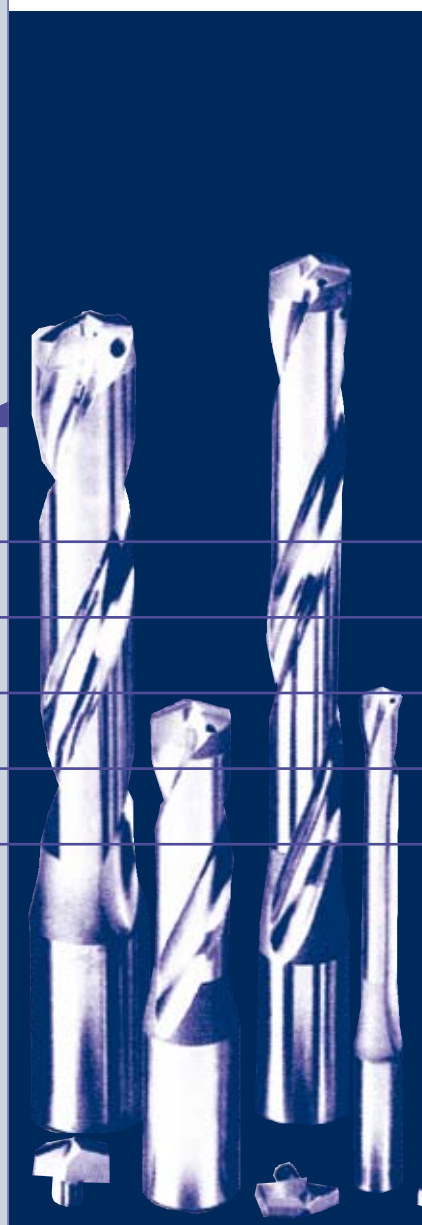


Combi-Yes Drills



MODEL YTDI



3

Combi-Yes Drills

YTDI 080T - YTDI 500T

6

Combi-Yes Drills

YTDI 080P - YTDI 500P

8

Combi-Yes Drills

YTDI 080H - YTDI 500H

10

Combi-Yes Drills

YTDI/NC 120 - YTDI/NC 200

12

Cutting Conditions

13



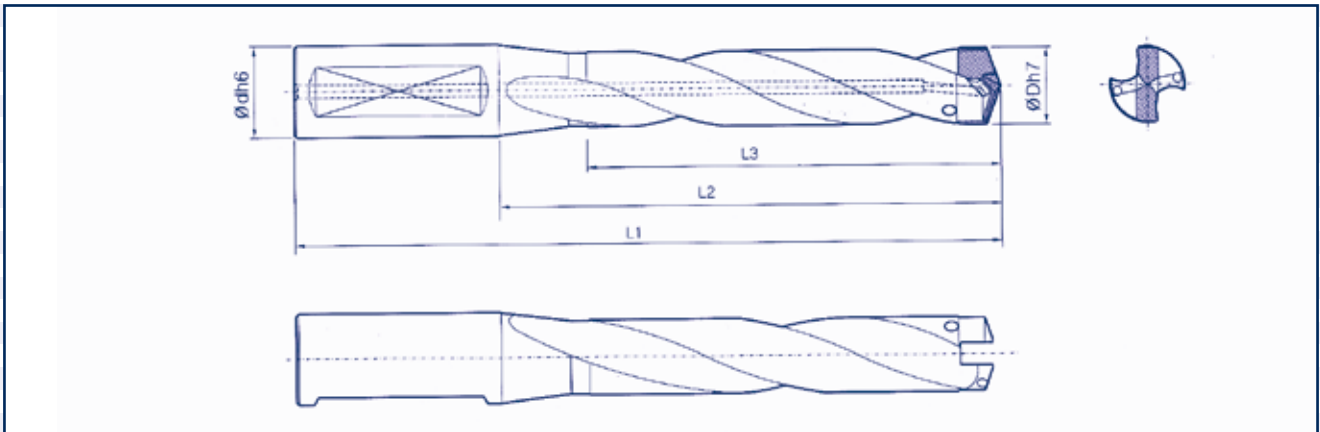
The cutting edge area of Carbide Inserts (ID) is made of high quality Micrograin Carbide to resist wear.

The drill body and shank consists of wear resistant tool steel and can be reused for an extremely long time.

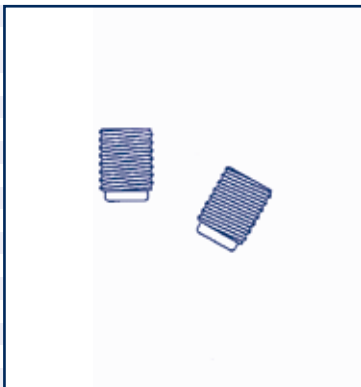
When Carbide insert is worn, new insert (ID) can easily be replaced.

Internal coolant supply improves chip flow and minimizes cutting heat.

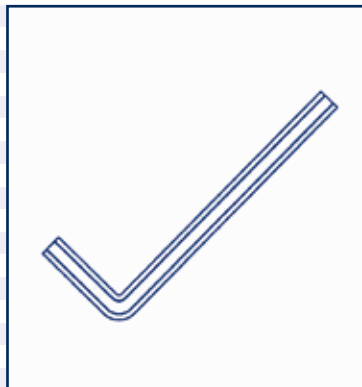
Flatted Shank, Whistle - Notch shank (2°) available on request.



