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

CD-S V(I)

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

Specification

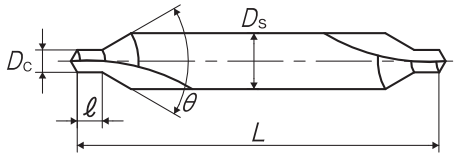
HSS Coating

■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 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Cast steels 鋳鋼	Cast irons 鋳鉄	Ductile cast irons 強靭鋳鉄
20~40 (m/min)	20~40 (m/min)	20~40 (m/min)	15~30 (m/min)	20~40 (m/min)	10~20 (m/min)	10~25 (m/min)

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	VC12.5	2.5	8	50	3.5	6.5	1	¥ 4,240 ※
3 × 60° × 10	VC13.0	3	10	55	4	8	1	¥ 5,880 ※
4 × 60° × 12	VC14.0	4	12	66	5	10	1	¥ 7,900 ※
5 × 60° × 14	VC15.0	5	14	78	6.5	12	1	¥ 11,600 ※

・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.”

※ = Specified Distribution Items. Made to order products.