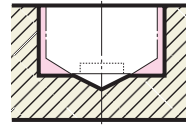


NIKKEN CARBIDE RIGHT HAND HELICAL RADICAL MILL REAMER OH



RRSS-F-OH

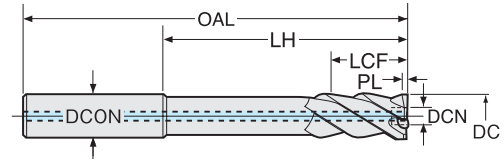
RIGHT HAND HELICAL For BLIND HOLE
Radical Mill Reamer (With Oil Hole)



Explanation of the Code No.

RRSS - **12.0** - **F** - **OH**

- RRSS: RADICAL MILLREAMER SERIES
- 12.0: DIAMETER
- F: FOR BLIND HOLE
- OH: WITH OH
- 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

MINIMUM DIAMETER : ϕ 5.0mm

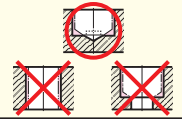
Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RRSS- 5.0F-OH	△	5.0	70	5	0.6	2.5	22	40
- 6.0F-OH	△	6.0	85	6	0.6	3.0	25	50
- 6.5F-OH	△	6.5	90	8	0.6	3.0	25	50
- 7.0F-OH	△	7.0	90	8	0.6	3.5	25	50
- 7.5F-OH	△	7.5	100	8	0.6	4.0	25	60
- 8.0F-OH	△	8.0						
- 8.5F-OH	△	8.5	105	10	0.6	4.5	25	60
- 9.0F-OH	△	9.0						
- 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						
-17.0F-OH	△	17.0	150	16	0.6	8.0	30	90
-18.0F-OH	△	18.0						
-19.0F-OH	△	19.0	155	20	0.6	9.0	30	90
-20.0F-OH	△	20.0						

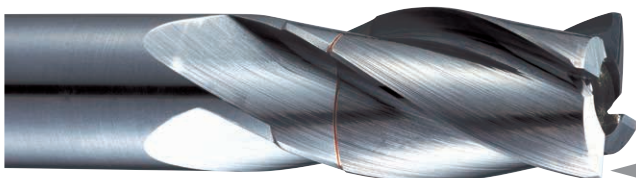
- ★PL means chamfering length to ϕ DC.
- ★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than ϕ DCN.
- ★This is not suitable to use on drilling machine due to tensile force of right-handed. Please use on machining center, NC lathe and milling 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 effective. 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 achieved 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.