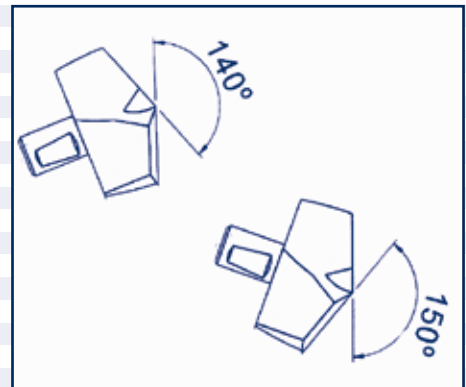
Set Screw Bolts



Allen Hex Key



Insert Drill (ID)



Non Ferrous (On request)

Point Angle: 140°

150° available on request

Micro Grain Carbide

Steel

Point Angle: 140°

150° available on request

Micro Grain Carbide

Combi-Yes Drills



Drill depth 3x Dia

Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 080T	10	80	35	24	ID08.0	ID08.1	ID08.2	ID08.3	ID08.4	M2.5	1.3
YTDI 085T	↓	82	37	26	ID08.5	ID08.6	ID08.7	ID08.8	ID08.9	↓	↓
YTDI 090T	↓	85	40	27	ID09.0	ID09.1	ID09.2	ID09.3	ID09.4	↓	↓
YTDI 095T	12	95	47	37	ID09.5	ID09.6	ID09.7	ID09.8	ID09.9	↓	↓
YTDI 100T	↓	↓	↓	↓	ID10.0	ID10.1	ID10.2	ID10.3	ID10.4	↓	↓
YTDI 105T	↓	100	52	42	ID10.5	ID10.6	ID10.7	ID10.8	ID10.9	↓	↓
YTDI 110T	↓	↓	↓	↓	ID11.0	ID11.1	ID11.2	ID11.3	ID11.4	↓	↓
YTDI 115T	↓	105	57	47	ID11.5	ID11.6	ID11.7	ID11.8	ID11.9	↓	↓
YTDI 120T	16	↓	↓	↓	ID12.0	ID12.1	ID12.2	ID12.3	ID12.4	M3	1.5
YTDI 125T	↓	110	62	45	ID12.5	ID12.6	ID12.7	ID12.8	ID12.9	↓	↓
YTDI 130T	↓	↓	↓	↓	ID13.0	ID13.1	ID13.2	ID13.3	ID13.4	↓	↓
YTDI 135T	↓	115	67	50	ID13.5	ID13.6	ID13.7	ID13.8	ID13.9	↓	↓
YTDI 140T	↓	↓	↓	↓	ID14.0	ID14.1	ID14.2	ID14.3	ID14.4	↓	↓
YTDI 145T	20	125	75	53	ID14.5	ID14.6	ID14.7	ID14.8	ID14.9	↓	↓
YTDI 150T	↓	↓	↓	↓	ID15.0	ID15.1	ID15.2	ID15.3	ID15.4	↓	↓
YTDI 155T	↓	↓	↓	↓	ID15.5	ID15.6	ID15.7	ID15.8	ID15.9	↓	↓
YTDI 160T	↓	130	80	55	ID16.0	ID16.1	ID16.2	ID16.3	ID16.4	↓	↓
YTDI 165T	↓	↓	↓	↓	ID16.5	ID16.6	ID16.7	ID16.8	ID16.9	↓	↓
YTDI 170T	↓	↓	↓	↓	ID17.0	ID17.1	ID17.2	ID17.3	ID17.4	↓	↓
YTDI 175T	↓	↓	↓	↓	ID17.5	ID17.6	ID17.7	ID17.8	ID17.9	↓	↓
YTDI 180T	↓	140	90	63	ID18.0	ID18.1	ID18.2	ID18.3	ID18.4	↓	↓
YTDI 185T	↓	↓	↓	↓	ID18.5	ID18.6	ID18.7	ID18.8	ID18.9	↓	↓
YTDI 190T	↓	↓	↓	↓	ID19.0	ID19.1	ID19.2	ID19.3	ID19.4	↓	↓
YTDI 195T	↓	↓	↓	↓	ID19.5	ID19.6	ID19.7	ID19.8	ID19.9	↓	↓
YTDI 200T	25	150	94	69	ID20.0	ID20.1	ID20.2	ID20.3	ID20.4	M4	2.0
YTDI 205T	↓	↓	↓	↓	ID20.5	ID20.6	ID20.7	ID20.8	ID20.9	↓	↓
YTDI 210T	↓	↓	↓	↓	ID21.0	ID21.1	ID21.2	ID21.3	ID21.4	↓	↓
YTDI 215T	↓	↓	↓	↓	ID21.5	ID21.6	ID21.7	ID21.8	ID21.9	↓	↓
YTDI 220T	↓	160	104	75	ID22.0	ID22.1	ID22.2	ID22.3	ID22.4	↓	↓
YTDI 225T	↓	↓	↓	↓	ID22.5	ID22.6	ID22.7	ID22.8	ID22.9	↓	↓
YTDI 230T	↓	↓	↓	↓	ID23.0	ID23.1	ID23.2	ID23.3	ID23.4	↓	↓
YTDI 235T	↓	↓	↓	↓	ID23.5	ID23.6	ID23.7	ID23.8	ID23.9	↓	↓
YTDI 240T	32	170	110	83	ID24.0	ID24.1	ID24.2	ID24.3	ID24.4	↓	↓
YTDI 245T	↓	↓	↓	↓	ID24.5	ID24.6	ID24.7	ID24.8	ID24.9	↓	↓
YTDI 250T	↓	↓	↓	↓	ID25.0	ID25.1	ID25.2	ID25.3	ID25.4	↓	↓
YTDI 255T	↓	↓	↓	↓	ID25.5	ID25.6	ID25.7	ID25.8	ID25.9	↓	↓
YTDI 260T	↓	180	120	90	ID26.0	ID26.1	ID26.2	ID26.3	ID26.4	↓	↓
YTDI 265T	↓	↓	↓	↓	ID26.5	ID26.6	ID26.7	ID26.8	ID26.9	↓	↓
YTDI 270T	↓	↓	↓	↓	ID27.0	ID27.1	ID27.2	ID27.3	ID27.4	↓	↓
YTDI 275T	↓	↓	↓	↓	ID27.5	ID27.6	ID27.7	ID27.8	ID27.9	↓	↓
YTDI 280T	↓	190	130	97	ID28.0	ID28.1	ID28.2	ID28.3	ID28.4	M5	2.5
YTDI 285T	↓	↓	↓	↓	ID28.5	ID28.6	ID28.7	ID28.8	ID28.9	↓	↓
YTDI 290T	↓	↓	↓	↓	ID29.0	ID29.1	ID29.2	ID29.3	ID29.4	↓	↓

Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 295T	32	190	130	97	ID29.5	ID29.6	ID29.7	ID29.8	ID29.9	M5	2.5
YTDI 300T		200	140	105	ID30.0	ID30.1	ID30.2	ID30.3	ID30.4		
YTDI 305T					ID30.5	ID30.6	ID30.7	ID30.8	ID30.9		
YTDI 310T					ID31.0	ID31.1	ID31.2	ID31.3	ID31.4		
YTDI 315T					ID31.5	ID31.6	ID31.7	ID31.8	ID31.9		
YTDI 320T		210	150	110	ID32.0	ID32.1	ID32.2	ID32.3	ID32.4	M6	3.0
YTDI 325T					ID32.5	ID32.6	ID32.7	ID32.8	ID32.9		
YTDI 330T					ID33.0	ID33.1	ID33.2	ID33.3	ID33.4		
YTDI 335T					ID33.5	ID33.6	ID33.7	ID33.8	ID33.9		
YTDI 340T	40	230	160	118	ID34.0	ID34.1	ID34.2	ID34.3	ID34.4		
YTDI 345T					ID34.5	ID34.6	ID34.7	ID34.8	ID34.9		
YTDI 350T					ID35.0	ID35.1	ID35.2	ID35.3	ID35.4		
YTDI 355T					ID35.5	ID35.6	ID35.7	ID35.8	ID35.9		
YTDI 360T		250	180	125	ID36.0	ID36.1	ID36.2	ID36.3	ID36.4	M6	3.0
YTDI 365T					ID36.5	ID36.6	ID36.7	ID36.8	ID36.9		
YTDI 370T					ID37.0	ID37.1	ID37.2	ID37.3	ID37.4		
YTDI 375T					ID37.5	ID37.6	ID37.7	ID37.8	ID37.9		
YTDI 380T				132	ID38.0	ID38.1	ID38.2	ID38.3	ID38.4		
YTDI 385T					ID38.5	ID38.6	ID38.7	ID38.8	ID38.9		
YTDI 390T					ID39.0	ID39.1	ID39.2	ID39.3	ID39.4		
YTDI 395T					ID39.5	ID39.6	ID39.7	ID39.8	ID39.9		
YTDI 400T		270	200	138	ID40.0	ID40.1	ID40.2	ID40.3	ID40.4	M8	4.0
YTDI 405T					ID40.5	ID40.6	ID40.7	ID40.8	ID40.9		
YTDI 410T					ID41.0	ID41.1	ID41.2	ID41.3	ID41.4		
YTDI 415T					ID41.5	ID41.6	ID41.7	ID41.8	ID41.9		
YTDI 420T				145	ID42.0	ID42.1	ID42.2	ID42.3	ID42.4		
YTDI 425T					ID42.5	ID42.6	ID42.7	ID42.8	ID42.9		
YTDI 430T					ID43.0	ID43.1	ID43.2	ID43.3	ID43.4		
YTDI 435T					ID43.5	ID43.6	ID43.7	ID43.8	ID43.9		
YTDI 440T		280	210	153	ID44.0	ID44.1	ID44.2	ID44.3	ID44.4		
YTDI 445T					ID44.5	ID44.6	ID44.7	ID44.8	ID44.9		
YTDI 450T					ID45.0	ID45.1	ID45.2	ID45.3	ID45.4		
YTDI 455T					ID45.5	ID45.6	ID45.7	ID45.8	ID45.9		
YTDI 460T				160	ID46.0	ID46.1	ID46.2	ID46.3	ID46.4	M8	4.0
YTDI 465T					ID46.5	ID46.6	ID46.7	ID46.8	ID46.9		
YTDI 470T					ID47.0	ID47.1	ID47.2	ID47.3	ID47.4		
YTDI 475T					ID47.5	ID47.6	ID47.7	ID47.8	ID47.9		
YTDI 480T		300	230	167	ID48.0	ID48.1	ID48.2	ID48.3	ID48.4		
YTDI 485T					ID48.5	ID48.6	ID48.7	ID48.8	ID48.9		
YTDI 490T					ID49.0	ID49.1	ID49.2	ID49.3	ID49.4		
YTDI 495T					ID49.5	ID49.6	ID49.7	ID49.8	ID49.9		
YTDI 500T					ID50.0	ID50.1	ID50.2	ID50.3	ID50.4		

