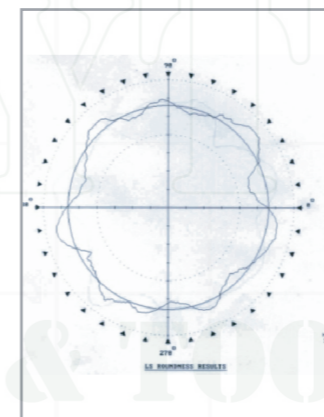
Resulted in great performance

- ▶ Roundness : O=1.80μm,
- ▶ Roughness : Ra = 0.14μm
- ▶ Cycle time 650% increase

Photo illustrates the reamed actual work-piece, EPS Pinion shaft.

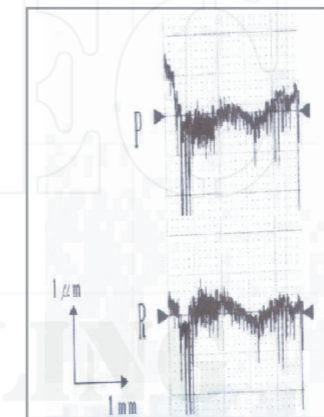


Roundness measures



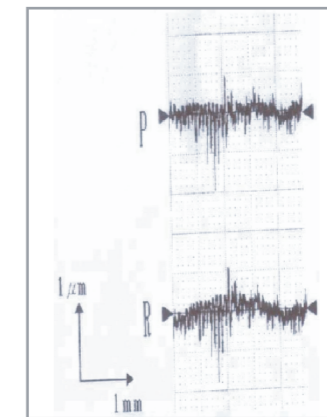
Measuring : External
O = 1.80μm

Roughness for hole mouth



P: Polarity
R : Round measure
Ra = 0.14 μm
Rmax = 3.18 μm
Rz = 1.58 μm

Roughness for hole end



P: Polarity
R : Round measure
Ra = 0.10 μm
Rmax = 1.46 μm
Rz = 0.94 μm

❖ YSR Speedy reamer ran at faster cycle time, higher speed & feed, longer tool life along with greater roundness and roughness.

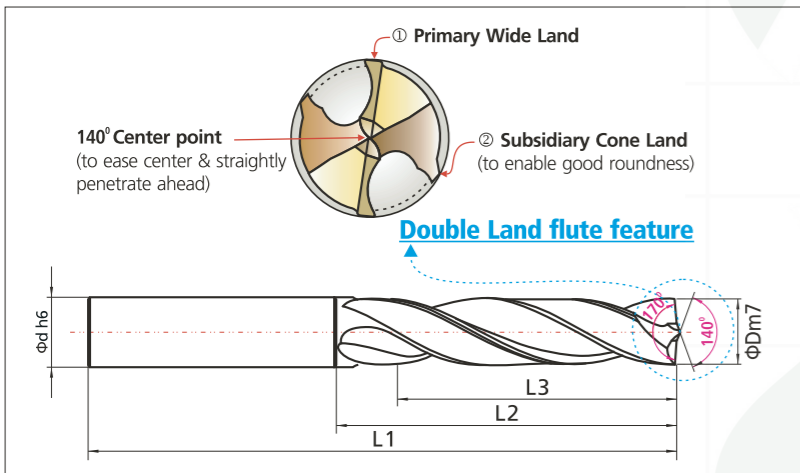
Note

All the dimension is similar to YSD drills. Recommended pre-drilling size -0.2mm.

Solid Carbide "F" (flat bottom) point drills

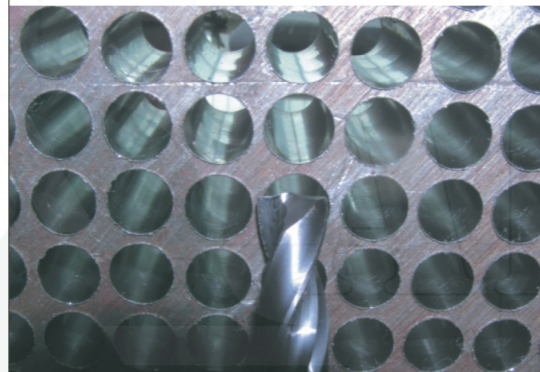


YSDF YSDLF



"F" point test photo as below

Drill : YSDLF 100 TiAlN
 Material : SCM440(42CrMo4)
 rpm : 2,000
 f : 0.2mm/rev (F : 400mm/min)



YSDF - Solid Carbide "F" Point Drill

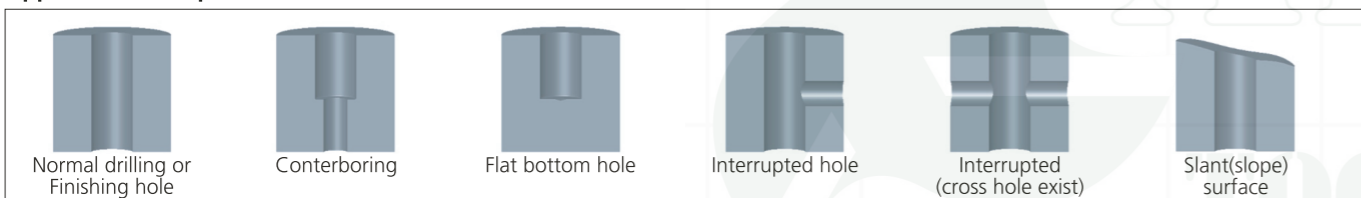
Code No.	D	d	L1	L2	L3
YSDF 030-035	3.0-3.5	4	55	20	15
YSDF 036-041	3.6-4.1			25	19
YSDF 042-051	4.2-5.1	5	62	32	25
YSDF 052-061	5.2-6.1	6	66	36	27
YSDF 062-071	6.2-7.1	7	74	42	32
YSDF 072-081	7.2-8.1	8	79	46	34
YSDF 082-091	8.2-9.1	9	84	50	37
YSDF 092-101	9.2-10.1	10	89	53	38
YSDF 102-111	10.2-11.1	11	95	55	40
YSDF 112-121	11.2-12.1	12	102	62	44
YSDF 122-131	12.2-13.1	13			42
YSDF 132-141	13.2-14.1	14	107	64	43
YSDF 142-151	14.2-15.1	15	111	67	45
YSDF 152-161	15.2-16.1	16	115	69	
YSDF 162-171	16.2-17.1	17	119	71	46
YSDF 172-181	17.2-18.1	18	123	74	47
YSDF 182-191	18.2-19.1	19	127	76	48
YSDF 192-200	19.2-20.0	20	131	80	50

YSDLF - Solid Carbide "F" Point Long Drill

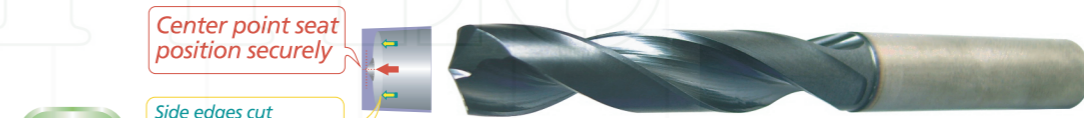
Code No.	D	d	L1	L2	L3
YSDLF 030-035	3.0-3.5	4	80	45	40
YSDLF 036-041	3.6-4.1				39
YSDLF 042-051	4.2-5.1	5			38
YSDLF 052-061	5.2-6.1	6	83	50	41
YSDLF 062-071	6.2-7.1	7	85	53	43
YSDLF 072-081	7.2-8.1	8	90	58	46
YSDLF 082-091	8.2-9.1	9	98	64	51
YSDLF 092-101	9.2-10.1	10	105	68	53
YSDLF 102-111	10.2-11.1	11	110	73	57
YSDLF 112-121	11.2-12.1	12	120	80	62
YSDLF 122-131	12.2-13.1	13	137	90	71
YSDLF 132-141	13.2-14.1	14	147	96	75
YSDLF 142-151	14.2-15.1	15	153	100	78
YSDLF 152-161	15.2-16.1	16	160	112	88
YSDLF 162-171	16.2-17.1	17			87
YSDLF 172-181	17.2-18.1	18			85
YSDLF 182-191	18.2-19.1	19			84
YSDLF 192-200	19.2-20.0	20			82

- Note : "F" point drill is available on request.

Application example.

