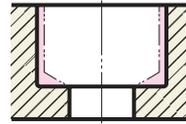


# NIKKEN CARBIDE RADICAL MILL REAMER LONG TYPE



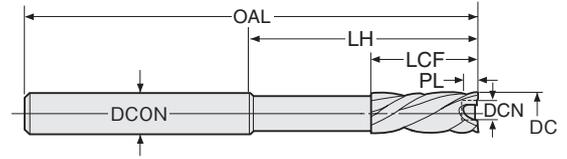
## RFS

For STEPPED HOLE  
Carbide Radical Mill Reamer (Long Type)



Explanation of the Code No.

**RFS** - **12.0**  
 • DIAMETER  
 • RADICAL MILLREAMER SERIES  
 RFS : STRAIGHT SHANK LONG TYPE FOR STEPPED HOLE



**MILLING BLADE** **LH-HELIX 30-35°** **TICN2 COAT** **P.133** \*See P.4 for icons.

STOCK: ●=STANDARD STOCK ITEM(IN JAPAN) △=PRODUCTION BY ORDER

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RFS-13.1	△	13.1	165	12	0.6	6.0	22	110
-13.2	△	13.2						
-13.3	△	13.3						
-13.4	△	13.4						
-13.5	△	13.5						
-13.6	△	13.6						
-13.7	△	13.7						
-13.8	△	13.8						
-13.9	△	13.9						
-13.97	△	13.97						
-13.98	△	13.98						
-13.99	△	13.99						
			170	16	0.6	7.0	22	115

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RFS-14.0	△	14.0	170	16	0.6	7.0	29	115
-14.01	△	14.01						
-14.02	△	14.02						
-14.03	△	14.03						
-14.04	△	14.04						
-14.05	△	14.05						
			180	16	0.6	7.0	29	120
-15.0	△	15.0						
-16.0	△	16.0						
-17.0	△	17.0						
-18.0	△	18.0						
-19.0	△	19.0						
-20.0	△	20.0						

★PL means chamfering length to DC.  
 ★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than DCN.  
 ★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

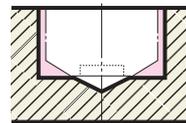
CARBIDE FOR STEPPED HOLE FOR BLIND HOLE

# NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER



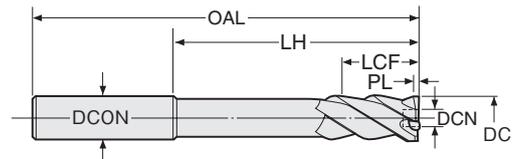
## RRSS-F

RIGHT HAND HELICAL For BLIND HOLE  
Radical Mill Reamer



Explanation of the Code No.

**RRSS** - **10.0** - **F**  
 • FOR BLIND HOLE  
 • DIAMETER  
 • RADICAL MILLREAMER SERIES  
 RRSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



**MILLING BLADE** **RH-HELIX 30-40°** **TICN2 COAT** **P.133** \*See P.4 for icons.

STOCK: ●=STANDARD STOCK ITEM(IN JAPAN) △=PRODUCTION BY ORDER

⚠ LCF must be longer than hole depth

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS- 2.97F	△	2.97	60	3	0.6	1.2	16	35
- 2.98F	△	2.98						
- 2.99F	△	2.99						
- 3.0 F	△	3.0						
- 3.01F	△	3.01						
- 3.02F	△	3.02						
- 3.03F	△	3.03						
- 3.04F	△	3.04						
- 3.05F	△	3.05						
- 3.1 F	△	3.1						
- 3.2 F	△	3.2						
- 3.3 F	△	3.3						
- 3.4 F	△	3.4						
- 3.5 F	△	3.5						
- 3.6 F	△	3.6						
- 3.7 F	△	3.7						
- 3.8 F	△	3.8						
- 3.9 F	△	3.9						
- 3.97F	△	3.97						
- 3.98F	△	3.98						
			60	4	0.6	2.0	18	35

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS- 3.99F	△	3.99	60	4	0.6	2.0	18	35
- 4.0 F	△	4.0						
- 4.01F	△	4.01						
- 4.02F	△	4.02						
- 4.03F	△	4.03						
- 4.04F	△	4.04						
- 4.05F	△	4.05						
			60	4	0.6	2.0	18	35
- 4.1 F	△	4.1						
- 4.2 F	△	4.2						
- 4.3 F	△	4.3						
- 4.4 F	△	4.4						
- 4.5 F	△	4.5						
- 4.6 F	△	4.6						
- 4.7 F	△	4.7						
- 4.8 F	△	4.8						
- 4.9 F	△	4.9						
- 4.97F	△	4.97						
- 4.98F	△	4.98						
- 4.99F	△	4.99						
			70	5	0.6	2.0	22	40
			70	5	0.6	2.5	22	40