Combi-Yes Drills


Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 080P	10	96	51	40	ID08.0	ID08.1	ID08.2	ID08.3	ID08.4	M2.5	1.3
YTDI 085P	↓	100	55	45	ID08.5	ID08.6	ID08.7	ID08.8	ID08.9	↓	↓
YTDI 090P	↓	105	60	47	ID09.0	ID09.1	ID09.2	ID09.3	ID09.4	↓	↓
YTDI 095P	12	115	67	57	ID09.5	ID09.6	ID09.7	ID09.8	ID09.9	↓	↓
YTDI 100P	↓	↓	↓	↓	ID10.0	ID10.1	ID10.2	ID10.3	ID10.4	↓	↓
YTDI 105P	↓	125	77	67	ID10.5	ID10.6	ID10.7	ID10.8	ID10.9	↓	↓
YTDI 110P	↓	↓	↓	↓	ID11.0	ID11.1	ID11.2	ID11.3	ID11.4	↓	↓
YTDI 115P	↓	130	82	72	ID11.5	ID11.6	ID11.7	ID11.8	ID11.9	↓	↓
YTDI 120P	16	↓	↓	↓	ID12.0	ID12.1	ID12.2	ID12.3	ID12.4	M3	1.5
YTDI 125P	↓	140	92	75	ID12.5	ID12.6	ID12.7	ID12.8	ID12.9	↓	↓
YTDI 130P	↓	↓	↓	↓	ID13.0	ID13.1	ID13.2	ID13.3	ID13.4	↓	↓
YTDI 135P	↓	145	97	80	ID13.5	ID13.6	ID13.7	ID13.8	ID13.9	↓	↓
YTDI 140P	↓	↓	↓	↓	ID14.0	ID14.1	ID14.2	ID14.3	ID14.4	↓	↓
YTDI 145P	20	148	98	83	ID14.5	ID14.6	ID14.7	ID14.8	ID14.9	↓	↓
YTDI 150P	↓	↓	↓	↓	ID15.0	ID15.1	ID15.2	ID15.3	ID15.4	↓	↓
YTDI 155P	↓	↓	↓	↓	ID15.5	ID15.6	ID15.7	ID15.8	ID15.9	↓	↓
YTDI 160P	↓	150	100	89	ID16.0	ID16.1	ID16.2	ID16.3	ID16.4	↓	↓
YTDI 165P	↓	↓	↓	↓	ID16.5	ID16.6	ID16.7	ID16.8	ID16.9	↓	↓
YTDI 170P	↓	↓	↓	↓	ID17.0	ID17.1	ID17.2	ID17.3	ID17.4	↓	↓
YTDI 175P	↓	↓	↓	↓	ID17.5	ID17.6	ID17.7	ID17.8	ID17.9	↓	↓
YTDI 180P	↓	170	120	100	ID18.0	ID18.1	ID18.2	ID18.3	ID18.4	↓	↓
YTDI 185P	↓	↓	↓	↓	ID18.5	ID18.6	ID18.7	ID18.8	ID18.9	↓	↓
YTDI 190P	↓	↓	↓	↓	ID19.0	ID19.1	ID19.2	ID19.3	ID19.4	↓	↓
YTDI 195P	↓	↓	↓	↓	ID19.5	ID19.6	ID19.7	ID19.8	ID19.9	↓	↓
YTDI 200P	25	190	134	110	ID20.0	ID20.1	ID20.2	ID20.3	ID20.4	M4	2.0
YTDI 205P	↓	↓	↓	↓	ID20.5	ID20.6	ID20.7	ID20.8	ID20.9	↓	↓
YTDI 210P	↓	↓	↓	↓	ID21.0	ID21.1	ID21.2	ID21.3	ID21.4	↓	↓
YTDI 215P	↓	↓	↓	↓	ID21.5	ID21.6	ID21.7	ID21.8	ID21.9	↓	↓
YTDI 220P	↓	200	144	121	ID22.0	ID22.1	ID22.2	ID22.3	ID22.4	↓	↓
YTDI 225P	↓	↓	↓	↓	ID22.5	ID22.6	ID22.7	ID22.8	ID22.9	↓	↓
YTDI 230P	↓	↓	↓	↓	ID23.0	ID23.1	ID23.2	ID23.3	ID23.4	↓	↓
YTDI 235P	↓	↓	↓	↓	ID23.5	ID23.6	ID23.7	ID23.8	ID23.9	↓	↓
YTDI 240P	32	220	160	133	ID24.0	ID24.1	ID24.2	ID24.3	ID24.4	↓	↓
YTDI 245P	↓	↓	↓	↓	ID24.5	ID24.6	ID24.7	ID24.8	ID24.9	↓	↓
YTDI 250P	↓	↓	↓	↓	ID25.0	ID25.1	ID25.2	ID25.3	ID25.4	↓	↓
YTDI 255P	↓	↓	↓	↓	ID25.5	ID25.6	ID25.7	ID25.8	ID25.9	↓	↓
YTDI 260P	↓	240	180	144	ID26.0	ID26.1	ID26.2	ID26.3	ID26.4	↓	↓
YTDI 265P	↓	↓	↓	↓	ID26.5	ID26.6	ID26.7	ID26.8	ID26.9	↓	↓
YTDI 270P	↓	↓	↓	↓	ID27.0	ID27.1	ID27.2	ID27.3	ID27.4	↓	↓
YTDI 275P	↓	↓	↓	↓	ID27.5	ID27.6	ID27.7	ID27.8	ID27.9	↓	↓
YTDI 280P	↓	250	190	155	ID28.0	ID28.1	ID28.2	ID28.3	ID28.4	M5	2.5
YTDI 285P	↓	↓	↓	↓	ID28.5	ID28.6	ID28.7	ID28.8	ID28.9	↓	↓
YTDI 290P	↓	↓	↓	↓	ID29.0	ID29.1	ID29.2	ID29.3	ID29.4	↓	↓

Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 295P	32	250	190	155	ID29.5	ID29.6	ID29.7	ID29.8	ID29.9	M5	2.5
YTDI 300P		260	200	165	ID30.0	ID30.1	ID30.2	ID30.3	ID30.4		
YTDI 305P					ID30.5	ID30.6	ID30.7	ID30.8	ID30.9		
YTDI 310P					ID31.0	ID31.1	ID31.2	ID31.3	ID31.4		
YTDI 315P					ID31.5	ID31.6	ID31.7	ID31.8	ID31.9		
YTDI 320P		270	210	177	ID32.0	ID32.1	ID32.2	ID32.3	ID32.4	M6	3.0
YTDI 325P					ID32.5	ID32.6	ID32.7	ID32.8	ID32.9		
YTDI 330P					ID33.0	ID33.1	ID33.2	ID33.3	ID33.4		
YTDI 335P					ID33.5	ID33.6	ID33.7	ID33.8	ID33.9		
YTDI 340P	40	300	230	188	ID34.0	ID34.1	ID34.2	ID34.3	ID34.4		
YTDI 345P					ID34.5	ID34.6	ID34.7	ID34.8	ID34.9		
YTDI 350P					ID35.0	ID35.1	ID35.2	ID35.3	ID35.4		
YTDI 355P					ID35.5	ID35.6	ID35.7	ID35.8	ID35.9		
YTDI 360P		310	240	199	ID36.0	ID36.1	ID36.2	ID36.3	ID36.4	M6	3.0
YTDI 365P					ID36.5	ID36.6	ID36.7	ID36.8	ID36.9		
YTDI 370P					ID37.0	ID37.1	ID37.2	ID37.3	ID37.4		
YTDI 375P					ID37.5	ID37.6	ID37.7	ID37.8	ID37.9		
YTDI 380P		320	250	210	ID38.0	ID38.1	ID38.2	ID38.3	ID38.4		
YTDI 385P					ID38.5	ID38.6	ID38.7	ID38.8	ID38.9		
YTDI 390P					ID39.0	ID39.1	ID39.2	ID39.3	ID39.4		
YTDI 395P					ID39.5	ID39.6	ID39.7	ID39.8	ID39.9		
YTDI 400P		340	270	221	ID40.0	ID40.1	ID40.2	ID40.3	ID40.4	M8	4.0
YTDI 405P					ID40.5	ID40.6	ID40.7	ID40.8	ID40.9		
YTDI 410P					ID41.0	ID41.1	ID41.2	ID41.3	ID41.4		
YTDI 415P					ID41.5	ID41.6	ID41.7	ID41.8	ID41.9		
YTDI 420P				232	ID42.0	ID42.1	ID42.2	ID42.3	ID42.4		
YTDI 425P					ID42.5	ID42.6	ID42.7	ID42.8	ID42.9		
YTDI 430P					ID43.0	ID43.1	ID43.2	ID43.3	ID43.4		
YTDI 435P					ID43.5	ID43.6	ID43.7	ID43.8	ID43.9		
YTDI 440P		370	300	243	ID44.0	ID44.1	ID44.2	ID44.3	ID44.4		
YTDI 445P					ID44.5	ID44.6	ID44.7	ID44.8	ID44.9		
YTDI 450P					ID45.0	ID45.1	ID45.2	ID45.3	ID45.4		
YTDI 455P					ID45.5	ID45.6	ID45.7	ID45.8	ID45.9		
YTDI 460P				255	ID46.0	ID46.1	ID46.2	ID46.3	ID46.4		
YTDI 465P					ID46.5	ID46.6	ID46.7	ID46.8	ID46.9		
YTDI 470P					ID47.0	ID47.1	ID47.2	ID47.3	ID47.4		
YTDI 475P					ID47.5	ID47.6	ID47.7	ID47.8	ID47.9		
YTDI 480P		390	320	265	ID48.0	ID48.1	ID48.2	ID48.3	ID48.4		
YTDI 485P					ID48.5	ID48.6	ID48.7	ID48.8	ID48.9		
YTDI 490P					ID49.0	ID49.1	ID49.2	ID49.3	ID49.4		
YTDI 495P					ID49.5	ID49.6	ID49.7	ID49.8	ID49.9		
YTDI 500P					ID50.0	ID50.1	ID50.2	ID50.3	ID50.4		

