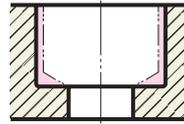


NIKKEN TOUGH-CUT SKILL REAMER

NIKKEN

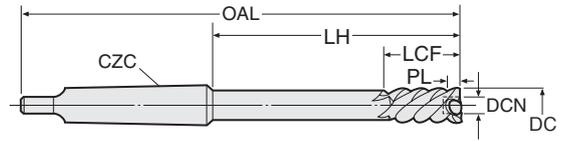
SRM-F

For STEPPED HOLE
Tough-Cut Skill Reamer (Morse Taper Shank)



Explanation of the Code No.

SRM - 10.0 - F
 • FOR STEPPED HOLE
 • DIAMETER
 • TOUGH-CUT SKILL REAMER SERIES
 SRM : MORSE TAPER 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	CZC	PL	DCN	LCF	LH
SRM- 74.0F	●	74.0	400	MT5	1.5	52.0	65	244
- 75.0F	●	75.0						
- 76.0F	●	76.0						
- 77.0F	●	77.0						
- 78.0F	●	78.0						
- 79.0F	●	79.0						
- 80.0F	●	80.0						
- 81.0F	●	81.0	400	MT5	1.5	58.0	65	244
- 82.0F	●	82.0						
- 83.0F	●	83.0						
- 84.0F	●	84.0						
- 85.0F	●	85.0						
- 86.0F	●	86.0						
- 87.0F	●	87.0						

Code No.	STOCK	DC H7	OAL	CZC	PL	DCN	LCF	LH
SRM- 88.0F	●	88.0	400	MT5	1.5	60.0	65	244
- 89.0F	●	89.0						
- 90.0F	●	90.0						
- 91.0F	●	91.0						
- 92.0F	●	92.0						
- 93.0F	●	93.0						
- 94.0F	●	94.0						
- 95.0F	●	95.0						
- 96.0F	●	96.0						
- 97.0F	●	97.0						
- 98.0F	●	98.0	400	MT5	1.5	68.0	65	244
- 99.0F	●	99.0						
- 100.0F	●	100.0						

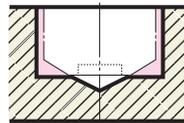
- ★PL means chamfering length to DC.
- ★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than DCN.
- ★Please use right-handed helix reamer when there are not enough space for the chips. ☞ P.98-101
- ★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

NIKKEN TOUGH-CUT SKILL REAMER

NIKKEN

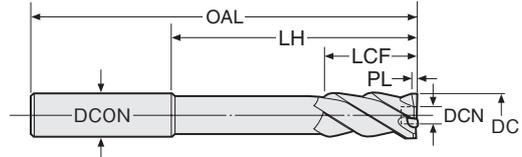
RSS-F

RIGHT HAND HELICAL For BLIND HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.

RSS - 10.0 - F
 • FOR BLIND HOLE
 • DIAMETER
 • TOUGH-CUT SKILL REAMER SERIES
 RSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



MILLING BLADE

RH-HELIX 30-40°

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
RSS- 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						
- 3.02F	△	3.02						
- 3.03F	△	3.03						
- 3.04F	△	3.04	70	3	0.6	1.5	20	45
- 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	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						
- 3.98F	△	3.98						

⚠ LCF must be longer than hole depth

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSS- 3.99F	△	3.99	80	4	0.6	1.5	22	53
- 4.0 F	△	4.0						
- 4.01F	△	4.01						
- 4.02F	△	4.02	80	4	0.6	1.5	22	53
- 4.03F	△	4.03						
- 4.04F	△	4.04						
- 4.05F	△	4.05	90	5	0.6	2.0	22	60
- 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	90	5	0.6	2.0	24	60
- 4.8 F	△	4.8						
- 4.9 F	△	4.9						
- 4.97F	△	4.97						
- 4.98F	△	4.98						
- 4.99F	△	4.99						
- 5.0 F	●	5.0						

