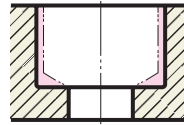


NIKKEN CARBIDE MILL REAMER



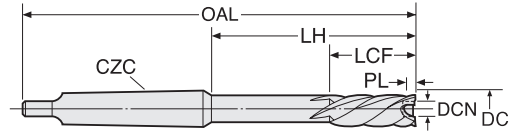
FMM

For STEPPED HOLE
Mill Reamer (Morse Taper Shank)



Explanation of the Code No.

- FMM - 15.0**
- DIAMETER
- MILLREAMER SERIES
- FMM : MORSE TAPER SHANK FOR STEPPED HOLE



MILLING BLADE

LH-HELIX 30°

P.135

*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
FMM- 5.0	△	5.0	115	MT1	0.6	2.5	22	49.5
- 5.5	△	5.5	130	MT1	0.6	3.0	25	64.5
- 6.0	△	6.0						
- 6.5	△	6.5	140	MT1	0.6	3.0	25	74.5
- 7.0	△	7.0	140	MT1	0.6	3.5	25	74.5
- 7.5	△	7.5	150	MT1	0.6	4.0	25	84.5
- 8.0	●	8.0						
- 8.5	△	8.5	165	MT1	0.6	4.5	25	99.5
- 9.0	●	9.0						
- 9.5	△	9.5	165	MT1	0.6	5.0	29	99.5
-10.0	●	10.0						
-10.5	△	10.5	170	MT1	0.6	5.0	29	104.5
-11.0	●	11.0						
-11.5	△	11.5	175	MT1	0.6	6.0	29	109.5
-12.0	●	12.0						
-12.5	△	12.5	180	MT1	0.6	6.0	29	114.5
-13.0	●	13.0						
-13.5	△	13.5	180	MT1	0.6	7.0	29	114.5
-14.0	●	14.0						
-14.5	△	14.5	160	MT2	0.6	7.0	29	80
-15.0	●	15.0						
-15.5	△	15.5	165	MT2	0.6	7.0	30	85
-16.0	●	16.0						
-16.5	△	16.5	165	MT2	0.6	8.0	30	85
-17.0	●	17.0						
-17.5	△	17.5	170	MT2	0.6	9.0	30	90
-18.0	●	18.0						
-18.5	△	18.5	180	MT2	0.6	10.0	30	100
-19.0	●	19.0						
-19.5	△	19.5	180	MT2	0.6	10.0	30	100
-20.0	●	20.0						
-20.5	△	20.5	180	MT2	0.6	10.0	33.5	100
-21.0	●	21.0						
-22.0	●	22.0	190	MT2	0.6	11.0	33.5	110
-23.0	●	23.0	195	MT2	0.6	12.0	33.5	115
-24.0	●	24.0	225	MT3	0.6	12.0	33.5	126
-25.0	●	25.0	225	MT3	0.6	13.0	33.5	126
-26.0	●	26.0	225	MT3	0.6	14.0	33.5	126
-27.0	●	27.0						
-28.0	●	28.0	230	MT3	0.9	15.0	39	131
-29.0	●	29.0	230	MT3	0.9	16.0	39	131
-30.0	●	30.0	235	MT3	0.9	16.0	39	136
-31.0	●	31.0	235	MT3	0.9	17.0	39	136
-32.0	●	32.0	245	MT3	0.9	18.0	39	146
-33.0	●	33.0	270	MT4	0.9	18.0	39	146
-34.0	●	34.0	275	MT4	0.9	19.0	41	151
-35.0	●	35.0	275	MT4	0.9	20.0	41	151
-36.0	●	36.0						
-37.0	●	37.0	275	MT4	0.9	21.0	46	151
-38.0	●	38.0	275	MT4	0.9	22.0	46	151
-39.0	●	39.0						
-40.0	●	40.0	275	MT4	0.9	23.0	46	151
-41.0	●	41.0	275	MT4	1.2	24.0	49	151
-42.0	●	42.0						
-43.0	●	43.0	275	MT4	1.2	25.0	49	151
-44.0	●	44.0	275	MT4	1.2	26.0	49	151

Code No.	STOCK	DC H7	OAL	CZC	PL	DCN	LCF	LH
FMM-45.0	●	45.0	275	MT4	1.2	26.0	49	151
-46.0	●	46.0	275	MT4	1.2	27.0	51	151
-47.0	●	47.0	275	MT4	1.2	28.0	51	151
-48.0	●	48.0	280	MT4	1.2	28.0	51	156
-49.0	●	49.0	280	MT4	1.2	29.0	56	156
-50.0	●	50.0	280	MT4	1.2	30.0	56	156
-51.0	●	51.0	290	MT4	1.2	36.0	50	166
-52.0	●	52.0						
-53.0	●	53.0						
-54.0	●	54.0						
-55.0	●	55.0						
-56.0	●	56.0	290	MT4	1.2	40.0	50	166
-57.0	●	57.0	295	MT4	1.2	40.0	50	171
-58.0	●	58.0						
-59.0	●	59.0						
-60.0	●	60.0	330	MT5	1.2	45.0	50	174
-61.0	●	61.0						
-62.0	●	62.0						
-63.0	●	63.0						
-64.0	●	64.0						
-65.0	●	65.0	330	MT5	1.2	50.0	50	174
-66.0	●	66.0						
-67.0	●	67.0						
-68.0	●	68.0						
-69.0	●	69.0						
-70.0	●	70.0	330	MT5	1.2	50.0	50	174
-71.0	●	71.0						
-72.0	●	72.0						
-73.0	●	73.0						
-74.0	●	74.0						
-75.0	●	75.0	340	MT5	1.2	55.0	50	184
-76.0	●	76.0						
-77.0	●	77.0						
-78.0	●	78.0						
-79.0	●	79.0						
-80.0	●	80.0	340	MT5	1.2	58.0	50	184
-81.0	●	81.0	340	MT5	1.2	58.0	50	184
-82.0	●	82.0						
-83.0	●	83.0						
-84.0	●	84.0						
-85.0	●	85.0						
-86.0	●	86.0	340	MT5	1.2	60.0	50	184
-87.0	●	87.0						
-88.0	●	88.0						
-89.0	●	89.0						
-90.0	●	90.0						
-91.0	●	91.0	340	MT5	1.2	65.0	50	184
-92.0	●	92.0						
-93.0	●	93.0						
-94.0	●	94.0						
-95.0	●	95.0						
-96.0	●	96.0	340	MT5	1.2	70.0	50	184
-97.0	●	97.0						
-98.0	●	98.0						
-99.0	●	99.0						
-100.0	●	100.0						

★PL means chamfering length to φDC. ★DCN is the front end bore diameter without bottom teeth, thus please make sure predrilled hole should be larger than φDCN.

★Please use right-handed helix reamer when there are not enough space for the chips. 右P.55 ★MT size is determined by reamer dia : ~φ14:MT1, φ15~φ23 : MT2, φ24~φ32 : MT3, φ33~φ62 : MT4, φ63~ : MT5

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

CARBIDE FOR STEPPED HOLE

