

Drill dia.	Shank dia.	Maximum dia.	Overall length	Drill length	Workpiece end-face Hole size
Dc	Ds	D ₁	L	ℓ	Dw

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/
Metal Surgical Instruments ⑫

JIS

CE-S(II)

High Helix Center Drills-Type B 60°, (Old JIS Type 2)



Specification

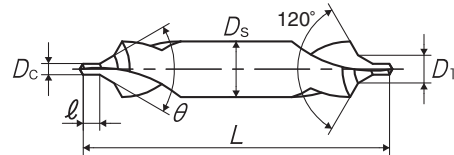
HSS

■ High helix center drills - old JIS Type 2 suitable for soft or relatively tough materials.

Cutting Speed depending on Materials

Low carbon steels 低碳素鋼 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)	D ₁ (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 60° × 6	CE21.0	1	6	2.5	45	1.5	4	1	¥ 3,270
1.5 × 60° × 8	CE21.5	1.5	8	4	50	2	6	1	¥ 3,100
2 × 60° × 10	CE22.0	2	10	5	55	3	8	1	¥ 4,510
2.5 × 60° × 12	CE22.5	2.5	12	6.5	60	3.5	10	1	¥ 6,520
3 × 60° × 14	CE23.0	3	14	8	65	4	12	1	¥ 8,530
4 × 60° × 18	CE24.0	4	18	10	76	5	14	1	¥ 17,800
5 × 60° × 22	CE25.0	5	22	12	88	6.5	17	1	¥ 24,600
6 × 60° × 25	CE26.0	6	25	15	100	8	21	1	¥ 35,300

- 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."