

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

CE-S V(I)

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



Specification

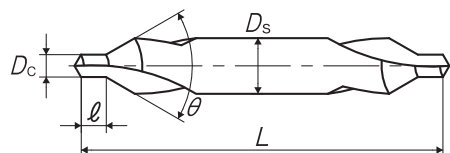


■ Optimum coating suitable for the cutting condition.

Cutting Speed depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅	Brass castings 黄銅鑄物	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物
20~40 (m/min)	20~40 (m/min)	5~15 (m/min)	30~60 (m/min)	30~60 (m/min)	25~50 (m/min)	25~50 (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	VCE12.5	2.5	8	50	3.5	6.5	1	¥ 4,240 [*]
3 × 60° × 10	VCE13.0	3	10	55	4	8	1	¥ 5,880 [*]
4 × 60° × 12	VCE14.0	4	12	66	5	10	1	¥ 7,900 [*]
5 × 60° × 14	VCE15.0	5	14	78	6.5	12	1	¥ 11,600 [*]

- 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."

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills
Premium Thread Mills

Dies

Center Drills
Centering Tools

Precision Machinery/
Medical Surgical Instruments

JIS

11-8