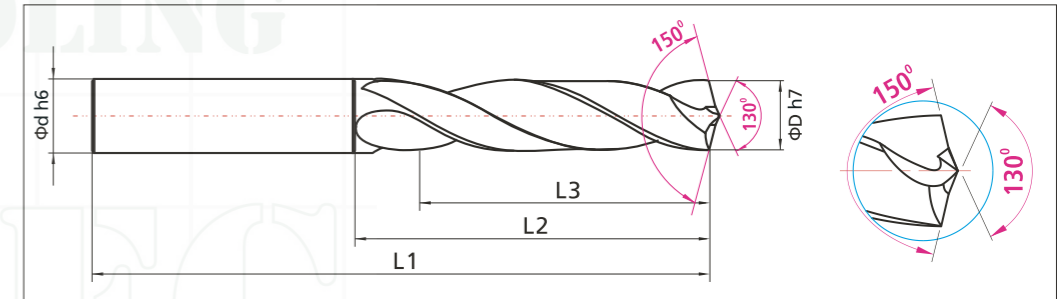


Solid Carbide "P" (Premium) point Drill



YSDP

YSDLP



- ▶ New premium dual point design (130° center+150° side edges)
- ▶ Enables Deep hole drilling
- ▶ Minimized vibration
- ▶ Higher penetration
- ▶ Faster chip evacuation rate
- ▶ Available with newest coating "Y+" to increase tool life

YSDP - Solid Carbide "P" Point Drill

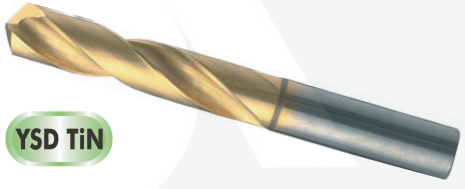
Code No.	D	d	L1	L2	L3
YSDP 030-035	3.0-3.5	4	55	20	15
YSDP 036-041	3.6-4.1			25	19
YSDP 042-051	4.2-5.1	5	62	32	25
YSDP 052-061	5.2-6.1	6	66	36	27
YSDP 062-071	6.2-7.1	7	74	42	32
YSDP 072-081	7.2-8.1	8	79	46	34
YSDP 082-091	8.2-9.1	9	84	50	37
YSDP 092-101	9.2-10.1	10	89	53	38
YSDP 102-111	10.2-11.1	11	95	55	40
YSDP 112-121	11.2-12.1	12	102	62	44
YSDP 122-131	12.2-13.1	13			42
YSDP 132-141	13.2-14.1	14	107	64	43
YSDP 142-151	14.2-15.1	15	111	67	45
YSDP 152-161	15.2-16.1	16	115	69	
YSDP 162-171	16.2-17.1	17	119	71	46
YSDP 172-181	17.2-18.1	18	123	74	47
YSDP 182-191	18.2-19.1	19	127	76	48
YSDP 192-200	19.2-20.0	20	131	80	50

- Note : "P" point drill is available on request.

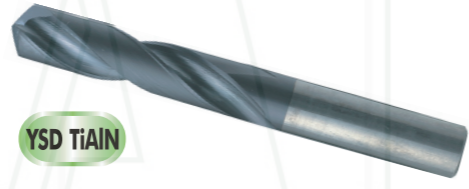
YSDLP - Solid Carbide "P" Point Long Drill

Code No.	D	d	L1	L2	L3
YSDLP 030-035	3.0-3.5	4	80	45	40
YSDLP 036-041	3.6-4.1				39
YSDLP 042-051	4.2-5.1	5			38
YSDLP 052-061	5.2-6.1	6	83	50	41
YSDLP 062-071	6.2-7.1	7	85	53	43
YSDLP 072-081	7.2-8.1	8	90	58	46
YSDLP 082-091	8.2-9.1	9	98	64	51
YSDLP 092-101	9.2-10.1	10	105	68	53
YSDLP 102-111	10.2-11.1	11	110	73	57
YSDLP 112-121	11.2-12.1	12	120	80	62
YSDLP 122-131	12.2-13.1	13	137	90	71
YSDLP 132-141	13.2-14.1	14	147	96	75
YSDLP 142-151	14.2-15.1	15	153	100	78
YSDLP 152-161	15.2-16.1	16	160	112	88
YSDLP 162-171	16.2-17.1	17			87
YSDLP 172-181	17.2-18.1	18			85
YSDLP 182-191	18.2-19.1	19			84
YSDLP 192-200	19.2-20.0	20			82

Solid Carbide Drill, Metric



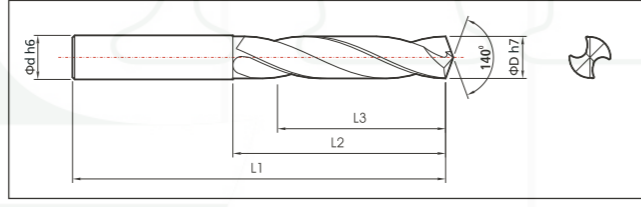
YSD TIN



YSD TiAlN



YSSD TIN ♦ Made-to-order



Model : YSD

- ▶ Solid Carbide drill, Yes standard length, Plain cylindrical HA shank.
- ▶ Effective cutting depth 3xDia. (Whistle notch HE shank available on request)
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.
- ▶ High performance carbide drill and re-sharpening & re-conditioning available

Carbide substrate

- ▶ Ultra-fine Micro Grain, PVD TiN, TiAlN coated as standard stock.

Application

- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

Code No.	D	d	L1	L2	L3
YSD 030	3.0	4.0	55	20	15
YSD 031	3.1				
YSD 032	3.2				
YSD 033	3.3				
YSD 034	3.4				
YSD 035	3.5				
YSD 036	3.6				
YSD 037	3.7				
YSD 038	3.8				
YSD 039	3.9				
YSD 040	4.0				
YSD 041	4.1				

Code No.	D	d	L1	L2	L3
YSD 042	4.2	5.0	62	32	25
YSD 043	4.3				
YSD 044	4.4				
YSD 045	4.5				
YSD 046	4.6				
YSD 047	4.7				
YSD 048	4.8				
YSD 049	4.9				
YSD 050	5.0				
YSD 051	5.1				

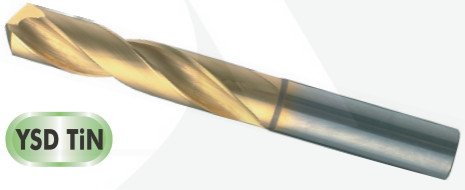
Code No.	D	d	L1	L2	L3
YSD 052	5.2	6.0	66	36	27
YSD 053	5.3				
YSD 054	5.4				
YSD 055	5.5				
YSD 056	5.6				
YSD 057	5.7				
YSD 058	5.8				
YSD 059	5.9				
YSD 060	6.0				
YSD 061	6.1				

Code No.	D	d	L1	L2	L3
YSD 062	6.2	7.0	74	42	32
YSD 063	6.3				
YSD 064	6.4				
YSD 065	6.5				
YSD 066	6.6				
YSD 067	6.7				
YSD 068	6.8				
YSD 069	6.9				
YSD 070	7.0				
YSD 071	7.1				
YSD 072	7.2	8.0	79	46	34
YSD 073	7.3				
YSD 074	7.4				
YSD 075	7.5				
YSD 076	7.6				
YSD 077	7.7				
YSD 078	7.8				
YSD 079	7.9				
YSD 080	8.0				
YSD 081	8.1				
YSD 082	8.2	9.0	84	50	37
YSD 083	8.3				
YSD 084	8.4				
YSD 085	8.5				
YSD 086	8.6				
YSD 087	8.7				
YSD 088	8.8				
YSD 089	8.9				
YSD 090	9.0				
YSD 091	9.1				
YSD 092	9.2	10.0	89	53	38
YSD 093	9.3				
YSD 094	9.4				
YSD 095	9.5				
YSD 096	9.6				
YSD 097	9.7				
YSD 098	9.8				
YSD 099	9.9				
YSD 100	10.0				
YSD 101	10.1				
YSD 102	10.2	11.0	95	55	40
YSD 103	10.3				
YSD 104	10.4				
YSD 105	10.5				
YSD 106	10.6				
YSD 107	10.7				
YSD 108	10.8				
YSD 109	10.9				
YSD 110	11.0				
YSD 111	11.1				

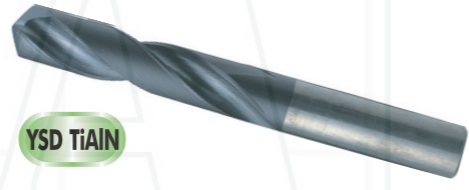
Code No.	D	d	L1	L2	L3
YSD 112	11.2	12.0	102	62	44
YSD 113	11.3				
YSD 114	11.4				
YSD 115	11.5				
YSD 116	11.6				
YSD 117	11.7				
YSD 118	11.8				
YSD 119	11.9				
YSD 120	12.0				
YSD 121	12.1				
YSD 122	12.2	13.0	107	64	43
YSD 123	12.3				
YSD 124	12.4				
YSD 125	12.5				
YSD 126	12.6				
YSD 127	12.7				
YSD 128	12.8				
YSD 129	12.9				
YSD 130	13.0				
YSD 131	13.1				
YSD 132	13.2	14.0	111	67	45
YSD 133	13.3				
YSD 134	13.4				
YSD 135	13.5				
YSD 136	13.6				
YSD 137	13.7				
YSD 138	13.8				
YSD 139	13.9				
YSD 140	14.0				
YSD 141	14.1				
YSD 142	14.2	15.0	115	69	45
YSD 143	14.3				
YSD 144	14.4				
YSD 145	14.5				
YSD 146	14.6				
YSD 147	14.7				
YSD 148	14.8				
YSD 149	14.9				
YSD 150	15.0				
YSD 151	15.1				
YSD 152	15.2	16.0	119	71	46
YSD 153	15.3				
YSD 154	15.4				
YSD 155	15.5				
YSD 156	15.6				
YSD 157	15.7				
YSD 158	15.8				
YSD 159	15.9				
YSD 160	16.0				
YSD 161	16.1				

