

11 Center Drills / Centering Tools

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

⑪-3

S

CE-S(I)

High Helix Center Drills-Type A 60°, (Old JIS Type 1)



Specification

HSS

■ High helix center drills - old JIS Type A suitable for soft or relatively tough materials.

Cutting Speed depending on Materials

Low carbon steels
低炭素鋼
15~30
(m/min)

Medium carbon steels
中炭素鋼
15~30
(m/min)

Stainless steels
ステンレス鋼
5~10
(m/min)

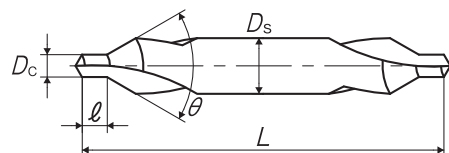
Brass
黄銅
25~50
(m/min)

Brass castings
黄銅鑄物
25~50
(m/min)

Wrought aluminum
アルミ圧延材
20~40
(m/min)

Aluminum alloy castings
アルミ合金鑄物
20~40
(m/min)

TYPE: 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
2.5 × 60° × 8	CE12.5	2.5	8	50	3.5	6.5	1	¥ 1,940
3 × 60° × 10	CE13.0	3	10	55	4	8	1	¥ 3,060
4 × 60° × 12	CE14.0	4	12	66	5	10	1	¥ 4,360
5 × 60° × 14	CE15.0	5	14	78	6.5	12	1	¥ 6,560

- 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."