

# HIGH SPEED STEEL HAND REAMERS

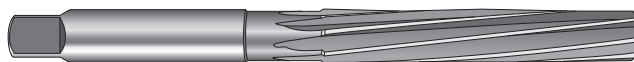
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GENERAL PURPOSE

RIGHT HAND CUT



**STRAIGHT FLUTE**  
(General Purpose Reaming)



**HELICAL FLUTE, LEFT HAND HELIX**  
(Reaming keyways & interrupted cut holes)

High Speed Steel Hand Reamers are designed for extreme accuracy and are used by hand for final sizing of drilled holes. Both styles of hand reamers have a 45° bevel lead and a ground starting taper ranging from 1/2" to 1" on the cutting end for easy entry. They are not suitable for reaming blind holes if bottoming is required. Square end can be held in a vise or a tap wrench depending on whether the work or the reamer is rotating. Special Hand Reamers with straight flutes and without the taper lead (suitable for full bottoming) may be made to order. Hand Reamers are also commonly known as Parallel Hand Reamers in Europe and Asia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				STRAIGHT FLUTE	HELICAL FLUTE
				HRSF	HRHF
1/16	.0625	1	2	-	-
5/64	.0781	1	2	-	-
3/32	.0938	1-1/8	2-1/4	-	-
7/64	.1094	1-7/32	2-7/16	-	-
1/8	.1250	1-5/16	2-5/8	-	-
9/64	.1406	1-3/8	2-13/16	-	-
5/32	.1562	1-1/2	3	-	-
11/64	.1719	1-5/8	3-3/16	-	-
3/16	.1875	1-3/4	3-7/16	-	-
13/64	.2031	1-3/4	3-7/16	-	-
7/32	.2188	1-7/8	3-11/16	-	-
15/64	.2344	1-7/8	3-11/16	-	-
1/4	.2500	2	3-15/16	-	-
17/64	.2656	2-1/8	4-3/16	-	-
9/32	.2812	2-1/8	4-3/16	-	-
19/64	.2969	2-1/4	4-1/2	-	-
5/16	.3125	2-1/4	4-1/2	-	-
21/64	.3281	2-1/4	4-1/2	CALL FOR PRICE	CALL FOR PRICE
11/32	.3438	2-7/16	4-7/8	-	-
23/64	.3594	2-7/16	4-7/8	-	-
3/8	.3750	2-5/8	5-1/4	-	-
25/64	.3906	2-5/8	5-1/4	-	-
13/32	.4062	2-5/8	5-1/4	-	-
27/64	.4219	2-13/16	5-5/8	-	-
7/16	.4375	2-13/16	5-5/8	-	-
29/64	.4531	2-13/16	5-5/8	-	-
15/32	.4688	3	6	-	-
31/64	.4844	3	6	-	-
1/2	.5000	3	6	-	-
33/64	.5156	3	6	-	-
17/32	.5312	3-3/16	6-7/16	-	-
35/64	.5469	3-3/16	6-7/16	-	-
9/16	.5625	3-3/16	6-7/16	-	-
37/64	.5781	3-3/16	6-7/16	-	-
19/32	.5938	3-7/16	6-7/8	-	-
39/64	.6094	3-7/16	6-7/8	-	-
5/8	.6250	3-7/16	6-7/8	-	-
41/64	.6406	3-7/16	6-7/8	-	-
21/32	.6562	3-7/16	6-7/8	-	-
43/64	.6719	3-11/16	7-7/16	-	-
11/16	.6875	3-11/16	7-7/16	-	-
45/64	.7031	3-11/16	7-7/16	-	-
23/32	.7188	3-11/16	7-7/16	-	-

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				STRAIGHT FLUTE	HELICAL FLUTE
				HRSF	HRHF
47/64	.7344	3-11/16	7-7/16	-	-
3/4	.7500	3-15/16	7-15/16	-	-
49/64	.7656	3-15/16	7-15/16	-	-
25/32	.7812	3-15/16	7-15/16	-	-
51/64	.7969	3-15/16	7-15/16	-	-
13/16	.8125	3-15/16	7-15/16	-	-
53/64	.8281	3-15/16	7-15/16	-	-
27/32	.8438	4-3/16	8-1/2	-	-
55/64	.8594	4-3/16	8-1/2	-	-
7/8	.8750	4-3/16	8-1/2	-	-
57/64	.8906	4-3/16	8-1/2	-	-
29/32	.9062	4-3/16	8-1/2	-	-
59/64	.9219	4-3/16	8-1/2	-	-
15/16	.9375	4-1/2	9-1/16	-	-
61/64	.9531	4-1/2	9-1/16	-	-
31/32	.9688	4-1/2	9-1/16	-	-
63/64	.9844	4-1/2	9-1/16	-	-
1	1.0000	4-1/2	9-1/16	CALL FOR PRICE	CALL FOR PRICE
1-1/32	1.0312	4-1/2	9-1/16	-	-
1-1/16	1.0625	4-7/8	9-3/4	-	-
1-3/32	1.0938	4-7/8	9-3/4	-	-
1-1/8	1.1250	4-7/8	9-3/4	-	-
1-5/32	1.1562	4-7/8	9-3/4	-	-
1-3/16	1.1875	5-1/4	10-7/16	-	-
1-7/32	1.2188	5-1/4	10-7/16	-	-
1-1/4	1.2500	5-1/4	10-7/16	-	-
1-9/32	1.2812	5-1/4	10-7/16	-	-
1-5/16	1.3125	5-1/4	10-7/16	-	-
1-11/32	1.3438	5-5/8	11-3/16	-	-
1-3/8	1.3750	6-5/16	12-5/8	-	-
1-13/32	1.4062	5-5/8	11-3/16	-	-
1-7/16	1.4375	5-5/8	11-3/16	-	-
1-15/32	1.4688	5-5/8	11-3/16	-	-
1-1/2	1.5000	6	12	-	-
1-9/16	1.5625	6	12	-	-
1-5/8	1.6250	6	12	-	-
1-11/16	1.6875	6-7/16	12-13/16	-	-
1-3/4	1.7500	6-7/16	12-13/16	-	-
1-13/16	1.8125	6-7/16	12-13/16	-	-
1-7/8	1.8750	6-7/8	13-11/16	-	-
1-15/16	1.9375	6-7/8	13-11/16	-	-
2	2.0000	6-7/8	13-11/16	-	-

**TOLERANCES**

1/16 - 1/4 dia.: +.0001 to +.0004"  
 1/4 - 1" dia.: +.0001 to +.0005"  
 1" - 3" dia.: +.0002 to +.0006"