

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

S  
JIS

## CE-QL

Long Shank High Helix Center Drills-Type A 90°



### Specification

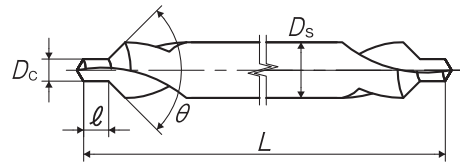
**HSS**

■ Long shank high helix center drills - Type A center drill for machining 90° center hole. Suitable for soft or relatively tough materials.

### Cutting Speed depending on Materials

Low carbon steels 低碳素鋼 <b>10~25</b> (m/min)	Medium carbon steels 中炭素鋼 <b>10~25</b> (m/min)	Stainless steels ステンレス鋼 <b>5~10</b> (m/min)	Brass 黄銅 <b>20~40</b> (m/min)	Brass castings 黄銅鑄物 <b>20~40</b> (m/min)	Wrought aluminum アルミ圧延材 <b>15~30</b> (m/min)	Aluminum alloy castings アルミ合金鑄物 <b>15~30</b> (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	CL1.0Z	1	4	100	1	3	1	¥ 8,560
1 × 90° × 4	CM1.0Z	1	4	150	1	3	1	¥ 13,000*
1.5 × 90° × 5	CL1.5Z	1.5	5	100	1.5	4	1	¥ 6,400
1.5 × 90° × 5	CM1.5Z	1.5	5	150	1.5	4	1	¥ 10,500
2 × 90° × 6	CL2.0Z	2	6	100	2	5	1	¥ 7,180
2 × 90° × 6	CM2.0Z	2	6	150	2	5	1	¥ 10,900
2.5 × 90° × 8	CL2.5Z	2.5	8	100	2.5	6.5	1	¥ 8,560
2.5 × 90° × 8	CM2.5Z	2.5	8	150	2.5	6.5	1	¥ 13,000
3 × 90° × 8	CL3.0Z	3	8	100	3	6.5	1	¥ 8,560
3 × 90° × 8	CM3.0Z	3	8	150	3	6.5	1	¥ 13,000
4 × 90° × 10	CL4.0Z	4	10	100	4.5	8.5	1	¥ 9,600
4 × 90° × 10	CM4.0Z	4	10	150	4.5	8.5	1	¥ 14,100
5 × 90° × 12	CL5.0Z	5	12	100	5.5	10	1	¥ 12,300
5 × 90° × 12	CM5.0Z	5	12	150	5.5	10	1	¥ 18,900

- 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."

- 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 / Metal / Surgical Instruments