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

CE-SL

Long Shank High Helix Center Drills-Type A 60°

Specification

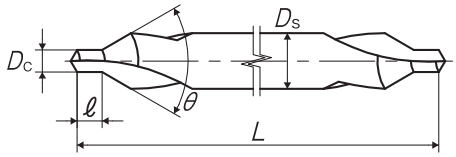
HSS

■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	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅	Brass castings 黄銅鋳物	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物
10~25 (m/min)	10~25 (m/min)	5~10 (m/min)	20~40 (m/min)	20~40 (m/min)	15~30 (m/min)	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 × 60° × 4	CEL1.0	1	4	100	1	2.5	1	¥ 7,130
1 × 60° × 4	CEM1.0	1	4	150	1	2.5	1	¥ 10,800
1.5 × 60° × 5	CEL1.5	1.5	5	100	1.5	4	1	¥ 5,330
1.5 × 60° × 5	CEM1.5	1.5	5	150	1.5	4	1	¥ 8,750
2 × 60° × 6	CEL2.0	2	6	100	2	5	1	¥ 5,980
2 × 60° × 6	CEM2.0	2	6	150	2	5	1	¥ 9,060
2.5 × 60° × 8	CEL2.5	2.5	8	100	2.5	6.5	1	¥ 7,130
2.5 × 60° × 8	CEM2.5	2.5	8	150	2.5	6.5	1	¥ 10,800
3 × 60° × 8	CEL3.0	3	8	100	3	6.5	1	¥ 7,130
3 × 60° × 8	CEM3.0	3	8	150	3	6.5	1	¥ 10,800
3 × 60° × 8	CEN3.0	3	8	200	3	6.5	1	¥ 14,200 ※
4 × 60° × 10	CEL4.0	4	10	100	4.5	8.5	1	¥ 8,000
4 × 60° × 10	CEM4.0	4	10	150	4.5	8.5	1	¥ 11,700
4 × 60° × 10	CEN4.0	4	10	200	4.5	8.5	1	¥ 15,400 ※
5 × 60° × 12	CEL5.0	5	12	100	5.5	10	1	¥ 10,200
5 × 60° × 12	CEM5.0	5	12	150	5.5	10	1	¥ 15,700
5 × 60° × 12	CEN5.0	5	12	200	5.5	10	1	¥ 20,600 ※

・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.”

※ = Specified Distribution Items. Made to order products.

Think threads with YAMAWA