Combi-Yes Drills



Drill depth 7x Dia

Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 080H	10	117	72	56	ID08.0	ID08.1	ID08.2	ID08.3	ID08.4	M2.5	1.3
YTDI 085H	↓	122	77	60	ID08.5	ID08.6	ID08.7	ID08.8	ID08.9	↓	↓
YTDI 090H	↓	126	81	67	ID09.0	ID09.1	ID09.2	ID09.3	ID09.4	↓	↓
YTDI 095H	12	140	92	77	ID09.5	ID09.6	ID09.7	ID09.8	ID09.9	↓	↓
YTDI 100H	↓	↓	↓	↓	ID10.0	ID10.1	ID10.2	ID10.3	ID10.4	↓	↓
YTDI 105H	↓	150	102	87	ID10.5	ID10.6	ID10.7	ID10.8	ID10.9	↓	↓
YTDI 110H	↓	↓	↓	↓	ID11.0	ID11.1	ID11.2	ID11.3	ID11.4	↓	↓
YTDI 115H	↓	160	112	97	ID11.5	ID11.6	ID11.7	ID11.8	ID11.9	↓	↓
YTDI 120H	16	↓	↓	↓	ID12.0	ID12.1	ID12.2	ID12.3	ID12.4	M3	1.5
YTDI 125H	↓	175	127	100	ID12.5	ID12.6	ID12.7	ID12.8	ID12.9	↓	↓
YTDI 130H	↓	↓	↓	↓	ID13.0	ID13.1	ID13.2	ID13.3	ID13.4	↓	↓
YTDI 135H	↓	180	132	105	ID13.5	ID13.6	ID13.7	ID13.8	ID13.9	↓	↓
YTDI 140H	↓	↓	↓	↓	ID14.0	ID14.1	ID14.2	ID14.3	ID14.4	↓	↓
YTDI 145H	20	185	135	115	ID14.5	ID14.6	ID14.7	ID14.8	ID14.9	↓	↓
YTDI 150H	↓	↓	↓	↓	ID15.0	ID15.1	ID15.2	ID15.3	ID15.4	↓	↓
YTDI 155H	↓	↓	↓	↓	ID15.5	ID15.6	ID15.7	ID15.8	ID15.9	↓	↓
YTDI 160H	↓	190	140	123	ID16.0	ID16.1	ID16.2	ID16.3	ID16.4	↓	↓
YTDI 165H	↓	↓	↓	↓	ID16.5	ID16.6	ID16.7	ID16.8	ID16.9	↓	↓
YTDI 170H	↓	↓	↓	↓	ID17.0	ID17.1	ID17.2	ID17.3	ID17.4	↓	↓
YTDI 175H	↓	↓	↓	↓	ID17.5	ID17.6	ID17.7	ID17.8	ID17.9	↓	↓
YTDI 180H	↓	210	160	138	ID18.0	ID18.1	ID18.2	ID18.3	ID18.4	↓	↓
YTDI 185H	↓	↓	↓	↓	ID18.5	ID18.6	ID18.7	ID18.8	ID18.9	↓	↓
YTDI 190H	↓	↓	↓	↓	ID19.0	ID19.1	ID19.2	ID19.3	ID19.4	↓	↓
YTDI 195H	↓	↓	↓	↓	ID19.5	ID19.6	ID19.7	ID19.8	ID19.9	↓	↓
YTDI 200H	25	230	174	153	ID20.0	ID20.1	ID20.2	ID20.3	ID20.4	M4	2.0
YTDI 205H	↓	↓	↓	↓	ID20.5	ID20.6	ID20.7	ID20.8	ID20.9	↓	↓
YTDI 210H	↓	↓	↓	↓	ID21.0	ID21.1	ID21.2	ID21.3	ID21.4	↓	↓
YTDI 215H	↓	↓	↓	↓	ID21.5	ID21.6	ID21.7	ID21.8	ID21.9	↓	↓
YTDI 220H	↓	240	184	168	ID22.0	ID22.1	ID22.2	ID22.3	ID22.4	↓	↓
YTDI 225H	↓	↓	↓	↓	ID22.5	ID22.6	ID22.7	ID22.8	ID22.9	↓	↓
YTDI 230H	↓	↓	↓	↓	ID23.0	ID23.1	ID23.2	ID23.3	ID23.4	↓	↓
YTDI 235H	↓	↓	↓	↓	ID23.5	ID23.6	ID23.7	ID23.8	ID23.9	↓	↓
YTDI 240H	32	270	210	183	ID24.0	ID24.1	ID24.2	ID24.3	ID24.4	↓	↓
YTDI 245H	↓	↓	↓	↓	ID24.5	ID24.6	ID24.7	ID24.8	ID24.9	↓	↓
YTDI 250H	↓	↓	↓	↓	ID25.0	ID25.1	ID25.2	ID25.3	ID25.4	↓	↓
YTDI 255H	↓	↓	↓	↓	ID25.5	ID25.6	ID25.7	ID25.8	ID25.9	↓	↓
YTDI 260H	↓	290	230	198	ID26.0	ID26.1	ID26.2	ID26.3	ID26.4	↓	↓
YTDI 265H	↓	↓	↓	↓	ID26.5	ID26.6	ID26.7	ID26.8	ID26.9	↓	↓
YTDI 270H	↓	↓	↓	↓	ID27.0	ID27.1	ID27.2	ID27.3	ID27.4	↓	↓
YTDI 275H	↓	↓	↓	↓	ID27.5	ID27.6	ID27.7	ID27.8	ID27.9	↓	↓
YTDI 280H	↓	300	240	213	ID28.0	ID28.1	ID28.2	ID28.3	ID28.4	M5	2.5
YTDI 285H	↓	↓	↓	↓	ID28.5	ID28.6	ID28.7	ID28.8	ID28.9	↓	↓
YTDI 290H	↓	↓	↓	↓	ID29.0	ID29.1	ID29.2	ID29.3	ID29.4	↓	↓

