

# AUCES AUCDS

The Single-Ended  
Coated Center Drills

For performing highly accurate center hole drilling

▪ Single-Ended Coated Center Drills ▪

## AUCES AUCDS



## High helical fluted A type 60° Single-Ended Coated Center Drill

**AUCES** HSS Coating



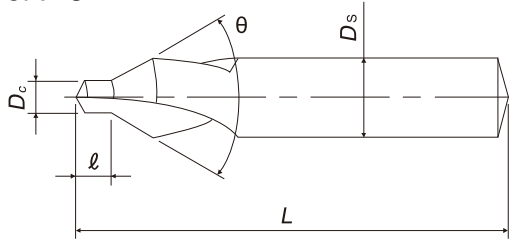
## Low helical fluted A type 60° Single-Ended Coated Center Drill

**AUCDS** HSS Coating

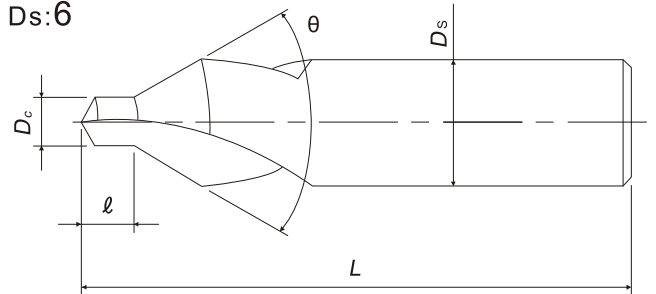


### Dimension and Sizes

Ds:1-5



Ds:6



### AUCES High helical fluted A type 60°

unit mm

size $D_c \times \theta \times D_s$	$D_c$	$D_s$	$L$	$l$	Product code	MSRP (JPY)
1x60°x4	1	4	35	1.1	YH61.00ZNEVD	1,610
1.5x60°x5	1.5	5	40	1.6	YH61.50ZNEVE	1,530
2x60°x6	2	6	45	2.1	YH62.00ZNEVF	1,670
2.5x60°x8	2.5	8	50	2.7	YH62.50ZNEVI	2,020
3x60°x8	3	8	50	3.2	YH63.00ZNEVI	2,020
4x60°x10	4	10	55	4.3	YH64.00ZNEVJ	2,960
5x60°x12	5	12	65	5.3	YH65.00ZNEVM	3,820
6x60°x16	6	16	70	6.4	YH66.00ZNEVP	8,910

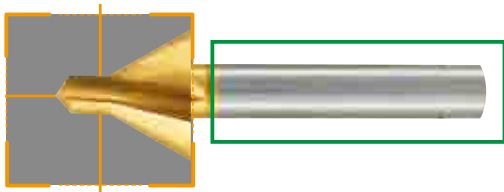
### AUCDS Low helical fluted A type 60°

unit mm

size $D_c \times \theta \times D_s$	$D_c$	$D_s$	$L$	$l$	Product code	MSRP (JPY)
1x60°x4	1	4	35	1.1	YL61.00ZNEVD	1,610
1.5x60°x5	1.5	5	40	1.6	YL61.50ZNEVE	1,530
2x60°x6	2	6	45	2.1	YL62.00ZNEVF	1,670
2.5x60°x8	2.5	8	50	2.7	YL62.50ZNEVI	2,020
3x60°x8	3	8	50	3.2	YL63.00ZNEVI	2,020
4x60°x10	4	10	55	4.3	YL64.00ZNEVJ	2,960
5x60°x12	5	12	65	5.3	YL65.00ZNEVM	3,820
6x60°x16	6	16	70	6.4	YL66.00ZNEVP	8,910

## Characteristics

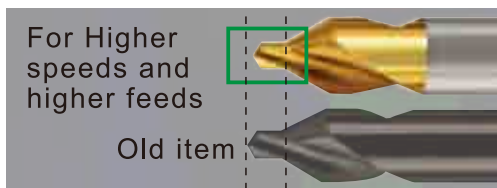
- Single-Ended Drills developed to offer higher accuracy in center hole drilling!
- Single-Ended Coated Center Drills provide excellent quality and stable processing of center holes.
- Compared to the Double-Ended Drills, Single-Ended Drills can be easily installed and result in stable drilling!



