

11 Center Drills / Centering Tools

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

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

CESA

High Helix Center Drills-JIS Type A 60°



Specification

HSS

■ High helix center drills - JIS 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)

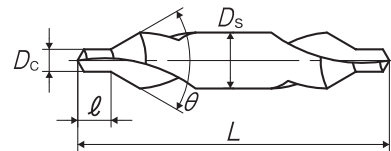
Brass
黄銅
25~50
(m/min)

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



Segment : 51

Size Dc × θ × Ds	Code	Dc (mm)	Ds (mm)	L (mm)	ℓ (mm)	Dw (mm)	TYPE	MSRP
0.5 × 60° × 3.15	CEA0.5	0.5	3.15	31.5	0.8	1.06	1	¥ 2,480
0.63 × 60° × 3.15	CEA0.63	0.63	3.15	31.5	1	1.32	1	¥ 2,230
0.8 × 60° × 3.15	CEA0.8	0.8	3.15	31.5	1.2	1.7	1	¥ 1,710
1 × 60° × 3.15	CEA1.0	1	3.15	31.5	1.5	2.12	1	¥ 1,520
1.25 × 60° × 3.15	CEA1.25	1.25	3.15	31.5	1.9	2.65	1	¥ 1,400
1.6 × 60° × 4	CEA1.6	1.6	4	35.5	2.4	3.35	1	¥ 1,340
2 × 60° × 5	CEA2.0	2	5	40	3	4.25	1	¥ 1,120
2.5 × 60° × 6.3	CEA2.5	2.5	6.3	45	3.8	5.3	1	¥ 1,210
3.15 × 60° × 8	CEA3.15	3.15	8	50	4.8	6.7	1	¥ 1,620
4 × 60° × 10	CEA4.0	4	10	56	6	8.5	1	¥ 2,960
5 × 60° × 12.5	CEA5.0	5	12.5	63	7.5	10.6	1	¥ 3,970
6.3 × 60° × 16	CEA6.3	6.3	16	71	9.2	13.2	1	¥ 7,660
8 × 60° × 20	CEA8.0	8	20	80	11.5	17	1	¥ 15,600
10 × 60° × 25	CEA010	10	25	100	14.2	21.2	1	¥ 27,300

- 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."