

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

C-CD-SL

Long Shank Low Helix Carbide Center Drills-Type A 60°



Specification

HF

■ Long shank 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
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

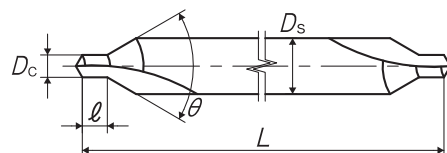
Thermal refined steels
調質鋼
5~10
(m/min)
35~45HRC

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)

TYPE: 1



Segment : 52

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 60° × 4	CCDL1.0	1	4	100	1	2.5	1	¥ 19,300 [*]
1.5 × 60° × 5	CCDL1.5	1.5	5	100	1.5	4	1	¥ 22,200 [*]
2 × 60° × 6	CCDL2.0	2	6	100	2	5	1	¥ 25,100 [*]
2 × 60° × 6	CCDM2.0	2	6	150	2	5	1	¥ 30,400 [*]
2.5 × 60° × 8	CCDL2.5	2.5	8	100	2.5	6.5	1	¥ 33,300 [*]
2.5 × 60° × 8	CCDM2.5	2.5	8	150	2.5	6.5	1	¥ 40,300 [*]
3 × 60° × 8	CCDL3.0	3	8	100	3	6.5	1	¥ 33,300 [*]
3 × 60° × 8	CCDM3.0	3	8	150	3	6.5	1	¥ 40,300 [*]
4 × 60° × 10	CCDL4.0	4	10	100	4.5	8.5	1	¥ 42,000 [*]
4 × 60° × 10	CCDM4.0	4	10	150	4.5	8.5	1	¥ 50,900 [*]
5 × 60° × 12	CCDL5.0	5	12	100	5.5	10	1	¥ 51,200 [*]
5 × 60° × 12	CCDM5.0	5	12	150	5.5	10	1	¥ 61,100 [*]

• 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."

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

JIS ⑪-16