

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

C-CD-S

Carbide Center Drills-Type A 60°



Specification

HF

■ Low helix carbide center drills - Type A 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

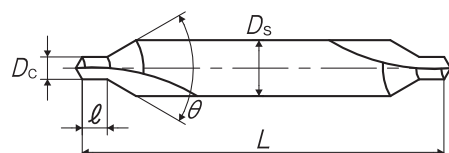
Thermal refined steels
調質鋼
5~15
(m/min)
35~45HRC

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 × 60° × 4	CCD1.0	1	4	35	1	2.5	1	¥ 15,900
1.2 × 60° × 5	CCD1.2	1.2	5	40	1.2	3	1	¥ 22,800 ※
1.5 × 60° × 5	CCD1.5	1.5	5	40	1.5	4	1	¥ 20,100
2 × 60° × 6	CCD2.0	2	6	45	2	5	1	¥ 24,500
2.5 × 60° × 7.7	CCD2.5	2.5	7.7	50	2.5	6.5	1	¥ 31,500
2.5 × 60° × 8	CCD2.5-8	2.5	8	50	2.5	6.5	1	¥ 32,700 ※
3 × 60° × 7.7	CCD3.0	3	7.7	55	3	6.5	1	¥ 31,500
3 × 60° × 8	CCD3.0-8	3	8	55	3	6.5	1	¥ 32,700 ※
4 × 60° × 10	CCD4.0	4	10	65	4.5	8.5	1	¥ 49,700
5 × 60° × 11	CCD5.0	5	11	78	5.5	9	1	¥ 53,400
5 × 60° × 12	CCD5.0-12	5	12	78	5.5	10	1	¥ 53,700 ※
6 × 60° × 18	CCD6.0	6	18	90	6.5	15	1	¥ 135,000 ※

• 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."