

| Drill dia. | Shank dia. | Overall length | Drill length | Body length | Workpiece end-face Hole size |
|------------|------------|----------------|--------------|-------------|------------------------------|
| Dc | Ds | L | ℓ | ℓ_2 | 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 Tools

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

⑪-63

JIS

JO-CDR V

Joint- Low Helix Center Drills-Type R, Coated



Specification Cutting Speed depending on Materials

HSS-Co

Low carbon steels
低炭素鋼
10~25
(m/min)

Medium carbon steels
中炭素鋼
10~25
(m/min)

High carbon steels
高炭素鋼
10~25
(m/min)

Alloy steels
合金鋼
10~25
(m/min)

Cast steels
鋁鋼
10~25
(m/min)

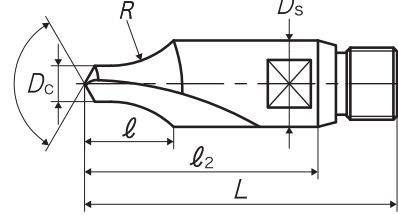
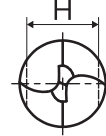
Cast irons
鋁鉄
8~15
(m/min)

Ductile cast irons
強靱鋁鉄
8~20
(m/min)

Coating

Joint tool for low helix type R center hole drill.

TYPE: 1



Segment : 5C

| Size Dc × R | Code | Dc (mm) | Ds (mm) | L (mm) | ℓ (mm) | ℓ_2 (mm) | H (mm) | Rmax | Adaptable holder Shank dia. | Dw (mm) | TYPE | MSRP |
|----------------|----------|------------|------------|-----------|----------------|------------------|-----------|------|--------------------------------|------------|------|----------|
| 4 × R12.5 | JVCY4.0R | 4 | 10 | 37.5 | 10.3 | 27.5 | 8 | 12.5 | 14 | 8.5 | 1 | ¥ 8,000 |
| 5 × R16 | JVCY5.0R | 5 | 12 | 43.5 | 12.6 | 32.5 | 10 | 16 | 16 | 9 | 1 | ¥ 9,930 |
| 6 × R20 | JVCY6.0R | 6 | 16 | 48.5 | 16.4 | 34.5 | 13 | 20 | 20 | 13.5 | 1 | ¥ 12,400 |

- 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."