# Yes Carbide Cutting Tools

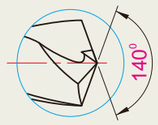
— High Performance Carbide Tools Line

Yes® YESTOOL Co., Ltd.

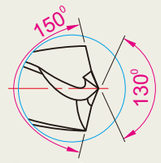


| | |
|---|---|
| YSR(L) YSBR | Solid Carbide "Speedy" Reamer, Broach Reamer |
| YSDF YSDLF | Solid Carbide "F"(flat bottom) point Drill |
| YSDP YSDLP | Solid Carbide "P"(Premium) point Drill |
| YSD YSSD | Solid Carbide Drill, Step Drill |
| YSDL | Solid Carbide Long series Drill |
| YSDC YSDCF YSDCP | Solid Carbide Coolant Drill, HA shank |
| YSDC,D5 YSDCF,D5 YSDCP,D5 | Solid Carbide Coolant Drill, 5xD, HE shank |
| YSDC,D8 YSDCF,D8 YSDCP,D8 | Solid Carbide Coolant Drill, Long series 8xD, HE shank |
| YCD | Solid Carbide Chamfer Drill |
| YCH | Chamfer Holder for YCD |

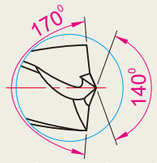
## Solid Carbide Series




Standard Point




"P" Premium Point

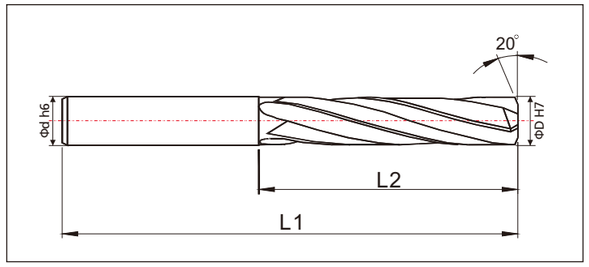



"F" Flatted Point

# 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 | 4 |
| 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 | | | |
| YSRL 052 ~ 061 | 5.2 ~ 6.1 | 6.0 | 82 | 49 | |
| YSRL 062 ~ 071 | 6.2 ~ 7.1 | 7.0 | 84 | 52 | |
| YSRL 072 ~ 081 | 7.2 ~ 8.1 | 8.0 | 89 | 57 | |
| YSRL 082 ~ 091 | 8.2 ~ 9.1 | 9.0 | 96 | 62 | |
| YSRL 092 ~ 101 | 9.2 ~ 10.1 | 10.0 | 103 | 66 | 4 |
| YSRL 102 ~ 111 | 10.2 ~ 11.1 | 11.0 | 108 | 71 | |
| YSRL 112 ~ 121 | 11.2 ~ 12.1 | 12.0 | 118 | 78 | |
| YSRL 122 ~ 131 | 12.2 ~ 13.1 | 13.0 | 135 | 88 | |
| 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 | | | |
| YSRL 182 ~ 191 | 18.2 ~ 19.1 | 19.0 | | | |
| YSRL 192 ~ 200 | 19.2 ~ 20.0 | 20.0 | | | |

Note

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

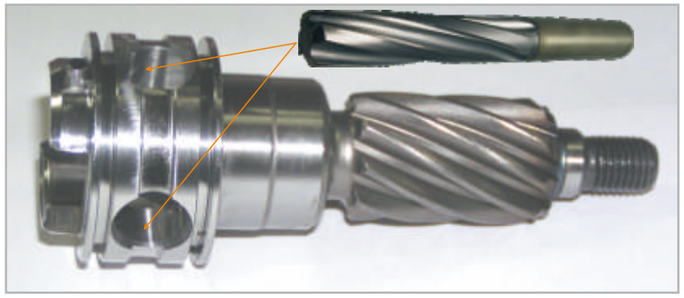
## Machining case of YSR

- 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

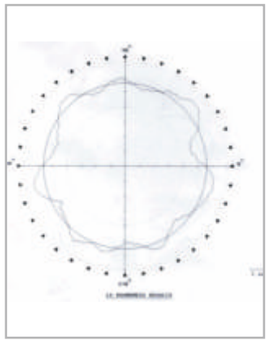
## Resulted in great performance

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

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

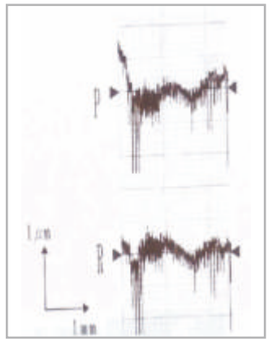


Roundness measures



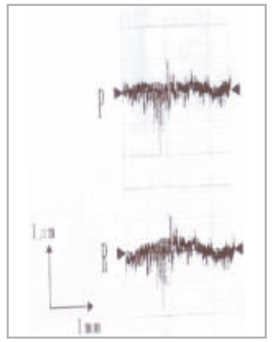
Measuring : External
O = 1.80μm

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



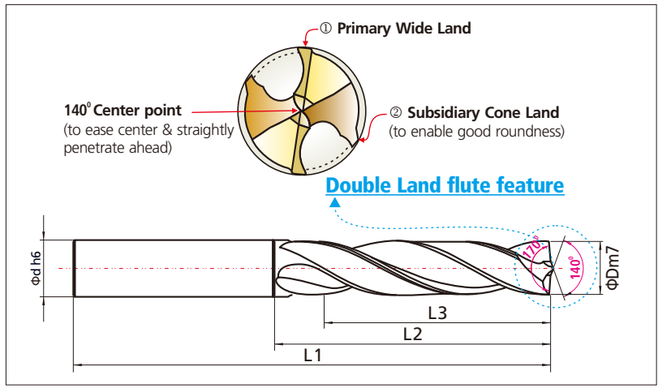
P: Polarity
R : Round measure
Ra = 0.10μm
Rmax = 1.46μm
Rz = 0.94μm

