

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

Spiral Fluted Taps (for blind hole) ①

Spiral Fluted Taps (for through hole) ②

Spiral Pointed Taps (for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills Premium Thread Mills ⑨

Dies ⑩

Center Drills Centering Tools ⑪

Precision Machinery/Metal Surgical Instruments ⑫

JIS ⑪-10

JIS

## CD-S V(I)

Coating Low Helix A Type 60° Center Hole Drill Former JIS Type 1



### Specification

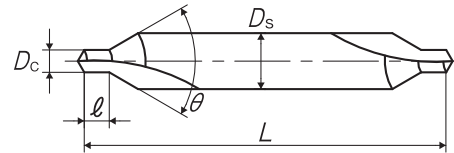
**HSS Coating**

■ The CD-S V(I) is a coated low helix former JIS type 1 center hole drill with excellent wear resistance and welding resistance.

### Cutting Speed depending on Materials

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

### TYPE: 1



Segment : 51

| Size<br>Dc × θ × Ds | Code   | Dc<br>(mm) | Ds<br>(mm) | L<br>(mm) | ℓ<br>(mm) | Dw<br>(mm) | TYPE | MSRP                   |
|---------------------|--------|------------|------------|-----------|-----------|------------|------|------------------------|
| 2.5 × 60° × 8       | VC12.5 | 2.5        | 8          | 50        | 3.5       | 6.5        | 1    | ¥ 4,240 <sup>**</sup>  |
| 3 × 60° × 10        | VC13.0 | 3          | 10         | 55        | 4         | 8          | 1    | ¥ 5,880 <sup>**</sup>  |
| 4 × 60° × 12        | VC14.0 | 4          | 12         | 66        | 5         | 10         | 1    | ¥ 7,900 <sup>**</sup>  |
| 5 × 60° × 14        | VC15.0 | 5          | 14         | 78        | 6.5       | 12         | 1    | ¥ 11,600 <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."