



超硬リーマ Rシリーズ オイルホール付

[R Series with Oil Hole]



限定サイズ
パープルコーティング (Purple Coating)
登録商標 第4202221号 Registered trademark
商品コード: CRO.000H
Product Code

■ 特長 [Features of R Series with Oil Hole]

オイルホールを付加することにより、加工時の熱影響を抑えることができ耐摩耗性が向上。
Addition of oil hole can reduce cutting heat emission and improve abrasion resistance.

製品長さを短く設定し、工具剛性を向上させ、更なる高精度加工を実現。
By setting a shortened product length, improved tool rigidity and higher precision reaming is possible.

Rシリーズと同様に、ステンレス等の難削材から超硬鋼まで加工が可能。
From stainless steel to hardened steels, to the R series can be used on difficult-to-cut materials.

刃径公差 +0.005/0を採用。
Tolerance is between 0mm to 0.005mm.

■ オイルホールの効果 [Effects of Oil Hole]

刃溝に備えた油穴から切削油を射出し、刃先へダイレクトに切削油が当たる事で、加工時の熱影響を抑えることが可能。
Makes heat effect down when cutting because cooling the cutting edge directly with cutting oil ejected from oil holes on flute.

※ より良い加工のために、内部給油と外部給油の併用を推奨いたします。
※ If you want better cutting result, please use a combination of inside oil and outside oil.



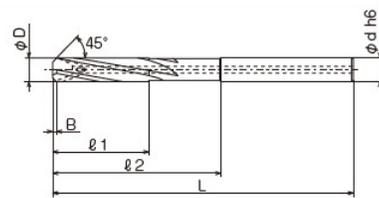
■ 参考切削条件 [Recommended Cutting Conditions]

| 切削材 Workpiece | 工速 Cutting Speed SMP/SPM | ステンレス Stainless Steel SUS | 超硬鋼 Quenched and Tempered Steels | | チタン合金 Titanium Alloy (Ti-6Al-4V) | リーマ径(φmm) Reamer Dia. | リーマ径(φmm) Removal Amount | |
|---------------------------------|--------------------------------|------------------------------------|--|----------|---|--------------------------|-----------------------------|-----|
| | | | ~ S04HRC | ~ S05HRC | | | I | II |
| 鋼 (S45C) | 15 ~ 30 | 10 ~ 20 | 9 ~ 18 | 6 ~ 12 | 10 ~ 20 | 5 | 0.1 | 0.1 |
| リーマ径 (φmm) Removal Amount | II | II | I | I | I | 6 | | 0.2 |
| | | | | | | 7 | | |
| | | | | | | 8 | | |
| | | | | | | 9 | | |
| | | | | | | 10 | 0.2 | 0.3 |

Removal amount is to be set according to size on right table "Removal Amount" in reference to the upper table number. 1~5 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.



■ 寸法表 [R Series with Oil Hole Specification Table]



刃径公差 (+0.005)
(Tolerance) (0)

(限定サイズ)
単価:円 unit price: in JPY

| 型式・刃径φD Diameter (呼び寸法) | 刃長 l1 Flute Length | 首下長 l2 Body Length | 全長 L Overall Length | シャンク径φd Shank Diameter | 食付き長B Chamfer Length | 刃数 Number of Flutes | 標準定価 Retail Price |
|-------------------------------|--------------------------|--------------------------|---------------------------|------------------------------|----------------------------|---------------------------|-------------------------|
| CR 4.970 H | | | | | | | 13,940 |
| CR 4.980 H | | | | | | | 13,940 |
| CR 4.990 H | | | | | 0.5 | | 13,940 |
| CR 5.000 H | | | | | | | 13,940 |
| CR 5.005 H | 20 | 35 | | 5.0 | | | 13,940 |
| CR 5.010 H | | | | | | | 13,940 |
| CR 5.020 H | | | | | | | 13,940 |
| CR 5.030 H | | | | | | | 13,940 |
| CR 5.970 H | | | 75 | | | | 15,550 |
| CR 5.980 H | | | | | | | 15,550 |
| CR 5.990 H | | | | | 0.8 | | 15,550 |
| CR 6.000 H | | | | | | | 15,550 |
| CR 6.005 H | | 42 | | 6.0 | | | 15,670 |
| CR 6.010 H | | | | | | 4 | 15,670 |
| CR 6.020 H | 24 | | | | | | 15,670 |
| CR 6.030 H | | | | | | | 15,670 |
| CR 8.000 H | | | | | | | 19,900 |
| CR 8.005 H | | | | | | | 20,210 |
| CR 8.010 H | | 48 | 85 | 8.0 | | | 20,210 |
| CR 8.020 H | | | | | | | 20,210 |
| CR 8.030 H | | | | | | | 20,210 |
| CR 10.000 H | | | | | 1.0 | | 31,320 |
| CR 10.005 H | | | | | | | 32,770 |
| CR 10.010 H | 30 | 60 | 110 | 10.0 | | | 32,770 |
| CR 10.020 H | | | | | | | 32,770 |
| CR 10.030 H | | | | | | | 32,770 |