

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

S
JIS

CE-SL

Long Shank High Helix Center Drills-Type A 60°



Specification

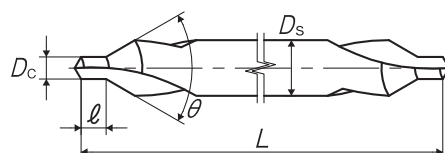
HSS

■ Long shank high helix center drills - Type A 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)
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TYPE: 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 60° × 4	CEL1.0	1	4	100	1	2.5	1	¥ 8,200
1 × 60° × 4	CEM1.0	1	4	150	1	2.5	1	¥ 12,500
1.5 × 60° × 5	CEL1.5	1.5	5	100	1.5	4	1	¥ 6,130
1.5 × 60° × 5	CEM1.5	1.5	5	150	1.5	4	1	¥ 10,100
2 × 60° × 6	CEL2.0	2	6	100	2	5	1	¥ 6,880
2 × 60° × 6	CEM2.0	2	6	150	2	5	1	¥ 10,500
2.5 × 60° × 8	CEL2.5	2.5	8	100	2.5	6.5	1	¥ 8,200
2.5 × 60° × 8	CEM2.5	2.5	8	150	2.5	6.5	1	¥ 12,500
3 × 60° × 8	CEL3.0	3	8	100	3	6.5	1	¥ 8,200
3 × 60° × 8	CEM3.0	3	8	150	3	6.5	1	¥ 12,500
3 × 60° × 8	CEN3.0	3	8	200	3	6.5	1	¥ 16,400*
4 × 60° × 10	CEL4.0	4	10	100	4.5	8.5	1	¥ 9,200
4 × 60° × 10	CEM4.0	4	10	150	4.5	8.5	1	¥ 13,500
4 × 60° × 10	CEN4.0	4	10	200	4.5	8.5	1	¥ 17,800*
5 × 60° × 12	CEL5.0	5	12	100	5.5	10	1	¥ 11,800
5 × 60° × 12	CEM5.0	5	12	150	5.5	10	1	¥ 18,100
5 × 60° × 12	CEN5.0	5	12	200	5.5	10	1	¥ 23,700*

• 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/
Metal/Surgical Instruments ⑫