

YU-DD18

YU-DD18 AMERICA

BEST VALUE IN THE WORLD OF CUTTING TOOLS



DREAM DRILLS



DREAM DRILLS

SOLID CARBIDE DREAM DRILLS

YG-1 CO., LTD.

YG-1 CO., LTD.

YG-1 USA

730 Corporate Woods Parkway, Vernon Hills, IL 60061 USA

- Phone: 800-765-8665
- Technical Assistance: 888-868-5988
- [Http://www.yg1usa.com](http://www.yg1usa.com)

YG-1 HEAD OFFICE

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- Phone: +82-32-526-0909
- [Http://www.yg1.kr](http://www.yg1.kr)
- E-mail: yg1@yg1.kr

Note The new address above has currently been updated since Korean new postal standard was valid from 2014. Be noticed that the location of the Headquarters has NOT changed.



Tool specifications are subject to change without prior notice.

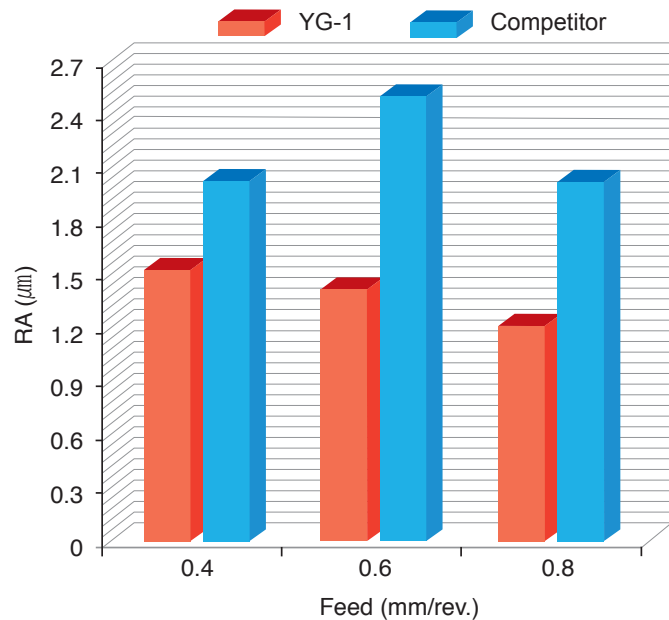
YG1YUDD180720004

- NEW SIZES** DREAM DRILLS · **GENERAL** with/without Coolant Holes
- NEW SIZES** DREAM DRILLS · **HIGH FEED** with Coolant Holes
- NEW SERIES** DREAM DRILLS · **FLAT BOTTOM** without Coolant Holes
- NEW SIZES** DREAM DRILLS · **INOX** with Coolant Holes
- NEW SIZES** DREAM DRILLS · **ALU** with Coolant Holes
- NEW SIZES** DREAM DRILLS · **MQL** with Coolant Holes(10xD ~ 40xD)
- NEW SIZES** DREAM DRILLS · **HIGH HARDENED STEELS** HRc50-70

