

Drill dia.	Shank dia.	—	Maximum dia.	Overall length	Drill length	Larger cut length	Workpiece end-face Hole size
Dc	Ds	Dc2	D1	L	ℓ	ℓ2	Dw

JIS

## CESC

High Helix Center Drills-JIS Type C 60°



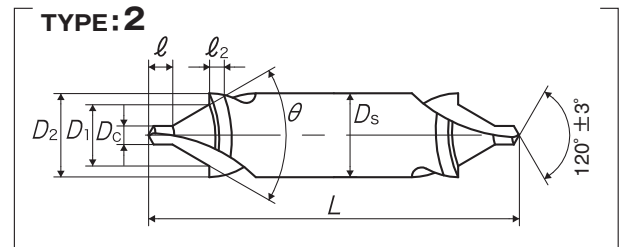
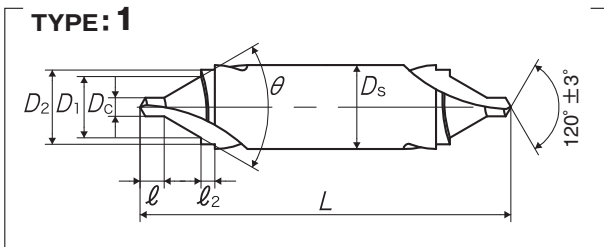
### Specification

**HSS**

■ High helix center drills - JIS Type C suitable for soft or relatively tough materials.

### Cutting Speed depending on Materials

Low carbon steels 低碳素鋼	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
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)



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	Dc2 (mm)	D1 (mm)	L (mm)	ℓ (mm)	ℓ2 (mm)	Dw (mm)	TYPE	MSRP
0.5 × 60° × 3.15	CEC0.5	0.5	3.15	1.6	1.06	31.5	0.8	0.6	1.6	1	¥ 4,590
0.63 × 60° × 3.15	CEC0.63	0.63	3.15	2	1.32	31.5	1	0.8	2	1	¥ 4,130
0.8 × 60° × 3.15	CEC0.8	0.8	3.15	2.5	1.7	31.5	1.2	1	2.5	1	¥ 3,540
1 × 60° × 3.15	CEC1.0	1	3.15	3.15	2.12	31.5	1.5	1.2	3.15	2	¥ 3,540
1.25 × 60° × 4	CEC1.25	1.25	4	4	2.65	35.5	1.9	1.5	4	2	¥ 3,320
1.6 × 60° × 5	CEC1.6	1.6	5	5	3.35	40	2.4	1.8	5	2	¥ 2,810
2 × 60° × 6.3	CEC2.0	2	6.3	6.3	4.25	45	3	2.2	6.3	2	¥ 2,920
2.5 × 60° × 8	CEC2.5	2.5	8	8	5.3	50	3.8	3	8	2	¥ 3,320
3.15 × 60° × 10	CEC3.15	3.15	10	10	6.7	56	4.8	3.5	10	2	¥ 4,820
4 × 60° × 12.5	CEC4.0	4	12.5	12.5	8.5	63	6	4.2	12.5	2	¥ 6,100
5 × 60° × 16	CEC5.0	5	16	16	10.6	71	7.5	5.5	16	2	¥ 10,800
6.3 × 60° × 18	CEC6.3	6.3	18	18	13.2	75	9.2	5.5	18	2	¥ 20,000
8 × 60° × 22.4	CEC8.0	8	22.4	22.4	17	90	11.5	5.5	22.4	2	¥ 29,900
10 × 60° × 28	CEC010	10	28	28	21.2	112	14.2	7	28	2	¥ 68,800

• 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