Code No.	D	d	L1	L2	L3
YSD 162	16.2	17.0	123	74	47
YSD 163	16.3				
YSD 164	16.4				
YSD 165	16.5				
YSD 166	16.6				
YSD 167	16.7				
YSD 168	16.8				
YSD 169	16.9				
YSD 170	17.0				
YSD 171	17.1				
YSD 172	17.2	18.0	127	76	48
YSD 173	17.3				
YSD 174	17.4				
YSD 175	17.5				
YSD 176	17.6				
YSD 177	17.7				
YSD 178	17.8				
YSD 179	17.9				
YSD 180	18.0				
YSD 181	18.1				
YSD 182	18.2	19.0	131	80	50
YSD 183	18.3				
YSD 184	18.4				
YSD 185	18.5				
YSD 186	18.6				
YSD 187	18.7				
YSD 188	18.8				
YSD 189	18.9				
YSD 190	19.0				
YSD 191	19.1				
YSD 192	19.2				
YSD 193	19.3				
YSD 194	19.4				
YSD 195	19.5				
YSD 196	19.6				
YSD 197	19.7				
YSD 198	19.8				
YSD 199	19.9				
YSD 200	20.0				

Solid Carbide Drill, Inch



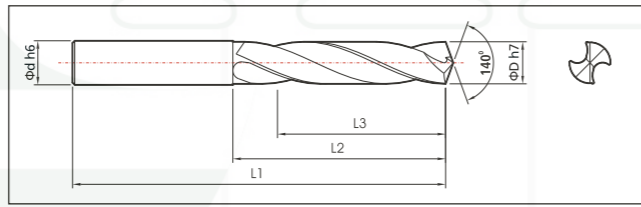
YSD TIN



YSD TiAlN



YSSD TIN ♦ Made-to-order



Model : YSD

- ▶ Solid Carbide drill, Yes standard length, Plain cylindrical HA shank.
- ▶ Effective cutting depth 3xDia. (Whistle notch HE shank available on request)
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.
- ▶ High performance carbide drill and re-sharpening & re-conditioning available

Carbide substrate

- ▶ Ultra-fine Micro Grain, PVD TiN, TiAlN coated as standard stock.

Application

- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

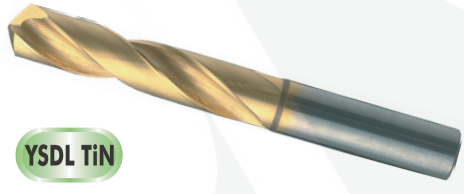
Inch Size

Code No.	D	d	L1	L2	L3
YSD .1250	1/8	3/16	2.16	0.78	0.59
YSD .1562	5/32		2.44	1.25	1
YSD .1875	3/16		2.91	1.65	1.25
YSD .2188	7/32	1/4	3.11	1.81	1.33
YSD .2500	1/4				
YSD .2656	17/64	5/16	3.5	2.08	1.5
YSD .2812	9/32				
YSD .2969	19/64				
YSD .3125	5/16	3/8	4.84	2.91	1.85
YSD .3281	21/64				
YSD .3438	11/32				
YSD .3594	23/64	7/16	5.5	3.74	1.57
YSD .3750	3/8				

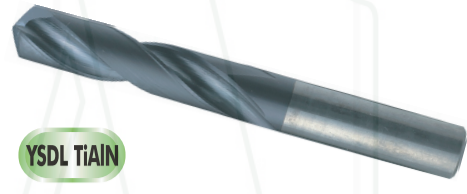
Inch Size

Code No.	D	d	L1	L2	L3
YSD .3906	25/64	7/16	3.74	2.16	1.57
YSD .4062	13/32				
YSD .4219	27/64				
YSD .4375	7/16	1/2	4.01	2.44	1.65
YSD .4531	29/64				
YSD .4688	15/32				
YSD .4844	31/64	9/16	4.37	2.63	1.77
YSD .5000	1/2				
YSD .5625	9/16				
YSD .6250	5/8	11/16	4.84	2.91	1.85
YSD .6875	11/16				
YSD .7500	3/4				

Solid Carbide Drill, Long Series, Metric



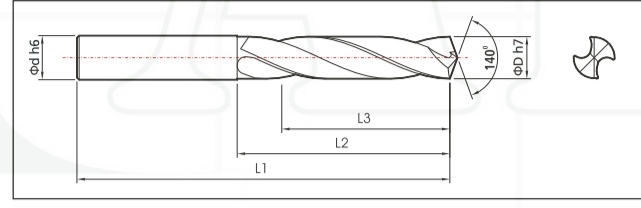
YSDL TiN



YSDL TiAlN



YSSD TiN Made-to-order



Model : YSDL

- ▶ Solid Carbide drill, Yes standard length, Plain cylindrical HA shank.
- ▶ Effective cutting depth 5xDia. Whistle notch HE shank available on request)
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.
- ▶ High performance carbide drill and re-sharpening & re-conditioning available

Carbide substrate

- ▶ Ultra-fine Micro Grain, PVD TiN, TiAlN coated as standard stock.

Application

- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

Code No.	D	d	L1	L2	L3
YSDL 030	3.0	4.0	80	45	40
YSDL 031	3.1				
YSDL 032	3.2				
YSDL 033	3.3				
YSDL 034	3.4				
YSDL 035	3.5				
YSDL 036	3.6				
YSDL 037	3.7				
YSDL 038	3.8				
YSDL 039	3.9				
YSDL 040	4.0	39			
YSDL 041	4.1				

Code No.	D	d	L1	L2	L3
YSDL 042	4.2	5.0	80	45	38
YSDL 043	4.3				
YSDL 044	4.4				
YSDL 045	4.5				
YSDL 046	4.6				
YSDL 047	4.7				
YSDL 048	4.8				
YSDL 049	4.9				
YSDL 050	5.0				
YSDL 051	5.1				

Code No.	D	d	L1	L2	L3
YSDL 052	5.2	6.0	83	50	41
YSDL 053	5.3				
YSDL 054	5.4				
YSDL 055	5.5				
YSDL 056	5.6				
YSDL 057	5.7				
YSDL 058	5.8				
YSDL 059	5.9				
YSDL 060	6.0				
YSDL 061	6.1				

Continued ▶▶

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Solid Carbide Drill, Long Series, Metric

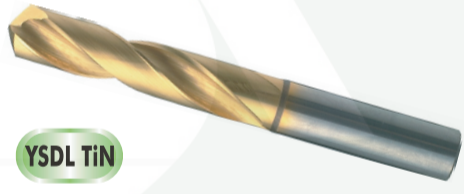
Code No.	D	d	L1	L2	L3
YSDL 062	6.2	7.0	85	53	43
YSDL 063	6.3				
YSDL 064	6.4				
YSDL 065	6.5				
YSDL 066	6.6				
YSDL 067	6.7				
YSDL 068	6.8				
YSDL 069	6.9				
YSDL 070	7.0				
YSDL 071	7.1				
YSDL 072	7.2	8.0	90	58	46
YSDL 073	7.3				
YSDL 074	7.4				
YSDL 075	7.5				
YSDL 076	7.6				
YSDL 077	7.7				
YSDL 078	7.8				
YSDL 079	7.9				
YSDL 080	8.0				
YSDL 081	8.1				
YSDL 082	8.2	9.0	98	64	51
YSDL 083	8.3				
YSDL 084	8.4				
YSDL 085	8.5				
YSDL 086	8.6				
YSDL 087	8.7				
YSDL 088	8.8				
YSDL 089	8.9				
YSDL 090	9.0				
YSDL 091	9.1				
YSDL 092	9.2	10.0	105	68	53
YSDL 093	9.3				
YSDL 094	9.4				
YSDL 095	9.5				
YSDL 096	9.6				
YSDL 097	9.7				
YSDL 098	9.8				
YSDL 099	9.9				
YSDL 100	10.0				
YSDL 101	10.1				
YSDL 102	10.2	11.0	110	73	57
YSDL 103	10.3				
YSDL 104	10.4				
YSDL 105	10.5				
YSDL 106	10.6				
YSDL 107	10.7				

Code No.	D	d	L1	L2	L3
YSDL 108	10.8	11.0	110	73	57
YSDL 109	10.9				
YSDL 110	11.0				
YSDL 111	11.1				
YSDL 112	11.2				
YSDL 113	11.3				
YSDL 114	11.4				
YSDL 115	11.5				
YSDL 116	11.6				
YSDL 117	11.7				
YSDL 118	11.8	12.0	120	80	62
YSDL 119	11.9				
YSDL 120	12.0				
YSDL 121	12.1				
YSDL 122	12.2				
YSDL 123	12.3				
YSDL 124	12.4				
YSDL 125	12.5				
YSDL 126	12.6				
YSDL 127	12.7				
YSDL 128	12.8	13.0	137	90	71
YSDL 129	12.9				
YSDL 130	13.0				
YSDL 131	13.1				
YSDL 132	13.2				
YSDL 133	13.3				
YSDL 134	13.4				
YSDL 135	13.5				
YSDL 136	13.6				
YSDL 137	13.7				
YSDL 138	13.8	14.0	147	96	75
YSDL 139	13.9				
YSDL 140	14.0				
YSDL 141	14.1				
YSDL 142	14.2				
YSDL 143	14.3				
YSDL 144	14.4				
YSDL 145	14.5				
YSDL 146	14.6				
YSDL 147	14.7				
YSDL 148	14.8	15.0	153	100	78
YSDL 149	14.9				
YSDL 150	15.0				
YSDL 151	15.1				
YSDL 152	15.2				
YSDL 153	15.3				

