



Being the best through innovation



HSS, HSSCo8 & HSSCo5

GOLD-P DRILLS

GOLD-P COATING

- Competitive price and same performance as full TiN coating



RECOMMENDED CUTTING CONDITIONS

D1GP182, D1GP139, D1GP138, D2GP185, D2GP186, D2GP187, DLGP195 SERIES

HSS, HSSCo5 & HSSCo8 STRAIGHT SHANK, GOLD-P COATED

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

ISO	VDI 3323	Material Description	SFM	Drill Diameter												
				METRIC	2.0	3.0	-	4.0	6.0	-	-	8.0	-	10.0	-	13
				FRACTIONAL	-	-	1/8	-	-	1/4	5/16	-	3/8	-	1/2	-
DECIMAL	.0787	.1181	.1250	.1575	.2362	.2500	.3125	.3150	.3750	.3937	.5000	.5118				
P	1	Non-alloy steel	132	RPM	6370	4240	3180	2120	2120	1270	980					
			FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
			115	RPM	5570	3710	2790	1860	1860	1110	860					
			FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
	99		RPM	4770	3180	2390	1590	1590	950	730						
	FEED		.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094							
	66		RPM	3180	2120	1590	1060	1060	640	490						
	FEED		.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071							
	6	Low alloy steel	115	RPM	5570	3710	2790	1860	1860	1110	860					
			FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
99			RPM	4770	3180	2390	1590	1590	950	730						
FEED			.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094							
99	RPM		4770	3180	2390	1590	1590	950	730							
FEED	.0008 - .0020		.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071								
8	High alloyed steel, and tool steel		99	RPM	4770	3180	2390	1590	1590	950	730					
			FEED	.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071						
10		High alloyed steel, and tool steel	66	RPM	3180	2120	1590	1060	1060	640	490					
			FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
M			Stainless steel	12	82	RPM	3980	2650	1990	1330	1330	800	610			
					FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094				
				13	66	RPM	3180	2120	1590	1060	1060	640	490			
					FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094				
	14			49	RPM	2390	1590	1190	800	800	480	370				
				FEED	.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071					
K	15	Grey cast iron	132	RPM	6370	4240	3180	2120	2120	1270	980					
			FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
			115	RPM	5570	3710	2790	1860	1860	1110	860					
			FEED	.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071						
	17		Nodular cast iron	132	RPM	6370	4240	3180	2120	2120	1270	980				
				FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094					
				99	RPM	4770	3180	2390	1590	1590	950	730				
				FEED	.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071					
19	Malleable cast iron	115		RPM	5570	3710	2790	1860	1860	1110	860					
		FEED		.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094						
		99		RPM	4770	3180	2390	1590	1590	950	730					
		FEED		.0008 - .0020	.0008 - .0024	.0016 - .0031	.0016 - .0039	.0016 - .0039	.0031 - .0055	.0047 - .0071						
N		Aluminum-wrought alloy	21	214	RPM	10350	6900	5170	3450	3450	2070	1590				
				FEED	.0020 - .0035	.0028 - .0043	.0047 - .0063	.0047 - .0071	.0047 - .0071	.0063 - .0087	.0087 - .011					
			22	214	RPM	10350	6900	5170	3450	3450	2070	1590				
				FEED	.0020 - .0035	.0028 - .0043	.0047 - .0063	.0047 - .0071	.0047 - .0071	.0063 - .0087	.0087 - .011					
23	Aluminum-cast, alloyed		165	RPM	7960	5310	3980	2650	2650	1590	1220					
			FEED	.0020 - .0035	.0028 - .0043	.0047 - .0063	.0047 - .0071	.0047 - .0071	.0063 - .0087	.0087 - .011						
29			Non Metallic Materials	99	RPM	4770	3180	2390	1590	1590	950	730				
				FEED	.0016 - .0031	.0024 - .0039	.0031 - .0047	.0047 - .0063	.0047 - .0063	.0063 - .0087	.0071 - .0094					
S		Titanium Alloys		36	66	RPM	3180	2120	1590	1060	1060	640	490			
					FEED	.0008 - .0020	.0008 - .0024	.0016 - .0031	.0020 - .0035	.0020 - .0035	.0028 - .0051	.0031 - .0055				