

| Drill dia. | Shank dia. | Overall length | Drill length | Workpiece end-face Hole size |
|------------|------------|----------------|--------------|------------------------------|
| Dc | Ds | L | ℓ | Dw |

JIS

① Spiral Fluted Taps (for blind hole)

② Spiral Fluted Taps (for through hole)

③ Spiral Pointed Taps (for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps (Simple inspection tools)

⑧ Pipe Taps

⑨ Thread Mills (Premium Thread Mills)

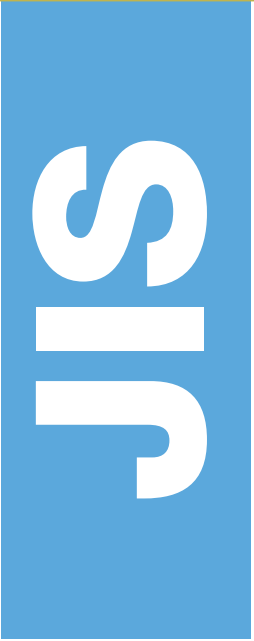
⑩ Dies

⑪ Center Drills / Centering Tools

⑫ Precision Machinery / Medical Surgical Instruments

JIS

⑪-23



C-CD-Q

Low Helix Carbide Center Drills-Type A 90°



Specification



Low helix center drills - Type A center drill for machining 90° center hole. Suitable for hard materials and mass production.

Cutting Speed depending on Materials

High carbon steels
高炭素鋼
30~50
(m/min)

Alloy steels
合金鋼
20~40
(m/min)

Thermal refined steels
調質鋼
10~25
(m/min)
25~35HRC

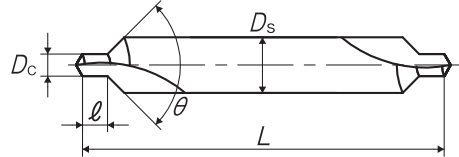
Thermal refined steels
調質鋼
5~15
(m/min)
35~45HRC

Cast irons
鑄鉄
30~50
(m/min)

Brass castings
黄銅鑄物
30~60
(m/min)

Aluminum alloy castings
アルミ合金鑄物
30~60
(m/min)

TYPE: 1



Segment : 52

| Size Dc × θ × Ds | Code | Dc (mm) | Ds (mm) | L (mm) | ℓ (mm) | Dw (mm) | TYPE | MSRP |
|---------------------|-----------|------------|------------|-----------|-----------|------------|------|------------|
| 1 × 90° × 4 | CC1.0Q | 1 | 4 | 35 | 1 | 3 | 1 | ¥ 14,400* |
| 1.5 × 90° × 5 | CC1.5Q | 1.5 | 5 | 40 | 1.5 | 4 | 1 | ¥ 18,200* |
| 2 × 90° × 6 | CC2.0Q | 2 | 6 | 45 | 2 | 5 | 1 | ¥ 22,200* |
| 2.5 × 90° × 7.7 | CC2.5Q | 2.5 | 7.7 | 50 | 2.5 | 6.5 | 1 | ¥ 28,600* |
| 2.5 × 90° × 8 | CC2.5Q-8 | 2.5 | 8 | 50 | 2.5 | 6.5 | 1 | ¥ 29,700* |
| 3 × 90° × 7.7 | CC3.0Q | 3 | 7.7 | 55 | 3 | 6.5 | 1 | ¥ 28,600* |
| 3 × 90° × 8 | CC3.0Q-8 | 3 | 8 | 55 | 3 | 6.5 | 1 | ¥ 29,700* |
| 4 × 90° × 10 | CC4.0Q | 4 | 10 | 65 | 4.5 | 8.5 | 1 | ¥ 45,100* |
| 5 × 90° × 11 | CC5.0Q | 5 | 11 | 78 | 5.5 | 9 | 1 | ¥ 48,500* |
| 5 × 90° × 12 | CC5.0Q-12 | 5 | 12 | 78 | 5.5 | 10 | 1 | ¥ 48,800* |
| 6 × 90° × 18 | CC6.0Q | 6 | 18 | 90 | 6.5 | 15 | 1 | ¥ 122,000* |

* Machining conditions are calculated based on the workpiece end-face hole size Dw.

* For details on machining conditions, see TECHNICAL INFORMATION, "27. Table of recommend centering condition."