Code No.	D	d	L1	L2	L3
YSDL 154	15.4	16.0	160	112	85
YSDL 155	15.5				
YSDL 156	15.6				
YSDL 157	15.7				
YSDL 158	15.8				
YSDL 159	15.9				
YSDL 160	16.0				
YSDL 161	16.1				
YSDL 162	16.2				
YSDL 163	16.3				
YSDL 164	16.4	17.0	170	87	
YSDL 165	16.5				
YSDL 166	16.6				
YSDL 167	16.7				
YSDL 168	16.8				
YSDL 169	16.9				
YSDL 170	17.0				
YSDL 171	17.1				
YSDL 172	17.2				
YSDL 173	17.3				
YSDL 174	17.4	18.0	180	89	
YSDL 175	17.5				
YSDL 176	17.6				
YSDL 177	17.7				
YSDL 178	17.8				
YSDL 179	17.9				
YSDL 180	18.0				
YSDL 181	18.1				
YSDL 182	18.2				
YSDL 183	18.3				
YSDL 184	18.4	19.0	190	91	
YSDL 185	18.5				
YSDL 186	18.6				
YSDL 187	18.7				
YSDL 188	18.8				
YSDL 189	18.9				
YSDL 190	19.0				
YSDL 191	19.1				
YSDL 192	19.2				
YSDL 193	19.3				
YSDL 194	19.4	20.0	200	93	
YSDL 195	19.5				
YSDL 196	19.6				
YSDL 197	19.7				
YSDL 198	19.8				
YSDL 199	19.9				
YSDL 200	20.0				

Solid Carbide Series

Solid Carbide Drill, Long Series, Inch



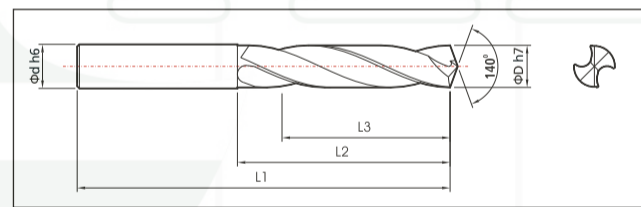
YSDL TiN



YSDL TiAlN



YSSD TiN Made-to-order



Model : YSDL

- ▶ Solid Carbide drill, Yes standard length, Plain cylindrical HA shank.
- ▶ Effective cutting depth 5xDia. Whistle notch HE shank available on request)
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.
- ▶ High performance carbide drill and re-sharpening & re-conditioning available

Carbide substrate

- ▶ Ultra-fine Micro Grain, PVD TiN, TiAlN coated as standard stock.

Application

- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

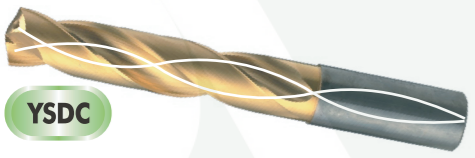
Code No.	D	d	L1	L2	L3
YSDL .1250	1/8	3/16	3.15	1.77	1.57
YSDL .1562	5/32				
YSDL .1875	3/16				
YSDL .2188	7/32				
YSDL .2500	1/4				
YSDL .2656	17/64				
YSDL .2812	9/32				
YSDL .2969	19/64				
YSDL .3125	5/16				
YSDL .3281	21/64				
YSDL .3438	11/32	3/8	4.13	2.67	2.08
YSDL .3594	23/64				
YSDL .3750	3/8				

Code No.	D	d	L1	L2	L3				
YSDL .3906	25/64	7/16	4.33	2.87	2.24				
YSDL .4062	13/32								
YSDL .4219	27/64								
YSDL .4375	7/16								
YSDL .4531	29/64								
YSDL .4688	15/32								
YSDL .4844	31/64								
YSDL .5000	1/2								
YSDL .5625	9/16					9/16	5.78	3.77	2.95
YSDL .6250	5/8								
YSDL .6875	11/16								
YSDL .7500	3/4								

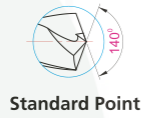
53

Solid Carbide Series

Solid Carbide Coolant Drill, Metric



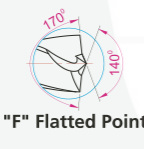
YSDC



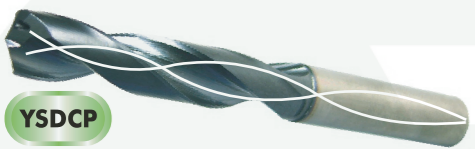
Standard Point



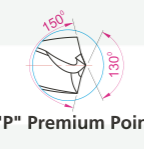
YSDCF



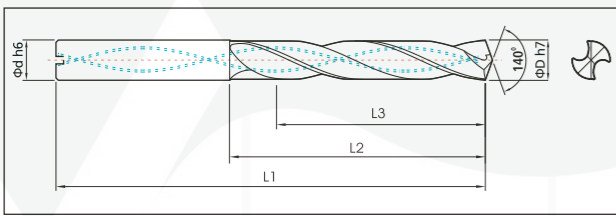
"F" Flatted Point



YSDCP



"P" Premium Point



Model : YSDC

- ▶ Solid Carbide Coolant hole drill, HA shank
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.

Carbide substrate:

- ▶ Micro Grain Carbide, TiN & TiAlN

Application

- ▶ High productivity. Coolant fed design efficiently cools the workpiece and provides good chip removal.
- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.

Code No.	D	d	L1	L2	L3
YSDC 050	5.0	5.0			35
YSDC 051	5.1				
YSDC 052	5.2				
YSDC 053	5.3				
YSDC 054	5.4				
YSDC 055	5.5		72	42	
YSDC 056	5.6	6.0			33
YSDC 057	5.7				
YSDC 058	5.8				
YSDC 059	5.9				
YSDC 060	6.0				

Code No.	D	d	L1	L2	L3
YSDC 061	6.1	6.0	72	42	33
YSDC 062	6.2				
YSDC 063	6.3				
YSDC 064	6.4				
YSDC 065	6.5				
YSDC 066	6.6				
YSDC 067	6.7	7.0	97	60	50
YSDC 068	6.8				
YSDC 069	6.9				
YSDC 070	7.0				
YSDC 071	7.1				

Code No.	D	d	L1	L2	L3
YSDC 072	7.2				
YSDC 073	7.3				
YSDC 074	7.4				
YSDC 075	7.5				
YSDC 076	7.6				
YSDC 077	7.7	8.0	97	60	48
YSDC 078	7.8				
YSDC 079	7.9				
YSDC 080	8.0				
YSDC 081	8.1				

❖ Available small dia. below 5.0 and special step coolant drill on request.
❖ YSDCP & YSDCF available upon request only

Code No.	D	d	L1	L2	L3
YSDC 082	8.2				
YSDC 083	8.3				
YSDC 084	8.4				
YSDC 085	8.5				
YSDC 086	8.6	9.0		47	
YSDC 087	8.7				
YSDC 088	8.8				
YSDC 089	8.9				
YSDC 090	9.0				
YSDC 091	9.1		97	60	
YSDC 092	9.2				
YSDC 093	9.3				
YSDC 094	9.4				
YSDC 095	9.5				
YSDC 096	9.6	10.0		45	
YSDC 097	9.7				
YSDC 098	9.8				
YSDC 099	9.9				
YSDC 100	10.0				
YSDC 101	10.1				
YSDC 102	10.2				
YSDC 103	10.3				
YSDC 104	10.4				
YSDC 105	10.5				
YSDC 106	10.6	11.0		84	
YSDC 107	10.7				
YSDC 108	10.8				
YSDC 109	10.9				
YSDC 110	11.0				
YSDC 111	11.1		140	100	
YSDC 112	11.2				
YSDC 113	11.3				
YSDC 114	11.4				
YSDC 115	11.5				
YSDC 116	11.6	12.0		82	
YSDC 117	11.7				
YSDC 118	11.8				
YSDC 119	11.9				
YSDC 120	12.0				
YSDC 121	12.1				

Code No.	D	d	L1	L2	L3
YSDC 122	12.2				
YSDC 123	12.3				
YSDC 124	12.4				
YSDC 125	12.5				
YSDC 126	12.6	13.0		83	
YSDC 127	12.7				
YSDC 128	12.8				
YSDC 129	12.9				
YSDC 130	13.0				
YSDC 131	13.1				
YSDC 132	13.2				
YSDC 133	13.3				
YSDC 134	13.4				
YSDC 135	13.5				
YSDC 136	13.6	14.0		81	
YSDC 137	13.7				
YSDC 138	13.8				
YSDC 139	13.9				
YSDC 140	14.0				
YSDC 141	14.1		143	102	
YSDC 142	14.2				
YSDC 143	14.3				
YSDC 144	14.4				
YSDC 145	14.5				
YSDC 146	14.6	15.0		80	
YSDC 147	14.7				
YSDC 148	14.8				
YSDC 149	14.9				
YSDC 150	15.0				
YSDC 151	15.1				
YSDC 152	15.2				
YSDC 153	15.3				
YSDC 154	15.4				
YSDC 155	15.5				
YSDC 156	15.6	16.0		78	
YSDC 157	15.7				
YSDC 158	15.8				
YSDC 159	15.9				
YSDC 160	16.0				
YSDC 161	16.1				

