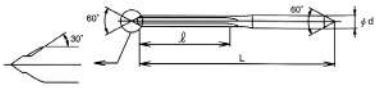
CSR Solid Carbide Reamer (Straight Shank)

ดอกรีมเมอร์คาร์ไบด์ ก้านตรง

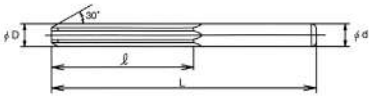
ผลิตจากทังสเตนคาร์ไบด์อย่างดี

Okazaki

โอกาซากิ



TYPE A:φ 1.0~φ 2.9



TYPE B:φ 3.0~φ 12.0



Unit : mm

KT Code	TOOL No.	D Dia.	l Flute length	L Overall length	d Shank Dia.	NT No. of teeth	ราคา
O081-CSR-0100	CSR-010	1.0	12	50	1.0	4	
O081-CSR-0150	CSR-015	1.5	15	50	1.5	4	
O081-CSR-0200	CSR-020	2.0	18	50	2.0	4	
O081-CSR-0210	CSR-021	2.1	20	50	2.5	4	
O081-CSR-0220	CSR-022	2.2	20	50	2.5	4	
O081-CSR-0230	CSR-023	2.3	20	50	2.5	4	
O081-CSR-0240	CSR-024	2.4	20	50	2.5	4	
O081-CSR-0250	CSR-025	2.5	20	50	2.5	4	
O081-CSR-0260	CSR-026	2.6	20	50	3.0	4	
O081-CSR-0270	CSR-027	2.7	20	50	3.0	4	
O081-CSR-0280	CSR-028	2.8	20	50	3.0	4	
O081-CSR-0290	CSR-029	2.9	20	50	3.0	4	
O081-CSR-0300	CSR-030	3.0	27	60	3.0	4	
O081-CSR-0310	CSR-031	3.1	27	60	3.5	4	
O081-CSR-0320	CSR-032	3.2	27	60	3.5	4	
O081-CSR-0330	CSR-033	3.3	27	60	3.5	4	
O081-CSR-0340	CSR-034	3.4	27	60	3.5	4	
O081-CSR-0350	CSR-035	3.5	27	60	3.5	4	
O081-CSR-0360	CSR-036	3.6	27	60	4.0	4	
O081-CSR-0370	CSR-037	3.7	27	60	4.0	4	
O081-CSR-0380	CSR-038	3.8	27	60	4.0	4	
O081-CSR-0390	CSR-039	3.9	27	60	4.0	4	
O081-CSR-0400	CSR-040	4.0	27	60	4.0	4	
O081-CSR-0410	CSR-041	4.1	30	70	4.5	6	
O081-CSR-0420	CSR-042	4.2	30	70	4.5	6	
O081-CSR-0430	CSR-043	4.3	30	70	4.5	6	
O081-CSR-0440	CSR-044	4.4	30	70	4.5	6	
O081-CSR-0450	CSR-045	4.5	30	70	4.5	6	
O081-CSR-0460	CSR-046	4.6	30	70	5.0	6	
O081-CSR-0470	CSR-047	4.7	30	70	5.0	6	
O081-CSR-0480	CSR-048	4.8	30	70	5.0	6	
O081-CSR-0490	CSR-049	4.9	30	70	5.0	6	
O081-CSR-0500	CSR-050	5.0	30	70	5.0	6	
O081-CSR-0550	CSR-055	5.5	30	80	5.5	6	
O081-CSR-0600	CSR-060	6.0	30	80	6.0	6	
O081-CSR-0650	CSR-065	6.5	35	80	7.0	6	
O081-CSR-0700	CSR-070	7.0	35	80	7.0	6	
O081-CSR-0750	CSR-075	7.5	35	80	8.0	6	
O081-CSR-0800	CSR-080	8.0	35	80	8.0	6	
O081-CSR-0850	CSR-085	8.5	40	90	9.0	6	
O081-CSR-0900	CSR-090	9.0	40	90	9.0	6	
O081-CSR-0950	CSR-095	9.5	40	90	10.0	6	
O081-CSR-1000	CSR-100	10.0	40	90	10.0	6	
O081-CSR-1050	CSR-105	10.5	40	90	11.0	6	
O081-CSR-1100	CSR-110	11.0	40	90	11.0	6	
O081-CSR-1150	CSR-115	11.5	45	90	12.0	6	
O081-CSR-1200	CSR-120	12.0	45	90	12.0	6	

TECHNICAL INFORMATION : CSR

ข้อมูลทางด้านเทคนิค ของดอกรีมเมอร์คาร์ไบด์ ก้านตรง

Recommended Drilling Conditions for CSR

Work Material		Carbon Steels, Alloy Steels (S55C, SKD, SUS)		Aluminum Alloys (A2024, AC8A)		Cast Iron (FC, FCD)	
Cutting Speed		5~9 m/min		10~20 m/min		9~12 m/min	
Drilling Condition: Dia. (mm) / Removal Amount (mm)		Spindle Speed (rpm)	Feed (mm/rev)	Spindle Speed (rpm)	Feed (mm/rev)	Spindle Speed (rpm)	Feed (mm/rev)
2	0.1 ~ 0.2	1000	0.1 ~ 0.2	2800	0.2 ~ 0.3	1800	0.2 ~ 0.3
4	0.1 ~ 0.2	500	0.1 ~ 0.2	1400	0.2 ~ 0.3	940	0.2 ~ 0.3
6	0.2 ~ 0.3	340	0.2 ~ 0.3	950	0.2 ~ 0.3	630	0.2 ~ 0.3
8	0.2 ~ 0.3	250	0.2 ~ 0.3	720	0.3 ~ 0.4	470	0.3 ~ 0.4
10	0.2 ~ 0.3	190	0.2 ~ 0.3	570	0.3 ~ 0.4	380	0.3 ~ 0.4
12	0.2 ~ 0.3	160	0.2 ~ 0.3	480	0.4 ~ 0.5	300	0.3 ~ 0.5

- **Applicable Work Material**

S50C Carbon Steels	SCM Alloy Steels	SKD Hardened Steels	SKD11 Hardened Steels	SUS304 Stainless Steels	FC Cast Iron	A7075 Aluminum Alloys
~30HRC	~40HRC	~50HRC	~60HRC			
○	○	○		○	○	○

1) Because the change of the appropriate drilling condition is remarkable because of the working condition and the machine tool used, it is necessary to adjust the reamer processing properly.
2) The cutting oil must use no water solubility cutting oil with lubricity enough.

- **Diameter tolerance table**

Dia.	Tolerance
1.0 ≤ Dia < 3.0	+0.006 +0.002
3.0 ≤ Dia < 6.0	+0.009 +0.004
6.0 ≤ Dia < 10.0	+0.012 +0.006
10.0 ≤ Dia < 12.0	+0.015 +0.007