Drill depth 7x Dia



Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)
YTDI 295H	32	300	240	213	ID29.5	ID29.6	ID29.7	ID29.8	ID29.9	M5	2.5
YTDI 300H		320	260	228	ID30.0	ID30.1	ID30.2	ID30.3	ID30.4		
YTDI 305H					ID30.5	ID30.6	ID30.7	ID30.8	ID30.9		
YTDI 310H					ID31.0	ID31.1	ID31.2	ID31.3	ID31.4		
YTDI 315H					ID31.5	ID31.6	ID31.7	ID31.8	ID31.9		
YTDI 320H		340	280	243	ID32.0	ID32.1	ID32.2	ID32.3	ID32.4	M6	3.0
YTDI 325H					ID32.5	ID32.6	ID32.7	ID32.8	ID32.9		
YTDI 330H					ID33.0	ID33.1	ID33.2	ID33.3	ID33.4		
YTDI 335H					ID33.5	ID33.6	ID33.7	ID33.8	ID33.9		
YTDI 340H	40	360	290	258	ID34.0	ID34.1	ID34.2	ID34.3	ID34.4		
YTDI 345H					ID34.5	ID34.6	ID34.7	ID34.8	ID34.9		
YTDI 350H					ID35.0	ID35.1	ID35.2	ID35.3	ID35.4		
YTDI 355H					ID35.5	ID35.6	ID35.7	ID35.8	ID35.9		
YTDI 360H		380	310	273	ID36.0	ID36.1	ID36.2	ID36.3	ID36.4	M6	3.0
YTDI 365H					ID36.5	ID36.6	ID36.7	ID36.8	ID36.9		
YTDI 370H					ID37.0	ID37.1	ID37.2	ID37.3	ID37.4		
YTDI 375H					ID37.5	ID37.6	ID37.7	ID37.8	ID37.9		
YTDI 380H		400	330	288	ID38.0	ID38.1	ID38.2	ID38.3	ID38.4		
YTDI 385H					ID38.5	ID38.6	ID38.7	ID38.8	ID38.9		
YTDI 390H					ID39.0	ID39.1	ID39.2	ID39.3	ID39.4		
YTDI 395H					ID39.5	ID39.6	ID39.7	ID39.8	ID39.9		
YTDI 400H		420	350	303	ID40.0	ID40.1	ID40.2	ID40.3	ID40.4	M8	4.0
YTDI 405H					ID40.5	ID40.6	ID40.7	ID40.8	ID40.9		
YTDI 410H					ID41.0	ID41.1	ID41.2	ID41.3	ID41.4		
YTDI 415H					ID41.5	ID41.6	ID41.7	ID41.8	ID41.9		
YTDI 420H				318	ID42.0	ID42.1	ID42.2	ID42.3	ID42.4		
YTDI 425H					ID42.5	ID42.6	ID42.7	ID42.8	ID42.9		
YTDI 430H					ID43.0	ID43.1	ID43.2	ID43.3	ID43.4		
YTDI 435H					ID43.5	ID43.6	ID43.7	ID43.8	ID43.9		
YTDI 440H		460	390	333	ID44.0	ID44.1	ID44.2	ID44.3	ID44.4		
YTDI 445H					ID44.5	ID44.6	ID44.7	ID44.8	ID44.9		
YTDI 450H					ID45.0	ID45.1	ID45.2	ID45.3	ID45.4		
YTDI 455H					ID45.5	ID45.6	ID45.7	ID45.8	ID45.9		
YTDI 460H				348	ID46.0	ID46.1	ID46.2	ID46.3	ID46.4		
YTDI 465H					ID46.5	ID46.6	ID46.7	ID46.8	ID46.9		
YTDI 470H					ID47.0	ID47.1	ID47.2	ID47.3	ID47.4		
YTDI 475H					ID47.5	ID47.6	ID47.7	ID47.8	ID47.9		
YTDI 480H		490	420	363	ID48.0	ID48.1	ID48.2	ID48.3	ID48.4		
YTDI 485H					ID48.5	ID48.6	ID48.7	ID48.8	ID48.9		
YTDI 490H					ID49.0	ID49.1	ID49.2	ID49.3	ID49.4		
YTDI 495H					ID49.5	ID49.6	ID49.7	ID49.8	ID49.9		
YTDI 500H					ID50.0	ID50.1	ID50.2	ID50.3	ID50.4		

Combi-Yes Drills



Drill depth 2x Dia

Ordering code	Shank Dia(h6) d2	Overall Length L1	Flute Length L2	Cutting Length L3	Insert Drill Spec Diameter (d1 h7)					Bolt size	Allen key (mm)		
YTDI/NC 120	12	102	40	25	ID12.0	ID12.1	ID12.2	ID12.3	ID12.4	M3	1.5		
YTDI/NC 125	13	↓	43	27	ID12.5	ID12.6	ID12.7	ID12.8	ID12.9	↓	↓		
YTDI/NC 130	↓	↓	↓	↓	ID13.0	ID13.1	ID13.2	ID13.3	ID13.4				
YTDI/NC 135	14	107	46	29	ID13.5	ID13.6	ID13.7	ID13.8	ID13.9				
YTDI/NC 140	↓	↓	↓	↓	ID14.0	ID14.1	ID14.2	ID14.3	ID14.4				
YTDI/NC 145	15	111	49	31	ID14.5	ID14.6	ID14.7	ID14.8	ID14.9				
YTDI/NC 150	↓	↓	↓	↓	ID15.0	ID15.1	ID15.2	ID15.3	ID15.4				
YTDI/NC 155	16	115	52	33	ID15.5	ID15.6	ID15.7	ID15.8	ID15.9				
YTDI/NC 160	↓	↓	↓	↓	ID16.0	ID16.1	ID16.2	ID16.3	ID16.4				
YTDI/NC 165	17	119	56	35	ID16.5	ID16.6	ID16.7	ID16.8	ID16.9				
YTDI/NC 170	↓	↓	↓	↓	ID17.0	ID17.1	ID17.2	ID17.3	ID17.4				
YTDI/NC 175	18	123	59	37	ID17.5	ID17.6	ID17.7	ID17.8	ID17.9				
YTDI/NC 180	↓	↓	↓	↓	ID18.0	ID18.1	ID18.2	ID18.3	ID18.4				
YTDI/NC 185	19	127	62	39	ID18.5	ID18.6	ID18.7	ID18.8	ID18.9				
YTDI/NC 190	↓	↓	↓	↓	ID19.0	ID19.1	ID19.2	ID19.3	ID19.4				
YTDI/NC 195	20	131	65	41	ID19.5	ID19.6	ID19.7	ID19.8	ID19.9				
YTDI/NC 200	↓	↓	↓	↓	ID20.0	ID20.1	ID20.2	ID20.3	ID20.4			M4	2.0