Code No.	D	d	L1	L2	L3
YSDC 162	16.2				
YSDC 163	16.3				
YSDC 164	16.4				
YSDC 165	16.5				
YSDC 166	16.6	17.0		79	
YSDC 167	16.7				
YSDC 168	16.8				
YSDC 169	16.9				
YSDC 170	17.0				
YSDC 171	17.1				
YSDC 172	17.2				
YSDC 173	17.3				
YSDC 174	17.4				
YSDC 175	17.5				
YSDC 176	17.6	18.0		77	
YSDC 177	17.7				
YSDC 178	17.8				
YSDC 179	17.9				
YSDC 180	18.0				
YSDC 181	18.1		146	104	
YSDC 182	18.2				
YSDC 183	18.3				
YSDC 184	18.4				
YSDC 185	18.5				
YSDC 186	18.6	19.0		76	
YSDC 187	18.7				
YSDC 188	18.8				
YSDC 189	18.9				
YSDC 190	19.0				
YSDC 191	19.1				
YSDC 192	19.2				
YSDC 193	19.3				
YSDC 194	19.4				
YSDC 195	19.5				
YSDC 196	19.6	20.0		74	
YSDC 197	19.7				
YSDC 198	19.8				
YSDC 199	19.9				
YSDC 200	20.0				

Solid Carbide Coolant Drill, Inch



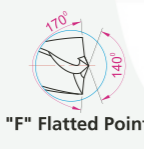
YSDC



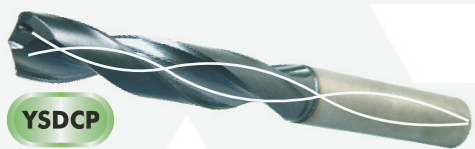
Standard Point



YSDCF



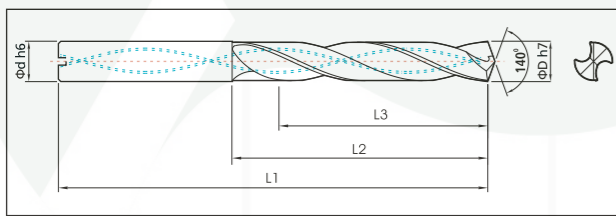
"F" Flatted Point



YSDCP



"P" Premium Point



Model : YSDC

- ▶ Solid Carbide Coolant hole drill, HA shank
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.

Carbide substrate:

- ▶ Micro Grain Carbide, TiN & TiAlN

Application

- ▶ High productivity. Coolant fed design efficiently cools the workpiece and provides good chip removal.
- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.

Inch Size

Code No.	D	d	L1	L2	L3
YSDC .1875	3/16	3/16	3.22		1.54
YSDC .2188	7/32			1.73	
YSDC .2500	1/4	1/4	3.23		1.34
YSDC .2656	17/64				
YSDC .2812	9/32				
YSDC .2969	19/64	5/16	3.58	2.08	1.61
YSDC .3125	5/16				
YSDC .3281	21/64				
YSDC .3438	11/32				
YSDC .3594	23/64	3/8	4.05	2.4	1.81
YSDC .3750	3/8				

Inch Size

Code No.	D	d	L1	L2	L3
YSDC .3906	25/64				
YSDC .4062	13/32				
YSDC .4219	27/64	7/16	4.37	2.63	2
YSDC .4375	7/16				
YSDC .4531	29/64				
YSDC .4688	15/32				
YSDC .4844	31/64	1/2	4.64	2.79	2.05
YSDC .5000	1/2				
YSDC .5625	9/16	9/16	4.88	3.03	2.17
YSDC .6250	5/8	5/8	5.23	3.26	2.32
YSDC .6875	11/16	11/16	5.62	3.66	2.6
YSDC .7500	3/4	3/4	6.02	3.97	2.86

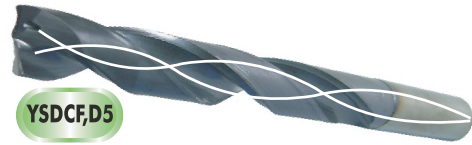
Solid Carbide Coolant Drill, Reinforced Shank



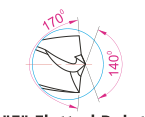
YSDC,D5



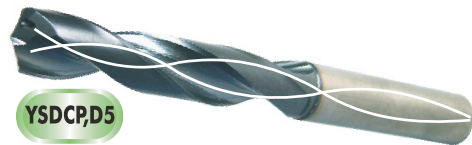
Standard Point



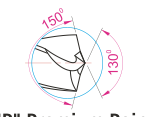
YSDCF,D5



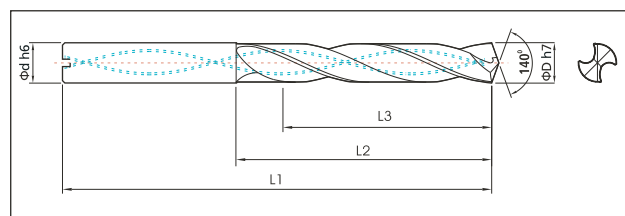
"F" Flatted Point



YSDCP,D5



"P" Premium Point



Model : YSDC, D5

- ▶ Solid Carbide Coolant hole drill, Whistle notch DIN6535 HE shank, effective cutting depth 5xDia.
- ▶ Cylindrical HA shank is available on request.
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.

Carbide substrate:

- ▶ Micro Grain Carbide , TiN & TiAlN

Application

- ▶ High productivity. Coolant fed design efficiently cools the workpiece and provides good chip removal.
- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.

Code No.	D	d	L1	L2	L3
YSDC 050D5	5.0				
YSDC 051D5	5.1				
YSDC 052D5	5.2				
YSDC 053D5	5.3				
YSDC 054D5	5.4				
YSDC 055D5	5.5	6.0	82	44	35
YSDC 056D5	5.6				
YSDC 057D5	5.7				
YSDC 058D5	5.8				
YSDC 059D5	5.9				
YSDC 060D5	6.0				
YSDC 061D5	6.1				
YSDC 062D5	6.2				
YSDC 063D5	6.3	8.0	91	53	43
YSDC 064D5	6.4				
YSDC 065D5	6.5				

Code No.	D	d	L1	L2	L3
YSDC 066D5	6.6				
YSDC 067D5	6.7				
YSDC 068D5	6.8				43
YSDC 069D5	6.9				
YSDC 070D5	7.0				
YSDC 071D5	7.1				
YSDC 072D5	7.2				
YSDC 073D5	7.3	8.0	91	53	
YSDC 074D5	7.4				
YSDC 075D5	7.5				
YSDC 076D5	7.6				41
YSDC 077D5	7.7				
YSDC 078D5	7.8				
YSDC 079D5	7.9				
YSDC 080D5	8.0				
YSDC 081D5	8.1	10.0	103	61	48

Code No.	D	d	L1	L2	L3
YSDC 082D5	8.2				
YSDC 083D5	8.3				
YSDC 084D5	8.4				
YSDC 085D5	8.5				
YSDC 086D5	8.6				48
YSDC 087D5	8.7				
YSDC 088D5	8.8				
YSDC 089D5	8.9				
YSDC 090D5	9.0	10.0	103	61	
YSDC 091D5	9.1				
YSDC 092D5	9.2				
YSDC 093D5	9.3				
YSDC 094D5	9.4				46
YSDC 095D5	9.5				
YSDC 096D5	9.6				
YSDC 097D5	9.7				

Solid Carbide Series

Solid Carbide Coolant Drill, Reinforced Shank

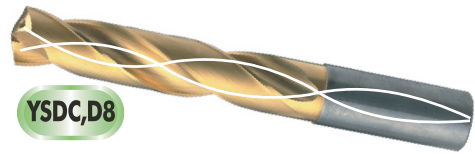
Code No.	D	d	L1	L2	L3
YSDC 098D5	9.8				
YSDC 099D5	9.9	10.0	103	61	46
YSDC 100D5	10.0				
YSDC 101D5	10.1				
YSDC 102D5	10.2				
YSDC 103D5	10.3				
YSDC 104D5	10.4				
YSDC 105D5	10.5				55
YSDC 106D5	10.6				
YSDC 107D5	10.7				
YSDC 108D5	10.8				
YSDC 109D5	10.9				
YSDC 110D5	11.0	12.0	118	71	
YSDC 111D5	11.1				
YSDC 112D5	11.2				
YSDC 113D5	11.3				
YSDC 114D5	11.4				
YSDC 115D5	11.5				53
YSDC 116D5	11.6				
YSDC 117D5	11.7				
YSDC 118D5	11.8				
YSDC 119D5	11.9				
YSDC 120D5	12.0				
YSDC 121D5	12.1				
YSDC 122D5	12.2				
YSDC 123D5	12.3				
YSDC 124D5	12.4				
YSDC 125D5	12.5				
YSDC 126D5	12.6	14.0	124	77	58
YSDC 127D5	12.7				
YSDC 128D5	12.8				
YSDC 129D5	12.9				
YSDC 130D5	13.0				
YSDC 131D5	13.1				56

