

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

S  
JIS

## CD-Q V

Low Helix Center Drills-Type A 90°, Coated



### Specification

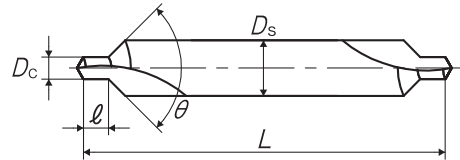


■ Low helix center drills - Type A center drill for machining 90° center hole. Coated to improve wear resistance and anti-welding.

### Cutting Speed depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Cast steels 鑄鋼	Cast irons 鑄鐵	Ductile cast irons 強韌鑄鐵
20~40 (m/min)	20~40 (m/min)	20~40 (m/min)	15~30 (m/min)	20~40 (m/min)	10~20 (m/min)	10~25 (m/min)

### TYPE: 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 90° × 4	VCY1.0Q	1	4	35	1	3	1	¥ 3,850 <sup>*</sup>
1.5 × 90° × 5	VCY1.5Q	1.5	5	40	1.5	4	1	¥ 3,480 <sup>*</sup>
2 × 90° × 6	VCY2.0Q	2	6	45	2	5	1	¥ 3,660 <sup>*</sup>
2.5 × 90° × 7.7	VCY2.5Q	2.5	7.7	50	2.5	6.5	1	¥ 4,280 <sup>*</sup>
3 × 90° × 7.7	VCY3.0Q	3	7.7	55	3	6.5	1	¥ 4,280 <sup>*</sup>
4 × 90° × 10	VCY4.0Q	4	10	65	4.5	8.5	1	¥ 6,880 <sup>*</sup>
5 × 90° × 11	VCY5.0Q	5	11	78	5.5	9	1	¥ 7,440 <sup>*</sup>
6 × 90° × 18	VCY6.0Q	6	18	90	6.5	15	1	¥ 21,400 <sup>*</sup>

• 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."

- 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 / Metal Surgical Instruments