

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

JIS

⑪-33



## CE-T

### High Helix A Type 75° Center Hole Drill



#### Specification

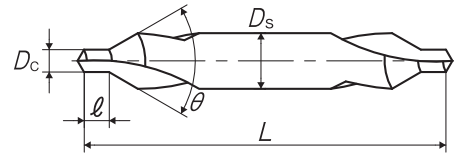
**HSS**

■ High helix center drills - Type A center drill for machining 75° center hole. Suitable for soft or relatively tough materials.

#### Cutting Speed depending on Materials

Low carbon steels 低碳素鋼 <b>15~30</b> (m/min)	Medium carbon steels 中炭素鋼 <b>15~30</b> (m/min)	Stainless steels ステンレス鋼 <b>5~10</b> (m/min)	Brass 黄銅 <b>25~50</b> (m/min)	Brass castings 黄銅鑄物 <b>25~50</b> (m/min)	Wrought aluminum アルミ圧延材 <b>20~40</b> (m/min)	Aluminum alloy castings アルミ合金鑄物 <b>20~40</b> (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 × 75° × 4	CE1.0T	1	4	35	1	2.5	1	¥ 2,130 <sup>*</sup>
1.5 × 75° × 5	CE1.5T	1.5	5	40	1.5	4	1	¥ 1,670 <sup>*</sup>
2 × 75° × 6	CE2.0T	2	6	45	2	5	1	¥ 1,850 <sup>*</sup>
2.5 × 75° × 7.7	CE2.5T	2.5	7.7	50	2.5	6.5	1	¥ 2,270 <sup>*</sup>
3 × 75° × 7.7	CE3.0T	3	7.7	55	3	6.5	1	¥ 2,270 <sup>*</sup>
4 × 75° × 10	CE4.0T	4	10	65	4.5	8.5	1	¥ 4,520 <sup>*</sup>
5 × 75° × 11	CE5.0T	5	11	78	5.5	9	1	¥ 4,880 <sup>*</sup>
6 × 75° × 18	CE6.0T	6	18	90	6.5	15	1	¥ 16,500 <sup>*</sup>
8 × 75° × 18	CE8.0T	8	18	100	8.5	15	1	¥ 18,900 <sup>*</sup>
10 × 75° × 18	CE010T	10	18	100	11	15	1	¥ 18,900 <sup>*</sup>

• 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."