Code No.	D	d	L1	L2	L3
YSDC 132D5	13.2				
YSDC 133D5	13.3				
YSDC 134D5	13.4				
YSDC 135D5	13.5				
YSDC 136D5	13.6	14.0	124	77	56
YSDC 137D5	13.7				
YSDC 138D5	13.8				
YSDC 139D5	13.9				
YSDC 140D5	14.0				
YSDC 141D5	14.1				
YSDC 142D5	14.2				
YSDC 143D5	14.3				
YSDC 144D5	14.4				
YSDC 145D5	14.5				
YSDC 146D5	14.6				55
YSDC 147D5	14.7				
YSDC 148D5	14.8				
YSDC 149D5	14.9				
YSDC 150D5	15.0	16.0	133	83	
YSDC 151D5	15.1				
YSDC 152D5	15.2				
YSDC 153D5	15.3				
YSDC 154D5	15.4				
YSDC 155D5	15.5				
YSDC 156D5	15.6				53
YSDC 157D5	15.7				
YSDC 158D5	15.8				
YSDC 159D5	15.9				
YSDC 160D5	16.0				
YSDC 161D5	16.1				
YSDC 162D5	16.2				
YSDC 163D5	16.3	18.0	143	93	68
YSDC 164D5	16.4				
YSDC 165D5	16.5				

Code No.	D	d	L1	L2	L3
YSDC 166D5	16.6				
YSDC 167D5	16.7				68
YSDC 168D5	16.8				
YSDC 169D5	16.9				
YSDC 170D5	17.0				
YSDC 171D5	17.1				
YSDC 172D5	17.2				
YSDC 173D5	17.3	18.0	143	93	
YSDC 174D5	17.4				
YSDC 175D5	17.5				66
YSDC 176D5	17.6				
YSDC 177D5	17.7				
YSDC 178D5	17.8				
YSDC 179D5	17.9				
YSDC 180D5	18.0				
YSDC 181D5	18.1				
YSDC 182D5	18.2				
YSDC 183D5	18.3				
YSDC 184D5	18.4				
YSDC 185D5	18.5				65
YSDC 186D5	18.6				
YSDC 187D5	18.7				
YSDC 188D5	18.8				
YSDC 189D5	18.9				
YSDC 190D5	19.0				
YSDC 191D5	19.1	20.0	153	101	
YSDC 192D5	19.2				
YSDC 193D5	19.3				
YSDC 194D5	19.4				
YSDC 195D5	19.5				
YSDC 196D5	19.6				63
YSDC 197D5	19.7				
YSDC 198D5	19.8				
YSDC 199D5	19.9				
YSDC 200D5	20.0				

❖ Available small dia. below 5.0mm & coolant step drill on request.
❖ YSDC, D5 with plain cylindrical HA shank available on request.

Solid Carbide Coolant Drill, Long series (8xD)



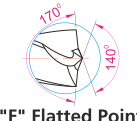
YSDC,D8



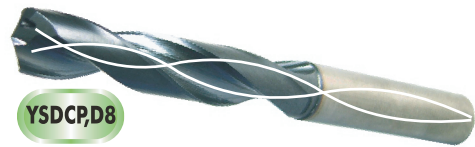
Standard Point



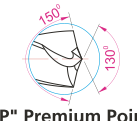
YSDCF,D8



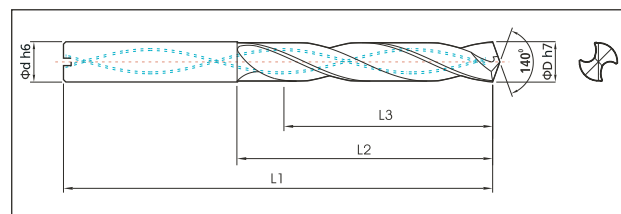
"F" Flatted Point



YSDCP,D8



"P" Premium Point



Model : YSDC, D8

- ▶ Solid Carbide Coolant hole drill, Whistle notch DIN6535 HE shank, effective cutting depth 8xDia.
- ▶ Cylindrical HA shank is available on request.
- ▶ 140° self-centering point for accurate hole positioning. regular helix angle : 28° ~ 30°.
- ▶ Manufactured with heavy duty construction and excellent chip evacuation.

Carbide substrate:

- ▶ Micro Grain Carbide , TiN & TiAlN

Application

- ▶ High productivity. Coolant fed design efficiently cools the workpiece and provides good chip removal.
- ▶ To eliminate the need for center drilling and partially reaming. Highest hole quality and tolerance.
- ▶ Specially designed for machining center or CNC application.

Code No.	D	d	L1	L2	L3
YSDC 050D8	5.0				
YSDC 051D8	5.1				
YSDC 052D8	5.2				
YSDC 053D8	5.3				
YSDC 054D8	5.4				
YSDC 055D8	5.5	6.0	95	57	48
YSDC 056D8	5.6				
YSDC 057D8	5.7				
YSDC 058D8	5.8				
YSDC 059D8	5.9				
YSDC 060D8	6.0				
YSDC 061D8	6.1				
YSDC 062D8	6.2				
YSDC 063D8	6.3	8.0	114	76	66
YSDC 064D8	6.4				
YSDC 065D8	6.5				

Code No.	D	d	L1	L2	L3
YSDC 066D8	6.6				
YSDC 067D8	6.7				
YSDC 068D8	6.8				66
YSDC 069D8	6.9				
YSDC 070D8	7.0				
YSDC 071D8	7.1				
YSDC 072D8	7.2				
YSDC 073D8	7.3	8.0	114	76	
YSDC 074D8	7.4				
YSDC 075D8	7.5				
YSDC 076D8	7.6				64
YSDC 077D8	7.7				
YSDC 078D8	7.8				
YSDC 079D8	7.9				
YSDC 080D8	8.0				
YSDC 081D8	8.1	10.0	137	95	82

Code No.	D	d	L1	L2	L3
YSDC 082D8	8.2				
YSDC 083D8	8.3				
YSDC 084D8	8.4				
YSDC 085D8	8.5				
YSDC 086D8	8.6				82
YSDC 087D8	8.7				
YSDC 088D8	8.8				
YSDC 089D8	8.9	10.0	137	95	
YSDC 090D8	9.0				
YSDC 091D8	9.1				
YSDC 092D8	9.2				
YSDC 093D8	9.3				
YSDC 094D8	9.4				80
YSDC 095D8	9.5				
YSDC 096D8	9.6				
YSDC 097D8	9.7				

Solid Carbide Series

Solid Carbide Coolant Drill, Long series (8xD)

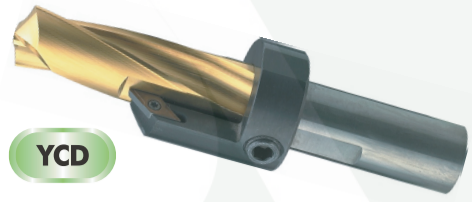
Code No.	D	d	L1	L2	L3
YSDC 098D8	9.8				
YSDC 099D8	9.9	10.0	137	95	80
YSDC 100D8	10.0				
YSDC 101D8	10.1				
YSDC 102D8	10.2				
YSDC 103D8	10.3				
YSDC 104D8	10.4				
YSDC 105D8	10.5				98
YSDC 106D8	10.6				
YSDC 107D8	10.7				
YSDC 108D8	10.8				
YSDC 109D8	10.9				
YSDC 110D8	11.0	12.0	161	114	
YSDC 111D8	11.1				
YSDC 112D8	11.2				
YSDC 113D8	11.3				
YSDC 114D8	11.4				
YSDC 115D8	11.5				96
YSDC 116D8	11.6				
YSDC 117D8	11.7				
YSDC 118D8	11.8				
YSDC 119D8	11.9				
YSDC 120D8	12.0				
YSDC 121D8	12.1				
YSDC 122D8	12.2				
YSDC 123D8	12.3				
YSDC 124D8	12.4				
YSDC 125D8	12.5				
YSDC 126D8	12.6	14.0	180	133	114
YSDC 127D8	12.7				
YSDC 128D8	12.8				
YSDC 129D8	12.9				
YSDC 130D8	13.0				
YSDC 131D8	13.1				112

Code No.	D	d	L1	L2	L3
YSDC 132D8	13.2				
YSDC 133D8	13.3				
YSDC 134D8	13.4				
YSDC 135D8	13.5				
YSDC 136D8	13.6	14.0	180	133	112
YSDC 137D8	13.7				
YSDC 138D8	13.8				
YSDC 139D8	13.9				
YSDC 140D8	14.0				
YSDC 141D8	14.1				
YSDC 142D8	14.2				
YSDC 143D8	14.3				
YSDC 144D8	14.4				
YSDC 145D8	14.5				
YSDC 146D8	14.6				124
YSDC 147D8	14.7				
YSDC 148D8	14.8				
YSDC 149D8	14.9				
YSDC 150D8	15.0	16.0	202	152	
YSDC 151D8	15.1				
YSDC 152D8	15.2				
YSDC 153D8	15.3				
YSDC 154D8	15.4				
YSDC 155D8	15.5				
YSDC 156D8	15.6				122
YSDC 157D8	15.7				
YSDC 158D8	15.8				
YSDC 159D8	15.9				
YSDC 160D8	16.0				
YSDC 161D8	16.1				
YSDC 162D8	16.2				
YSDC 163D8	16.3	18.0	221	171	146
YSDC 164D8	16.4				
YSDC 165D8	16.5				