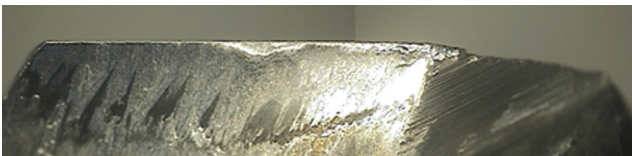
CASE STUDY

► SOLID CARBIDE DREAM DRILLS - ALU with Coolant Holes

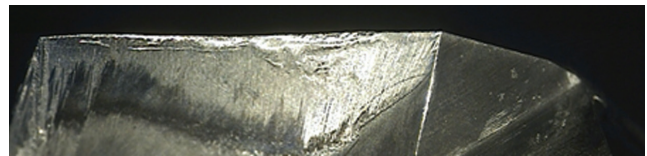
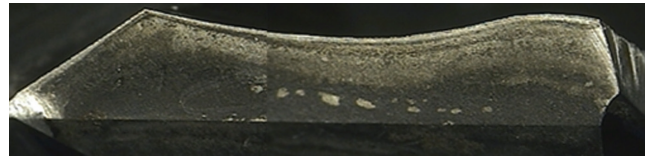
CUTTING CONDITION	
Tool	D5433100 (Dream Drills-Alu)
Size	Ø10.0×Ø10×61×103
Work Material	<ul style="list-style-type: none"> • AISI : 6061 • JIS : A6061 • DIN : AlMgSiCu
RPM	6,367 rev./min.
Feed	.0157 ~ .0315 inch/rev.
SFM	656 ft/min.
Drilling Depth	1.77"
Coolant	Wet cut



► YG-1 (Total Drilling 820 Holes)



► Competitor (Total Drilling 820 Holes)



DLC-COATED SOLID CARBIDE DREAM DRILLS

ALU with Coolant Holes (5XD)

DGE466 SERIES
DGE718 SERIES

- ▶ Optimized thinning for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
- ▶ Wider and deeper flute gullets for maximum chip removal
- ▶ Special geometry and smooth coating reduces built up edge and improves finishes
- ▶ Tolerance : Dia. Tolerance $\varnothing D1$: See page 104
Shank Tolerance $\varnothing D2$: -.0001 -.0005


5 × D


Unit : inch

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
DLC	D1		D2	L1	L2
DGE466013	13/64	.2031	15/64	1-3/4	3-15/16
DGE718013	13/64	.2031	1/4	1-3/4	3-15/16
DGE466014	7/32	.2188	15/64	1-57/64	3-15/16
DGE718014	7/32	.2188	1/4	1-57/64	3-15/16
DGE466015	15/64	.2344	15/64	1-57/64	3-15/16
DGE718015	15/64	.2344	1/4	1-57/64	3-15/16
DGE718016	1/4	.2500	1/4	2-3/64	4-19/64
DGE466016	1/4	.2500	17/64	2-3/64	4-19/64
DGE466206	F	.2570	17/64	2-13/64	4-19/64
DGE718206	F	.2570	5/16	2-13/64	4-19/64
DGE466017	17/64	.2656	17/64	2-13/64	4-19/64
DGE718017	17/64	.2656	5/16	2-13/64	4-19/64
DGE466209	I	.2720	.272	2-13/64	4-19/64
DGE718209	I	.2720	5/16	2-13/64	4-19/64
DGE466018	9/32	.2812	5/16	2-23/64	4-41/64
DGE466019	19/64	.2969	5/16	2-33/64	4-41/64
DGE466020	5/16	.3125	5/16	2-33/64	4-41/64
DGE466021	21/64	.3281	11/32	2-43/64	5
DGE718021	21/64	.3281	3/8	2-43/64	5
DGE466217	Q	.3320	11/32	2-43/64	5
DGE718217	Q	.3320	3/8	2-43/64	5
DGE466022	11/32	.3438	11/32	2-27/32	5

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
DLC	D1		D2	L1	L2
DGE718022	11/32	.3438	3/8	2-27/32	5
DGE718023	23/64	.3594	3/8	3	5-23/64
DGE466023	23/64	.3594	25/64	3	5-23/64
DGE718221	U	.3680	3/8	3	5-23/64
DGE466221	U	.3680	25/64	3	5-23/64
DGE718024	3/8	.3750	3/8	3-5/32	5-23/64
DGE466024	3/8	.3750	25/64	3-5/32	5-23/64
DGE466025	25/64	.3906	25/64	3-5/32	5-23/64
DGE718025	25/64	.3906	7/16	3-5/32	5-23/64
DGE466026	13/32	.4062	27/64	3-5/16	5-7/8
DGE718026	13/32	.4062	7/16	3-5/16	5-7/8
DGE466027	27/64	.4219	27/64	3-15/32	5-7/8
DGE718027	27/64	.4219	7/16	3-15/32	5-7/8
DGE718028	7/16	.4375	7/16	3-5/8	6-7/32
DGE466028	7/16	.4375	15/32	3-5/8	6-7/32
DGE466029	29/64	.4531	15/32	3-25/32	6-7/32
DGE718029	29/64	.4531	1/2	3-25/32	6-7/32
DGE466030	15/32	.4688	15/32	3-25/32	6-7/32
DGE718030	15/32	.4688	1/2	3-25/32	6-7/32
DGE466031	31/64	.4844	1/2	3-15/16	6-37/64
DGE466032	1/2	.5000	1/2	4-3/32	6-37/64

