

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

JO-CES

Joint- High Helix Center Drills-Type A 60°



Specification Cutting Speed depending on Materials

HSS

Low carbon steels
低炭素鋼
10~25
(m/min)

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

Stainless steels
ステンレス鋼
5~10
(m/min)

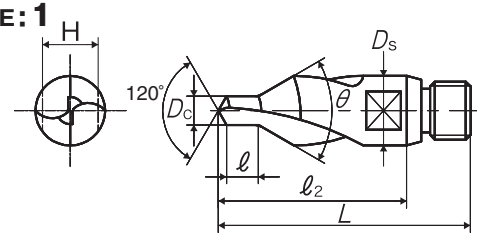
Brass
黄銅
20~40
(m/min)

Brass castings
黄銅鑄物
20~40
(m/min)

Wrought aluminum
アルミ圧延材
15~30
(m/min)

Aluminum alloy castings
アルミ合金鑄物
15~30
(m/min)

TYPE: 1



■ The JO-CES is a high helix JIS type A center hole drill joint tool that is particularly suitable for soft material and relatively free machining 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°	JCE4.0	4	10	37.5	4.5	27.5	8	14	8.5	1	¥ 3,090
5 × 60°	JCE5.0	5	12	43.5	5.5	32.5	10	16	10	1	¥ 3,180
6 × 60°	JCE6.0	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-CES V

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



Specification

HSS

Coating

Cutting Speed depending on Materials

Low carbon steels
低炭素鋼
15~30
(m/min)

Medium carbon steels
中炭素鋼
15~30
(m/min)

Stainless steels
ステンレス鋼
5~15
(m/min)

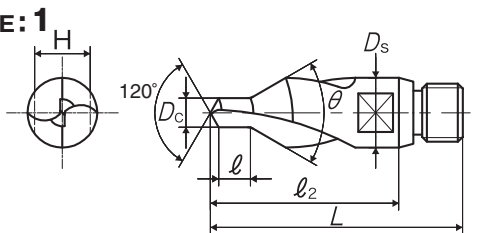
Brass
黄銅
25~30
(m/min)

Brass castings
黄銅鑄物
25~30
(m/min)

Wrought aluminum
アルミ圧延材
20~40
(m/min)

Aluminum alloy castings
アルミ合金鑄物
20~40
(m/min)

TYPE: 1



■ Optimum coating suitable for the cutting condition.

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°	JVCE4.0	4	10	37.5	4.5	27.5	8	14	8.5	1	¥ 5,450
5 × 60°	JVCE5.0	5	12	43.5	5.5	32.5	10	16	10	1	¥ 6,270
6 × 60°	JVCE6.0	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."