Code No.	D	d	L1	L2	L3
YSDC 166D8	16.6				
YSDC 167D8	16.7				146
YSDC 168D8	16.8				
YSDC 169D8	16.9				
YSDC 170D8	17.0				
YSDC 171D8	17.1				
YSDC 172D8	17.2				
YSDC 173D8	17.3	18.0	221	171	
YSDC 174D8	17.4				
YSDC 175D8	17.5				
YSDC 176D8	17.6				144
YSDC 177D8	17.7				
YSDC 178D8	17.8				
YSDC 179D8	17.9				
YSDC 180D8	18.0				
YSDC 181D8	18.1				
YSDC 182D8	18.2				
YSDC 183D8	18.3				
YSDC 184D8	18.4				
YSDC 185D8	18.5				
YSDC 186D8	18.6				154
YSDC 187D8	18.7				
YSDC 188D8	18.8				
YSDC 189D8	18.9				
YSDC 190D8	19.0				
YSDC 191D8	19.1	20.0	242	190	
YSDC 192D8	19.2				
YSDC 193D8	19.3				
YSDC 194D8	19.4				
YSDC 195D8	19.5				
YSDC 196D8	19.6				152
YSDC 197D8	19.7				
YSDC 198D8	19.8				
YSDC 199D8	19.9				
YSDC 200D8	20.0				

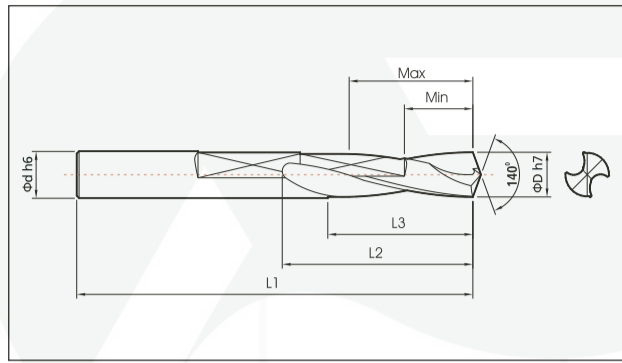
❖ Available small dia. below 5.0mm & coolant step drill on request.
❖ Plain cylindrical HA shank available on request.

Solid Carbide Chamfer Drill, Metric



YCD

(The above picture illustrate YCD + YCH complete kit.)



Model : YCD

- ▶ Solid Carbide Chamfer drill, Plain cylindrical shank with flat grinding to fit YCH holder.
- ▶ 140° self-centering point for accurate hole positioning. Slow helix angle : 15° spiral(to adjust cutting depth).
- ▶ YCD is used with combination YCH chamfer holder and carbide insert XCGX1102.
- ▶ Holder can be moved back and forth by one locking screw to adjust cutting depth.

Carbide substrate:

- ▶ Ultra-fine Micro Grain, TiN(standard stock), TiAlN

Application

- ▶ Economically drilling and chamfering(or countersinking) in one operation
- ▶ To eliminate the need for center drilling and partially reaming. Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD 051	5.1							
YCD 052	5.2							
YCD 053	5.3							
YCD 054	5.4							
YCD 055	5.5							
YCD 056	5.6	6.0	66	30	24	9	20	YCH 060
YCD 057	5.7							
YCD 058	5.8							
YCD 059	5.9							
YCD 060	6.0							
YCD 061	6.1							
YCD 062	6.2							
YCD 063	6.3							
YCD 064	6.4							
YCD 065	6.5	7.0	74	37	30	11	25	YCH 070
YCD 066	6.6							
YCD 067	6.7							
YCD 068	6.8							
YCD 069	6.9							
YCD 070	7.0							

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD 071	7.1							
YCD 072	7.2							
YCD 073	7.3							
YCD 074	7.4							
YCD 075	7.5							
YCD 076	7.6	8.0	79	41	33	12	28	YCH 080
YCD 077	7.7							
YCD 078	7.8							
YCD 079	7.9							
YCD 080	8.0							
YCD 081	8.1							
YCD 082	8.2							
YCD 083	8.3							
YCD 084	8.4							
YCD 085	8.5	9.0	84	45	36	14	31	YCH 090
YCD 086	8.6							
YCD 087	8.7							
YCD 088	8.8							
YCD 089	8.9							
YCD 090	9.0							

Continued ▶▶

61

Yes

62

Yes

Solid Carbide Chamfer Drill, Metric

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD 091	9.1							
YCD 092	9.2							
YCD 093	9.3							
YCD 094	9.4							
YCD 095	9.5	10.0	89	49	39	16	34	YCH 100
YCD 096	9.6							
YCD 097	9.7							
YCD 098	9.8							
YCD 099	9.9							
YCD 100	10.0							
YCD 101	10.1							
YCD 102	10.2							
YCD 103	10.3							
YCD 104	10.4							
YCD 105	10.5	11.0	95	47	36	17	31	YCH 110
YCD 106	10.6							
YCD 107	10.7							
YCD 108	10.8							
YCD 109	10.9							
YCD 110	11.0							
YCD 111	11.1							
YCD 112	11.2							
YCD 113	11.3							
YCD 114	11.4							
YCD 115	11.5	12.0	102	53	41	19	35	YCH 120
YCD 116	11.6							
YCD 117	11.7							
YCD 118	11.8							
YCD 119	11.9							
YCD 120	12.0							
YCD 121	12.1							
YCD 122	12.2							
YCD 123	12.3							
YCD 124	12.4							
YCD 125	12.5	13.0	102	54	41	19	35	YCH 130
YCD 126	12.6							
YCD 127	12.7							
YCD 128	12.8							
YCD 129	12.9							
YCD 130	13.0							
YCD 131	13.1							
YCD 132	13.2							
YCD 133	13.3							
YCD 134	13.4							
YCD 135	13.5	14.0	107	58	44	20	38	YCH 140
YCD 136	13.6							
YCD 137	13.7							
YCD 138	13.8							
YCD 139	13.9							
YCD 140	14.0							
YCD 141	14.1							
YCD 142	14.2							
YCD 143	14.3	15.0	111	62	47	24	41	YCH 150
YCD 144	14.4							
YCD 145	14.5							

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD 146	14.6							
YCD 147	14.7							
YCD 148	14.8	15.0	111	62	47	24	41	YCH 150
YCD 149	14.9							
YCD 150	15.0							
YCD 151	15.1							
YCD 152	15.2							
YCD 153	15.3							
YCD 154	15.4							
YCD 155	15.5	16.0	115	65	49	25	43	YCH 160
YCD 156	15.6							
YCD 157	15.7							
YCD 158	15.8							
YCD 159	15.9							
YCD 160	16.0							
YCD 161	16.1							
YCD 162	16.2							
YCD 163	16.3							
YCD 164	16.4							
YCD 165	16.5	17.0	119	69	52	26	46	YCH 170
YCD 166	16.6							
YCD 167	16.7							
YCD 168	16.8							
YCD 169	16.9							
YCD 170	17.0							
YCD 171	17.1							
YCD 172	17.2							
YCD 173	17.3							
YCD 174	17.4							
YCD 175	17.5	18.0	123	73	55	27	48	YCH 180
YCD 176	17.6							
YCD 177	17.7							
YCD 178	17.8							
YCD 179	17.9							
YCD 180	18.0							
YCD 181	18.1							
YCD 182	18.2							
YCD 183	18.3							
YCD 184	18.4							
YCD 185	18.5	19.0	127	76	57	28	50	YCH 190
YCD 186	18.6							
YCD 187	18.7							
YCD 188	18.8							
YCD 189	18.9							
YCD 190	19.0							
YCD 191	19.1							
YCD 192	19.2							
YCD 193	19.3							
YCD 194	19.4							
YCD 195	19.5	20.0	131	80	60	30	53	YCH 200
YCD 196	19.6							
YCD 197	19.7							
YCD 198	19.8							
YCD 199	19.9							
YCD 200	20.0							

Solid Carbide Series

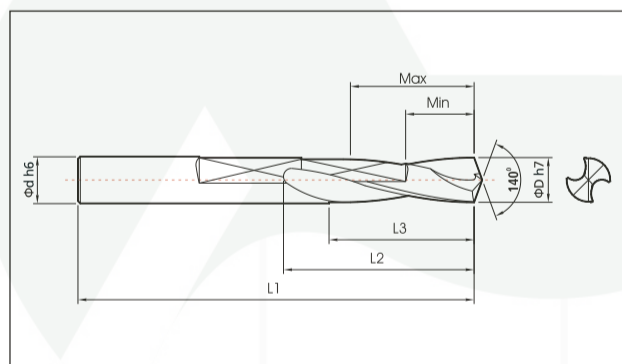
Solid Carbide Series

Solid Carbide Chamfer Drill, Inch



YCD

(The above picture illustrate YCD + YCH complete kit.)



Model : YCD

- ▶ Solid Carbide Chamfer drill, Plain cylindrical shank with flat grinding to fit YCH holder.
- ▶ 140° self-centering point for accurate hole positioning. Slow helix angle : 15° spiral(to adjust cutting depth).
- ▶ YCD is used with combination YCH chamfer holder and carbide insert XCGX1102.
- ▶ Holder can be moved back and forth by one locking screw to adjust cutting depth.

Carbide substrate:

- ▶ Ultra-fine Micro Grain, TiN(standard stock), TiAlN

Application

- ▶ Economically drilling and chamfering(or countersinking) in one operation
- ▶ To eliminate the need for center drilling and partially reaming. Specially designed for machining center or CNC application.
- ▶ Broad range application from general to tough material.