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

Next page

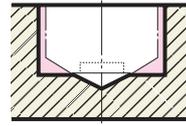
HSS FOR STEPPED HOLE FOR BLIND HOLE

NIKKEN TOUGH-CUT SKILL REAMER



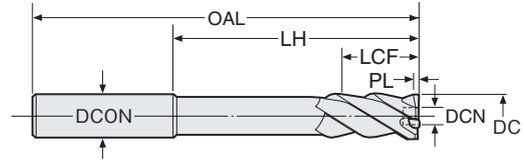
RSS-F

RIGHT HAND HELICAL For BLIND HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.

RSS - **10.0** - **F**
 • FOR BLIND HOLE
 • DIAMETER
 • TOUGH-CUT SKILL REAMER SERIES
 RSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



MILLING BLADE

RH-HELIX 30°

PN

P.139

*See P.4 for icons.

⚠ LCF must be longer than hole depth

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

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSS- 5.01F	△	5.01	90	5	0.6	2.0	24	60
- 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						
- 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						
- 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						
- 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						
- 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						
- 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
RSS- 8.05F	△	8.05	125	8	0.6	3.5	25	85
- 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						
- 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						
- 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						
- 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						
-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						
-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.

▶Next page ▶▶▶▶

HSS

FOR BLIND HOLE

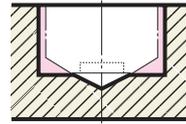


NIKKEN TOUGH-CUT SKILL REAMER

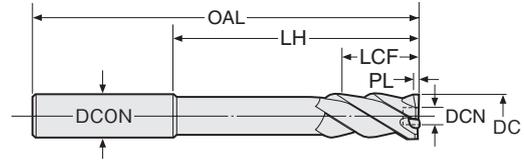


RSS-F

RIGHT HAND HELICAL For BLIND HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.
RSS - 10.0 - F
 • FOR BLIND HOLE
 • DIAMETER
 • TOUGH-CUT SKILL REAMER SERIES
 RSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



MILLING BLADE

RH-HELIX 30°

PN

P.139

*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						
RSS-11.4 F	△	11.4	160	12	0.6	5.5	30	105						
-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	160	12	0.6	5.5	30	105						
-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	165	12	0.6	5.5	30	110						
-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	△	12.99												
-13.0 F	●	13.0												
-13.01F	△	13.01							165	12	0.6	5.5	30	110
-13.02F	△	13.02												
-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	170	16	0.6	6.5	35	115						
-13.6 F	△	13.6												
-13.7 F	△	13.7												
-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							170	16	0.6	6.5	35	115
-14.02F	△	14.02												
-14.03F	△	14.03												
-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	195	20	0.6	8.0	40	130						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSS-18.0 F	●	18.0	195	20	0.6	8.0	40	130
-18.5 F	△	18.5						
-19.0 F	●	19.0						
-19.5 F	△	19.5	205	20	0.6	9.0	40	140
-20.0 F	●	20.0						
-20.5 F	△	20.5	215	20	0.6	9.0	40	150
-21.0 F	●	21.0						
-21.5 F	△	21.5	215	20	0.6	10.0	40	150
-22.0 F	●	22.0						
-22.5 F	△	22.5	230	25	0.6	11.0	40	160
-23.0 F	●	23.0						
-23.5 F	△	23.5						
-24.0 F	●	24.0						
-24.5 F	△	24.5						
-25.0 F	●	25.0	230	25	0.6	12.0	40	160
-25.5 F	△	25.5						
-26.0 F	●	26.0	230	25	0.6	13.0	40	160
-26.5 F	△	26.5						
-27.0 F	●	27.0						
-27.5 F	△	27.5	240	32	0.9	14.0	45	160
-28.0 F	●	28.0						
-28.5 F	△	28.5	240	32	0.9	15.0	45	160
-29.0 F	●	29.0						
-29.5 F	△	29.5						
-30.0 F	●	30.0						
-31.0 F	●	31.0						
-32.0 F	●	32.0						
-33.0 F	●	33.0	280	32	0.9	17	45	200
-34.0 F	●	34.0						
-35.0 F	●	35.0	280	32	0.9	19	48	200
-36.0 F	●	36.0						
-37.0 F	●	37.0	285	32	0.9	19	48	205
-38.0 F	●	38.0						
-39.0 F	●	39.0	285	32	0.9	21	52	205
-40.0 F	●	40.0						
-41.0 F	●	41.0	285	32	1.2	23	55	205
-42.0 F	●	42.0						
-43.0 F	●	43.0	290	32	1.2	24	55	210
-44.0 F	●	44.0						
-45.0 F	●	45.0	290	32	1.2	25	55	210
-46.0 F	●	46.0						
-47.0 F	●	47.0	295	32	1.2	26	60	215
-48.0 F	●	48.0						
-49.0 F	●	49.0	310	32	1.2	27	60	230
-50.0 F	●	50.0						
-51.0 F	●	51.0	310	32	1.2	28	60	230
-52.0 F	●	52.0						
-53.0 F	●	53.0	310	32	1.2	30	60	230
-54.0 F	●	54.0						
-55.0 F	●	55.0	320	32	1.2	33	60	230
-56.0 F	●	56.0						
-57.0 F	●	57.0	320	32	1.2	34	60	240
-58.0 F	●	58.0						
-59.0 F	●	59.0	320	32	1.2	35	60	240
-60.0 F	●	60.0						
-61.0 F	●	61.0	320	32	1.2	36	60	240
-62.0 F	●	62.0						
-63.0 F	●	63.0	320	32	1.2	37	60	240

