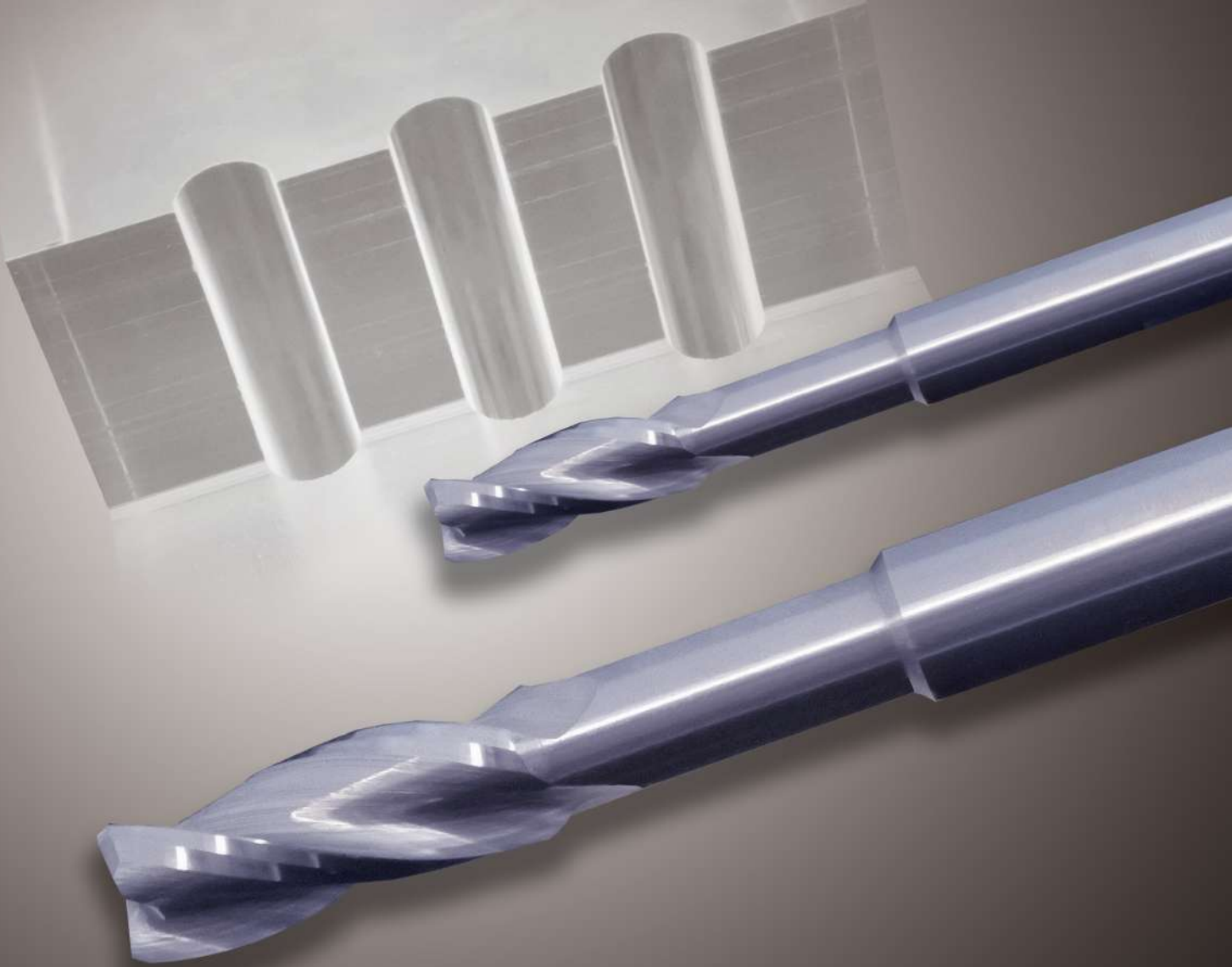


CSOER-Re

CARBIDE REAMER for RESIN (with Oil Hole)



** Unique flute geometry and larger gash surface enhance machinability.*

** The Oil Holes provide for better heat prevention and smoother chip discharge even in blind hole machining in resin workpiece.*



EIKOSHA CO., LTD.

<http://www.eiko-sha.co.jp/>



Cutting Condition Table

CSOER-Re



Dia.	Resin				Removal amount (mm/dia)
	Cutting speed				
	15~19m/min				
	Spindle speed rpm		Feed mm/min		
3	1,592	~ 2,016	127	~ 202	0.1
4	1,194	~ 1,512	96	~ 151	0.1
5	955	~ 1,210	76	~ 121	0.1
6	796	~ 1,008	64	~ 101	0.1
7	682	~ 864	55	~ 86	0.1
8	597	~ 756	48	~ 76	0.1
9	531	~ 672	42	~ 67	0.15
10	477	~ 605	38	~ 61	0.15
11	434	~ 550	35	~ 55	0.15
12	398	~ 504	32	~ 50	0.15



CAUTION

- It is not applicable for fiber reinforced resin workpieces.
- Both internal and external fed coolant are strongly recommended.
- The finished hole diameter may change depending on the inspection environment and storage conditions (room temperature and so on).
- Annealing treatment is required for high precision machining. A process to prevent residual stress that stays after heat generating machining process.



