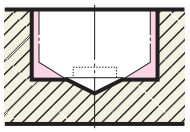
# NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER OH

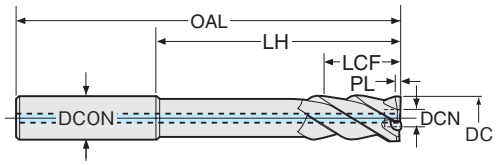
NIKKEN

## RRSS-F-OH

RIGHT HAND HELICAL For BLIND HOLE
**Radical Mill Reamer** (With Oil Hole)



Explanation of the Code No.
RRSS - 12.0 - F - OH
- OH: WITH OH
- F: FOR BLIND HOLE
- 12.0: DIAMETER
- RRSS: RADICAL MILLREAMER SERIES
  RRSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE




MILLING BLADE | RH-HELIX 30-40º | TiCN2 COAT | P.133 *See P.4 for icons.

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

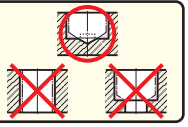
**MINIMUM DIAMETER : 5.0mm**

| Code No. | STOCK | DC H7 | OAL | DCON | PL | DCN | LCF | LH |
|---|---|---|---|---|---|---|---|---|
| RRSS- 5.0F-OH | △ | 5.0 | 70 | 5 | 0.6 | 2.5 | 22 | 40 |
| - 6.0F-OH | △ | 6.0 | 85 | 6 | 0.6 | 3.0 | 25 | 50 |
| - 6.5F-OH | △ | 6.5 | 90 | 8 | 0.6 | 3.0 | 25 | 50 |
| - 7.0F-OH | △ | 7.0 | 90 | 8 | 0.6 | 3.5 | 25 | 50 |
| - 7.5F-OH | △ | 7.5 | 100 | 8 | 0.6 | 4.0 | 25 | 60 |
| - 8.0F-OH | △ | 8.0 | | | | | | |
| - 8.5F-OH | △ | 8.5 | 105 | 10 | 0.6 | 4.5 | 25 | 60 |
| - 9.0F-OH | △ | 9.0 | | | | | | |
| - 9.5F-OH | △ | 9.5 | 110 | 10 | 0.6 | 5.0 | 29 | 60 |
| -10.0F-OH | △ | 10 | | | | | | |
| -10.5F-OH | △ | 10.5 | 115 | 12 | 0.6 | 5.0 | 29 | 65 |
| -11.0F-OH | △ | 11.0 | | | | | | |

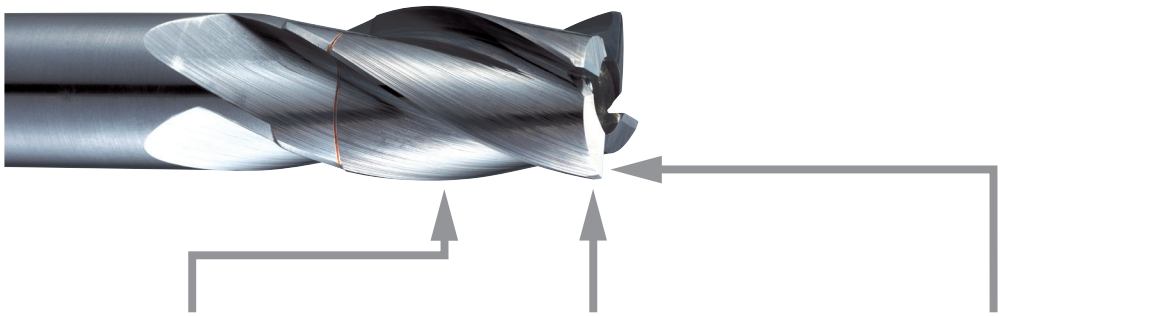
| Code No. | STOCK | DC H7 | OAL | DCON | PL | DCN | LCF | LH |
|---|---|---|---|---|---|---|---|---|
| RRSS-11.5F-OH | △ | 11.5 | 125 | 12 | 0.6 | 6.0 | 29 | 70 |
| -12.0F-OH | △ | 12.0 | | | | | | |
| -12.5F-OH | △ | 12.5 | 130 | 12 | 0.6 | 6.0 | 29 | 75 |
| -13.0F-OH | △ | 13.0 | | | | | | |
| -13.5F-OH | △ | 13.5 | 130 | 16 | 0.6 | 7.0 | 29 | 75 |
| -14.0F-OH | △ | 14.0 | | | | | | |
| -15.0F-OH | △ | 15.0 | 140 | 16 | 0.6 | 7.0 | 29 | 80 |
| -16.0F-OH | △ | 16.0 | 150 | 16 | 0.6 | 7.0 | 30 | 90 |
| -17.0F-OH | △ | 17.0 | 150 | 16 | 0.6 | 8.0 | 30 | 90 |
| -18.0F-OH | △ | 18.0 | 155 | 20 | 0.6 | 9.0 | 30 | 90 |
| -19.0F-OH | △ | 19.0 | 155 | 20 | 0.6 | 9.0 | 30 | 90 |
| -20.0F-OH | △ | 20.0 | 160 | 20 | 0.6 | 9.0 | 30 | 95 |

★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.
★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 fixed cycle if you finish the seating face.

⚠
- This is for blind hole. Please do not use for through hole or stepped hole.
- High pressure coolant is not etlective. The guide line of the coolant pressure is around 0.5-2.0Mpa.



## RIGHT-HANDED HELICAL REAMER STRUCTURE



**Burnishing**

This is a polishing section without cutting edge to clean up the roughness of the finished surface.

**Reamer blade (Finishing)**

Smooth finish is achieved by reamer blade for the optimal finishing removal from milling blade.

**Milling blade (Semi-Finish)**

Semi-finish (Optimal finishing removal) is achived by milling blade from drilled hole variation.

LINE UP OF RIGHT-HELIX REAMER

**RSS-F** ; POWDER HIGH-SPEED STEEL WITH ION NITRO PROCESSING
**RNS-F** ; POWDER HIGH-SPEED STEEL WITH **TiN** COATING
**RXS-F** ; K10 GRADE CARBIDE NON COATING
**RXS-F-DLC** ; K10 GRADE CARBIDE WITH **DLC** COATING
**RRSS-F** ; SUPERFINE PARTICLE CARBIDE WITH **TiCN2** COATING
**RRSS-F-DLC** ; SUPERFINE PARTICLE CARBIDE WITH **DLC** COATING
ALL REAMERS ARE WITH MILLING BLADE.