

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

C-CD-QL

Long Shank Low Helix Carbide Center Drills-Type A 90°



Specification

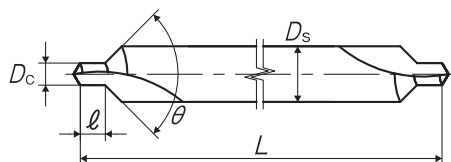


■ The C-CD-QL is a carbide long shank low helix center hole drill suitable for hard materials and mass production of center with 90° center holes.

Cutting Speed depending on Materials

High carbon steels 高炭素鋼 25~40 (m/min)	Alloy steels 合金鋼 15~30 (m/min)	Thermal refined steels 調質鋼 10~20 (m/min) 25~35HRC	Thermal refined steels 調質鋼 5~10 (m/min) 35~45HRC	Cast irons 鑄鉄 25~40 (m/min)	Brass castings 黄銅鑄物 25~50 (m/min)	Aluminum alloy castings アルミ合金鑄物 25~50 (m/min)
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TYPE: 1



Segment : 52

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 90° × 4	CCL1.0Q	1	4	100	1	3	1	¥ 21,300 [*]
1.5 × 90° × 5	CCL1.5Q	1.5	5	100	1.5	4	1	¥ 24,500 [*]
2 × 90° × 6	CCL2.0Q	2	6	100	2	5	1	¥ 27,700 [*]
2 × 90° × 6	CCM2.0Q	2	6	150	2	5	1	¥ 33,500 [*]
2.5 × 90° × 8	CCL2.5Q	2.5	8	100	2.5	6.5	1	¥ 36,700 [*]
2.5 × 90° × 8	CCM2.5Q	2.5	8	150	2.5	6.5	1	¥ 44,400 [*]
3 × 90° × 8	CCL3.0Q	3	8	100	3	6.5	1	¥ 36,700 [*]
3 × 90° × 8	CCM3.0Q	3	8	150	3	6.5	1	¥ 44,400 [*]
4 × 90° × 10	CCL4.0Q	4	10	100	4.5	8.5	1	¥ 46,200 [*]
4 × 90° × 10	CCM4.0Q	4	10	150	4.5	8.5	1	¥ 56,000 [*]
5 × 90° × 12	CCL5.0Q	5	12	100	5.5	10	1	¥ 56,400 [*]
5 × 90° × 12	CCM5.0Q	5	12	150	5.5	10	1	¥ 67,300 [*]

• 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."