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

CEQA

High Helix Center Drills-JIS Type A 90°

Specification

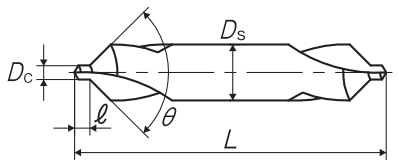
HSS

■High helix center drills - JIS Type A center drill for machining 90° center hole. Suitable for soft and 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
15~30 (m/min)	15~30 (m/min)	5~10 (m/min)	25~50 (m/min)	25~50 (m/min)	20~40 (m/min)	20~40 (m/min)

TYPE : 1



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
1 × 90° × 4	CEA1.0Q	1	4	35.5	1.1	2.8	1	¥ 1,610
1.25 × 90° × 5	CEA1.25Q	1.25	5	40	1.4	3.55	1	¥ 1,340
1.6 × 90° × 6.3	CEA1.6Q	1.6	6.3	45	1.8	4.5	1	¥ 1,450
2 × 90° × 8	CEA2.0Q	2	8	50	2.2	5.6	1	¥ 1,950
2.5 × 90° × 10	CEA2.5Q	2.5	10	56	2.8	7.1	1	¥ 3,560
3.15 × 90° × 11.2	CEA3.15Q	3.15	11.2	60	3.6	9	1	¥ 3,970
4 × 90° × 12.5	CEA4.0Q	4	12.5	63	4.5	11.2	1	¥ 4,760
5 × 90° × 16	CEA5.0Q	5	16	71	5.6	14	1	¥ 9,200
6.3 × 90° × 20	CEA6.3Q	6.3	20	80	7.1	18	1	¥ 18,700
8 × 90° × 25	CEA8.0Q	8	25	100	9	22.4	1	¥ 32,700
10 × 90° × 31.5	CEA010Q	10	31.5	125	11.2	28	1	¥ 46,400
12.5 × 90° × 35.5	CEA12.5Q	12.5	35.5	140	14	31.5	1	¥ 83,700

・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.”