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

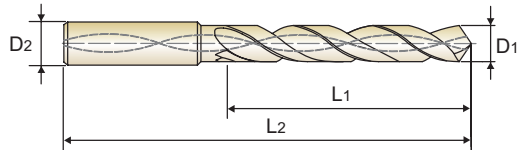
P			H		M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
							◎				

DLC-COATED SOLID CARBIDE DREAM DRILLS
ALU with Coolant Holes (5XD)

LONG

DGE433 SERIES

- ▶ Optimized thinning for Aluminum & Aluminum Alloys to prevent any clogging from chip welding
- ▶ Wider and deeper flute gullets for maximum chip removal
- ▶ Special geometry and smooth coating reduces built up edge and improves finishes



5 × D

DIN 6537
MG
h6
m7
118°
20 bar
P.81

Unit : mm

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
DLC	D1					
DGE433030	3.0		.1181	6	28	66
DGE433031	3.1		.1220	6	28	66
DGE433008F	3.175	1/8	.1250	6	28	66
DGE433032	3.2		.1260	6	28	66
DGE433033	3.3		.1299	6	28	66
DGE433034	3.4		.1339	6	28	66
DGE433035	3.5		.1378	6	28	66
DGE433009F	3.572	9/64	.1406	6	28	66
DGE433036	3.6		.1417	6	28	66
DGE433037	3.7		.1457	6	28	66
DGE433038	3.8		.1496	6	36	74
DGE433039	3.9		.1535	6	36	74
DGE433010F	3.969	5/32	.1563	6	36	74
DGE433040	4.0		.1575	6	36	74
DGE433041	4.1		.1614	6	36	74
DGE433042	4.2		.1654	6	36	74
DGE433043	4.3		.1693	6	36	74
DGE433011F	4.366	11/64	.1719	6	36	74
DGE433044	4.4		.1732	6	36	74
DGE433045	4.5		.1772	6	36	74
DGE433046	4.6		.1811	6	36	74
DGE433047	4.7		.1850	6	36	74
DGE433012F	4.763	3/16	.1875	6	36	74
DGE433048	4.8		.1890	6	44	82

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
DLC	D1					
DGE433049	4.9		.1929	6	44	82
DGE433050	5.0		.1969	6	44	82
DGE433051	5.1		.2008	6	44	82
DGE433013F	5.159	13/64	.2031	6	44	82
DGE433052	5.2		.2047	6	44	82
DGE433053	5.3		.2087	6	44	82
DGE433054	5.4		.2126	6	44	82
DGE433055	5.5		.2165	6	44	82
DGE433014F	5.556	7/32	.2188	6	44	82
DGE433056	5.6		.2205	6	44	82
DGE433057	5.7		.2244	6	44	82
DGE433058	5.8		.2283	6	44	82
DGE433059	5.9		.2323	6	44	82
DGE433015F	5.953	15/64	.2344	6	44	82
DGE433060	6.0		.2362	6	44	82
DGE433061	6.1		.2402	8	53	91
DGE433062	6.2		.2441	8	53	91
DGE433063	6.3		.2480	8	53	91
DGE433016F	6.350	1/4	.2500	8	53	91
DGE433064	6.4		.2520	8	53	91
DGE433065	6.5		.2559	8	53	91
DGE433006L	6.528	F	.2570	8	53	9
DGE433066	6.6		.2598	8	53	91
DGE433067	6.7		.2638	8	53	91

