

Drill dia.	Shank dia.	Maximum dia.	Overall length	Drill length	Body length	Workpiece end-face Hole size
Dc	Ds	D1	L	ℓ	ℓ_2	Dw

JO-C-CDS

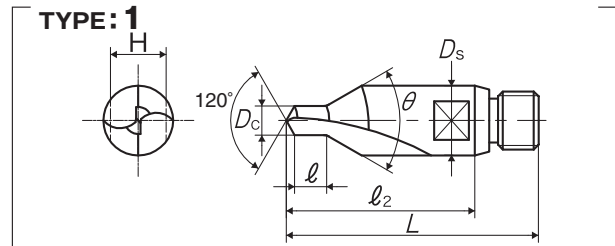
Joint- Low Helix Carbide Center Drills-Type A 60°



Specification Cutting Speed depending on Materials

HF	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼	Thermal refined steels 調質鋼	Cast irons 鑄鉄	Brass castings 黄銅鑄物	Aluminum alloy castings アルミ合金鑄物
	25~40 (m/min)	15~30 (m/min)	10~20 (m/min)	5~10 (m/min)	25~40 (m/min)	25~50 (m/min)	25~50 (m/min)
			25~35HRC	35~45HRC			

■The JO-C-CDS is a carbide type A center hole drill joint tool suitable for hard materials and mass production processing.



Segment : 5C

Size Dc × θ	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	ℓ_2 (mm)	H (mm)	Adaptable holder Shank dia.	Dw (mm)	TYPE	MSRP
4 × 60°	JCCY4.0	4	10	37.5	4.5	27.5	8	14	8.5	1	¥ 16,100
5 × 60°	JCCY5.0	5	12	43.5	5.5	32.5	10	16	10	1	¥ 19,400
6 × 60°	JCCY6.0	6	16	48.5	6.5	34.5	13	20	13.5	1	¥ 47,000

- 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."

JO-CDS(II)

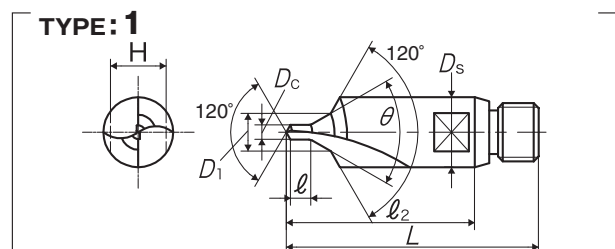
Joint- Low Helix Center Drills-Type B 60°, (Old JIS Type 2)



Specification Cutting Speed depending on Materials

HSS	Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Cast steels 鑄鋼	Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄
	10~25 (m/min)	10~25 (m/min)	10~25 (m/min)	10~20 (m/min)	10~25 (m/min)	5~10 (m/min)	5~15 (m/min)

■The JO-CDS(II) is a old JIS type 2 center hole drill joint tool suitable for relatively hard materials.



Segment : 5C

Size Dc × θ	Code	Dc (mm)	Ds (mm)	D1 (mm)	L (mm)	ℓ (mm)	ℓ_2 (mm)	H (mm)	Adaptable holder Shank dia.	Dw (mm)	TYPE	MSRP
2 × 60°	JC22.0	2	10	5	37.5	3	27.5	8	14	8	1	¥ 3,250
2.5 × 60°	JC22.5	2.5	12	6.5	43.5	3.5	32.5	10	16	10	1	¥ 3,280
3 × 60°	JC23.0	3	16	8	48.5	4	34.5	13	20	12	1	¥ 4,040

- 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."