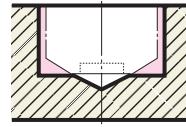


# NIKKEN CARBIDE MILL REAMER

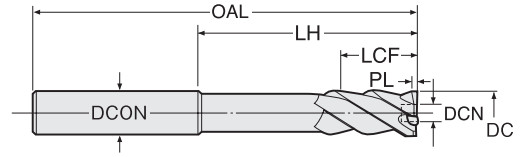


## RXS-F

RIGHT HAND HELICAL For BLIND HOLE  
Mill Reamer (Straight Shank)



Explanation of the Code No.  
**RXS** - **10.0** - **F**  
 ● FOR BLIND HOLE  
 ● DIAMETER  
 ● MILLREAMER SERIES  
 RXS : STRAIGHT SHANK, RIGHT HAND HELICAL FOR BLIND HOLE



⚠ LCF must be longer than hole depth

MILLING BLADE

RH-HELIX 30-40°

P.135

\*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
RXS- 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	60	3	0.6	1.2	16	35
- 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	60	4	0.6	2.0	18	35
- 3.9 F	△	3.9						
- 3.97F	△	3.97						
- 3.98F	△	3.98						
- 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	75	5	0.6	2.0	22	45
- 4.3 F	△	4.3						
- 4.4 F	△	4.4						
- 4.5 F	△	4.5						
- 4.6 F	△	4.6	75	5	0.6	2.0	22	45
- 4.7 F	△	4.7						
- 4.8 F	△	4.8						
- 4.9 F	△	4.9						
- 4.97F	△	4.97	75	5	0.6	2.5	22	45
- 4.98F	△	4.98						
- 4.99F	△	4.99						
- 5.0 F	●	5.0						
- 5.01F	△	5.01	75	5	0.6	2.5	22	45
- 5.02F	△	5.02						
- 5.03F	△	5.03						
- 5.04F	△	5.04						
- 5.05F	△	5.05	75	5	0.6	2.5	22	45
- 5.1 F	△	5.1						
- 5.2 F	△	5.2						
- 5.3 F	△	5.3						
- 5.4 F	△	5.4	100	6	0.6	2.5	25	65
- 5.5 F	△	5.5						
- 5.6 F	△	5.6						
- 5.7 F	△	5.7						
- 5.8 F	△	5.8	100	6	0.6	3.0	25	65
- 5.9 F	△	5.9						
- 5.97F	△	5.97						
- 5.98F	△	5.98						
- 5.99F	△	5.99	100	6	0.6	3.0	25	65
- 6.0 F	●	6.0						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RXS- 6.01F	△	6.01	100	6	0.6	3.0	25	65
- 6.02F	△	6.02						
- 6.03F	△	6.03						
- 6.04F	△	6.04						
- 6.05F	△	6.05	100	6	0.6	3.0	25	65
- 6.1 F	△	6.1						
- 6.2 F	△	6.2						
- 6.3 F	△	6.3						
- 6.4 F	△	6.4	110	8	0.6	3.0	25	70
- 6.5 F	△	6.5						
- 6.6 F	△	6.6						
- 6.7 F	△	6.7						
- 6.8 F	△	6.8	110	8	0.6	3.5	25	70
- 6.9 F	△	6.9						
- 6.97F	△	6.97						
- 6.98F	△	6.98						
- 6.99F	△	6.99	110	8	0.6	3.5	25	70
- 7.0 F	●	7.0						
- 7.01F	△	7.01						
- 7.02F	△	7.02						
- 7.03F	△	7.03	110	8	0.6	3.5	25	70
- 7.04F	△	7.04						
- 7.05F	△	7.05						
- 7.1 F	△	7.1						
- 7.2 F	△	7.2	110	8	0.6	3.5	25	70
- 7.3 F	△	7.3						
- 7.4 F	△	7.4						
- 7.5 F	△	7.5						
- 7.6 F	△	7.6	125	8	0.6	4.0	25	85
- 7.7 F	△	7.7						
- 7.8 F	△	7.8						
- 7.9 F	△	7.9						
- 7.97F	△	7.97	125	8	0.6	4.0	25	85
- 7.98F	△	7.98						
- 7.99F	△	7.99						
- 8.0 F	●	8.0						
- 8.01F	△	8.01	125	8	0.6	4.0	25	85
- 8.02F	△	8.02						
- 8.03F	△	8.03						
- 8.04F	△	8.04						
- 8.05F	△	8.05	125	8	0.6	4.0	25	85
- 8.1 F	△	8.1						
- 8.2 F	△	8.2						
- 8.3 F	△	8.3						
- 8.4 F	△	8.4	135	10	0.6	4.5	25	90
- 8.5 F	△	8.5						
- 8.6 F	△	8.6						
- 8.7 F	△	8.7						
- 8.8 F	△	8.8	135	10	0.6	4.5	25	90
- 8.9 F	△	8.9						
- 8.97F	△	8.97						
- 8.98F	△	8.98						
- 8.99F	△	8.99	135	10	0.6	4.5	25	90
- 9.0 F	●	9.0						
- 9.01F	△	9.01						
- 9.02F	△	9.02						
- 9.03F	△	9.03	135	10	0.6	4.5	25	90
- 9.04F	△	9.04						