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

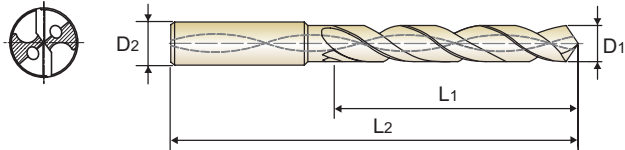
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
						◎					

DLC-COATED SOLID CARBIDE DREAM DRILLS ALU with Coolant Holes (5XD)

LONG

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DIN 6537
MG
h6
m7
118°
20 bar
P.81

5 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433017F	6.747	17/64	.2656	8	53	91
DGE433068	6.8		.2677	8	53	91
DGE433069	6.9		.2717	8	53	91
DGE433009L	6.909	I	.2720	8	53	91
DGE433070	7.0		.2756	8	53	91
DGE433071	7.1		.2795	8	53	91
DGE433018F	7.144	9/32	.2812	8	53	91
DGE433072	7.2		.2835	8	53	91
DGE433073	7.3		.2874	8	53	91
DGE433074	7.4		.2913	8	53	91
DGE433075	7.5		.2953	8	53	91
DGE433019F	7.541	19/64	.2969	8	53	91
DGE433076	7.6		.2992	8	53	91
DGE433077	7.7		.3031	8	53	91
DGE433078	7.8		.3071	8	53	91
DGE433079	7.9		.3110	8	53	91
DGE433020F	7.938	5/16	.3125	8	53	91
DGE433080	8.0		.3150	8	53	91
DGE433081	8.1		.3189	10	61	103
DGE433082	8.2		.3228	10	61	103
DGE433083	8.3		.3268	10	61	103
DGE433021F	8.334	21/64	.3281	10	61	103
DGE433084	8.4		.3307	10	61	103
DGE433017L	8.433	Q	.3320	10	61	103
DGE433085	8.5		.3346	10	61	103
DGE433086	8.6		.3386	10	61	103

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433087	8.7		.3425	10	61	103
DGE433022F	8.731	11/32	.3438	10	61	103
DGE433088	8.8		.3465	10	61	103
DGE433089	8.9		.3504	10	61	103
DGE433090	9.0		.3543	10	61	103
DGE433091	9.1		.3583	10	61	103
DGE433023F	9.128	23/64	.3594	10	61	103
DGE433092	9.2		.3622	10	61	103
DGE433093	9.3		.3661	10	61	103
DGE433021L	9.347	U	.3680	10	61	103
DGE433094	9.4		.3701	10	61	103
DGE433095	9.5		.3740	10	61	103
DGE433024F	9.525	3/8	.3750	10	61	103
DGE433096	9.6		.3780	10	61	103
DGE433097	9.7		.3819	10	61	103
DGE433098	9.8		.3858	10	61	103
DGE433099	9.9		.3898	10	61	103
DGE433025F	9.922	25/64	.3906	10	61	103
DGE433100	10.0		.3937	10	61	103
DGE433101	10.1		.3976	12	71	118
DGE433102	10.2		.4016	12	71	118
DGE433103	10.3		.4055	12	71	118
DGE433026F	10.319	13/32	.4062	12	71	118
DGE433104	10.4		.4094	12	71	118
DGE433105	10.5		.4134	12	71	118
DGE433106	10.6		.4173	12	71	118

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
						◎					

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ALU with Coolant Holes (5XD)

LONG

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5 × D

DIN 6537
MG
h6
m7
118°
20 bar
P.81

Unit : mm

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433107	10.7		.4212	12	71	118
DGE433027F	10.716	27/64	.4219	12	71	118
DGE433108	10.8		.4252	12	71	118
DGE433109	10.9		.4291	12	71	118
DGE433110	11.0		.4330	12	71	118
DGE433111	11.1		.4370	12	71	118
DGE433028F	11.113	7/16	.4375	12	71	118
DGE433112	11.2		.4409	12	71	118
DGE433113	11.3		.4448	12	71	118
DGE433114	11.4		.4488	12	71	118
DGE433115	11.5		.4527	12	71	118
DGE433029F	11.509	29/64	.4531	12	71	118
DGE433116	11.6		.4566	12	71	118
DGE433117	11.7		.4606	12	71	118
DGE433118	11.8		.4645	12	71	118
DGE433119	11.9		.4685	12	71	118
DGE433030F	11.906	15/32	.4688	12	71	118
DGE433120	12.0		.4724	12	71	118
DGE433121	12.1		.4764	14	77	124
DGE433122	12.2		.4803	14	77	124
DGE433123	12.3		.4843	14	77	124
DGE433031F	12.303	31/64	.4844	14	77	124
DGE433124	12.4		.4882	14	77	124
DGE433125	12.5		.4921	14	77	124
DGE433126	12.6		.4961	14	77	124
DGE433032F	12.7	1/2	.5000	14	77	124

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433128	12.8		.5039	14	77	124
DGE433129	12.9		.5079	14	77	124
DGE433130	13.0		.5118	14	77	124
DGE433131	13.1		.5157	14	77	124
DGE433132	13.2		.5197	14	77	124
DGE433133	13.3		.5236	14	77	124
DGE433134	13.4		.5276	14	77	124
DGE433135	13.5		.5314	14	77	124
DGE433136	13.6		.5354	14	77	124
DGE433137	13.7		.5394	14	77	124
DGE433138	13.8		.5433	14	77	124
DGE433139	13.9		.5472	14	77	124
DGE433140	14.0		.5512	14	77	124
DGE433141	14.1		.5551	16	83	133
DGE433142	14.2		.5591	16	83	133
DGE433036F	14.288	9/16	.5625	16	83	133
DGE433143	14.3		.5630	16	83	133
DGE433144	14.4		.5669	16	83	133
DGE433145	14.5		.5708	16	83	133
DGE433146	14.6		.5748	16	83	133
DGE433147	14.7		.5787	16	83	133
DGE433148	14.8		.5827	16	83	133
DGE433149	14.9		.5866	16	83	133
DGE433150	15.0		.5905	16	83	133
DGE433151	15.1		.5945	16	83	133
DGE433152	15.2		.5984	16	83	133

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

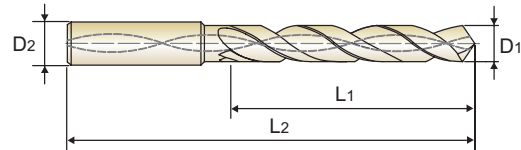
P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
						◎					

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LONG

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MG
h6
m7
118°
20 bar
P.81

5 × D

Unit : mm

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
DLC	D1					
DGE433153	15.3		.6024	16	83	133
DGE433154	15.4		.6063	16	83	133
DGE433155	15.5		.6102	16	83	133
DGE433156	15.6		.6142	16	83	133
DGE433157	15.7		.6181	16	83	133
DGE433158	15.8		.6220	16	83	133
DGE433040F	15.875	5/8	.6250	16	83	133
DGE433159	15.9		.6260	16	83	133
DGE433160	16.0		.6299	16	83	133
DGE433161	16.1		.6339	18	93	143
DGE433162	16.2		.6378	18	93	143
DGE433163	16.3		.6417	18	93	143
DGE433164	16.4		.6457	18	93	143
DGE433165	16.5		.6495	18	93	143
DGE433166	16.6		.6535	18	93	143
DGE433167	16.7		.6575	18	93	143
DGE433168	16.8		.6614	18	93	143
DGE433169	16.9		.6654	18	93	143
DGE433170	17.0		.6692	18	93	143
DGE433171	17.1		.6732	18	93	143
DGE433172	17.2		.6772	18	93	143
DGE433173	17.3		.6811	18	93	143
DGE433174	17.4		.6850	18	93	143
DGE433175	17.5		.6889	18	93	143
DGE433176	17.6		.6929	18	93	143

