

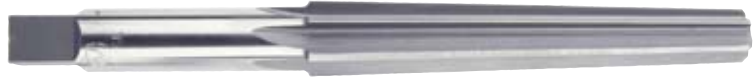
Morse Taper Finishing Reamers

High Speed Steel — Straight Shank
Straight Flute — Right Hand Cut

For accurate hand reaming of Morse Taper holes in sockets, sleeves and spindles.

Alésoir conique

Rima conica



List No. 1636 - Straight Shank

STANDARD PACKAGE All sizes — 1 each

DIA. OF REAMER		MORSE TAPER NO.	FLUTE LENGTH	OAL	SHANK DIA.	EDP NO.
LARGE END	SMALL END					
.3674	.2503	0	2¼	3¾	5/16	21491
.5170	.3674	1	3	5	7/16	21492
.7444	.5696	2	3½	6	9/8	21493
.9881	.7748	3	4¼	7¼	7/8	21494
1.2893	1.0167	4	5¼	8½	1½	21495
1.8005	1.4717	5	6¼	9¾	1½	21496

Morse Taper Finishing Reamers

High Speed Steel — Morse Taper Shank
Straight Flute — Right Hand Cut

For accurate production reaming of Morse Taper holes in sockets, sleeves and spindles.

Alésoir conique

Rima conica



List No. 1635 - Taper Shank

STANDARD PACKAGE All sizes — 1 each

DIA. OF REAMER		MORSE TAPER NO.	FLUTE LENGTH	OAL	TAPER SHANK	EDP NO.
LARGE END	SMALL END					
.3674	.2503	0	2¼	5 ¹¹ / ₃₂	0	21481*
.5170	.3674	1	3	6 ⁵ / ₁₆	1	21482*

* Available While Supplies Last

Taper Pipe Reamers

High Speed Steel — Right Hand Cut
Left Hand Helical Flute

3/4" Taper per foot. For reaming holes to be tapped with American Standard taper pipe taps.

Fraise à tuyau

Rima de tubería



List No. 2116

STANDARD PACKAGE All sizes — 1 each

SIZE	DIA. LARGE END	DIA. SMALL END	SHANK DIA.	FLUTE LENGTH	OAL	EDP NO.
1/8	.362	.316	.4375	3/4	2 1/8	36081
1/4	.472	.406	.5625	1 1/16	2 7/16	36082
3/8	.606	.540	.7000	1 1/16	2 9/16	36083
1/2	.751	.665	.6875	1 3/8	3 1/8	36084
3/4	.962	.876	.9063	1 3/8	3 1/4	36085
1	1.212	1.103	1.1250	1 3/4	3 3/4	36086
1 1/4	1.553	1.444	1.3125	1 3/4	4	36087
1 1/2	1.793	1.684	1.5000	1 3/4	4 1/4	36088
2	2.268	2.159	1.8750	1 3/4	4 1/2	36089

Taper Pin Reamers

High Speed Steel – Straight Shank

Right Hand Cut

1/4" Taper Per Foot

For reaming holes for standard taper pins. **Straight Flute** for hand reaming of most materials. **Helical Flute** for machine reaming of most materials. **Spiral Flute** for hand reaming of difficult-to-ream materials.

STANDARD PACKAGE All sizes —1 each

Alésoir conique à goupilles

Rima para agujeros cónicos



List No. 1680 Straight Flute Hand Reamers



List No. 1683 Helical Flute Machine Reamers
Left Hand Helix



List No. 1684 Spiral Flute Hand Reamers
Left Hand Helix

SIZE	SHANK DIA.	DIA.		FLUTE LENGTH	OAL	1680		1683		1684	
		SMALL END	LARGE END			EDP NO.	NO. OF FLUTES	EDP NO.	NO. OF FLUTES	EDP NO.	NO. OF FLUTES
7/0	5/64	.0497	.0666	13/16	113/16	22581	4	22611	2	22641	4
6/0	3/32	.0611	.0806	15/16	115/16	22582	4	22612	2	22642	4
5/0	7/64	.0719	.0966	13/16	23/16	22583	4	22613	2	22643	4
4/0	1/8	.0869	.1142	15/16	25/16	22584	4	22614	3	22644	4
3/0	9/64	.1029	.1302	15/16	25/16	22585	4	22615	3	22645	4
2/0	5/32	.1137	.1462	19/16	29/16	22586	4	22616	3	22646	4
0	11/64	.1287	.1638	111/16	215/16	22587	4	22617	3	22647	4
1	3/16	.1447	.1798	111/16	215/16	22588	6	22618	3	22648	6
2	13/64	.1605	.2008	115/16	33/16	22589	6	22619	3	22649	6
3	15/64	.1813	.2294	25/16	311/16	22590	6	22620	3	22650	6
4	17/64	.2071	.2604	29/16	41/16	22591	6	22621	3	22651	6
5	5/16	.2409	.2994	213/16	45/16	22592	6	22622	3	22652	6
6	23/64	.2773	.3540	311/16	57/16	22593	6	22623	3	22653	6
7	13/32	.3297	.4220	47/16	65/16	22594	6	22624	3	22654	6
8	7/16	.3971	.5050	53/16	73/16	22595	6	22625	3	22655	6
9	9/16	.4805	.6066	61/16	85/16	22596	6	22626	4	22656	6
10	5/8	.5799	.7219	613/16	95/16	22597	6	22627	4	22657	6

High Speed Steel Reamers Speed and Feed Recommendations

REAMER CUTTING SPEED – SFM

For machine reaming, the recommended starting point is **2/3 the speed used for drilling** in the same material.

REAMER FEED RATE – IPR

For machine reaming, the recommended starting point is **2 to 3 times the feed rate used for drilling** in the same material. It is important that the feed rate be high enough so that the reamer actually cuts rather than just rubbing or burnishing.

DRILLING SPEEDS & FEEDS are located on **Page #88** for reference.

NOTE

The speeds and feeds shown are suggested starting points only and may be increased or decreased depending on the actual material and machining conditions. Start conservatively and adjust speed and feed until the reaming cycle is optimized while producing the required surface finish and hole accuracy.