

**YU-ND22** AMERICA

BEST VALUE IN THE WORLD OF CUTTING TOOLS



**SOLID CARBIDE  
NC SPOTTING  
DRILLS**

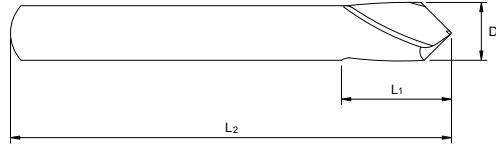


# NC SPOTTING DRILLS

SOLID CARBIDE

## NC Spotting Drill 90°

**D5321** SERIES



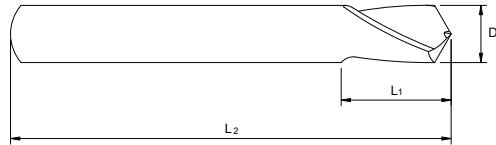
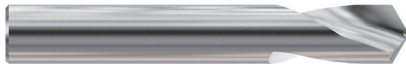
Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
	D1		L1	L2
D5321008	1/8	.1250	5/8	2"
D5321012	3/16	.1875	3/4	2"
D5321016	1/4	.2500	3/4	2-1/2
D5321020	5/16	.3125	1"	2-1/2
D5321024	3/8	.3750	1"	3"
D5321032	1/2	.5000	1"	3"
D5321040	5/8	.6250	1-1/4	3"
D5321048	3/4	.7500	1-3/4	4"

SOLID CARBIDE

## NC Spotting Drill 120°

**D5322** SERIES



Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
	D1		L1	L2
D5322008	1/8	.1250	5/8	2"
D5322012	3/16	.1875	3/4	2"
D5322016	1/4	.2500	3/4	2-1/2
D5322020	5/16	.3125	1"	2-1/2
D5322024	3/8	.3750	1"	3"
D5322032	1/2	.5000	1"	3"
D5322040	5/8	.6250	1-1/4	3"
D5322048	3/4	.7500	1-3/4	4"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	32	10	29	32	38	15	35	15	23	10	10	26	3	25	3	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎			◎	○					○			◎	○	○	○	○	○	
ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○													○					

## RECOMMENDED CUTTING CONDITIONS

### D5321, D5322 SERIES

### SOLID CARBIDE, NC SPOTTING DRILLS

SFM = ft/min.  
FEED(IPR) = inch/rev.

ISO	VDI 3323	Material Description	SFM	Drill Diameter								
				METRIC	-	-	-	-	-	-	-	-
				FRACTIONAL	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4
DECIMAL	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500				
P	1	Non-alloy steel	247	RPM	7960	4790	3980	2980	2390	1890	1490	1260
				FEED	.0016 - .0024	.0024 - .0035	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0051 - .0075	.0051 - .0075
	2		230	RPM	7430	4460	3710	2790	2230	1760	1390	1170
				FEED	.0016 - .0024	.0024 - .0035	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0051 - .0075	.0051 - .0075
	3		214	RPM	6900	4150	3450	2590	2070	1630	1290	1090
FEED		.0012 - .002		.0018 - .003	.0020 - .0031	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0043 - .0067		
6	230	RPM	7430	4460	3710	2790	2230	1760	1390	1170		
		FEED	.0016 - .0024	.0024 - .0035	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0051 - .0075	.0051 - .0075		
7	181	RPM	5840	3510	2920	2190	1750	1380	1090	920		
		FEED	.0012 - .0020	.0018 - .0030	.0020 - .0031	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0043 - .0067		
M	12	Stainless steel	115	RPM	3710	2230	1860	1390	1110	880	700	590
				FEED	.0016 - .0024	.0024 - .0035	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0051 - .0075	.0051 - .0075
K	15	Grey cast iron	296	RPM	9550	5740	4770	3580	2860	2260	1790	1510
				FEED	.0020 - .0028	.0028 - .0039	.0031 - .0043	.0039 - .0051	.0047 - .0063	.0059 - .0079	.0071 - .0094	.0071 - .0094
	16		230	RPM	7430	4460	3710	2790	2230	1760	1390	1170
				FEED	.0012 - .0020	.0018 - .0030	.0020 - .0031	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0043 - .0067
17	296	RPM	9550	5740	4770	3580	2860	2260	1790	1510		
		FEED	.002 - .0028	.0028 - .0039	.0031 - .0043	.0039 - .0051	.0047 - .0063	.0059 - .0079	.0071 - .0094	.0071 - .0094		
19	197	RPM	6370	3820	3180	2390	1910	1510	1190	1000		
		FEED	.0020 - .0028	.0028 - .0039	.0031 - .0043	.0039 - .0051	.0047 - .0063	.0059 - .0079	.0071 - .0094	.0071 - .0094		
N	21	Aluminum-wrought alloy	543	RPM	17510	10530	8750	6570	5250	4150	3280	2770
				FEED	.0024 - .0035	.0035 - .0047	.0039 - .0051	.0047 - .0059	.0059 - .0075	.0071 - .0091	.0083 - .0106	.0083 - .0106
	22		428	RPM	13790	8300	6900	5170	4140	3270	2590	2180
FEED		.0024 - .0035		.0035 - .0047	.0039 - .0051	.0047 - .0059	.0059 - .0075	.0071 - .0091	.0083 - .0106	.0083 - .0106		
23	362	RPM	11670	7020	5840	4380	3500	2770	2190	1840		
		FEED	.0024 - .0035	.0035 - .0047	.0039 - .0051	.0047 - .0059	.0059 - .0075	.0071 - .0091	.0083 - .0106	.0083 - .0106		
S	36	Titanium Alloys	115	RPM	3710	2230	1860	1390	1110	880	700	590
				FEED	.0012 - .0020	.0018 - .0030	.0020 - .0031	.0028 - .0039	.0031 - .0047	.0035 - .0055	.0043 - .0067	.0043 - .0067

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