

No. 031

Easy recognition for Centering Drilling

Centering Type
Cutting Tools

【Question】

I noticed a description "JIS B 0041-B2.5/8" on a drawing.
Can you tell me what kind of tool I should use?

【Answer】

The term "JIS B 0041" defines a simplified illustration method of how to create center holes. It basically means a B shaped Center Drill size $\phi 2.5$ should be used. However, please refer to the following guidelines and recheck the drawing as the JIS B 0041 specification have very detailed regulations.

【Guidance】

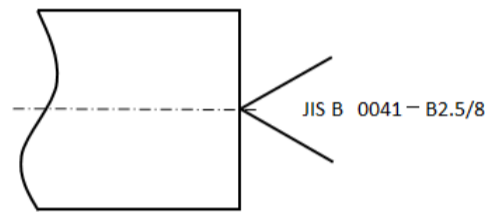
The letter "B" following the term "JIS B 0041" designates the type of center hole.

The number "2.5" designates the size of the drilled hole.

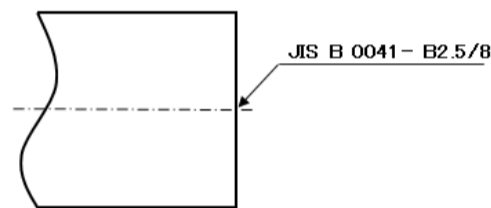
The "/8" designates the size of counter bore.

This indicates the tool you should select is a 2.5mm x 60° x 10mm B-Shaped Center Drill.

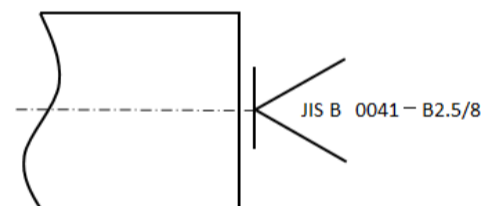
It is important to look carefully at the drawing as there are three different center holes finished with this mentioned.



Leave center holes on the finished surface.



Allowed to leave center holes on the finished



Prohibited from leaving center holes on the finished

【For your reference】

There are three Center Drills available for a "JIS B 0041-B2.5/8" specification.
Select the best one according to your center hole conditions.



CESB
High Helix Center Drills-JIS Type B
60°



CE-S(II)
Low Helix Center Drills-Type B 60°
(Old JIS Type 2)
2.5X60° X 12



CE-S(II)
High Helix Center Drills-Type B 60°
(Old JIS Type 2)
2.5X60° X 12