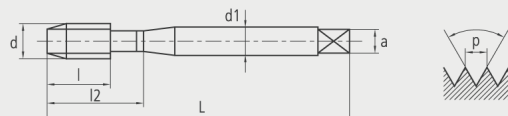


JIS R Line SFT | General Purpose & Unstable Working Conditions


Norm

Coating



L	l	l2	d1	a	d	p	Limit	
46	10	19	4	3.2	M3	0.5	6H	2.5
52	8.4	20	5	4	M4	0.7	6H	3.3
60	9.6	24	5.5	4.5	M5	0.8	6H	4.2
62	12	29	6	4.5	M6	1	6H	5
70	15	37	6.2	5	M8	1	6HX	7
70	15	37	6.2	5	M8	1.25	6H	6.8
75	18	41	7	5.5	M10	1	6HX	9
75	18	41	7	5.5	M10	1.25	6HX	8.8
75	18	41	7	5.5	M10	1.5	6H	8.5
82	18	48	8.5	6.5	M12	1.25	6HX	10.8
82	18	48	8.5	6.5	M12	1.5	6HX	10.5
82	18	48	8.5	6.5	M12	1.75	6H	10.3

HSS-E



JIS

CrN+X

C/2.5P

Art.Stock

515811 •

515812 •

515813 •

515814 •

515815 •

515816 •

515817 •

515818 •

515819 •

515820 •

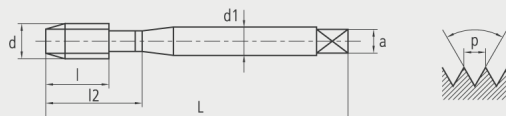
515821 •

515822 •

* Vc: 3-10m/min

* For Carbon Steel, Alloy Steel, Cast Iron, Stainless Steel, and Non-ferrous Alloys with a hardness of HRC 20-25.

P	M	K	N	S	H
●	○	○	○	-	-

JIS R Line | **POT** | General Purpose & Unstable Working Conditions


HSS-E



Norm

JIS

Coating

CrN+X



C/5P

Art.Stock

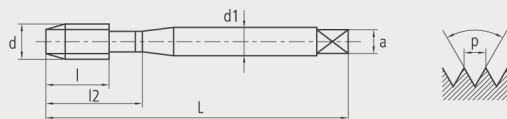
L	l	l2	d1	a	d	p	Limit	
46	10	19	4	3.2	M3	0.5	6H	2.5
52	12	20	5	4	M4	0.7	6H	3.3
60	14	24	5.5	4.5	M5	0.8	6H	4.2
62	16	29	6	4.5	M6	1	6H	5
70	21	37	6.2	5	M8	1	6HX	7
70	21	37	6.2	5	M8	1.25	6H	6.8
75	23	41	7	5.5	M10	1	6HX	9
75	23	41	7	5.5	M10	1.25	6HX	8.8
75	23	41	7	5.5	M10	1.5	6H	8.5
82	24	48	8.5	6.5	M12	1.25	6HX	10.8
82	24	48	8.5	6.5	M12	1.5	6HX	10.5
82	24	48	8.5	6.5	M12	1.75	6H	10.3

525811 •
525812 •
525813 •
525814 •
525815 •
525816 •
525817 •
525818 •
525819 •
525820 •
525821 •
525822 •

* Vc: 3-10m/min

* For Carbon Steel, Alloy Steel, Cast Iron, Stainless Steel, and Non-ferrous Alloys with a hardness of HRC 20-25.

P	M	K	N	S	H
●	○	○	○	-	-

JIS R Line SFT | General Purpose & Stable/ Unstable Working Conditions


Norm

Coating



L	l	l2	d1	a	d	p	Limit	
46	10	19	4	3.2	M3	0.5	6H	2.5
52	8.4	20	5	4	M4	0.7	6H	3.3
60	9.6	24	5.5	4.5	M5	0.8	6H	4.2
62	12	29	6	4.5	M6	1	6H	5
70	15	37	6.2	5	M8	1	6HX	7
70	15	37	6.2	5	M8	1.25	6H	6.8
75	18	41	7	5.5	M10	1	6HX	9
75	18	41	7	5.5	M10	1.25	6HX	8.8
75	18	41	7	5.5	M10	1.5	6H	8.5
82	18	48	8.5	6.5	M12	1.25	6HX	10.8
82	18	48	8.5	6.5	M12	1.5	6HX	10.5
82	18	48	8.5	6.5	M12	1.75	6H	10.3
88	20	48	10.5	8	M14	1.5	6HX	12.5
88	20	48	10.5	8	M14	2	6HX	12
95	20	52	12.5	10	M16	1.5	6HX	14.5
95	20	52	12.5	10	M16	2	6HX	14
100	25	55	14	11	M18	1.5	6HX	16.6
100	25	55	14	11	M18	2.5	6HX	15.5
105	25	58	15	12	M20	1.5	6HX	18.5
105	25	58	15	12	M20	2.5	6HX	17.5

* Vc: 5 - 10m/min

* For Carbon Steel, Alloy Steel, Stainless Steel, and Cast Iron with a hardness of HRC 20-32.

