

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

CE-S

High Helix Center Drills-Type A 60°



Specification

HSS

■ High helix center drills - Type A suitable for soft or relatively tough materials.

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
5~10
(m/min)

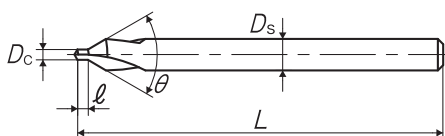
Brass
黄銅
25~50
(m/min)

Brass castings
黄銅鑄物
25~50
(m/min)

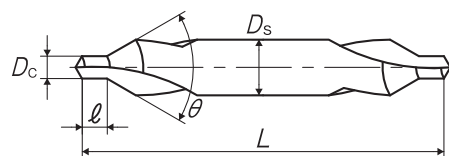
Wrought aluminum
アルミ圧延材
20~40
(m/min)

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

TYPE:1



TYPE:2



Unit: Inch

Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
0.3 × 60° × 3	CE0.3	0.3	3	35	0.3	1	1	¥ 2,280 *
0.4 × 60° × 3	CE0.4	0.4	3	35	0.4	1	1	¥ 2,080 *
0.5 × 60° × 3.5	CE0.5	0.5	3.5	35	0.5	1.5	2	¥ 3,010
0.6 × 60° × 3.5	CE0.6	0.6	3.5	35	0.6	1.5	2	¥ 2,730
0.7 × 60° × 3.5	CE0.7	0.7	3.5	35	0.7	2	2	¥ 2,420
0.8 × 60° × 3.5	CE0.8	0.8	3.5	35	0.8	2	2	¥ 2,070
0.9 × 60° × 4	CE0.9	0.9	4	35	0.9	2.5	2	¥ 1,940
1 × 60° × 4	CE1.0	1	4	35	1	2.5	2	¥ 1,700
1.2 × 60° × 5	CE1.2	1.2	5	40	1.2	3	2	¥ 1,550
1.5 × 60° × 5	CE1.5	1.5	5	40	1.5	4	2	¥ 1,330
2 × 60° × 6	CE2.0	2	6	45	2	5	2	¥ 1,480
2.5 × 60° × 7.7	CE2.5	2.5	7.7	50	2.5	6.5	2	¥ 1,810
3 × 60° × 7.7	CE3.0	3	7.7	55	3	6.5	2	¥ 1,810
3 × 60° × 8	CE3.0-8	3	8	55	3	6.5	2	¥ 1,940
4 × 60° × 10	CE4.0	4	10	65	4.5	8.5	2	¥ 3,610
5 × 60° × 11	CE5.0	5	11	78	5.5	9	2	¥ 3,900
5 × 60° × 12	CE5.0-12	5	12	78	5.5	10	2	¥ 4,830
6 × 60° × 16	CE6.0-16	6	16	90	6.5	13.5	2	¥ 9,370
6 × 60° × 18	CE6.0	6	18	90	6.5	15	2	¥ 13,200
8 × 60° × 18	CE8.0	8	18	100	8.5	15	2	¥ 15,100
10 × 60° × 18	CE010	10	18	100	11	15	2	¥ 15,100
12 × 60° × 25	CE012	12	25	120	13	21	2	¥ 32,000
1/16 × 60° × 5	CEU04	1/16	5	40	1.5	4	2	¥ 1,450 *
3/32 × 60° × 7.7	CEU06	3/32	7.7	50	2.5	6	2	¥ 1,990 *
1/8 × 60° × 7.7	CEU08	1/8	7.7	55	3	6.5	2	¥ 1,990 *
3/16 × 60° × 11	CEU12	3/16	11	78	5.5	9	2	¥ 4,340 *
1/4 × 60° × 18	CEU16	1/4	18	90	6.5	15	2	¥ 14,400 *

* 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."

* = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA