

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

11

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
低炭素鋼
10~25
(m/min)

Medium carbon steels
中炭素鋼
10~25
(m/min)

Stainless steels
ステンレス鋼
5~10
(m/min)

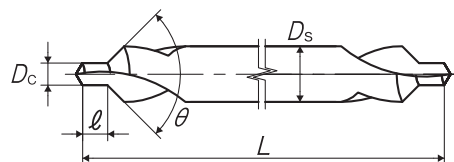
Brass
黄銅
20~40
(m/min)

Brass castings
黄銅鑄物
20~40
(m/min)

Wrought aluminum
アルミ圧延材
15~30
(m/min)

Aluminum alloy castings
アルミ合金鑄物
15~30
(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."

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

JIS
⑪-24