

# HIGH SPEED STEEL CHUCKING REAMERS - STRAIGHT SHANK

ICS

WIS

GENERAL PURPOSE

RIGHT HAND CUT



STRAIGHT FLUTE

High Speed Steel Straight Shank Straight Flute Fractional Size Chucking Reamers are designed for general purpose reaming of most ferrous and non-ferrous metals. The cutting edge is ground with a 45° chamfer angle for easy hole entry. They are also known as Machine Reamers. Available in 29 piece sets.



HELICAL FLUTE

High Speed Steel Helical Flute Fractional Size Chucking Reamers are designed for reaming materials where additional shear is necessary and to improve chip removal in blind holes. The cutting edge is ground with a 45° chamfer angle for easy hole entry. They are also known as Machine Reamers. Available in 29 piece sets.

## Fractional Sizes (Straight Shank) 3/64" to 2" Dia.

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	FLUTE	
					STRAIGHT	HELICAL
					CRSF	CRHF
3/64	.0469	.0455	1/2	2-1/2	14.02	-
1/16	.0625	.0585	1/2	2-1/2	14.02	-
5/64	.0781	.0720	3/4	3	12.36	-
3/32	.0938	.0880	3/4	3	10.58	-
7/64	.1094	.1030	7/8	3-1/2	12.36	-
1/8	.1250	.1190	7/8	3-1/2	9.30	12.06
9/64	.1406	.1350	1	4	14.84	16.98
5/32	.1562	.1510	1	4	13.76	16.98
11/64	.1719	.1645	1-1/8	4-1/2	14.84	16.98
3/16	.1875	.1805	1-1/8	4-1/2	13.76	16.98
13/64	.2031	.1945	1-1/4	5	18.16	19.18
7/32	.2188	.2075	1-1/4	5	17.38	18.76
15/64	.2344	.2265	1-1/2	6	18.16	19.18
1/4	.2500	.2405	1-1/2	6	14.96	17.54
17/64	.2656	.2485	1-1/2	6	19.98	21.34
9/32	.2812	.2485	1-1/2	6	19.98	21.34
19/64	.2969	.2807	1-1/2	6	21.46	21.34
5/16	.3125	.2807	1-1/2	6	17.64	19.90
21/64	.3281	.2807	1-1/2	6	22.94	23.94
11/32	.3438	.2807	1-1/2	6	22.94	23.94
23/64	.3594	.3120	1-3/4	7	22.94	23.94
3/8	.3750	.3120	1-3/4	7	19.40	23.18
25/64	.3906	.3120	1-3/4	7	23.42	26.66
13/32	.4062	.3120	1-3/4	7	23.42	26.66
27/64	.4219	.3745	1-3/4	7	26.32	27.90
7/16	.4375	.3745	1-3/4	7	23.42	26.66
29/64	.4531	.3745	1-3/4	7	29.30	28.78
15/32	.4688	.3745	1-3/4	7	27.96	28.66
31/64	.4844	.4375	2	8	29.30	29.96
1/2	.5000	.4375	2	8	24.64	26.82
33/64	.5156	.4375	2	8	43.24	45.28
17/32	.5313	.4375	2	8	31.30	34.70
35/64	.5469	.4375	2	8	42.30	45.28
9/16	.5625	.4375	2	8	30.00	33.52
37/64	.5781	.4375	2	8	48.94	50.82
19/32	.5938	.4375	2	8	35.76	38.92
39/64	.6094	.5620	2-1/4	9	48.94	50.46
5/8	.6250	.5620	2-1/4	9	34.10	36.72
41/64	.6406	.5620	2-1/4	9	56.12	57.88

TOLERANCES

- 3/64 - 1/2 dia.: +.0002 -.0000"
- 33/64 - 5/8 dia.: +.0003 -.0000"
- 41/64 - 1-1/2 dia.: +.0001 -.0005"
- 1-9/16 - 2 dia.: +.0002 -.0006"

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	FLUTE	
					STRAIGHT	HELICAL
					CRSF	CRHF
21/32	.6562	.5620	2-1/4	9	41.00	43.70
43/64	.6719	.5620	2-1/4	9	64.22	43.70
11/16	.6875	.5620	2-1/4	9	39.76	42.92
45/64	.7031	.5620	2-1/4	9	64.22	42.92
23/32	.7188	.5620	2-1/4	9	46.36	49.58
47/64	.7344	.6245	2-1/2	9-1/2	50.22	49.58
3/4	.7500	.6245	2-1/2	9-1/2	46.46	48.58
49/64	.7656	.6245	2-1/2	9-1/2	69.38	48.58
25/32	.7812	.6245	2-1/2	9-1/2	52.70	55.76
51/64	.7969	.6245	2-1/2	9-1/2	69.38	55.76
13/16	.8125	.6245	2-1/2	9-1/2	51.70	55.76
53/64	.8281	.6245	2-1/2	9-1/2	79.98	55.76
27/32	.8438	.6245	2-1/2	9-1/2	59.82	62.62
55/64	.8594	.7495	2-5/8	10	79.98	62.94
7/8	.8750	.7495	2-5/8	10	57.30	62.64
57/64	.8906	.7495	2-5/8	10	88.20	62.64
29/32	.9062	.7495	2-5/8	10	65.98	69.38
59/64	.9219	.7495	2-5/8	10	88.20	69.38
15/16	.9375	.7495	2-5/8	10	64.66	69.38
61/64	.9531	.7495	2-5/8	10	98.62	69.38
31/32	.9688	.7495	2-5/8	10	74.08	78.20
63/64	.9844	.8745	2-3/4	10-1/2	98.62	78.20
1	1.0000	.8745	2-3/4	10-1/2	70.46	78.20
1-1/32	1.0312	.8745	2-3/4	10-1/2	87.44	78.20
1-1/16	1.0625	.8745	2-3/4	10-1/2	81.74	87.98
1-3/32	1.0938	.8745	2-7/8	11	99.72	87.98
1-1/8	1.1250	.8745	2-7/8	11	87.44	96.88
1-5/32	1.1562	.8745	2-7/8	11	108.34	96.88
1-3/16	1.1875	.9995	2-7/8	11	99.72	106.62
1-1/4	1.2500	.9995	3	11-1/2	108.34	118.32
1-5/16	1.3125	.9995	3	11-1/2	129.96	129.72
1-3/8	1.3750	.9995	3-1/4	12	129.96	142.28
1-7/16	1.4375	1.2495	3-1/2	12-1/2	157.00	154.04
1-1/2	1.5000	1.2495	3-1/2	12-1/2	151.70	164.64
1-9/16	1.5625	1.2495	3-1/2	12-1/2	211.68	-
1-5/8	1.6250	1.2495	3-1/2	13	235.68	-
1-11/16	1.6875	1.2495	3-1/2	13	257.98	-
1-3/4	1.7500	1.2495	4	13-1/2	271.24	-
1-7/8	1.8750	1.5000	4	14	311.90	-
2	2.0000	1.5000	4	14	331.64	-

NUMBER OF FLUTES

- 3/64 - 5/32 dia.: 4 Flutes
- 11/64 - 39/64 dia.: 6 Flutes
- 5/8 - 1-1/32 dia.: 8 Flutes
- 1-1/16 - 1-5/16 dia.: 10 Flute
- 1-3/8 - 1-1/2 dia.: 12 Flutes
- 1-9/16 - 1-7/8 dia.: 14 Flutes
- 2" dia.: 16 Flutes