

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/Metal Surgical Instruments

JIS ⑪-61



JO-CDS

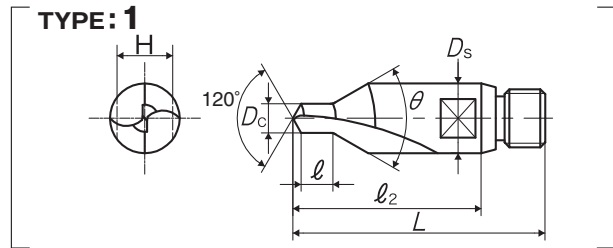
Joint- Low Helix Center Drills-Type A 60°



Specification Cutting Speed depending on Materials

HSS	Low carbon steels 低碳素鋼	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 鑄鐵	Ductile cast irons 強韌鑄鐵
	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 is a low helix type A center hole drill joint tool suitable for comparatively hard materials.



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°	JCY4.0	4	10	37.5	4.5	27.5	8	14	8.5	1	¥ 3,090
5 × 60°	JCY5.0	5	12	43.5	5.5	32.5	10	16	10	1	¥ 3,180
6 × 60°	JCY6.0	6	16	48.5	6.5	34.5	13	20	13.5	1	¥ 3,980

- 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 V

Joint- Low Helix Center Drills-Type A 60°, Coated



Specification

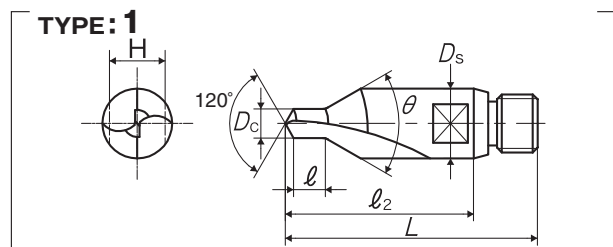
HSS **Coating**

Cutting Speed depending on Materials

Low carbon steels 低碳素鋼	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 鑄鐵
15~30 (m/min)	15~30 (m/min)	15~30 (m/min)	10~25 (m/min)	15~30 (m/min)	8~15 (m/min)

Ductile cast irons
強韌鑄鐵
10~20
(m/min)

■ Optimum coating suitable for the cutting.



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°	JVCY4.0	4	10	37.5	4.5	27.5	8	14	8.5	1	¥ 5,450
5 × 60°	JVCY5.0	5	12	43.5	5.5	32.5	10	16	10	1	¥ 6,270
6 × 60°	JVCY6.0	6	16	48.5	6.5	34.5	13	20	13.5	1	¥ 8,580

- 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."