Inch Size

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD .2010	#7							
YCD .2130	#3		2.59	1.18	0.94	0.35	0.78	
YCD .2570	F	1/4						YCH.2500
YCD .2720	I		2.91	1.45	1.18	0.43	0.98	
YCD .3125	5/16					0.47		
YCD .3320	Q	5/16	3.11	1.61	1.29		1.1	YCH.3125
YCD .3680	U					0.62		
YCD .3906	25/64	3/8	3.5	1.92	1.53		1.33	YCH.3750
YCD .4219	25/64	7/16	3.74	1.85	1.41	0.66	1.22	YCH.4375

Inch Size

Code No.	D	d	L1	L2	L3	Hole depth		Applicable Holder
						Min	Max	
YCD .4531	29/64	7/16	3.74	1.85	1.41	0.66	1.22	YCH.4375
YCD .4844	31/64					1.37		
YCD .5156	33/64	1/2	4.01	2.12	1.61	0.74		YCH.5000
YCD .5312	17/32					1.34		
YCD .5781	37/64	9/16	4.21	2.28	1.73	0.78	1.49	YCH.5625
YCD .6562	21/32							
YCD .6875	11/16	11/16	4.68	2.71	2.04	1.02	1.81	YCH.6875
YCD .7656	49/64	3/4	5.15	3.14	2.36			

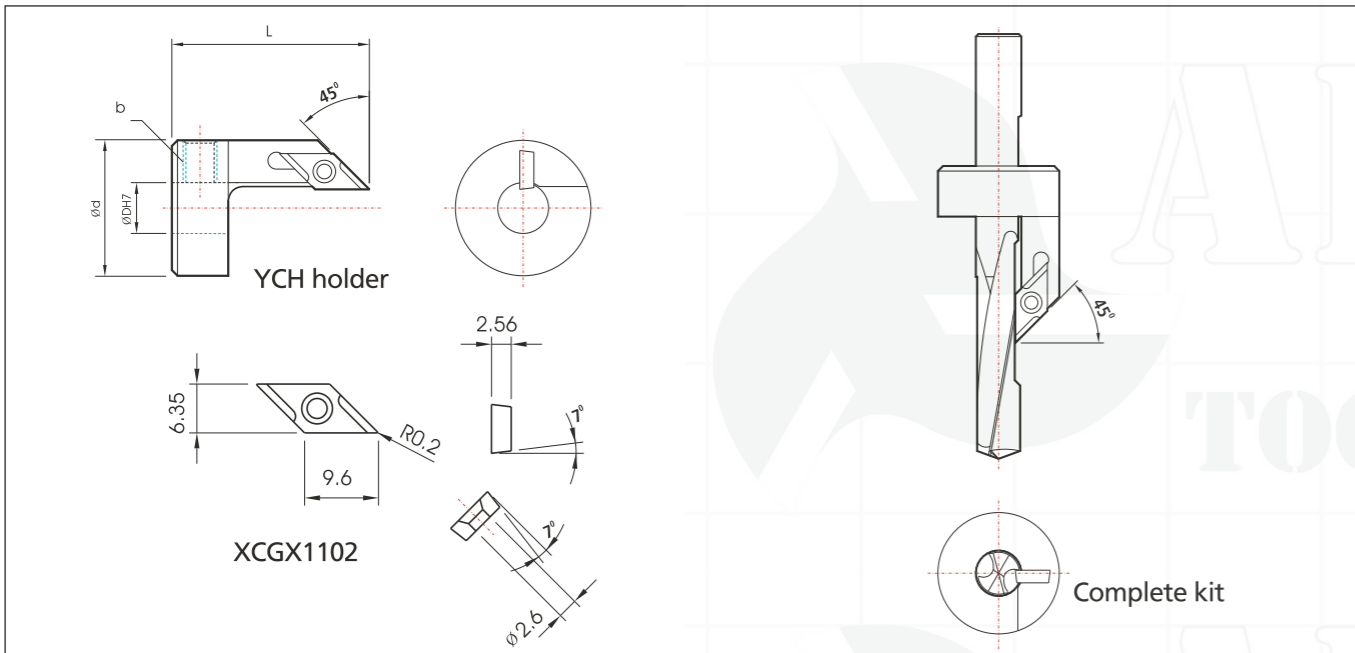
Chamfer Holder, Metric

YCH



Model : YCH

- ▶ Specially designed to work with Solid Chamfer Drill (YCD) & Insert XCGX1102.
- ▶ Drilling and chamfering in one operation economically.
- ▶ Carbide Insert XCGX1102 has two cutting edges for economic use.
- ▶ Holder moveable back and forth to adjust cutting depth by SS bolt.



Code No.	D	d	L	Socket Screw Bolt size (b)	Applicable size range(YCD model)
YCH 060	6.0	21	29	M6 x 1.0P	YCD 051~060
YCH 070	7.0	22	32		YCD 061~070
YCH 080	8.0	23	34		YCD 071~080
YCH 090	9.0	24	35		YCD 081~090
YCH 100	10.0	25	36	M8 x 1.25P	YCD 091~100
YCH 110	11.0	26	34		YCD 101~110
YCH 120	12.0	27	36		YCD 111~120
YCH 130	13.0	28	36		YCD 121~130
YCH 140	14.0	29	38		YCD 131~140
YCH 150	15.0	30	39		YCD 141~150
YCH 160	16.0	31	40	M10 x 1.5P	YCD 151~160
YCH 170	17.0	32	42		YCD 161~170
YCH 180	18.0	33	43		YCD 171~180
YCH 190	19.0	34	44		YCD 181~190
YCH 200	20.0	35	45		YCD 191~200

❖ See page 61 of applicable YCD drill together with this model.

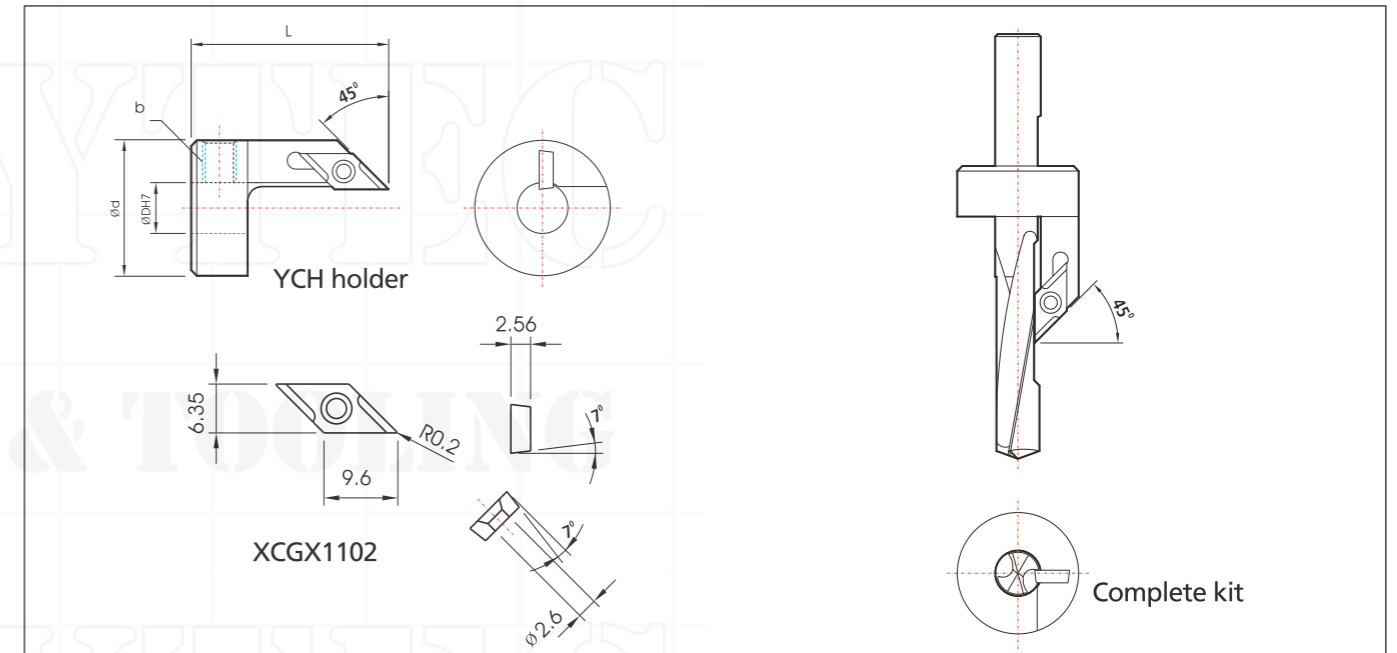
Chamfer Holder, Inch

YCH



Model : YCH

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Code No.	D	d	L	Socket Screw Bolt size (b)	Applicable size range(YCD model)
YCH .2500	.2500	0.83	1.14	M6 x 1.0P	YCD .2010~.2720
YCH .3125	.3125	0.91	1.34		YCD .3125~.3320
YCH .3750	.3750	0.98	1.42	M8 x 1.25P	YCD .3680~.3906
YCH .4375	.4375	1.02	1.34		YCD .4219~.4531
YCH .5000	.5000	1.1	1.42		YCD .4844~.5156
YCH .5625	.5625	1.14	1.5	M10 x 1.5P	YCD .5312~.5781
YCH .6875	.6875	1.26	1.65		YCD .6562~.6875
YCH .7500	.7500	1.34	1.73		YCD .7656~.8125

❖ See page 63 of applicable YCD drill together with this model.