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
DLC	D1					
DGE433177	17.7		.6968	18	93	143
DGE433178	17.8		.7008	18	93	143
DGE433179	17.9		.7047	18	93	143
DGE433180	18.0		.7087	18	93	143
DGE433181	18.1		.7126	20	101	153
DGE433182	18.2		.7165	20	101	153
DGE433183	18.3		.7205	20	101	153
DGE433184	18.4		.7244	20	101	153
DGE433185	18.5		.7283	20	101	153
DGE433186	18.6		.7323	20	101	153
DGE433187	18.7		.7362	20	101	153
DGE433188	18.8		.7402	20	101	153
DGE433189	18.9		.7441	20	101	153
DGE433190	19.0		.7480	20	101	153
DGE433048F	19.050	3/4	.7500	20	101	153
DGE433191	19.1		.7520	20	101	153
DGE433192	19.2		.7559	20	101	153
DGE433193	19.3		.7598	20	101	153
DGE433194	19.4		.7638	20	101	153
DGE433195	19.5		.7676	20	101	153
DGE433196	19.6		.7717	20	101	153
DGE433197	19.7		.7756	20	101	153
DGE433198	19.8		.7795	20	101	153
DGE433199	19.9		.7835	20	101	153
DGE433200	20.0		.7874	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P				H	M	K	N			S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
							◎				

**DLC-COATED SOLID CARBIDE DREAM DRILLS
ALU with Coolant Holes**

DGE466 | DGE718 | DGE433 SERIES

WORK MATERIAL		N								
		ALUMINUM ALLOY CASTING ALUMINUM DIE CASTING				WROUGHT ALUMINUM ALLOY				
DRILLING SPEED(SFM)		240 ~ 650 ft/min				240 ~ 650 ft/min				
DIAMETER		RPM	FEED	IPR	RPM	FEED	IPR	RPM	FEED	IPR
Metric(mm)	Decimal									
3.0~6.0	.1181 ~ .2362	8000 ~ 15000	0.2 ~ 0.5	.008 .020	8000 ~ 15000	0.15 ~ 0.3	.006 .012	8000 ~ 15000	0.15 ~ 0.3	.006 .012
~10.0	~.3937	6000 ~ 10500	0.3 ~ 1.0	.012 .039	6000 ~ 10500	0.20 ~ 0.4	.008 .016	6000 ~ 10500	0.20 ~ 0.4	.008 .016
~14.0	~.5512	4500 ~ 5800	0.3 ~ 1.0	.012 .039	4500 ~ 5800	0.20 ~ 0.4	.008 .016	4500 ~ 5800	0.20 ~ 0.4	.008 .016
~20.0	~.7874	3200 ~ 4600	0.3 ~ 1.0	.012 .039	3200 ~ 4600	0.30 ~ 1.0	.012 .039	3200 ~ 4600	0.30 ~ 1.0	.012 .039

RPM = rev./min.
FEED = mm/rev.
IPR = inch/rev.



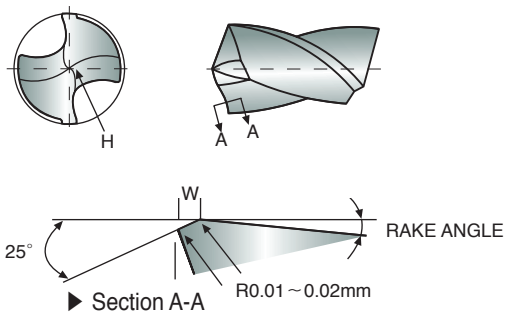
CHARACTERISTIC OF DREAM DRILLS

- YG-1's Dream Drill Series are suitable for high speed and accurate drilling operations by special design and high quality.
- Good performance for Steels, Cast Irons, Tool steels, Alloy steels and Stainless steels, Aluminum and Composite Material.
- Rapid chip evacuation and excellent chip breaking can be achieved by special designed cutting edges on point and chip breakers on leading edges.
- High accuracy and stability.
- Longer tool life with TiAlN coating.
- Self-centering

