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

JIS

CD-SL V

Long Shank Low Helix Center Drills-Type A 60°, Coated

■ Long shank low helix center drills - Type A suitable for relatively hard materials and coated to improve wear resistance and anti-welding.

Specification

HSS **Coating**

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
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
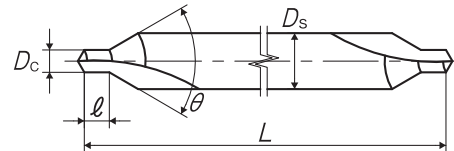
Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 60° ×4	VCDL1.0	1	4	100	1	2.5	1	¥ 9,870 ※
1 × 60° ×4	VCDM1.0	1	4	150	1	2.5	1	¥ 16,100 ※
1.5 × 60° × 5	VCDL1.5	1.5	5	100	1.5	4	1	¥ 8,020 ※
1.5 × 60° × 5	VCDM1.5	1.5	5	150	1.5	4	1	¥ 14,200 ※
2 × 60° × 6	VCDL2.0	2	6	100	2	5	1	¥ 8,830 ※
2 × 60° × 6	VCDM2.0	2	6	150	2	5	1	¥ 14,600 ※
2.5 × 60° ×8	VCDL2.5	2.5	8	100	2.5	6.5	1	¥ 9,970 ※
2.5 × 60° ×8	VCDM2.5	2.5	8	150	2.5	6.5	1	¥ 16,100 ※
3 × 60° × 8	VCDL3.0	3	8	100	3	6.5	1	¥ 9,970 ※
3 × 60° × 8	VCDM3.0	3	8	150	3	6.5	1	¥ 16,100 ※
4 × 60° ×10	VCDL4.0	4	10	100	4.5	8.5	1	¥ 12,100 ※
4 × 60° ×10	VCDM4.0	4	10	150	4.5	8.5	1	¥ 18,800 ※
5 × 60° × 12	VCDL5.0	5	12	100	5.5	10	1	¥ 15,800 ※
5 × 60° × 12	VCDM5.0	5	12	150	5.5	10	1	¥ 22,800 ※

· 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."

Sidebar tabs:
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

Think threads with YAMAWA

※ = Specified Distribution Items. Made to order products.