P	M	K	N	S	H
●	○	○	-	-	-

HSS-E



JIS

ZrN

C/2.5P

Art.Stock

535811 ●

535812 ●

535813 ●

535814 ●

535815 ●

535816 ●

535817 ●

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535823 ○

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535825 ○

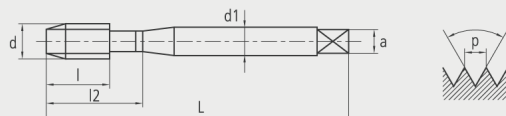
535826 ○

535827 ○

535828 ○

535829 ○

535830 ○

JIS R Line | **POT** | General Purpose & Stable/ Unstable Working Conditions


Norm

Coating



L	l	l2	d1	a	d	p	Limit	
46	10	19	4	3.2	M3	0.5	6H	2.5
52	12	20	5	4	M4	0.7	6H	3.3
60	14	24	5.5	4.5	M5	0.8	6H	4.2
62	16	29	6	4.5	M6	1	6H	5
70	21	37	6.2	5	M8	1	6HX	7
70	21	37	6.2	5	M8	1.25	6H	6.8
75	23	41	7	5.5	M10	1	6HX	9
75	23	41	7	5.5	M10	1.25	6HX	8.8
75	23	41	7	5.5	M10	1.5	6H	8.5
82	24	48	8.5	6.5	M12	1.25	6HX	10.8
82	24	48	8.5	6.5	M12	1.5	6HX	10.5
82	24	48	8.5	6.5	M12	1.75	6H	10.3
88	24	48	10.5	8	M14	1.5	6HX	12.5
88	24	48	10.5	8	M14	2	6HX	12
95	24	52	12.5	10	M16	1.5	6HX	14.5
95	24	52	12.5	10	M16	2	6HX	14
100	24	55	14	11	M18	1.5	6HX	16.6
100	24	55	14	11	M18	2.5	6HX	15.5
105	26	58	15	12	M20	1.5	6HX	18.5
105	26	58	15	12	M20	2.5	6HX	17.5

* Vc: 5 - 15m/min

* For Carbon Steel, Alloy Steel, Stainless Steel, and Cast Iron with a hardness of HRC 20-32.

P	M	K	N	S	H
●	○	○	-	-	-

HSS-E



JIS

ZrN

C/5P

Art.Stock

545811 ●

545812 ●

545813 ●

545814 ●

545815 ●

545816 ●

545817 ●

545818 ●

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545822 ●

545823 ○

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545825 ○

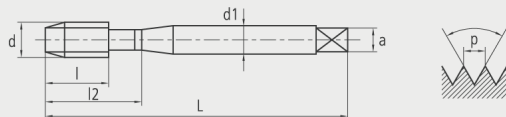
545826 ○

545827 ○

545828 ○

545829 ○

545830 ○

JIS R Line STT | General Purpose & Stable/ Unstable Working Conditions


Norm

Coating



L	l	l2	d1	a	d	p	Limit	
46	10	19	4	3.2	M3	0.5	6HX	2.5
52	12	20	5	4	M4	0.7	6HX	3.3
60	14	24	5.5	4.5	M5	0.8	6HX	4.2
62	16	29	6	4.5	M6	1	6HX	5
70	21	37	6.2	5	M8	1	6HX	7
70	21	37	6.2	5	M8	1.25	6HX	6.8
75	23	41	7	5.5	M10	1	6HX	9
75	23	41	7	5.5	M10	1.25	6HX	8.8
75	23	41	7	5.5	M10	1.5	6HX	8.5
82	24	48	8.5	6.5	M12	1.25	6HX	10.8
82	24	48	8.5	6.5	M12	1.5	6HX	10.5
82	24	48	8.5	6.5	M12	1.75	6HX	10.3
88	24	48	10.5	8	M14	1.5	6HX	12.5
88	24	48	10.5	8	M14	2	6HX	12
95	24	52	12.5	10	M16	1.5	6HX	14.5
95	24	52	12.5	10	M16	2	6HX	14
100	24	55	14	11	M18	1.5	6HX	16.6
100	24	55	14	11	M18	2.5	6HX	15.5
105	26	58	15	12	M20	1.5	6HX	18.5
105	26	58	15	12	M20	2.5	6HX	17.5

HSS-E



JIS

ZrN

C/1.5P

Art.Stock

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555830 •

* Cast Iron Vc: 15-25m/min ; Steel Vc: 5-8m/min

* Steel, Alloy Steel and Cast Iron HRC 20 to 32 ; High hard material HRC 28-38, blind hole

P	M	K	N	S	H
○	-	⊗	-	-	-