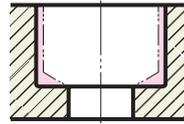


NIKKEN TOUGH-CUT SKILL REAMER



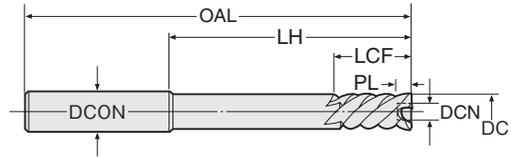
SRS-F

For STEPPED HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.

SRS - **10.0** - **F**
 • FOR STEPPED HOLE
 • DIAMETER
 • TOUGH-CUT SKILL REAMER SERIES
 SRS : STRAIGHT SHANK



MILLING BLADE

LH-HELIX 45°

PN

P.139

*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
SRS- 2.97F	△	2.97	70	3	0.6	1.5	20	45
- 2.98F	△	2.98						
- 2.99F	△	2.99						
- 3.0 F	△	3.0						
- 3.01F	△	3.01	70	3	0.6	1.5	20	45
- 3.02F	△	3.02						
- 3.03F	△	3.03						
- 3.1 F	△	3.1						
- 3.2 F	△	3.2	80	4	0.6	1.5	22	53
- 3.3 F	△	3.3						
- 3.4 F	△	3.4						
- 3.5 F	△	3.5						
- 3.6 F	△	3.6	80	4	0.6	1.5	22	53
- 3.7 F	△	3.7						
- 3.8 F	△	3.8						
- 3.9 F	△	3.9						
- 3.97F	△	3.97	90	5	0.6	2.0	24	60
- 3.98F	△	3.98						
- 3.99F	△	3.99						
- 4.0 F	△	4.0						
- 4.01F	△	4.01	90	5	0.6	2.0	24	60
- 4.02F	△	4.02						
- 4.03F	△	4.03						
- 4.04F	△	4.04						
- 4.05F	△	4.05	100	6	0.6	3.0	25	65
- 4.1 F	△	4.1						
- 4.2 F	△	4.2						
- 4.3 F	△	4.3						
- 4.4 F	△	4.4	100	6	0.6	3.0	25	65
- 4.5 F	△	4.5						
- 4.6 F	△	4.6						
- 4.7 F	△	4.7						
- 4.8 F	△	4.8	100	6	0.6	3.0	25	65
- 4.9 F	△	4.9						
- 4.97F	△	4.97						
- 4.98F	△	4.98						
- 4.99F	△	4.99	100	6	0.6	3.0	25	65
- 5.0 F	●	5.0						
- 5.01F	△	5.01						
- 5.02F	△	5.02						
- 5.03F	△	5.03	100	6	0.6	3.0	25	65
- 5.04F	△	5.04						
- 5.05F	△	5.05						
- 5.1 F	△	5.1						
- 5.2 F	△	5.2	100	6	0.6	3.0	25	65
- 5.3 F	△	5.3						
- 5.4 F	△	5.4						
- 5.5 F	△	5.5						
- 5.6 F	△	5.6	100	6	0.6	3.0	25	65
- 5.7 F	△	5.7						
- 5.8 F	△	5.8						
- 5.9 F	△	5.9						
- 5.97F	△	5.97	100	6	0.6	3.0	25	65
- 5.98F	△	5.98						
- 5.99F	△	5.99						
- 6.0 F	●	6.0						
- 6.01F	△	6.01	100	6	0.6	3.0	25	65
- 6.02F	△	6.02						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
SRS- 6.03F	△	6.03	100	6	0.6	3.0	25	65
- 6.04F	△	6.04						
- 6.05F	△	6.05						
- 6.1 F	△	6.1						
- 6.2 F	△	6.2	110	8	0.6	3.0	25	70
- 6.3 F	△	6.3						
- 6.4 F	△	6.4						
- 6.5 F	●	6.5						
- 6.6 F	△	6.6	110	8	0.6	3.0	25	70
- 6.7 F	△	6.7						
- 6.8 F	△	6.8						
- 6.9 F	△	6.9						
- 6.97F	△	6.97	110	8	0.6	3.0	25	70
- 6.98F	△	6.98						
- 6.99F	△	6.99						
- 7.0 F	●	7.0						
- 7.01F	△	7.01	110	8	0.6	3.0	25	70
- 7.02F	△	7.02						
- 7.03F	△	7.03						
- 7.04F	△	7.04						
- 7.05F	△	7.05	110	8	0.6	3.0	25	70
- 7.1 F	△	7.1						
- 7.2 F	△	7.2						
- 7.3 F	△	7.3						
- 7.4 F	△	7.4	125	8	0.6	3.5	25	85
- 7.5 F	●	7.5						
- 7.6 F	△	7.6						
- 7.7 F	△	7.7						
- 7.8 F	△	7.8	125	8	0.6	3.5	25	85
- 7.9 F	△	7.9						
- 7.97F	△	7.97						
- 7.98F	△	7.98						
- 7.99F	△	7.99	125	8	0.6	3.5	25	85
- 8.0 F	●	8.0						
- 8.01F	△	8.01						
- 8.02F	△	8.02						
- 8.03F	△	8.03	125	8	0.6	3.5	25	85
- 8.04F	△	8.04						
- 8.05F	△	8.05						
- 8.1 F	△	8.1						
- 8.2 F	△	8.2	135	10	0.6	4.0	30	90
- 8.3 F	△	8.3						
- 8.4 F	△	8.4						
- 8.5 F	●	8.5						
- 8.6 F	△	8.6	135	10	0.6	4.0	30	90
- 8.7 F	△	8.7						
- 8.8 F	△	8.8						
- 8.9 F	△	8.9						
- 8.97F	△	8.97	135	10	0.6	4.0	30	90
- 8.98F	△	8.98						
- 8.99F	△	8.99						
- 9.0 F	●	9.0						
- 9.01F	△	9.01	135	10	0.6	4.0	30	90
- 9.02F	△	9.02						
- 9.03F	△	9.03						
- 9.04F	△	9.04						
- 9.05F	△	9.05	135	10	0.6	4.0	30	90
- 9.1 F	△	9.1						