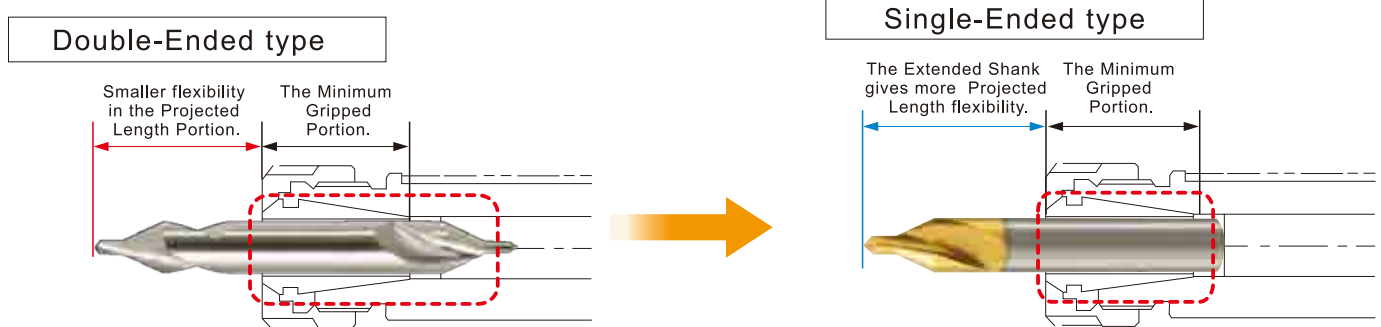
The Single-Ended Drills cutting edge and shank accuracy were improved when compared to Double-Edge Drills.



The shank marking position has been moved to the rear of the drill to ensure the collet or holder does not grip on the uneven surface of the markings.



High speed and high feed drilling is now possible from the shorter drill length.



## Process Data

Product	AUCES, Single-Ended Coated Center Drills	CE-S, Double-Ended Coated Center Drills
Size	$\Phi 3 \times 60^\circ \times 8$	
Workpiece material	S50C (96-98HRB)	
Drilling Speed	10m/min	30m/min
Feed	0.05mm/rev	0.12mm/rev
Large End Diameter	$\Phi 6\text{mm}$	
Drilling Speed	6mm	6.5mm
Drilling Fluid	Water Soluble FX30 Chlorine Free(emulsion x 20)	
Machine	Machining Center Vertical Type	

Conditions	AUCES	CE-S
S50C Cutting Speed:10m/min Feed:0.05mm/rev		
S50C Cutting Speed:30m/min Feed:0.12mm/rev		

Size	$\Phi 1 \times 60^\circ \times 4$
Workpiece material	S50C
Drilling Length	30m/min
Feed	0.04mm/rev
Large End Diameter	$\Phi 3$
Machine	Machining Center Vertical Type
Drilling Fluid	Water Soluble Oil (emulsion x20)



## Associated Product

### SHANK EXTENSION

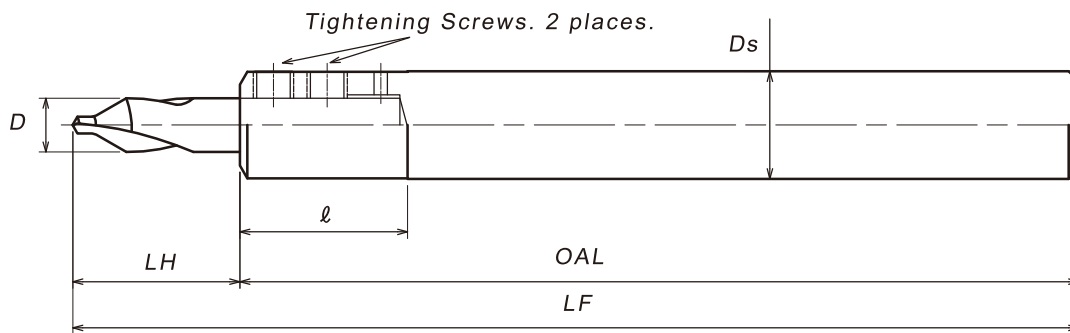


## Characteristics

- Shank Extensions equipped with the Single-Ended Coated Center Drill AUCES, AUCDS, AUPES and AUPEQ now make long shank processing achievable.
- Shank diameters of  $D_s$ :16 •  $D_s$ :20 available for the general tooling.

## Dimension and Sizes

- Total Overall Length LF:150mm for the Single-Ended Coated Center Drill AUCES, AUCES, AUPES and AUPEQ.



### SHANK EXTENSION

unit mm

size $D \times D_s \times LF$	$D$	$D_s$	OAL	LF	LH	$l$	Product code	MSRP (JPY)
SHANK EXTENSION D06 DS16 LF-150	6	16	128	150	22	23	SE0616M	11,900
SHANK EXTENSION D08 DS16 LF-150	8	16	125	150	25	25	SE0816M	11,900
SHANK EXTENSION D10 DS20 LF-150	10	20	123	150	27	28	SE1020M	13,300

## Cautions

- Insert a Center Drill or a Point Drill deep into the Shank Extension until the shank is under the two set screws. In order to prevent misalignment, alternatively tighten the 2 set screws for a balanced fastening.

### Warning

- ◆ Tools may shatter. Wear cover or eye glasses to avoid injury during tapping.
- ◆ Tools may shatter. Use tools under the proper tapping condition.
- ◆ Never wear gloves during turning operations as the gloves may get caught with the tools.
- ◆ Wear safety shoes to avoid injuring yourself by the falling tools.
- ◆ On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ◆ Fasten the work pieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆ Take a special care to fire trouble. High temperature during machining may cause fire.

Please note that specification may change without advance notice.

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