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


Solid Carbide Series

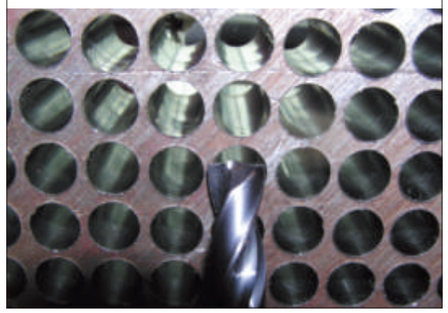
# Solid Carbide "F"(flat bottom) point drills

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.**

Normal drilling or Finishing hole | Conterboring | Flat bottom hole | Interrupted hole | Interrupted (cross hole exist) | Slant(slope) surface

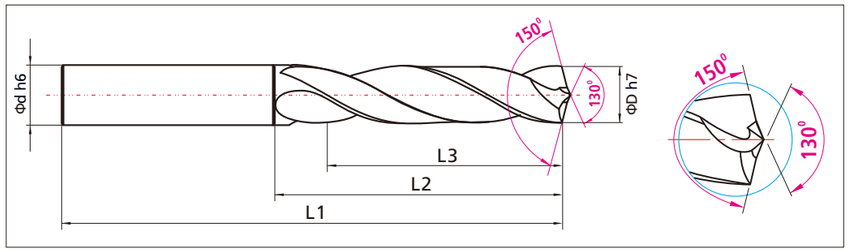




# Solid Carbide "P"(Premium) point Drill

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 |

## 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 |

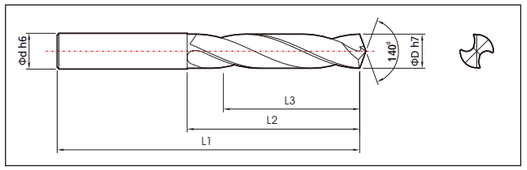
- **Note** : "P" point drill is available on request.

# 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 | | | 25 | 19 |
| 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 | | | 42 |
| 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 | 107 | 64 | 43 |
| 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 | 111 | 67 | 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 | 115 | 69 | 45 |
| 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 | | | | |

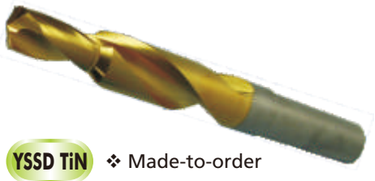
| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSD 162 | 16.2 | 17.0 | 119 | 71 | 46 |
| YSD 163 | 16.3 | | | | |
| YSD 164 | 16.4 | | | | |
| YSD 165 | 16.5 | | | | |
| YSD 166 | 16.6 | | | | |
| YSD 167 | 16.7 | | | | |
| YSD 168 | 16.8 | | | | |
| YSD 169 | 16.9 | | | | |
| YSD 170 | 17.0 | | | | |
| YSD 171 | 17.1 | | | | |
| YSD 172 | 17.2 | 18.0 | 123 | 74 | 47 |
| 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 | 127 | 76 | 48 |
| 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 | 20.0 | 131 | 80 | 50 |
| 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 Series

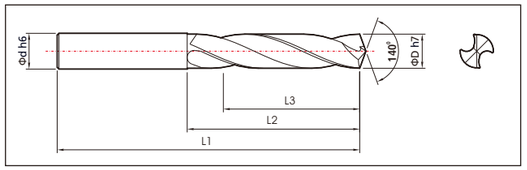
# Solid Carbide Drill, Inch

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 | | | | |
| YSD .2188 | 7/32 | 1/4 | 2.91 | 1.65 | 1.25 |
| YSD .2500 | 1/4 | | | | |
| YSD .2656 | 17/64 | 5/16 | 3.11 | 1.81 | 1.33 |
| YSD .2812 | 9/32 | | | | |
| YSD .2969 | 19/64 | | | | |
| YSD .3125 | 5/16 | | | | |
| YSD .3281 | 21/64 | 3/8 | 3.5 | 2.08 | 1.5 |
| YSD .3438 | 11/32 | | | | |
| YSD .3594 | 23/64 | | | | |
| 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 | | | | |
| YSD .4531 | 29/64 | 1/2 | 4.01 | 2.44 | 1.65 |
| YSD .4688 | 15/32 | | | | |
| YSD .4844 | 31/64 | | | | |
| YSD .5000 | 1/2 | | | | |
| YSD .5625 | 9/16 | 9/16 | 4.37 | 2.63 | 1.77 |
| YSD .6250 | 5/8 | 5/8 | 4.52 | 2.71 | |
| YSD .6875 | 11/16 | 11/16 | 4.84 | 2.91 | 1.85 |
| YSD .7500 | 3/4 | 3/4 | 5 | 2.99 | 1.88 |



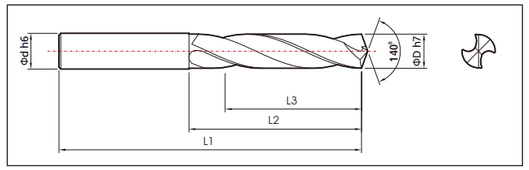


# Solid Carbide Drill, Long Series, Metric

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 | | | | 39 |
| YSDL 037 | 3.7 | | | | |
| YSDL 038 | 3.8 | | | | |
| YSDL 039 | 3.9 | | | | |
| YSDL 040 | 4.0 | | | | |
| 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 ▶▶

