

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

CD-R

Low Helix Center Drills-Type R



Specification

HSS

■The CD-R is a high helix type R center hole drill.

Cutting Speed depending on Materials

Low carbon steels
低炭素鋼
15~30
(m/min)

Medium carbon steels
中炭素鋼
15~30
(m/min)

High carbon steels
高炭素鋼
15~30
(m/min)

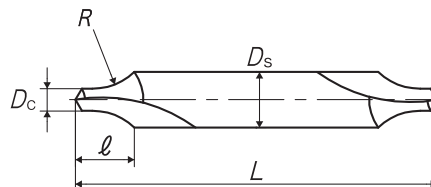
Alloy steels
合金鋼
10~25
(m/min)

Cast steels
鋳鋼
15~30
(m/min)

Cast irons
鋳鉄
10~15
(m/min)

Ductile cast irons
強靱鋳鉄
10~20
(m/min)

TYPE: 1



Segment : 51

Size Dc × R × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Rmax (mm)	Dw (mm)	TYPE	MSRP
0.7 × R × 3.5	CY0.7R	0.7	3.5	35	2.5	2.5	2	1	¥ 3,390 [*]
0.8 × R × 3.5	CY0.8R	0.8	3.5	35	2.6	2.5	2	1	¥ 2,890 [*]
1 × R × 4	CY1.0R	1	4	35	3.25	3.15	2.5	1	¥ 2,540 [*]
1.5 × R × 5	CY1.5R	1.5	5	40	4.6	5	4	1	¥ 2,000
2 × R × 6	CY2.0R	2	6	45	5.75	6.3	5	1	¥ 2,230
2.5 × R × 7.7	CY2.5R	2.5	7.7	50	7.3	8	6.5	1	¥ 2,890
3 × R × 7.7	CY3.0R	3	7.7	55	8.3	10	6.5	1	¥ 3,780
4 × R × 10	CY4.0R	4	10	65	10.6	12.5	8.5	1	¥ 6,130
5 × R × 11	CY5.0R	5	11	78	12.4	16	9	1	¥ 7,790 [*]
6 × R × 16	CY6.0R-16	6	16	90	16.9	20	13.5	1	¥ 11,800 [*]
6 × R × 18	CY6.0R	6	18	90	17.8	20	15	1	¥ 16,600 [*]

• 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."