Bag full of wisdom when you are in trouble

Think threads with YAMAWA

No. 022

How to use Point Drills

Centering Type Cutting Tools

【Question】

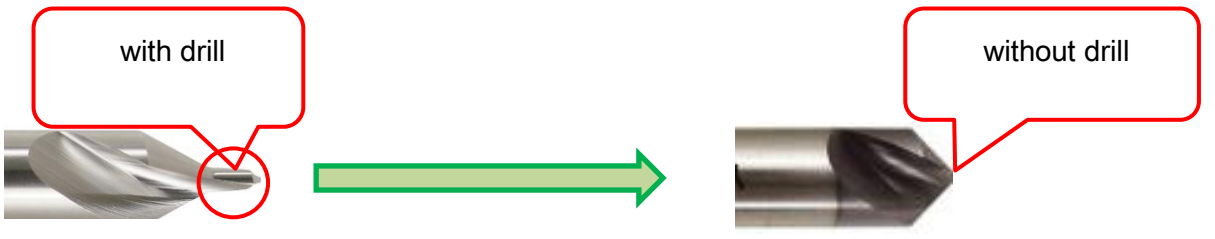
I have a surface finish problem on the drill diameter portion of Center Drills. I use them to create a center starting hole for tap drills and the drilled hole portion

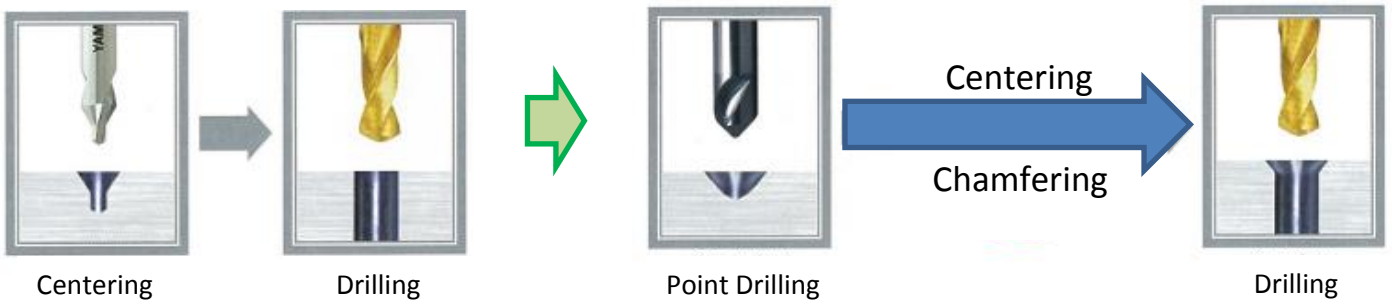
【Answer】

Please use Point Drills for spot drilling a centering hole prior to drilling. A Point Drill creates a guide for the drill to follow. Unlike Center Drills, Point Drills do not have a drill diameter portion so they should eliminate your problem.

【Solution】

Point Drills do not have a drill diameter portion for starting the centering hole. You can avoid problems like bad surface finishes that you may encounter when using Center Drills as a spot drill. (See following picture.) A Point Drill can also be used for hole or edge chamfering and angled channeling on flat workpieces as well as creating a center for starting drilled holes.
Note: Center Drills should be used exclusively to create angled holes that are used with stationary or live centers. The drill diameter portion of a center drill creates a clearance hole so the point of a stationary or live center never touches the bottom of the centered hole.





【Guide】

Yamawa Point Drills are offered as a 90° included angle PE-Q point drill and a 60° included angle PE-S Point Drill.
Additional Point Drills are offered as TiCN coated drills, long shanked drills, and carbide drills.
Point Drills have a high rigidity and are suitable for high speed center drilling. You can use Point Drills as a multi-purpose tool that can be used in various machining processes like hole chamfering, edge beveling and angled channeling.
See catalogs and leaflets for more information.