# 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 | 12.0 | 120 | 80 | 62 |
| YSDL 113 | 11.3 | | | | |
| YSDL 114 | 11.4 | | | | |
| YSDL 115 | 11.5 | | | | |
| YSDL 116 | 11.6 | | | | |
| YSDL 117 | 11.7 | | | | |
| YSDL 118 | 11.8 | | | | |
| YSDL 119 | 11.9 | | | | |
| YSDL 120 | 12.0 | | | | |
| YSDL 121 | 12.1 | | | | |
| YSDL 122 | 12.2 | 13.0 | 137 | 90 | 71 |
| YSDL 123 | 12.3 | | | | |
| YSDL 124 | 12.4 | | | | |
| YSDL 125 | 12.5 | | | | |
| YSDL 126 | 12.6 | | | | |
| YSDL 127 | 12.7 | | | | |
| YSDL 128 | 12.8 | | | | |
| YSDL 129 | 12.9 | | | | |
| YSDL 130 | 13.0 | | | | |
| YSDL 131 | 13.1 | | | | |
| YSDL 132 | 13.2 | 14.0 | 147 | 96 | 75 |
| YSDL 133 | 13.3 | | | | |
| YSDL 134 | 13.4 | | | | |
| YSDL 135 | 13.5 | | | | |
| YSDL 136 | 13.6 | | | | |
| YSDL 137 | 13.7 | | | | |
| YSDL 138 | 13.8 | | | | |
| YSDL 139 | 13.9 | | | | |
| YSDL 140 | 14.0 | | | | |
| YSDL 141 | 14.1 | | | | |
| YSDL 142 | 14.2 | 15.0 | 153 | 100 | 78 |
| YSDL 143 | 14.3 | | | | |
| YSDL 144 | 14.4 | | | | |
| YSDL 145 | 14.5 | | | | |
| YSDL 146 | 14.6 | | | | |
| YSDL 147 | 14.7 | | | | |
| YSDL 148 | 14.8 | | | | |
| YSDL 149 | 14.9 | | | | |
| YSDL 150 | 15.0 | | | | |
| YSDL 151 | 15.1 | | | | |
| YSDL 152 | 15.2 | 16.0 | 160 | 112 | 88 |
| YSDL 153 | 15.3 | | | | |

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDL 154 | 15.4 | 16.0 | 160 | 112 | 88 |
| 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 | 17.0 | | | 87 |
| YSDL 163 | 16.3 | | | | |
| YSDL 164 | 16.4 | | | | |
| 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 | 18.0 | | | 85 |
| YSDL 173 | 17.3 | | | | |
| YSDL 174 | 17.4 | | | | |
| 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 | 19.0 | | | 84 |
| YSDL 183 | 18.3 | | | | |
| YSDL 184 | 18.4 | | | | |
| 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 | 20.0 | | | 82 |
| YSDL 193 | 19.3 | | | | |
| YSDL 194 | 19.4 | | | | |
| YSDL 195 | 19.5 | | | | |
| YSDL 196 | 19.6 | | | | |
| YSDL 197 | 19.7 | | | | |
| YSDL 198 | 19.8 | | | | |
| YSDL 199 | 19.9 | | | | |
| YSDL 200 | 20.0 | | | | |



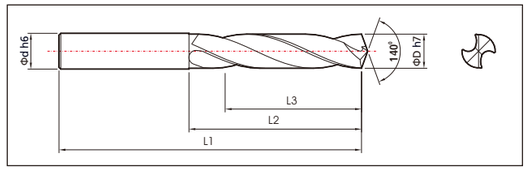


# Solid Carbide Drill, Long Series, Inch

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.

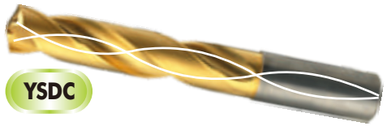
### Inch Size

| 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 | 1/4 | 3.26 | 2.08 | 1.69 |
| YSDL .2500 | 1/4 | | | | |
| YSDL .2656 | 17/64 | 5/16 | 3.54 | 2.28 | 1.81 |
| YSDL .2812 | 9/32 | | | | |
| YSDL .2969 | 19/64 | | | | |
| YSDL .3125 | 5/16 | | | | |
| YSDL .3281 | 21/64 | 3/8 | 4.13 | 2.67 | 2.08 |
| YSDL .3438 | 11/32 | | | | |
| YSDL .3594 | 23/64 | | | | |
| YSDL .3750 | 3/8 | | | | |

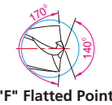
### Inch Size

| 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 | 1/2 | 5.39 | 3.54 | 2.79 |
| 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 | 5/8 | 6.29 | 4.4 | 3.46 |
| YSDL .6875 | 11/16 | 11/16 | | | |
| YSDL .7500 | 3/4 | 3/4 | | | |

# Solid Carbide Coolant Drill, Metric

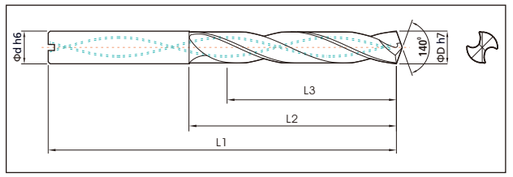


Standard Point




"F" Flatted Point

"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 elliminate 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 | 72 | 42 | 35 |
| YSDC 051 | 5.1 | | | | |
| YSDC 052 | 5.2 | 6.0 | | | 33 |
| YSDC 053 | 5.3 | | | | |
| YSDC 054 | 5.4 | | | | |
| YSDC 055 | 5.5 | | | | |
| YSDC 056 | 5.6 | | | | |
| 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 | 7.0 | 97 | 60 | 50 |
| YSDC 063 | 6.3 | | | | |
| YSDC 064 | 6.4 | | | | |
| YSDC 065 | 6.5 | | | | |
| YSDC 066 | 6.6 | | | | |
| YSDC 067 | 6.7 | | | | |
| 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 | 8.0 | 97 | 60 | 48 |
| YSDC 073 | 7.3 | | | | |
| YSDC 074 | 7.4 | | | | |
| YSDC 075 | 7.5 | | | | |
| YSDC 076 | 7.6 | | | | |
| YSDC 077 | 7.7 | | | | |
| 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

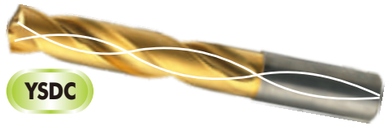
| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 082 | 8.2 | 9.0 | 97 | 60 | 47 |
| YSDC 083 | 8.3 | | | | |
| YSDC 084 | 8.4 | | | | |
| YSDC 085 | 8.5 | | | | |
| YSDC 086 | 8.6 | | | | |
| YSDC 087 | 8.7 | | | | |
| YSDC 088 | 8.8 | | | | |
| YSDC 089 | 8.9 | | | | |
| YSDC 090 | 9.0 | | | | |
| YSDC 091 | 9.1 | | | | |
| YSDC 092 | 9.2 | 10.0 | | | 45 |
| YSDC 093 | 9.3 | | | | |
| YSDC 094 | 9.4 | | | | |
| YSDC 095 | 9.5 | | | | |
| YSDC 096 | 9.6 | | | | |
| YSDC 097 | 9.7 | | | | |
| YSDC 098 | 9.8 | | | | |
| YSDC 099 | 9.9 | | | | |
| YSDC 100 | 10.0 | | | | |
| YSDC 101 | 10.1 | | | | |
| YSDC 102 | 10.2 | 11.0 | 140 | 100 | 84 |
| YSDC 103 | 10.3 | | | | |
| YSDC 104 | 10.4 | | | | |
| YSDC 105 | 10.5 | | | | |
| YSDC 106 | 10.6 | | | | |
| YSDC 107 | 10.7 | | | | |
| YSDC 108 | 10.8 | | | | |
| YSDC 109 | 10.9 | | | | |
| YSDC 110 | 11.0 | | | | |
| YSDC 111 | 11.1 | | | | |
| YSDC 112 | 11.2 | 12.0 | | | 82 |
| YSDC 113 | 11.3 | | | | |
| YSDC 114 | 11.4 | | | | |
| YSDC 115 | 11.5 | | | | |
| YSDC 116 | 11.6 | | | | |
| 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 | 13.0 | 143 | 102 | 83 |
| YSDC 123 | 12.3 | | | | |
| YSDC 124 | 12.4 | | | | |
| YSDC 125 | 12.5 | | | | |
| YSDC 126 | 12.6 | | | | |
| YSDC 127 | 12.7 | | | | |
| YSDC 128 | 12.8 | | | | |
| YSDC 129 | 12.9 | | | | |
| YSDC 130 | 13.0 | | | | |
| YSDC 131 | 13.1 | | | | |
| YSDC 132 | 13.2 | 14.0 | | | 81 |
| YSDC 133 | 13.3 | | | | |
| YSDC 134 | 13.4 | | | | |
| YSDC 135 | 13.5 | | | | |
| YSDC 136 | 13.6 | | | | |
| YSDC 137 | 13.7 | | | | |
| YSDC 138 | 13.8 | | | | |
| YSDC 139 | 13.9 | | | | |
| YSDC 140 | 14.0 | | | | |
| YSDC 141 | 14.1 | | | | |
| YSDC 142 | 14.2 | 15.0 | | | 80 |
| YSDC 143 | 14.3 | | | | |
| YSDC 144 | 14.4 | | | | |
| YSDC 145 | 14.5 | | | | |
| YSDC 146 | 14.6 | | | | |
| YSDC 147 | 14.7 | | | | |
| YSDC 148 | 14.8 | | | | |
| YSDC 149 | 14.9 | | | | |
| YSDC 150 | 15.0 | | | | |
| YSDC 151 | 15.1 | | | | |
| YSDC 152 | 15.2 | 16.0 | | | 78 |
| YSDC 153 | 15.3 | | | | |
| YSDC 154 | 15.4 | | | | |
| YSDC 155 | 15.5 | | | | |
| YSDC 156 | 15.6 | | | | |
| YSDC 157 | 15.7 | | | | |
| YSDC 158 | 15.8 | | | | |
| YSDC 159 | 15.9 | | | | |
| YSDC 160 | 16.0 | | | | |
| YSDC 161 | 16.1 | | | | |

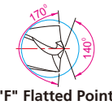
| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 162 | 16.2 | 17.0 | 146 | 104 | 79 |
| YSDC 163 | 16.3 | | | | |
| YSDC 164 | 16.4 | | | | |
| YSDC 165 | 16.5 | | | | |
| YSDC 166 | 16.6 | | | | |
| YSDC 167 | 16.7 | | | | |
| YSDC 168 | 16.8 | | | | |
| YSDC 169 | 16.9 | | | | |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


Solid Carbide Series

# Solid Carbide Coolant Drill, Inch

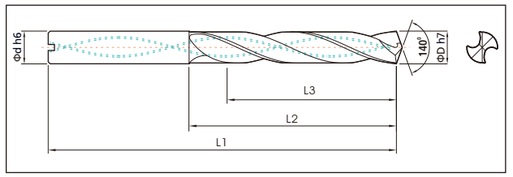


Standard Point




"F" Flatted Point

"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 elliminate 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 | 1.73 | 1.54 |
| YSDC .2188 | 7/32 | 1/4 | 3.23 | | 1.34 |
| YSDC .2500 | 1/4 | | | | |
| YSDC .2656 | 17/64 | 5/16 | 3.58 | 2.08 | 1.61 |
| YSDC .2812 | 9/32 | | | | |
| YSDC .2969 | 19/64 | | | | |
| YSDC .3125 | 5/16 | | | | |
| YSDC .3281 | 21/64 | 3/8 | 4.05 | 2.4 | 1.81 |
| YSDC .3438 | 11/32 | | | | |
| YSDC .3594 | 23/64 | | | | |
| YSDC .3750 | 3/8 | | | | |

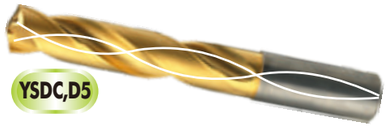
### Inch Size

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC .3906 | 25/64 | 7/16 | 4.37 | 2.63 | 2 |
| YSDC .4062 | 13/32 | | | | |
| YSDC .4219 | 27/64 | | | | |
| YSDC .4375 | 7/16 | | | | |
| YSDC .4531 | 29/64 | 1/2 | 4.64 | 2.79 | 2.05 |
| YSDC .4688 | 15/32 | | | | |
| YSDC .4844 | 31/64 | | | | |
| 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 |

