



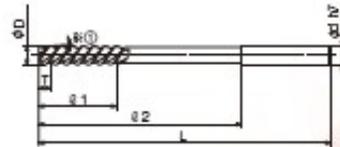
# ハイ・ヘリカル リーマ

[ Hi-Helical Reamer ]

※①刃付せ角度:  $\phi 1.50 \sim 4.49 \Rightarrow 3^\circ$   
 $\phi 4.50 \sim 10.20 \Rightarrow 2'30''$   
 $\phi 10.21 \sim 16.49 \Rightarrow 3^\circ$   
 ※①Chamfer angle for  $\phi 4.50 \sim 10.20 \text{mm}$  is  $2'30''$  instead of  $3^\circ$ .



商品コード: HHO.00  
 Product Code



## ■ 特長 [ Features of HI-Helical Reamer ]

コバルトハイス鋼を採用し、従来のハイスリーマに比べ工具寿命が向上。  
 Tool life is prolonged by using cobalt high-speed-steel, it better than old high-speed-steel reamer.

刃形状が左ネジレの為、切り屑が前方へスムーズに排出。  
 It enables excellent downward chip flow due to its left hand spiral flute.

## ■ 寸法表 [ HI-Helical Reamer Specification Table ]

刃径公差 (+0.005)  
 (Tolerance)  $\begin{matrix} +0.005 \\ 0 \end{matrix}$

0.01mmとび  
 Increment  
 単価:円 unit price: in JPY

型式・刃径φD (Diameter 呼び寸法)	刃長φ1 Flute Length	前下長φ2 Body Length	全長L Overall Length	食付長さT Chamfer Length	刃数 Number of Flutes	標準定価 Retail Price	
						1.0mm / 0.1mmとび Increment	0.01mmとび Increment
HH 1.50~1.59	10	25	45	2	2	19,250	21,590
HH 1.60~1.69						17,710	19,900
HH 1.70~1.79						16,430	18,500
HH 1.80~1.89						15,320	17,140
HH 1.90~1.99						14,050	15,770
HH 2.00	6,240	-					
HH 2.01~2.49	15	35	60	3	2	6,240	7,490
HH 2.50~2.89						6,240	7,490
HH 2.90~2.99						6,240	7,490
HH 3.00~3.49						4,810	5,760
HH 3.50~4.49						4,810	5,760
HH 4.50~5.49	25	60	90	3	2	4,810	5,760
HH 5.50~6.00						4,810	5,760
HH 6.01~6.49						5,230	6,280
HH 6.50~7.00						5,230	6,280
HH 7.01~7.49						5,880	7,070
HH 7.50~8.00	35	75	110	3	2	5,880	7,070
HH 8.01~8.49						6,240	7,490
HH 8.50~9.00						6,240	7,490
HH 9.01~9.49						6,840	8,220
HH 9.50~10.00						6,840	8,220
HH 10.01~10.49	40	90	125	3	2	7,260	8,720
HH 10.50~11.00						7,260	8,720
HH 11.01~11.49						9,780	11,710
HH 11.50~12.00						9,780	11,710
HH 12.01~12.49						10,450	12,480
HH 12.50~13.00	45	110	150	3	2	10,450	12,480
HH 13.01~13.49						10,450	12,480
HH 13.50~14.00						10,450	12,480
HH 14.01~14.49						12,360	14,780
HH 14.50~15.00						14,340	17,270
HH 15.01~15.49	50	115	160	3	2	17,770	21,310
HH 15.50~16.00						21,830	26,160
HH 16.01~16.49						26,940	32,380

## ■ 参考切削条件 [ Recommended Cutting Conditions ]

切削材 Workpiece	軟鋼 Mid Steels SS	炭素鋼 Carbon Steels S/C/O	合金鋼 Alloy Steels S/M/S/U	鋳鉄 Cast Iron P/CF/CD	リーマ径(φmm) Reamer Dia.		リーマ代(φmm) Removal Amount					
					I	II	I	II				
周速 (m/min) Cutting Speed	10 ~ 20	12 ~ 25	10 ~ 20	12 ~ 20	1	0.05	0.1	0.2				
					2	0.08						
					3							
					4							
					リーマ代 (φmm) Removal Amount	I	II	I	II	5	0.1	0.2
										6		
										7		
										8		

リーマ代の番号は条件表に対応  
 Removal amount is to be set according to size on right table  
 "Removal Amount" in reference to the upper table number I~II.

送り量に関しては P.4 の条件表をご参照下さい。  
 About feed, please check it on page 4.

受注生産につき、3本以上/1オーダーからの制作になります。  
 Made-to-order from 3pcs/size for order.

Carbide Drill

Carbide Reamers

Coarse Reamer

High Speed Steel Reamers

Made-to-order items