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

JIS

CE-Q V

High Helix Center Drills-Type A 90°, Coated

Specification

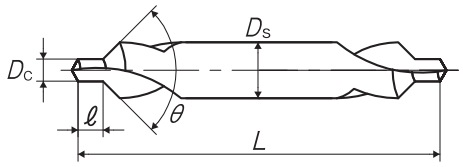
HSS Coating

■High helix center drills - Type A center drill for machining 90° center hole. Coated to improve wear resistance and anti-welding.

Cutting Speed depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅	Brass castings 黄銅鋳物	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物
20~40 (m/min)	20~40 (m/min)	5~15 (m/min)	30~60 (m/min)	30~60 (m/min)	25~50 (m/min)	25~50 (m/min)

TYPE : 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 90° × 4	VCY1.0Z	1	4	35	1	3	1	¥ 4,240
1.5 × 90° × 5	VCY1.5Z	1.5	5	40	1.5	4	1	¥ 3,830
2 × 90° × 6	VCY2.0Z	2	6	45	2	5	1	¥ 4,030
2.5 × 90° × 7.7	VCY2.5Z	2.5	7.7	50	2.5	6.5	1	¥ 4,710
3 × 90° × 7.7	VCY3.0Z	3	7.7	55	3	6.5	1	¥ 4,710
4 × 90° × 10	VCY4.0Z	4	10	65	4.5	8.5	1	¥ 7,570
5 × 90° × 11	VCY5.0Z	5	11	78	5.5	9	1	¥ 8,190
6 × 90° × 18	VCY6.0Z	6	18	90	6.5	15	1	¥ 23,600

・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.”