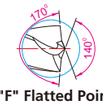




# Solid Carbide Coolant Drill, Reinforced Shank

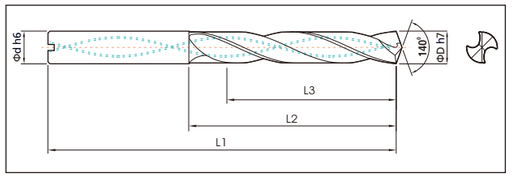


Standard Point




"F" Flatted Point

"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 elliminate 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 | 6.0 | 82 | 44 | 35 |
| YSDC 051D5 | 5.1 | | | | |
| YSDC 052D5 | 5.2 | | | | |
| YSDC 053D5 | 5.3 | | | | |
| YSDC 054D5 | 5.4 | | | | |
| YSDC 055D5 | 5.5 | | | | |
| YSDC 056D5 | 5.6 | | | | |
| YSDC 057D5 | 5.7 | | | | |
| YSDC 058D5 | 5.8 | | | | |
| YSDC 059D5 | 5.9 | | | | |
| YSDC 060D5 | 6.0 | | | | |
| YSDC 061D5 | 6.1 | 8.0 | 91 | 53 | 43 |
| YSDC 062D5 | 6.2 | | | | |
| YSDC 063D5 | 6.3 | | | | |
| YSDC 064D5 | 6.4 | | | | |
| YSDC 065D5 | 6.5 | | | | |

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 066D5 | 6.6 | 8.0 | 91 | 53 | 43 |
| YSDC 067D5 | 6.7 | | | | |
| YSDC 068D5 | 6.8 | | | | |
| YSDC 069D5 | 6.9 | | | | |
| YSDC 070D5 | 7.0 | | | | |
| YSDC 071D5 | 7.1 | | | | 41 |
| YSDC 072D5 | 7.2 | | | | |
| YSDC 073D5 | 7.3 | | | | |
| YSDC 074D5 | 7.4 | | | | |
| YSDC 075D5 | 7.5 | | | | |
| YSDC 076D5 | 7.6 | | | | |
| 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 | 10.0 | 103 | 61 | 48 |
| YSDC 083D5 | 8.3 | | | | |
| YSDC 084D5 | 8.4 | | | | |
| YSDC 085D5 | 8.5 | | | | |
| YSDC 086D5 | 8.6 | | | | |
| YSDC 087D5 | 8.7 | | | | |
| YSDC 088D5 | 8.8 | | | | |
| YSDC 089D5 | 8.9 | | | | |
| YSDC 090D5 | 9.0 | | | | |
| YSDC 091D5 | 9.1 | | | | 46 |
| YSDC 092D5 | 9.2 | | | | |
| YSDC 093D5 | 9.3 | | | | |
| YSDC 094D5 | 9.4 | | | | |
| YSDC 095D5 | 9.5 | | | | |
| YSDC 096D5 | 9.6 | | | | |
| YSDC 097D5 | 9.7 | | | | |

Continued

# Solid Carbide Coolant Drill, Reinforced Shank

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 098D5 | 9.8 | 10.0 | 103 | 61 | 46 |
| YSDC 099D5 | 9.9 | | | | |
| YSDC 100D5 | 10.0 | | | | |
| YSDC 101D5 | 10.1 | 12.0 | 118 | 71 | 55 |
| YSDC 102D5 | 10.2 | | | | |
| YSDC 103D5 | 10.3 | | | | |
| YSDC 104D5 | 10.4 | | | | |
| YSDC 105D5 | 10.5 | | | | |
| YSDC 106D5 | 10.6 | | | | |
| YSDC 107D5 | 10.7 | | | | |
| YSDC 108D5 | 10.8 | | | | |
| YSDC 109D5 | 10.9 | | | | |
| YSDC 110D5 | 11.0 | | | | |
| YSDC 111D5 | 11.1 | | | | 53 |
| YSDC 112D5 | 11.2 | | | | |
| YSDC 113D5 | 11.3 | | | | |
| YSDC 114D5 | 11.4 | | | | |
| YSDC 115D5 | 11.5 | | | | |
| YSDC 116D5 | 11.6 | | | | |
| YSDC 117D5 | 11.7 | | | | |
| YSDC 118D5 | 11.8 | | | | |
| YSDC 119D5 | 11.9 | | | | |
| YSDC 120D5 | 12.0 | | | | |
| YSDC 121D5 | 12.1 | 14.0 | 124 | 77 | 58 |
| YSDC 122D5 | 12.2 | | | | |
| YSDC 123D5 | 12.3 | | | | |
| YSDC 124D5 | 12.4 | | | | |
| YSDC 125D5 | 12.5 | | | | |
| YSDC 126D5 | 12.6 | | | | |
| 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 | 14.0 | 124 | 77 | 56 |
| YSDC 133D5 | 13.3 | | | | |
| YSDC 134D5 | 13.4 | | | | |
| YSDC 135D5 | 13.5 | | | | |
| YSDC 136D5 | 13.6 | | | | |
| YSDC 137D5 | 13.7 | | | | |
| YSDC 138D5 | 13.8 | | | | |
| YSDC 139D5 | 13.9 | | | | |
| YSDC 140D5 | 14.0 | | | | |
| YSDC 141D5 | 14.1 | 16.0 | 133 | 83 | 55 |
| YSDC 142D5 | 14.2 | | | | |
| YSDC 143D5 | 14.3 | | | | |
| YSDC 144D5 | 14.4 | | | | |
| YSDC 145D5 | 14.5 | | | | |
| YSDC 146D5 | 14.6 | | | | |
| YSDC 147D5 | 14.7 | | | | |
| YSDC 148D5 | 14.8 | | | | |
| YSDC 149D5 | 14.9 | | | | |
| YSDC 150D5 | 15.0 | | | | |
| YSDC 151D5 | 15.1 | | | | 53 |
| YSDC 152D5 | 15.2 | | | | |
| YSDC 153D5 | 15.3 | | | | |
| YSDC 154D5 | 15.4 | | | | |
| YSDC 155D5 | 15.5 | | | | |
| YSDC 156D5 | 15.6 | | | | |
| YSDC 157D5 | 15.7 | | | | |
| YSDC 158D5 | 15.8 | | | | |
| YSDC 159D5 | 15.9 | | | | |
| YSDC 160D5 | 16.0 | | | | |
| YSDC 161D5 | 16.1 | 18.0 | 143 | 93 | 68 |
| YSDC 162D5 | 16.2 | | | | |
| YSDC 163D5 | 16.3 | | | | |
| YSDC 164D5 | 16.4 | | | | |
| YSDC 165D5 | 16.5 | | | | |

