

Short Reamer for CNC Automatic Turning Machine

TURNING SKILL REAMER

Reaming operation optimized to minimize tool interference

Compact shape
High speed machining
High rigidity

NEW



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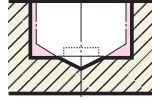
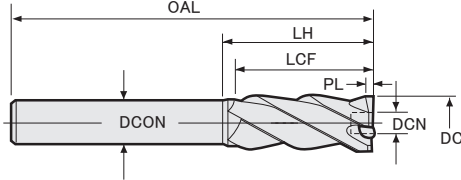
TURNING SKILL REAMER SERIES

NIKKEN

Forcing out cutting chips to avoid residual at the bottom

RSST-F

**Right hand spiral
Blind hole**

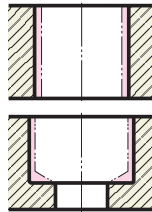
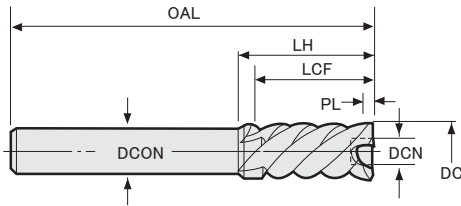


Code No.	DC H7	OAL	DCON	PL	DCN	LCF	LH
RSST- 3.0F	3.0	60	3	0.6	1.5	20	35
RSST- 4.0F	4.0	60	3	0.6	1.5	20	20
RSST- 5.0F	5.0	65	4	0.6	2.0	25	25
RSST- 6.0F	6.0	65	5	0.6	3.0	25	25
RSST- 7.0F	7.0	70	6	0.6	3.0	25	25
RSST- 8.0F	8.0	70	6	0.6	3.5	25	25
RSST- 9.0F	9.0	70	8	0.6	4.0	25	25
RSST-10.0F	10.0	70	8	0.6	4.5	25	25
RSST-11.0F	11.0	80	10	0.6	4.5	30	30
RSST-12.0F	12.0	80	10	0.6	5.5	30	30

Equipped with end-cutting blade

SRST-F

**Left hand spiral
Through hole & Stepped hole**



Code No.	DC H7	OAL	DCON	PL	DCN	LCF	LH
SRST- 3.0F	3.0	60	3	0.6	1.5	20	35
SRST- 4.0F	4.0	60	3	0.6	1.5	20	20
SRST- 5.0F	5.0	65	4	0.6	2.0	25	25
SRST- 6.0F	6.0	65	5	0.6	3.0	25	25
SRST- 7.0F	7.0	70	6	0.6	3.0	25	25
SRST- 8.0F	8.0	70	6	0.6	3.5	25	25
SRST- 9.0F	9.0	70	8	0.6	4.0	25	25
SRST-10.0F	10.0	70	8	0.6	4.5	25	25
SRST-11.0F	11.0	80	10	0.6	4.5	30	30
SRST-12.0F	12.0	80	10	0.6	5.5	30	30

Recommended cutting speed (m/min) ◎ : Ideal ○ : Suitable

Materials	recommended coolant	Mild steel SS	Carbon Steel S55C	Carbon Steel S55C	Free-cutting steel	Alloy steel SUJ SCM	Tool steel SKH SKD	Stainless steel SUS	Brass Bronze	Cast iron Ductile F C F C D	Aluminum Aluminum casting Die casting
Cutting speed m/min	Water-soluble	◎ 10~16	◎ 10~16	◎ 10~14	○ 10~16	◎ 10~16	◎ 8~14	○ 6~10	○ 10~18	○ 10~18	○ 12~22

Calculate spindle RPM (min⁻¹)

At first, determine the cutting speed in reference to "material x cutting speed" chart.

Mild steel SS
10~16

The value indicates the minimum value to get the best cutting tool performance, but recommends setting the middle value in the chart.

$$S = \frac{\text{Cutting speed (m/min.)} \times 1000}{3.14 \times \text{DC (mm)}}$$

Coolant

The dilution rate is recommended 5-10 times in case of water-soluble coolant.

Check it out!

NIKKEN turning sleeves can optimize Turning Short Reamer performance.

SK sleeve
for CNC automatic turning machine



MINI MINI sleeve
for CNC automatic turning machine