*PL means chamfering length to DC.

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

▶Next page

HSS FOR BLIND HOLE

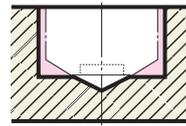


NIKKEN TOUGH-CUT SKILL REAMER



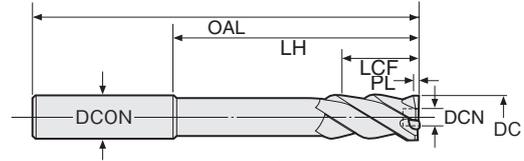
RSS-F

RIGHT HAND HELICAL For BLIND HOLE
Tough-Cut Skill Reamer (Straight Shank)



Explanation of the Code No.

RSS - 10.0 - F
 ● FOR BLIND HOLE
 ● DIAMETER
 ● TOUGH-CUT SKILL REAMER SERIES
 RSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



⚠ LCF must be longer than hole depth

MILLING BLADE RH-HELIX 30° 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
RSS- 64.0F	●	64.0	320	32	1.2	42	60	240
- 65.0F	●	65.0	320	42	1.2	45	65	240
- 66.0F	●	66.0	330	42	1.2	45	65	240
- 67.0F	●	67.0						
- 68.0F	●	68.0	330	42	1.2	48	65	240
- 69.0F	●	69.0						
- 70.0F	●	70.0						
- 71.0F	●	71.0	330	42	1.2	50	65	240
- 72.0F	●	72.0						
- 73.0F	●	73.0	330	42	1.2	52	65	240
- 74.0F	●	74.0						
- 75.0F	●	75.0						
- 76.0F	●	76.0	330	42	1.2	52	65	240
- 77.0F	●	77.0						
- 78.0F	●	78.0	330	42	1.2	55	65	240
- 79.0F	●	79.0						
- 80.0F	●	80.0						
- 81.0F	●	81.0	330	42	1.2	58	65	240
- 82.0F	●	82.0						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSS- 83.0F	●	83.0	330	42	1.2	58	65	240
- 84.0F	●	84.0	330	42	1.2	60	65	240
- 85.0F	●	85.0						
- 86.0F	●	86.0	330	42	1.2	60	65	240
- 87.0F	●	87.0						
- 88.0F	●	88.0						
- 89.0F	●	89.0	330	42	1.2	62	65	240
- 90.0F	●	90.0						
- 91.0F	●	91.0	330	42	1.2	62	65	240
- 92.0F	●	92.0						
- 93.0F	●	93.0	330	42	1.2	65	65	240
- 94.0F	●	94.0						
- 95.0F	●	95.0						
- 96.0F	●	96.0	330	42	1.2	68	65	240
- 97.0F	●	97.0						
- 98.0F	●	98.0	330	42	1.2	70	65	240
- 99.0F	●	99.0						
-100.0F	●	100.0	330	42	1.2	70	65	240

