

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

⑪-19



## CD-Q

### Low Helix Center Drills-Type A 90°



#### Specification

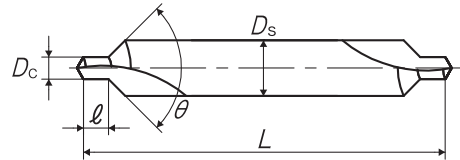
**HSS**

■ Low helix center drills - Type A center drill for machining 90° center hole. Suitable for relatively hard materials.

#### Cutting Speed depending on Materials

Low carbon steels 低碳素鋼 <b>15~30</b> (m/min)	Medium carbon steels 中炭素鋼 <b>15~30</b> (m/min)	High carbon steels 高炭素鋼 <b>15~30</b> (m/min)	Alloy steels 合金鋼 <b>10~25</b> (m/min)	Cast steels 鑄鋼 <b>15~30</b> (m/min)	Cast irons 鑄鐵 <b>10~15</b> (m/min)	Ductile cast irons 強韌鑄鐵 <b>10~20</b> (m/min)
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#### TYPE: 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
0.5 × 90° × 3.5	CY0.5Q	0.5	3.5	35	0.5	1.5	1	¥ 3,620 <sup>*</sup>
0.6 × 90° × 3.5	CY0.6Q	0.6	3.5	35	0.6	2	1	¥ 3,280 <sup>*</sup>
0.8 × 90° × 3.5	CY0.8Q	0.8	3.5	35	0.8	2.5	1	¥ 2,490 <sup>*</sup>
1 × 90° × 4	CY1.0Q	1	4	35	1	3	1	¥ 2,040
1.2 × 90° × 5	CY1.2Q	1.2	5	40	1.2	3.5	1	¥ 1,860 <sup>*</sup>
1.5 × 90° × 5	CY1.5Q	1.5	5	40	1.5	4	1	¥ 1,600
2 × 90° × 6	CY2.0Q	2	6	45	2	5	1	¥ 1,780
2.5 × 90° × 7.7	CY2.5Q	2.5	7.7	50	2.5	6.5	1	¥ 2,180
3 × 90° × 7.7	CY3.0Q	3	7.7	55	3	6.5	1	¥ 2,180
4 × 90° × 10	CY4.0Q	4	10	65	4.5	8.5	1	¥ 4,340
5 × 90° × 11	CY5.0Q	5	11	78	5.5	9	1	¥ 4,680
6 × 90° × 16	CY6.0Q-16	6	16	90	6.5	13.5	1	¥ 11,300 <sup>*</sup>
6 × 90° × 18	CY6.0Q	6	18	90	6.5	15	1	¥ 15,900 <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."