

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

⑪-5



## CD-S(I)

Low Helix Center Drills-Type A 60°, (Old JIS Type 1)



### Specification

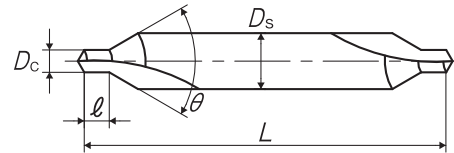
**HSS**

■ The CD-S(I) is an old JIS 1 low helix center hole drill 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
2.5 × 60° × 8	C12.5	2.5	8	50	3.5	6.5	1	¥ 1,940
3 × 60° × 10	C13.0	3	10	55	4	8	1	¥ 3,060
4 × 60° × 12	C14.0	4	12	66	5	10	1	¥ 4,360
5 × 60° × 14	C15.0	5	14	78	6.5	12	1	¥ 6,560

- 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."