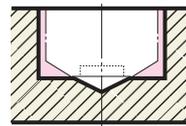
- ★PL means chamfering length to DC.
- ★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than DCN.
- ★Depending on the material, the chips may be tangled. When the hole depth is more than twice of the hole diameter, we recommend Right-Handed Helix Radical Reamer with OH. Please see below.
- ★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.

NIKKEN TOUGH-CUT SKILL REAMER WITH OH



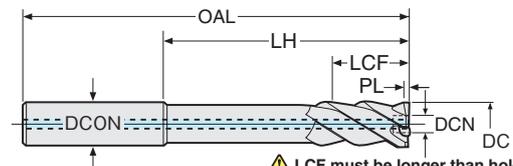
RSS-F-OH

RIGHT HAND HELICAL For BLIND HOLE
Tough-Cut Skill Reamer (Oil Hoal)



Explanation of the Code No.

RSS - 10.0 - F - OH
 ● FOR BLIND HOLE
 ● FOR BLIND HOLE
 ● DIAMETER
 ● TOUGH-CUT SKILL REAMER SERIES
 RSS : STRAIGHT SHANK RIGHT HAND HELICAL FOR BLIND HOLE



⚠ LCF must be longer than hole depth

MILLING BLADE RH-HELIX 30° 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
RSS- 5.0F-OH	△	5.0	90	5	0.6	2.0	24	60
- 6.0F-OH	△	6.0	100	6	0.6	3.0	25	65
- 6.5F-OH	△	6.5	110	8	0.6	3.0	25	70
- 7.0F-OH	△	7.0	110	8	0.6	3.0	25	70
- 7.5F-OH	△	7.5	110	8	0.6	3.0	25	70
- 8.0F-OH	△	8.0	125	8	0.6	3.5	25	85
- 8.5F-OH	△	8.5	135	10	0.6	4.0	30	90
- 9.0F-OH	△	9.0						
- 9.5F-OH	△	9.5	150	10	0.6	4.5	30	100
-10.0F-OH	△	10.0						
-10.5F-OH	△	10.5	155	12	0.6	4.5	30	105
-11.0F-OH	△	11.0						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSS-11.5F-OH	△	11.5	160	12	0.6	5.5	30	105
-12.0F-OH	△	12.0	165	12	0.6	5.5	30	110
-12.5F-OH	△	12.5						
-13.0F-OH	△	13.0	170	16	0.6	6.5	35	115
-13.5F-OH	△	13.5						
-14.0F-OH	△	14.0	180	16	0.6	6.5	35	120
-15.0F-OH	△	15.0						
-16.0F-OH	△	16.0	185	16	0.6	6.5	35	125
-17.0F-OH	△	17.0						
-18.0F-OH	△	18.0	195	20	0.6	8.0	40	130
-19.0F-OH	△	19.0						
-20.0F-OH	△	20.0	205	20	0.6	9.0	40	140

- ★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 G86.



-This is for blind hole. Please do not use for through hole or stepped hole. Radical mill reamer with OH for blind hole is also available. P.27
 -High pressure coolant is not effective. The guide line of the coolant pressure is around 0.5-2.0Mpa.