★PL means chamfering length to φDC.

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

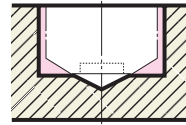
Next page >>>>

# NIKKEN CARBIDE MILL REAMER



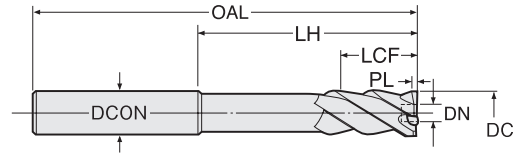
## RXS-F

RIGHT HAND HELICAL For BLIND HOLE  
Mill Reamer (Straight Shank)



Explanation of the Code No.

**RXS** - **10.0** - **F**  
 ● FOR BLIND HOLE  
 ● DIAMETER  
 ● MILLREAMER SERIES  
 RXS : STRAIGHT SHANK, RIGHT HAND HELICAL FOR BLIND HOLE



MILLING BLADE

RH-HELIX 30°

P.135

\*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
RXS- 9.05F	△	9.05	135	10	0.6	4.5	25	90
- 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	150	10	0.6	5.0	29	100
-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	155	12	0.6	5.0	29	105
-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						
-11.4 F	△	11.4						
-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	160	12	0.6	6.0	29	105
-12.01F	△	12.01						
-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						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH						
RXS-12.4 F	△	12.4	165	12	0.6	6.0	29	110						
-12.5 F	△	12.5												
-12.6 F	△	12.6												
-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												
-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												
-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	170	16	0.6	7.0	29	115						
-14.01F	△	14.01												
-14.02F	△	14.02												
-14.03F	△	14.03												
-14.04F	△	14.04												
-14.05F	△	14.05												
-15.0 F	●	15.0							185	16	0.6	7.0	30	125
-15.5 F	△	15.5												
-16.0 F	●	16.0												
-16.5 F	△	16.5												
-17.0 F	●	17.0												
-17.5 F	△	17.5												
-18.0 F	●	18.0												
-18.5 F	△	18.5												
-19.0 F	●	19.0												
-19.5 F	△	19.5												
-20.0 F	●	20.0												
-21.0 F	●	21.0	205	20	0.6	10.0	30	140						
-22.0 F	●	22.0												
-23.0 F	●	23.0												
-24.0 F	●	24.0												
-25.0 F	●	25.0												
-26.0 F	●	26.0												
-27.0 F	●	27.0												
-28.0 F	●	28.0												
-29.0 F	●	29.0												
-30.0 F	●	30.0												
-31.0 F	●	31.0	230	25	0.6	13.0	33.5	160						
-32.0 F	●	32.0												
-33.0 F	●	33.0												
-34.0 F	●	34.0												

\*PL means chamfering length to φDC.

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

Next page >>>

CARBIDE FOR BLIND HOLE

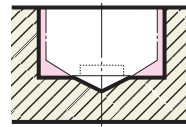


# NIKKEN CARBIDE MILL REAMER

**NIKKEN**

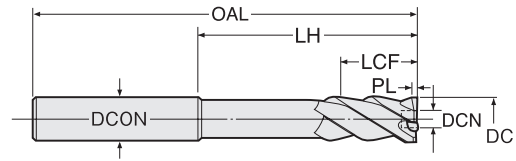
**RXS-F**

RIGHT HAND HELICAL For BLIND HOLE  
Mill Reamer (Straight Shank)



Explanation of the Code No.