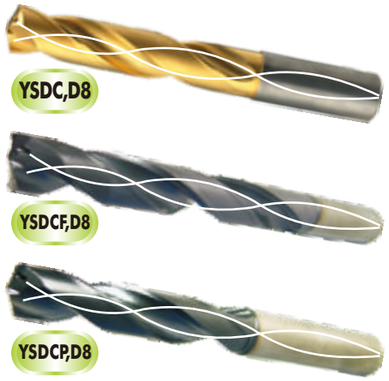
| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 166D5 | 16.6 | 18.0 | 143 | 93 | 68 |
| YSDC 167D5 | 16.7 | | | | |
| YSDC 168D5 | 16.8 | | | | |
| YSDC 169D5 | 16.9 | | | | |
| YSDC 170D5 | 17.0 | | | | 66 |
| YSDC 171D5 | 17.1 | | | | |
| YSDC 172D5 | 17.2 | | | | |
| YSDC 173D5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

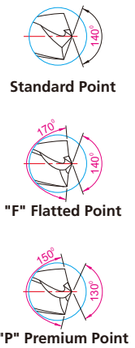
❖ Available small dia. below 5.0mm & coolant step drill on request.
❖ YSDC, D5 with plain cylindrical HA shank available on request.

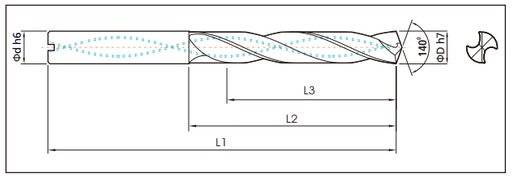




# Solid Carbide Coolant Drill, Long series (8xD)




## 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 elliminate 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 | 6.0 | 95 | 57 | 48 |
| YSDC 051D8 | 5.1 | | | | |
| YSDC 052D8 | 5.2 | | | | |
| YSDC 053D8 | 5.3 | | | | |
| YSDC 054D8 | 5.4 | | | | |
| YSDC 055D8 | 5.5 | | | | |
| YSDC 056D8 | 5.6 | | | | |
| YSDC 057D8 | 5.7 | | | | |
| YSDC 058D8 | 5.8 | | | | |
| YSDC 059D8 | 5.9 | | | | |
| YSDC 060D8 | 6.0 | | | | |
| YSDC 061D8 | 6.1 | 8.0 | 114 | 76 | 66 |
| YSDC 062D8 | 6.2 | | | | |
| YSDC 063D8 | 6.3 | | | | |
| YSDC 064D8 | 6.4 | | | | |
| YSDC 065D8 | 6.5 | | | | |

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 066D8 | 6.6 | 8.0 | 114 | 76 | 66 |
| YSDC 067D8 | 6.7 | | | | |
| YSDC 068D8 | 6.8 | | | | |
| YSDC 069D8 | 6.9 | | | | |
| YSDC 070D8 | 7.0 | | | | |
| YSDC 071D8 | 7.1 | | | | 64 |
| YSDC 072D8 | 7.2 | | | | |
| YSDC 073D8 | 7.3 | | | | |
| YSDC 074D8 | 7.4 | | | | |
| YSDC 075D8 | 7.5 | | | | |
| YSDC 076D8 | 7.6 | | | | |
| 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 | 10.0 | 137 | 95 | 82 |
| YSDC 083D8 | 8.3 | | | | |
| YSDC 084D8 | 8.4 | | | | |
| YSDC 085D8 | 8.5 | | | | |
| YSDC 086D8 | 8.6 | | | | |
| YSDC 087D8 | 8.7 | | | | |
| YSDC 088D8 | 8.8 | | | | |
| YSDC 089D8 | 8.9 | | | | |
| YSDC 090D8 | 9.0 | | | | |
| YSDC 091D8 | 9.1 | | | | 80 |
| YSDC 092D8 | 9.2 | | | | |
| YSDC 093D8 | 9.3 | | | | |
| YSDC 094D8 | 9.4 | | | | |
| YSDC 095D8 | 9.5 | | | | |
| YSDC 096D8 | 9.6 | | | | |
| YSDC 097D8 | 9.7 | | | | |