Watch the introduction video for Carbide Reamer for Resin (CSOER-Re) here.



We also produce Cutter Series for Resin. Watch the introduction video here.

CSOER-Re



CARBIDE REAMER for RESIN (with Oil Hole)



◇ 3 oil holes help prevent heat generation even in blind holes and

◇ Unique flute geometry and larger gash surface enhance machinability.

EIKO

EIKOSHA CO., LTD.



ISO 9001:2015

Head Office/Tokyo Sales Office

〒144-0052
3-16-12 Kamata Ota Ward 144-0052 Tokyo
TEL 03-3738-3970 FAX 03-3732-3665

Osaka Sales Office

〒532-0011
7-6-12 Nishinakajima Yodogawa Ward
532-0011 Osaka
TEL 06-6838-3936 FAX 06-6838-3937

EIKO

EIKOSHA CO., LTD.

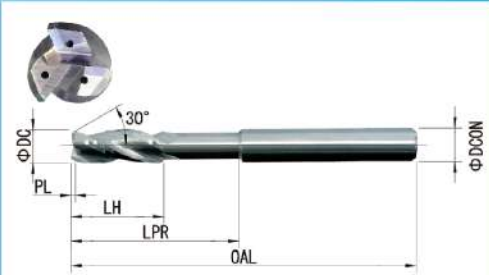
<http://www.eiko-sha.co.jp/>


EIKO TOOL



CSOER-Re

Carbide Reamer for Resin (with Oil Hole)



Helix Angle - Right 30° Chamfer Angle 30°
Ultra Micro Grain Carbide No. of Flutes 3

Helix Angle Right 24-30°
Chamfer Angle 45°
Ultra Micro Grain Carbide

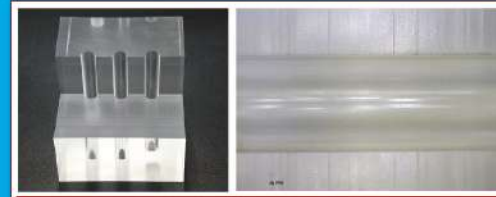
(Tolerance)	DC	DCON
	+0.005	h6
	0	

DC (mm)	Size(mm)					Retail Price
	OAL	DCON	LPR	LH	PL	
3	75	3	36	18	0.5	15,000
3.1	75	4	36	18	0.5	15,300
3.2	75	4	36	18	0.5	15,300
3.3	75	4	36	18	0.5	15,300
3.4	75	4	36	18	0.5	15,300
3.5	75	4	36	18	0.5	15,300
3.6	75	4	36	18	0.5	15,300
3.7	75	4	36	18	0.5	15,300
3.8	75	4	36	18	0.5	15,300
3.9	75	4	36	18	0.5	15,300
4	75	4	36	18	0.5	14,000
4.1	75	4	36	18	0.5	15,500
4.2	75	4	36	18	0.5	15,500
4.3	75	4	36	18	0.5	15,500
4.4	75	4	36	18	0.5	15,500
4.5	75	4	36	18	0.5	15,500
4.6	75	5	36	18	0.5	16,700
4.7	75	5	36	18	0.5	16,700
4.8	75	5	36	18	0.5	16,700
4.9	75	5	36	18	0.5	16,700
5	75	5	36	18	0.5	16,000
5.1	75	5	36	18	0.5	18,300
5.2	75	5	36	18	0.5	18,300
5.3	75	5	36	18	0.5	18,300
5.4	75	5	36	18	0.5	18,300
5.5	75	5	36	18	0.5	18,300
5.6	100	6	50	25	0.5	22,000
5.7	100	6	50	25	0.5	22,000
5.8	100	6	50	25	0.5	22,000
5.9	100	6	50	25	0.5	22,000
6	100	6	50	25	0.5	21,300
6.1	100	6	50	25	0.5	24,000
6.2	100	6	50	25	0.5	24,000
6.3	100	6	50	25	0.5	24,000
6.4	100	6	50	25	0.5	24,000
6.5	100	6	50	25	0.5	24,000
6.6	100	7	50	25	0.5	26,000
6.7	100	7	50	25	0.5	26,000
6.8	100	7	50	25	0.5	26,000
6.9	100	7	50	25	0.5	26,000
7	100	7	50	25	0.5	25,300
7.1	100	7	50	25	0.5	28,000
7.2	100	7	50	25	0.5	28,000
7.3	100	7	50	25	0.5	28,000
7.4	100	7	50	25	0.5	28,000