★PL means chamfering length to DC.  
 ★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

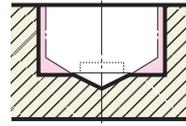
Next page >>>

# NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER



## RRSS-F

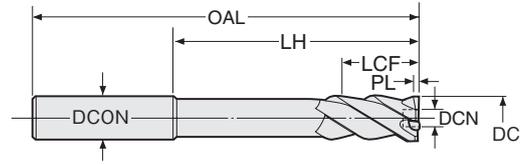
RIGHT HAND HELICAL For BLIND HOLE  
Radical Mill Reamer



Explanation of the Code No.

RRSS - 10.0 - F

- FOR BLIND HOLE
- DIAMETER
- RADICAL MILLREAMER SERIES
- RRSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



\*See P.4 for icons.

STOCK: ●=STANDARD STOCK ITEM(IN JAPAN) △=PRODUCTION BY ORDER

⚠ LCF must be longer than hole depth

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS- 5.01F	△	5.01	70	5	0.6	2.5	22	40
- 5.02F	△	5.02						
- 5.03F	△	5.03						
- 5.04F	△	5.04						
- 5.05F	△	5.05						
- 5.1 F	△	5.1						
- 5.2 F	△	5.2						
- 5.3 F	△	5.3	85	6	0.6	3.0	25	50
- 5.4 F	△	5.4						
- 5.5 F	△	5.5						
- 5.6 F	△	5.6						
- 5.7 F	△	5.7						
- 5.8 F	△	5.8						
- 5.9 F	△	5.9						
- 5.97F	△	5.97						
- 5.98F	△	5.98						
- 5.99F	△	5.99						
- 6.0 F	△	6.0	85	6	0.6	3.0	25	50
- 6.01F	△	6.01						
- 6.02F	△	6.02						
- 6.03F	△	6.03						
- 6.04F	△	6.04						
- 6.05F	△	6.05						
- 6.1 F	△	6.1						
- 6.2 F	△	6.2						
- 6.3 F	△	6.3						
- 6.4 F	△	6.4						
- 6.5 F	△	6.5	90	8	0.6	3.0	25	50
- 6.6 F	△	6.6						
- 6.7 F	△	6.7						
- 6.8 F	△	6.8						
- 6.9 F	△	6.9						
- 6.97F	△	6.97						
- 6.98F	△	6.98						
- 6.99F	△	6.99						
- 7.0 F	△	7.0						
- 7.01F	△	7.01						
- 7.02F	△	7.02	90	8	0.6	3.5	25	50
- 7.03F	△	7.03						
- 7.04F	△	7.04						
- 7.05F	△	7.05						
- 7.1 F	△	7.1						
- 7.2 F	△	7.2						
- 7.3 F	△	7.3						
- 7.4 F	△	7.4						
- 7.5 F	△	7.5						
- 7.6 F	△	7.6						
- 7.7 F	△	7.7	100	8	0.6	4.0	25	60
- 7.8 F	△	7.8						
- 7.9 F	△	7.9						
- 7.97F	△	7.97						
- 7.98F	△	7.98						
- 7.99F	△	7.99						
- 8.0 F	△	8.0						
- 8.01F	△	8.01						
- 8.02F	△	8.02						
- 8.03F	△	8.03						
- 8.04F	△	8.04						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS- 8.05F	△	8.05	100	8	0.6	4.0	25	60
- 8.1 F	△	8.1						
- 8.2 F	△	8.2						
- 8.3 F	△	8.3						
- 8.4 F	△	8.4						
- 8.5 F	△	8.5						
- 8.6 F	△	8.6						
- 8.7 F	△	8.7	105	10	0.6	4.5	25	60
- 8.8 F	△	8.8						
- 8.9 F	△	8.9						
- 8.97F	△	8.97						
- 8.98F	△	8.98						
- 8.99F	△	8.99						
- 9.0 F	△	9.0						
- 9.01F	△	9.01						
- 9.02F	△	9.02						
- 9.03F	△	9.03						
- 9.04F	△	9.04	105	10	0.6	4.5	25	60
- 9.05F	△	9.05						
- 9.1 F	△	9.1						
- 9.2 F	△	9.2						
- 9.3 F	△	9.3						
- 9.4 F	△	9.4						
- 9.5 F	△	9.5						
- 9.6 F	△	9.6						
- 9.7 F	△	9.7						
- 9.8 F	△	9.8						
- 9.9 F	△	9.9	110	10	0.6	5.0	29	60
- 9.97F	△	9.97						
- 9.98F	△	9.98						
- 9.99F	△	9.99						
- 10.0 F	△	10.0						
- 10.01F	△	10.01						
- 10.02F	△	10.02						
- 10.03F	△	10.03						
- 10.04F	△	10.04						
- 10.05F	△	10.05						
- 10.1 F	△	10.1	110	10	0.6	5.0	29	60
- 10.2 F	△	10.2						
- 10.3 F	△	10.3						
- 10.4 F	△	10.4						
- 10.5 F	△	10.5						
- 10.6 F	△	10.6						
- 10.7 F	△	10.7						
- 10.8 F	△	10.8						
- 10.9 F	△	10.9						
- 10.97F	△	10.97						
- 10.98F	△	10.98						
- 10.99F	△	10.99						
- 11.0 F	△	11.0	115	12	0.6	5.0	29	65
- 11.01F	△	11.01						
- 11.02F	△	11.02						
- 11.03F	△	11.03						
- 11.04F	△	11.04						
- 11.05F	△	11.05						
- 11.1 F	△	11.1						
- 11.2 F	△	11.2						
- 11.3 F	△	11.3						

