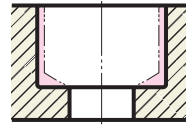


NIKKEN CARBIDE RADICAL MILL REAMER LONG TYPE

NIKKEN

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	170	16	0.6	7.0	22	115
-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						

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	170	16	0.6	7.0	29	115
-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	185	16	0.6	7.0	30	125
-17.0	△	17.0	185	16	0.6	8.0	30	125
-18.0	△	18.0	195	20	0.6	9.0	30	130
-19.0	△	19.0	195	20	0.6	9.0	30	130
-20.0	△	20.0	205	20	0.6	9.0	30	140

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

CARBIDE

FOR STEPPED HOLE



FOR BLIND HOLE

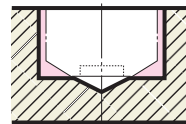


NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER

NIKKEN

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

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	60	3	0.6	1.2	16	35
- 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	60	4	0.6	2.0	18	35
- 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						

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	60	4	0.6	2.0	18	35
- 4.04F	△	4.04						
- 4.05F	△	4.05						
- 4.1 F	△	4.1						
- 4.2 F	△	4.2	70	5	0.6	2.0	22	40
- 4.3 F	△	4.3						
- 4.4 F	△	4.4						
- 4.5 F	△	4.5						
- 4.6 F	△	4.6	70	5	0.6	2.5	22	40
- 4.7 F	△	4.7						
- 4.8 F	△	4.8						
- 4.9 F	△	4.9						
- 4.97F	△	4.97	70	5	0.6	2.5	22	40
- 4.98F	△	4.98						
- 4.99F	△	4.99						
- 5.0 F	△	5.0						

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

⚠ LCF must be longer than hole depth

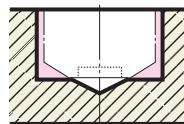
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NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER

NIKKEN

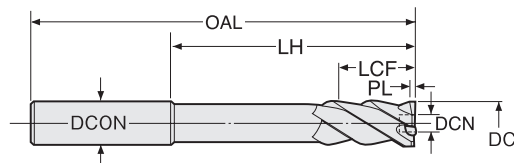
RRSS-F

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- 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	85	6	0.6	3.0	25	50
- 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	85	6	0.6	3.0	25	50
- 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	90	8	0.6	3.0	25	50
- 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	100	8	0.6	4.0	25	60
- 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	105	10	0.6	4.5	25	60
- 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	105	10	0.6	4.5	25	60
- 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	110	10	0.6	5.0	29	60
- 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	110	10	0.6	5.0	29	60
- 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	115	12	0.6	5.0	29	65
- 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	115	12	0.6	5.0	29	65
- 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	125	12	0.6	6.0	29	70

★PL means chamfering length to ΦDC.

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

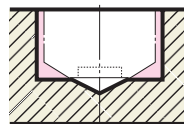
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NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER

NIKKEN

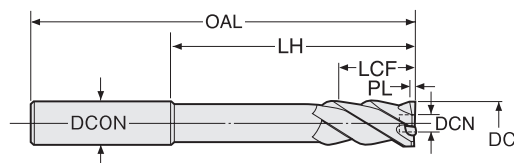
RRSS-F

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-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	140	16	0.6	7.0	29	80
-14.05F	△	14.05						
-15.0 F	△	15.0						
-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 Φ DC.

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