Continued ▶▶

# Solid Carbide Coolant Drill, Long series (8xD)

| Code No. | D | d | L1 | L2 | L3 |
|---|---|---|---|---|---|
| YSDC 098D8 | 9.8 | 10.0 | 137 | 95 | 80 |
| YSDC 099D8 | 9.9 | | | | |
| YSDC 100D8 | 10.0 | | | | |
| YSDC 101D8 | 10.1 | 12.0 | 161 | 114 | 98 |
| YSDC 102D8 | 10.2 | | | | |
| YSDC 103D8 | 10.3 | | | | |
| YSDC 104D8 | 10.4 | | | | |
| YSDC 105D8 | 10.5 | | | | |
| YSDC 106D8 | 10.6 | | | | |
| YSDC 107D8 | 10.7 | | | | |
| YSDC 108D8 | 10.8 | | | | |
| YSDC 109D8 | 10.9 | | | | |
| YSDC 110D8 | 11.0 | | | | |
| YSDC 111D8 | 11.1 | | | | 96 |
| YSDC 112D8 | 11.2 | | | | |
| YSDC 113D8 | 11.3 | | | | |
| YSDC 114D8 | 11.4 | | | | |
| YSDC 115D8 | 11.5 | | | | |
| YSDC 116D8 | 11.6 | | | | |
| YSDC 117D8 | 11.7 | | | | |
| YSDC 118D8 | 11.8 | | | | |
| YSDC 119D8 | 11.9 | | | | |
| YSDC 120D8 | 12.0 | | | | |
| YSDC 121D8 | 12.1 | 14.0 | 180 | 133 | 114 |
| YSDC 122D8 | 12.2 | | | | |
| YSDC 123D8 | 12.3 | | | | |
| YSDC 124D8 | 12.4 | | | | |
| YSDC 125D8 | 12.5 | | | | |
| YSDC 126D8 | 12.6 | | | | |
| 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 | 14.0 | 180 | 133 | 112 |
| YSDC 133D8 | 13.3 | | | | |
| YSDC 134D8 | 13.4 | | | | |
| YSDC 135D8 | 13.5 | | | | |
| YSDC 136D8 | 13.6 | | | | |
| YSDC 137D8 | 13.7 | | | | |
| YSDC 138D8 | 13.8 | | | | |
| YSDC 139D8 | 13.9 | | | | |
| YSDC 140D8 | 14.0 | | | | |
| YSDC 141D8 | 14.1 | 16.0 | 202 | 152 | 124 |
| YSDC 142D8 | 14.2 | | | | |
| YSDC 143D8 | 14.3 | | | | |
| YSDC 144D8 | 14.4 | | | | |
| YSDC 145D8 | 14.5 | | | | |
| YSDC 146D8 | 14.6 | | | | |
| YSDC 147D8 | 14.7 | | | | |
| YSDC 148D8 | 14.8 | | | | |
| YSDC 149D8 | 14.9 | | | | |
| YSDC 150D8 | 15.0 | | | | |
| YSDC 151D8 | 15.1 | | | | 122 |
| YSDC 152D8 | 15.2 | | | | |
| YSDC 153D8 | 15.3 | | | | |
| YSDC 154D8 | 15.4 | | | | |
| YSDC 155D8 | 15.5 | | | | |
| YSDC 156D8 | 15.6 | | | | |
| YSDC 157D8 | 15.7 | | | | |
| YSDC 158D8 | 15.8 | | | | |
| YSDC 159D8 | 15.9 | | | | |
| YSDC 160D8 | 16.0 | | | | |
| YSDC 161D8 | 16.1 | 18.0 | 221 | 171 | 146 |
| YSDC 162D8 | 16.2 | | | | |
| YSDC 163D8 | 16.3 | | | | |
| YSDC 164D8 | 16.4 | | | | |
| YSDC 165D8 | 16.5 | | | | |

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

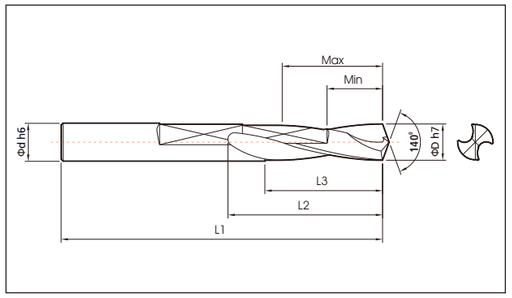
❖ Available small dia. below 5.0mm & coolant step drill on request.
❖ Plain cylindrical HA shank available on request.





# Solid Carbide Chamfer Drill, Metric

(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 elliminate 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 Min | Hole depth Max | Applicable Holder |
|---|---|---|---|---|---|---|---|---|
| YCD 051 | 5.1 | 6.0 | 66 | 30 | 24 | 9 | 20 | YCH 060 |
| YCD 052 | 5.2 | | | | | | | |
| YCD 053 | 5.3 | | | | | | | |
| YCD 054 | 5.4 | | | | | | | |
| YCD 055 | 5.5 | | | | | | | |
| YCD 056 | 5.6 | | | | | | | |
| YCD 057 | 5.7 | | | | | | | |
| YCD 058 | 5.8 | | | | | | | |
| YCD 059 | 5.9 | | | | | | | |
| YCD 060 | 6.0 | | | | | | | |
| YCD 061 | 6.1 | 7.0 | 74 | 37 | 30 | 11 | 25 | YCH 070 |
| YCD 062 | 6.2 | | | | | | | |
| YCD 063 | 6.3 | | | | | | | |
| YCD 064 | 6.4 | | | | | | | |
| YCD 065 | 6.5 | | | | | | | |
| 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 Min | Hole depth Max | Applicable Holder |
|---|---|---|---|---|---|---|---|---|
| YCD 071 | 7.1 | 8.0 | 79 | 41 | 33 | 12 | 28 | YCH 080 |
| YCD 072 | 7.2 | | | | | | | |
| YCD 073 | 7.3 | | | | | | | |
| YCD 074 | 7.4 | | | | | | | |
| YCD 075 | 7.5 | | | | | | | |
| YCD 076 | 7.6 | | | | | | | |
| YCD 077 | 7.7 | | | | | | | |
| YCD 078 | 7.8 | | | | | | | |
| YCD 079 | 7.9 | | | | | | | |
| YCD 080 | 8.0 | | | | | | | |
| YCD 081 | 8.1 | 9.0 | 84 | 45 | 36 | 14 | 31 | YCH 090 |
| YCD 082 | 8.2 | | | | | | | |
| YCD 083 | 8.3 | | | | | | | |
| YCD 084 | 8.4 | | | | | | | |
| YCD 085 | 8.5 | | | | | | | |
| YCD 086 | 8.6 | | | | | | | |
| YCD 087 | 8.7 | | | | | | | |
| YCD 088 | 8.8 | | | | | | | |
| YCD 089 | 8.9 | | | | | | | |
| YCD 090 | 9.0 | | | | | | | |

Continued ▶▶

# Solid Carbide Chamfer Drill, Metric

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

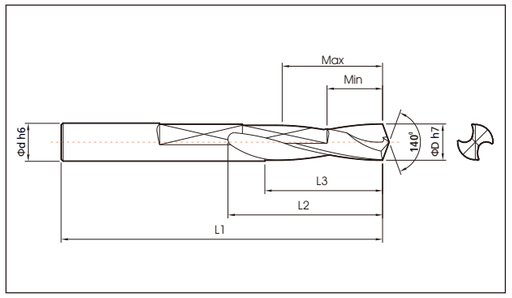
| Code No. | D | d | L1 | L2 | L3 | Hole depth Min | Hole depth Max | Applicable Holder |
|---|---|---|---|---|---|---|---|---|
| YCD 146 | 14.6 | 15.0 | 111 | 62 | 47 | 24 | 41 | YCH 150 |
| YCD 147 | 14.7 | | | | | | | |
| YCD 148 | 14.8 | | | | | | | |
| YCD 149 | 14.9 | | | | | | | |
| YCD 150 |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