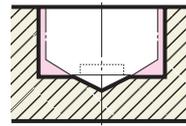
★PL means chamfering length to DC.  
★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

# NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER



## RRSS-F

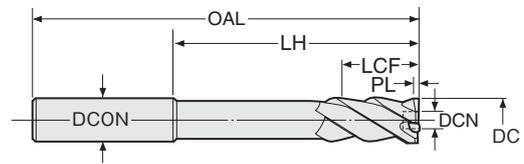
RIGHT HAND HELICAL For BLIND HOLE  
Radical Mill Reamer



Explanation of the Code No.

RRSS - 10.0 - F

- FOR BLIND HOLE
- DIAMETER
- RADICAL MILLREAMER SERIES
- RRSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



\*See P.4 for icons.

STOCK: ●=STANDARD STOCK ITEM(IN JAPAN) △=PRODUCTION BY ORDER

⚠ LCF must be longer than hole depth

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS-11.4 F	△	11.4	125	12	0.6	6.0	29	70
-11.5 F	△	11.5						
-11.6 F	△	11.6						
-11.7 F	△	11.7						
-11.8 F	△	11.8						
-11.9 F	△	11.9						
-11.97F	△	11.97						
-11.98F	△	11.98						
-11.99F	△	11.99						
-12.0 F	△	12.0						
-12.01F	△	12.01	125	12	0.6	6.0	29	70
-12.02F	△	12.02						
-12.03F	△	12.03						
-12.04F	△	12.04						
-12.05F	△	12.05						
-12.1 F	△	12.1						
-12.2 F	△	12.2						
-12.3 F	△	12.3						
-12.4 F	△	12.4						
-12.5 F	△	12.5						
-12.6 F	△	12.6	130	12	0.6	6.0	29	75
-12.7 F	△	12.7						
-12.8 F	△	12.8						
-12.9 F	△	12.9						
-12.97F	△	12.97						
-12.98F	△	12.98						
-12.99F	△	2.99						
-13.0 F	△	13.0						
-13.01F	△	13.01						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS-13.02F	△	13.02	130	16	0.6	7.0	29	75
-13.03F	△	13.03						
-13.04F	△	13.04						
-13.05F	△	13.05						
-13.1 F	△	13.1						
-13.2 F	△	13.2						
-13.3 F	△	13.3						
-13.4 F	△	13.4						
-13.5 F	△	13.5						
-13.6 F	△	13.6						
-13.7 F	△	13.7	130	16	0.6	7.0	29	75
-13.8 F	△	13.8						
-13.9 F	△	13.9						
-13.97F	△	13.97						
-13.98F	△	13.98						
-13.99F	△	13.99						
-14.0 F	△	14.0						
-14.01F	△	14.01						
-14.02F	△	14.02						
-14.03F	△	14.03						
-14.04F	△	14.04						
-14.05F	△	14.05						
-15.0 F	△	15.0	140	16	0.6	7.0	29	80
-16.0 F	△	16.0						
-17.0 F	△	17.0						
-18.0 F	△	18.0						
-19.0 F	△	19.0						
-20.0 F	△	20.0						

★PL means chamfering length to DC.

★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than DCN.

★Depending on the material, the chips may be tangled. When the hole depth is more than twice of the hole diameter, we recommend Right-Handed Helix Radical Reamer with OH. (P.27)

★This is not suitable to use on drilling machine due to tensile force of right-handed. Please use on machining center, NC lathe and milling machine.

★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

CARBIDE FOR BLIND HOLE