★PL means chamfering length to DC.

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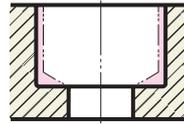
HSS FOR STEPPED HOLE

NIKKEN TOUGH-CUT SKILL REAMER



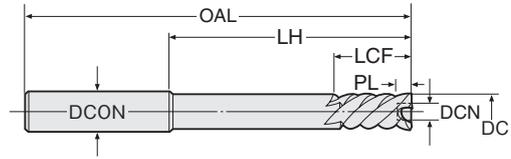
SRS-F

For STEPPED HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.

SRS - **10.0** - **F**
 ● FOR STEPPED HOLE
 ● DIAMETER
 ● TOUGH-CUT SKILL REAMER SERIES
 SRS : STRAIGHT SHANK



MILLING BLADE

LH-HELIX 45°

PN

P.139

*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
SRS- 9.2 F	△	9.2	135	10	0.6	4.0	30	90
- 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	150	10	0.6	4.5	30	100
- 9.9 F	△	9.9						
- 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	150	10	0.6	4.5	30	100
-10.05F	△	10.05						
-10.1 F	△	10.1						
-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	155	12	0.6	4.5	30	105
-10.9 F	△	10.9						
-10.97F	△	10.97						
-10.98F	△	10.98						
-10.99F	△	10.99						
-11.0 F	●	11.0						
-11.01F	△	11.01						
-11.02F	△	11.02						
-11.03F	△	11.03						
-11.04F	△	11.04	155	12	0.6	4.5	30	105
-11.05F	△	11.05						
-11.1 F	△	11.1						
-11.2 F	△	11.2						
-11.3 F	△	11.3						
-11.4 F	△	11.4						
-11.5 F	●	11.5						
-11.6 F	△	11.6						
-11.7 F	△	11.7						
-11.8 F	△	11.8	160	12	0.6	5.5	30	105
-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						
-12.02F	△	12.02						
-12.03F	△	12.03						
-12.04F	△	12.04	160	12	0.6	5.5	30	105
-12.05F	△	12.05						
-12.1 F	△	12.1						
-12.2 F	△	12.2						
-12.3 F	△	12.3	165	12	0.6	5.5	30	110

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
SRS-12.4 F	△	12.4						
-12.5 F	●	12.5						
-12.6 F	△	12.6						
-12.7 F	△	12.7						
-12.8 F	△	12.8						
-12.9 F	△	12.9	165	12	0.6	5.5	30	110
-12.97F	△	12.97						
-12.98F	△	12.98						
-12.99F	△	12.99						
-13.0 F	●	13.0						
-13.01F	△	13.01						
-13.02F	△	13.02						
-13.03F	△	13.03						
-13.04F	△	13.04	165	12	0.6	5.5	30	110
-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						
-13.8 F	△	13.8	170	16	0.6	6.5	35	115
-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	170	16	0.6	6.5	35	115
-14.04F	△	14.04						
-14.05F	△	14.05						
-14.5 F	△	14.5	180	16	0.6	6.5	35	120
-15.0 F	△	15.0						
-15.5 F	△	15.5	185	16	0.6	6.5	35	125
-16.0 F	△	16.0						
-16.5 F	△	16.5	185	16	0.6	7.0	35	125
-17.0 F	△	17.0						
-17.5 F	△	17.5						
-18.0 F	△	18.0						
-18.5 F	△	18.5	195	20	0.6	8.0	40	130
-19.0 F	△	19.0						
-19.5 F	△	19.5	205	20	0.6	9.0	40	140
-20.0 F	△	20.0						
-21.0 F	△	21.0	215	20	0.6	9.0	40	150
-22.0 F	△	22.0	215	20	0.6	10.0	40	150
-23.0 F	△	23.0	230	25	0.6	11.0	40	160
-24.0 F	△	24.0						
-25.0 F	△	25.0	230	25	0.6	12.0	40	160
-26.0 F	△	26.0						
-27.0 F	△	27.0	230	25	0.6	13.0	40	160
-28.0 F	△	28.0	240	32	0.6	14.0	45	160
-29.0 F	△	29.0						
-30.0 F	△	30.0	240	32	0.6	15.0	45	160

★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 use right-hand helix reamer when there are not enough space for the chips. (P.98~P.101)

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

HSS FOR STEPPED HOLE