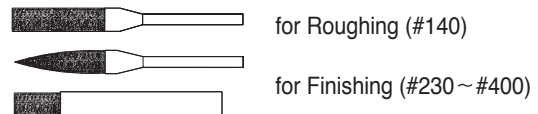


HONING GUIDE OF DREAM DRILLS

Dimension of Honing



Scraper

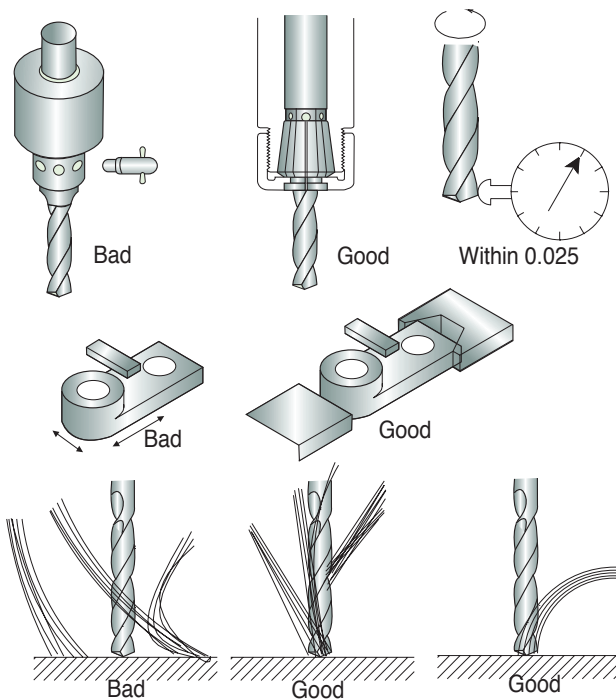


Work Material	Alloy Steels	Mild Steels	Cast Iron
W(mm)	0.15 ~ 0.2	0.1 ~ 0.15	0.03

▶ The dimension W of stocked products is 0.1 ~ 0.15.



USE OF DREAM DRILLS



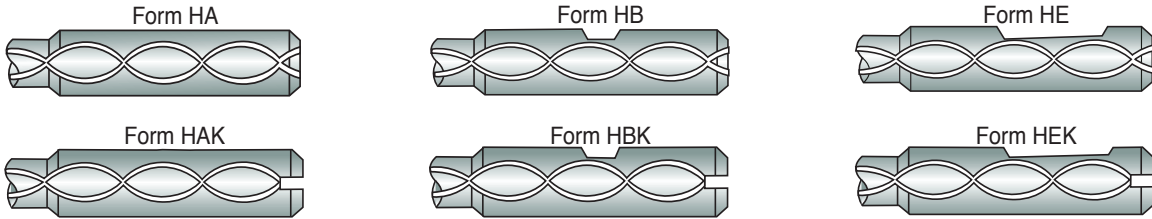
- ▶ Chucking with spring collet correctly.
- ▶ Radial run out at cutting lip must not exceed 0.025 mm.

▶ Tighten clamp of work piece.

- ▶ Supply coolant enough to the entrance of holes.
- ▶ In using Dream Drill with Coolant holes, high pressure coolant is needed.

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SHANK TYPE DREAM DRILLS WITH COOLANT HOLES



► If you need other Shank Type, we can supply them.

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DRILL DIAMETER TOLERANCE INCH

$\mu\text{m} = 1/1000\text{mm}$

up to .118	over .118 up to .236	over .236 up to .394	over .394 up to .709
+0 -.00055	+0 -.00071	+0 -.00087	+0 -.00106

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DRILL DIAMETER TOLERANCE METRIC

Diameter (mm)	1 - 3 from to	3 - 6 over to	6 - 10 over to	10 - 18 over to	18 - 30 over to
h6	0 -.00024	0 -.00032	0 -.00036	0 -.00044	0 -.00052
h7	0 -.0004	0 -.00048	0 -.00059	0 -.00071	0 -.00083
h8	0 -.00056	0 -.00071	0 -.00087	0 -.00107	0 -.00130
m7	+0.00048 +0.00007	+0.00063 +0.00015	+0.00083 +0.00023	+0.00099 +0.00027	+0.00114 +0.00031

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COOLANT RECOMMENDATIONS FOR CARBIDE DREAM DRILLS

