

# 11 Center Drills / Centering Tools

Drill dia.	Shank dia.	Overall length	Drill length	Workpiece end-face Hole size
Dc	Ds	L	$\ell$	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



## CE-Q V

High Helix Center Drills-Type A 90°, Coated



### Specification



■ 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  
**20~40**  
(m/min)

Medium carbon steels  
中炭素鋼  
**20~40**  
(m/min)

Stainless steels  
ステンレス鋼  
**5~15**  
(m/min)

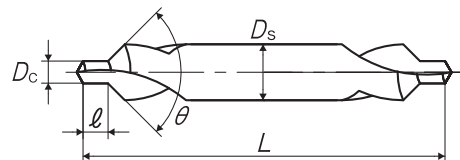
Brass  
黄銅  
**30~60**  
(m/min)

Brass castings  
黄銅鑄物  
**30~60**  
(m/min)

Wrought aluminum  
アルミ圧延材  
**25~50**  
(m/min)

Aluminum alloy castings  
アルミ合金鑄物  
**25~50**  
(m/min)

### TYPE : 1



Segment : 51

Size Dc × $\theta$ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	$\ell$ (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."

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Think threads with  
**YAMAWA**