JIS

JO-CES

Joint- High Helix Center Drills-Type A 60°

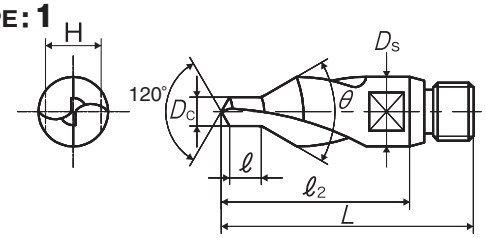
Specification

HSS

Cutting Speed depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅	Brass castings 黄銅鋳物	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物
10~25 (m/min)	10~25 (m/min)	5~10 (m/min)	20~40 (m/min)	20~40 (m/min)	15~30 (m/min)	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)	ℓ2 (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.”

JIS

JO-CES V

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

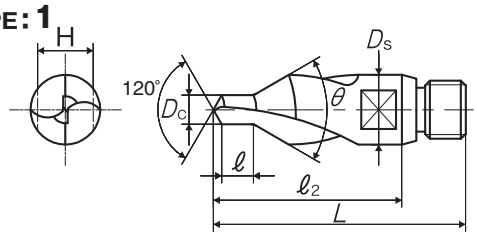
Specification

HSS Coating

Cutting Speed depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅	Brass castings 黄銅鋳物	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物
15~30 (m/min)	15~30 (m/min)	5~15 (m/min)	25~30 (m/min)	25~30 (m/min)	20~40 (m/min)	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)	ℓ2 (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.”

Think threads with YAMAWA