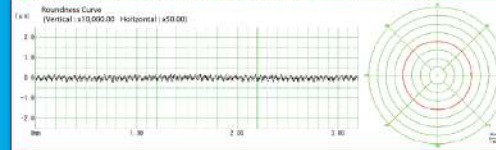
DC (mm)	Size(mm)					Retail Price
	OAL	DCON	LPR	LH	PL	
7.5	100	7	50	25	0.5	28,000
7.6	100	8	50	25	0.5	30,700
7.7	100	8	50	25	0.5	30,700
7.8	100	8	50	25	0.5	30,700
7.9	100	8	50	25	0.5	30,700
8	100	8	50	25	0.5	29,700
8.1	100	8	50	25	0.5	32,700
8.2	100	8	50	25	0.5	32,700
8.3	100	8	50	25	0.5	32,700
8.4	100	8	50	25	0.5	32,700
8.5	100	8	50	25	0.5	32,700
8.6	100	9	50	25	1	34,700
8.7	100	9	50	25	1	34,700
8.8	100	9	50	25	1	34,700
8.9	100	9	50	25	1	34,700
9	100	9	50	25	1	33,700
9.1	100	9	50	25	1	37,200
9.2	100	9	50	25	1	37,200
9.3	100	9	50	25	1	37,200
9.4	100	9	50	25	1	37,200
9.5	100	9	50	25	1	37,200
9.6	100	10	50	25	1	38,700
9.7	100	10	50	25	1	38,700
9.8	100	10	50	25	1	38,700
9.9	100	10	50	25	1	38,700
10	100	10	50	25	1	37,700
10.1	100	10	50	25	1	41,600
10.2	100	10	50	25	1	41,600
10.3	100	10	50	25	1	41,600
10.4	100	10	50	25	1	41,600
10.5	100	10	50	25	1	41,600
10.6	100	11	50	25	1	42,700
10.7	100	11	50	25	1	42,700
10.8	100	11	50	25	1	42,700
10.9	100	11	50	25	1	42,700
11	100	11	50	25	1	41,300
11.1	100	11	50	25	1	45,700
11.2	100	11	50	25	1	45,700
11.3	100	11	50	25	1	45,700
11.4	100	11	50	25	1	45,700
11.5	100	11	50	25	1	45,700
11.6	100	12	50	25	1	46,700
11.7	100	12	50	25	1	46,700
11.8	100	12	50	25	1	46,700
11.9	100	12	50	25	1	46,700
12	100	12	50	25	1	45,000

DC (mm)	Size(mm)					Retail Price
	OAL	DCON	LPR	LH	PL	
3.01~3.05	75	3	36	18	0.5	16,500
3.95~3.99	75	4	36	18	0.5	15,400
4.01~4.05	75	4	36	18	0.5	15,400
4.95~4.99	75	5	36	18	0.5	17,600
5.01~5.05	75	5	36	18	0.5	17,600
5.95~5.99	100	6	50	25	0.5	23,500
6.01~6.05	100	6	50	25	0.5	23,500
6.95~6.99	100	7	50	25	0.5	27,900
7.01~7.05	100	7	50	25	0.5	27,900
7.95~7.99	100	8	50	25	0.5	32,600
8.01~8.05	100	8	50	25	0.5	32,600
8.95~8.99	100	9	50	25	1	37,000
9.01~9.05	100	9	50	25	1	37,000
9.95~9.99	100	10	50	25	1	41,400
10.01~10.05	100	10	50	25	1	41,400
10.95~10.99	100	11	50	25	1	45,500
11.01~11.05	100	11	50	25	1	45,500
11.95~11.99	100	12	50	25	1	49,500
12.01~12.05	100	12	50	25	1	49,500

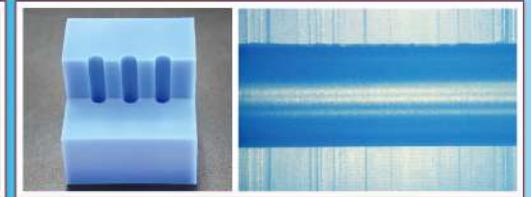
TECHNICAL DATA



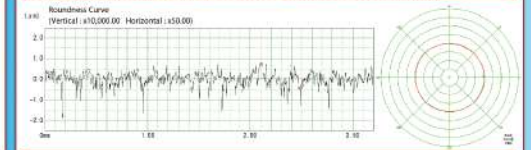
Acrylic
Cutting Condition : Spindle Speed:1,008 rpm , Feed:101mm/min



Surface Roughness Ra0.069 Rz0.426
Roundness Hole Diameter: 6.006 Roundness:0.001



MC Nylon
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min



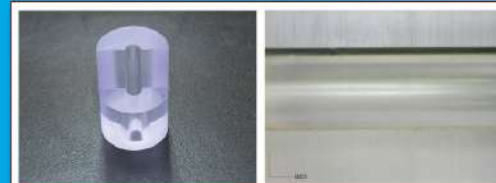
Surface Roughness Ra0.224 Rz2.202
Roundness Hole Diameter: 6.000 Roundness:0.003



Duracon
Cutting Condition : Spindle Speed:1,008 rpm , Feed:101mm/min



PPS
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min



PVC (Transparent)
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min



PEEK
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min



PVC Gray
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min



Bakelite
Cutting Condition : Spindle speed:1,008 rpm , Feed:101mm/min