**RXS - 10.0 - F**  
 ● FOR BLIND HOLE  
 ● DIAMETER  
 ● MILLREAMER SERIES  
 RXS : STRAIGHT SHANK, RIGHT HAND HELICAL FOR BLIND HOLE



⚠ LCF must be longer than hole depth

MILLING BLADE

RH-HELIX 30°

P.135

\*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
RXS-35.0F	●	35.0	280	32	0.9	20.0	41	200
-36.0F	●	36.0	285	32	0.9	20.0	41	205
-37.0F	●	37.0	285	32	0.9	21.0	46	205
-38.0F	●	38.0	285	32	0.9	22.0	46	205
-39.0F	●	39.0						
-40.0F	●	40.0	290	32	1.2	23.0	46	210
-41.0F	●	41.0	290	32	1.2	24.0	49	210
-42.0F	●	42.0						

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RXS-43.0F	●	43.0	290	32	1.2	25.0	49	210
-44.0F	●	44.0	290	32	1.2	26.0	49	210
-45.0F	●	45.0						
-46.0F	●	46.0	295	32	1.2	27.0	51	215
-47.0F	●	47.0	295	32	1.2	28.0	51	215
-48.0F	●	48.0	310	32	1.2	28.0	51	230
-49.0F	●	49.0	310	32	1.2	29.0	56	230
-50.0F	●	50.0	310	32	1.2	30.0	56	230

★PL means chamfering length to  $\phi$ DC.

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

Depending on the material, the chips may tangle. When the hole depth is more than twice of the hole diameter, we recommend Right-Hand 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.

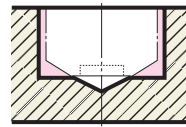
★Please slightly decrease feed rate before reaching the bottom of the hole without using G86.

# NIKKEN CARBIDE MILL REAMER OH

**NIKKEN**

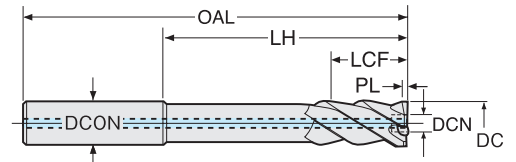
**RXS-F-OH**

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



Explanation of the Code No.

**RXS - 10.0 - F - OH**  
 ● OH付の意  
 ● FOR BLIND HOLE  
 ● DIAMETER  
 ● MILLREAMER SERIES  
 RXS : STRAIGHT SHANK, RIGHT HAND HELICAL FOR BLIND HOLE



⚠ LCF must be longer than hole depth

MILLING BLADE

RH-HELIX 30°

P.135

\*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
RXS- 5.0F-OH	△	5.0	75	5	0.6	2.5	22	45
- 6.0F-OH	△	6.0	100	6	0.6	3.0	25	65
- 7.0F-OH	△	7.0	110	8	0.6	3.5	25	70
- 8.0F-OH	△	8.0	125	8	0.6	4.0	25	85
- 9.0F-OH	△	9.0	135	10	0.6	4.5	25	90
-10.0F-OH	△	10.0	150	10	0.6	5.0	29	100
-11.0F-OH	△	11.0	155	12	0.6	5.0	29	105
-12.0F-OH	△	12.0	160	12	0.6	6.0	29	105
-13.0F-OH	△	13.0	165	12	0.6	6.0	29	110
-14.0F-OH	△	14.0	170	16	0.6	7.0	29	115
-15.0F-OH	△	15.0	180	16	0.6	7.0	29	120
-16.0F-OH	△	16.0	185	16	0.6	7.0	30	125
-17.0F-OH	△	17.0	185	16	0.6	8.0	30	125

Code No.	STOCK	DC H7	OAL	DCON	PL	DCN	LCF	LH
RXS-18.0F-OH	△	18.0	195	20	0.6	9.0	30	130
-19.0F-OH	△	19.0	205	20	0.6	10.0	30	140
-20.0F-OH	△	20.0						
-21.0F-OH	△	21.0	215	20	0.6	10.0	33.5	150
-22.0F-OH	△	22.0	215	20	0.6	11.0	33.5	150
-23.0F-OH	△	23.0	230	25	0.6	12.0	33.5	160
-24.0F-OH	△	24.0	230	25	0.6	13.0	33.5	160
-25.0F-OH	△	25.0						
-26.0F-OH	△	26.0	230	25	0.6	14.0	33.5	160
-27.0F-OH	△	27.0	240	32	0.6	15.0	39	160
-28.0F-OH	△	28.0	240	32	0.9	16.0	39	160
-29.0F-OH	△	29.0						
-30.0F-OH	△	30.0						

★PL means chamfering length to  $\phi$ DC.

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