# Solid Carbide Chamfer Drill, Inch

(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 elliminate 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 Min | Hole depth Max | Applicable Holder |
|---|---|---|---|---|---|---|---|---|
| YCD .2010 | #7 | 1/4 | 2.59 | 1.18 | 0.94 | 0.35 | 0.78 | YCH.2500 |
| YCD .2130 | #3 | | | | | | | |
| YCD .2570 | F | | 2.91 | 1.45 | 1.18 | 0.43 | 0.98 | |
| YCD .2720 | I | | | | | | | |
| YCD .3125 | 5/16 | 5/16 | 3.11 | 1.61 | 1.29 | 0.47 | 1.1 | YCH.3125 |
| YCD .3320 | Q | | | | | 0.62 | | |
| YCD .3680 | U | 3/8 | 3.5 | 1.92 | 1.53 | | 1.33 | YCH.3750 |
| YCD .3906 | 25/64 | | | | | | | |
| YCD .4219 | 25/64 | 7/16 | 3.74 | 1.85 | 1.41 | 0.66 | 1.22 | YCH.4375 |

### Inch Size

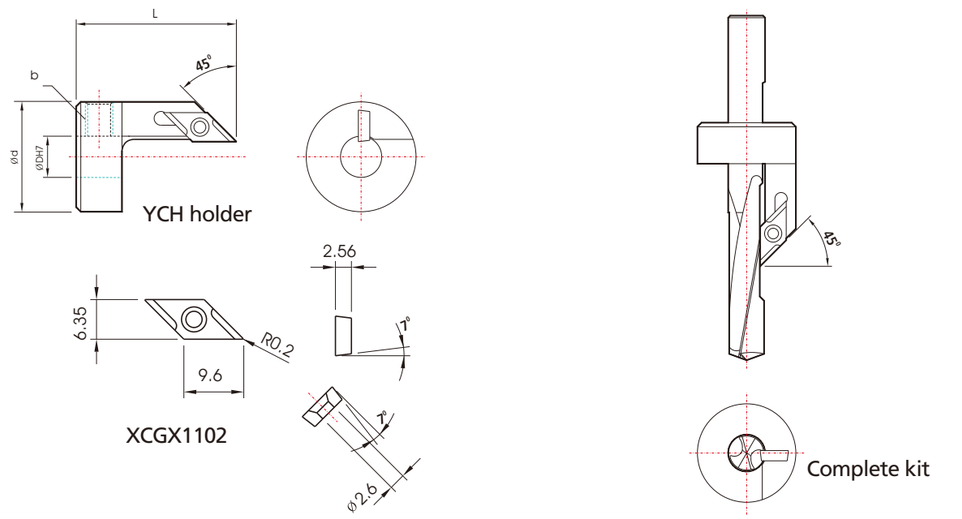
| Code No. | D | d | L1 | L2 | L3 | Hole depth Min | Hole depth Max | Applicable Holder |
|---|---|---|---|---|---|---|---|---|
| YCD .4531 | 29/64 | 7/16 | 3.74 | 1.85 | 1.41 | 0.66 | 1.22 | YCH.4375 |
| YCD .4844 | 31/64 | 1/2 | 4.01 | 2.12 | 1.61 | 0.74 | 1.37 | YCH.5000 |
| YCD .5156 | 33/64 | | | | | | 1.34 | |
| YCD .5312 | 17/32 | 9/16 | 4.21 | 2.28 | 1.73 | 0.78 | 1.49 | YCH.5625 |
| YCD .5781 | 37/64 | | | | | | | |
| YCD .6562 | 21/32 | 11/16 | 4.68 | 2.71 | 2.04 | 1.02 | 1.81 | YCH.6875 |
| YCD .6875 | 11/16 | | | | | | | |
| YCD .7656 | 49/64 | 3/4 | 5.15 | 3.14 | 2.36 | 1.18 | 2.08 | YCH.7500 |
| YCD .8125 | 13/16 | | | | | | | |

# 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 | M10 x 1.5P | YCD 141~150 |
| YCH 160 | 16.0 | 31 | 40 | | 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.



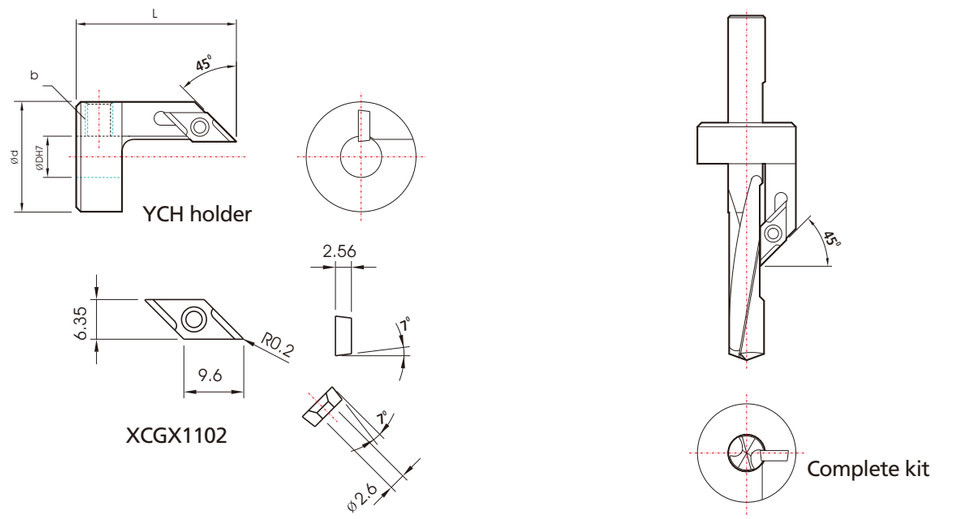


# Chamfer Holder, Inch

YCH

**Model : YCH**

- 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 .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 | | YCD .5312~.5781 |
| YCH .6875 | .6875 | 1.26 | 1.65 | M10 x 1.5P | YCD .6562~.6875 |
| YCH .7500 | .7500 | 1.34 | 1.73 | | YCD .7656~.8125 |

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