

Drill dia.	Shank dia.	Maximum dia.	Overall length	Drill length	Workpiece end-face Hole size
Dc	Ds	D1	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

11-29



CD-S(II)

Low Helix Center Drills-Type B 60°, (Old JIS Type 2)



Specification

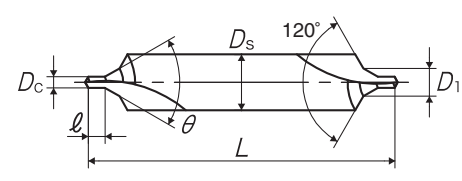
HSS

■ The CD-S(II) is an old JIS type 2 center hole drill suitable for relatively hard materials.

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
15~30 (m/min)	15~30 (m/min)	15~30 (m/min)	10~25 (m/min)	15~30 (m/min)	10~15 (m/min)	10~20 (m/min)

TYPE: 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	D1 (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 60° × 6	C21.0	1	6	2.5	45	1.5	4	1	¥ 3,270
1.5 × 60° × 8	C21.5	1.5	8	4	50	2	6	1	¥ 3,100
2 × 60° × 10	C22.0	2	10	5	55	3	8	1	¥ 4,510
2.5 × 60° × 12	C22.5	2.5	12	6.5	60	3.5	10	1	¥ 6,520
3 × 60° × 14	C23.0	3	14	8	65	4	12	1	¥ 8,530
4 × 60° × 18	C24.0	4	18	10	76	5	14	1	¥ 17,800
5 × 60° × 22	C25.0	5	22	12	88	6.5	17	1	¥ 24,600
6 × 60° × 25	C26.0	6	25	15	100	8	21	1	¥ 35,300

- 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."