

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

11-9

CD-S V

Type A Low Helix Coated 60° Center Hole Drill



Specification

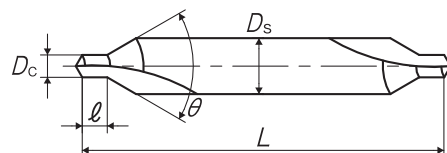


■ The CD-S V is a coated type A center hole drill with excellent abrasion resistance and welding resistance.

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 鑄鋼	Cast irons 鑄鐵	Ductile cast irons 強韌鑄鐵
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
1 × 60° × 4	VCY1.0	1	4	35	1	2.5	1	¥ 3,560 ※
1.5 × 60° × 5	VCY1.5	1.5	5	40	1.5	4	1	¥ 3,120 ※
2 × 60° × 6	VCY2.0	2	6	45	2	5	1	¥ 3,310 ※
2.5 × 60° × 7.7	VCY2.5	2.5	7.7	50	2.5	6.5	1	¥ 3,760 ※
3 × 60° × 7.7	VCY3.0	3	7.7	55	3	6.5	1	¥ 3,760 ※
4 × 60° × 10	VCY4.0	4	10	65	4.5	8.5	1	¥ 6,140 ※
5 × 60° × 11	VCY5.0	5	11	78	5.5	9	1	¥ 6,880 ※
6 × 60° × 18	VCY6.0	6	18	90	6.5	15	1	¥ 20,000 ※

- 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."