NC = No Coolant





Recommended CUTTING DATA

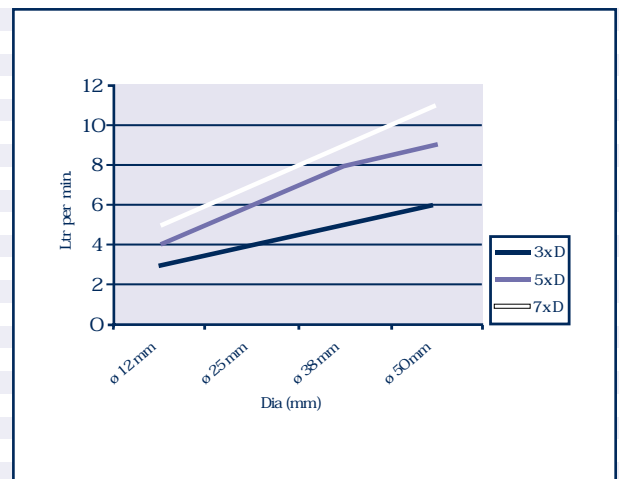
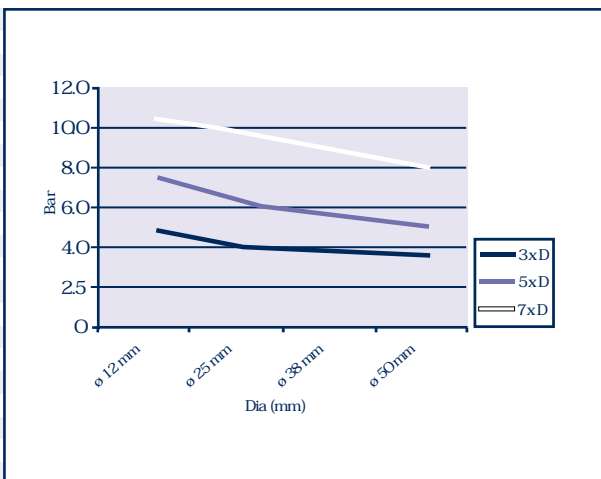
Drill Dia	8 - 16		16 - 25		25 - 32		32 - 40		40 - 50	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Material Group	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)
Grey cast iron	50 - 70	0.20 - 0.30	50 - 70	0.25 - 0.45	50 - 80	0.35 - 0.55	60 - 90	0.34 - 0.58	80 - 100	0.38 - 0.60
Nodular cast iron	40 - 65	0.15 - 0.25	40 - 65	0.22 - 0.45	45 - 75	0.32 - 0.52	50 - 80	0.35 - 0.62	70 - 100	0.38 - 0.60
Carbon steel	55 - 70	0.15 - 0.30	55 - 70	0.16 - 0.40	60 - 85	0.20 - 0.40	70 - 90	0.22 - 0.48	75 - 95	0.25 - 0.54
Alloy steel	50 - 75	0.15 - 0.30	50 - 75	0.15 - 0.40	55 - 80	0.18 - 0.40	60 - 90	0.25 - 0.47	65 - 95	0.27 - 0.52
Hardened	40 - 50	0.10 - 0.20	40 - 60	0.12 - 0.28	40 - 50	0.16 - 0.35	40 - 60	0.20 - 0.38	40 - 60	0.22 - 0.42
Stainless	30 - 40	0.10 - 0.20	35 - 50	0.10 - 0.22	35 - 50	0.15 - 0.28	40 - 55	0.18 - 0.30	40 - 55	0.22 - 0.32
Aluminium	80 - 100	0.20 - 0.30	80 - 100	0.25 - 0.40	90 - 100	0.30 - 0.45	90 - 100	0.30 - 0.45	90 - 120	0.30 - 0.50

These are indications only. It is recommended to use these values as a starting point until optimal results are obtained.

The data is recommended for 3 x Dia. The speed should be decreased 10 to 35% respectively for over 3xD

Internal Coolant Supply

Cutting Conditions (indications only)



Coolant Pressure (Bar) for YTDI drill

ø 12 mm ø 25 mm ø 38 mm ø 50 mm

Coolant Volume (Liter per min.) for YTDI drill

ø 12 mm ø 25 mm ø 38 mm ø 50 mm

	4.5	4.0	4.0	4.0
5 x D	7.5	6.0	5.5	5.0
7 x D	10.0	9.0	8.0	8.0

	3 x D	3	4	5	6
5 x D	5 x D	4	6	8	9
7 x D	7 x D	5	7	9	11

3 x D



COMBIDEX[®]

NL -3115 HE

