

Straight Shank Chucking Reamers

High Speed Steel
Straight Flute — Right Hand Cut

45° Chamfer for reaming of most materials

Alésoir machine

Rima de máquina



List No. 1655

Diameter Tolerances

up to 1/2" — +.0002/-0

over 1/2" to 5/8" — +.0003/-0

over 5/8" to 1 1/2" — +.0001/+0.0004

Decimal Sizes: Pages 96-100

Dowel Pin Sizes: Page 100

Metric Sizes: Pages 94-95

STANDARD All sizes - 1 each

PACKAGE

FRAC-TIONAL	SIZE WIRE GAGE AND DECIMAL	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OAL	NO. OF FLUTES	EDP NO.
	#60	.0400	.0390	1/2	2 1/2	4	22101
	59	.0410	.0390	1/2	2 1/2	4	22102
	58	.0420	.0390	1/2	2 1/2	4	22103
	57	.0430	.0390	1/2	2 1/2	4	22104
	56	.0465	.0455	1/2	2 1/2	4	22105
3/64		.0469	.0455	1/2	2 1/2	4	22106
	55	.0520	.0510	1/2	2 1/2	4	22107
	54	.0550	.0510	1/2	2 1/2	4	22108
	53	.0595	.0585	1/2	2 1/2	4	22109
1/16		.0625	.0585	1/2	2 1/2	4	22110
	52	.0635	.0585	1/2	2 1/2	4	22111
	51	.0670	.0660	3/4	3	4	22112
	50	.0700	.0660	3/4	3	4	22113
	49	.0730	.0660	3/4	3	4	22114
	48	.0760	.0720	3/4	3	4	22115
5/64		.0781	.0720	3/4	3	4	22116
	47	.0785	.0720	3/4	3	4	22117
	46	.0810	.0771	3/4	3	4	22118
	45	.0820	.0771	3/4	3	4	22119
	44	.0860	.0810	3/4	3	4	22120
	43	.0890	.0810	3/4	3	4	22121
	42	.0935	.0880	3/4	3	4	22122
3/32		.0938	.0880	3/4	3	4	22123
	41	.0960	.0928	7/8	3 1/2	4	22124
	40	.0980	.0928	7/8	3 1/2	4	22125
	39	.0995	.0928	7/8	3 1/2	4	22126
	38	.1015	.0950	7/8	3 1/2	4	22127
	37	.1040	.0950	7/8	3 1/2	4	22128
	36	.1065	.1030	7/8	3 1/2	4	22129
7/64		.1094	.1030	7/8	3 1/2	4	22130
	35	.1100	.1030	7/8	3 1/2	4	22131
	34	.1110	.1055	7/8	3 1/2	4	22132
	33	.1130	.1055	7/8	3 1/2	4	22133
	32	.1160	.1120	7/8	3 1/2	4	22134
	31	.1200	.1120	7/8	3 1/2	4	22135
	.1240	.1240	.1190	7/8	3 1/2	4	22136
1/8		.1250	.1190	7/8	3 1/2	4	22137
	.1260	.1260	.1190	7/8	3 1/2	4	22138
	30	.1285	.1190	7/8	3 1/2	4	22139
	29	.1360	.1275	1	4	4	22140
	28	.1405	.1350	1	4	4	22141
9/64		.1406	.1350	1	4	4	22142
	27	.1440	.1350	1	4	4	22143
	26	.1470	.1430	1	4	4	22144
	25	.1495	.1430	1	4	4	22145
	24	.1520	.1460	1	4	4	22146
	23	.1540	.1460	1	4	4	22147
5/32		.1562	.1510	1	4	6	22148
	22	.1570	.1510	1	4	6	22149

(continued)

Straight Shank Chucking Reamers (continued)

List No. 1655

Alésoir machine

Rima de máquina

FRAC- TIONAL	SIZE		WIRE GAGE AND DECIMAL	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OAL	NO. OF FLUTES	EDP NO.
	LETTER								
1 ¹ / ₆₄		#21	.1590	.1530	1 ¹ / ₈	4 ¹ / ₂	6	22150	
		20	.1610	.1530	1 ¹ / ₈	4 ¹ / ₂	6	22151	
		19	.1660	.1595	1 ¹ / ₈	4 ¹ / ₂	6	22152	
		18	.1695	.1595	1 ¹ / ₈	4 ¹ / ₂	6	22153	
			.1719	.1645	1 ¹ / ₈	4 ¹ / ₂	6	22154	
			.1730	.1645	1 ¹ / ₈	4 ¹ / ₂	6	22155	
			.1770	.1704	1 ¹ / ₈	4 ¹ / ₂	6	22156	
			.1800	.1755	1 ¹ / ₈	4 ¹ / ₂	6	22157	
3 ¹ / ₁₆			.1820	.1755	1 ¹ / ₈	4 ¹ / ₂	6	22158	
			.1850	.1805	1 ¹ / ₈	4 ¹ / ₂	6	22159	
			.1865	.1865	1 ¹ / ₈	4 ¹ / ₂	6	22160	
			.1875	.1805	1 ¹ / ₈	4 ¹ / ₂	6	22161	
			.1885	.1805	1 ¹ / ₈	4 ¹ / ₂	6	22162	
1 ³ / ₆₄		12	.1890	.1805	1 ¹ / ₈	4 ¹ / ₂	6	22163	
		11	.1910	.1860	1 ¹ / ₄	5	6	22164	
		10	.1935	.1895	1 ¹ / ₄	5	6	22165	
		9	.1960	.1895	1 ¹ / ₄	5	6	22166	
		8	.1990	.1895	1 ¹ / ₄	5	6	22167	
		7	.2010	.1895	1 ¹ / ₄	5	6	22168	
			.2031	.1945	1 ¹ / ₄	5	6	22169	
		6	.2040	.1945	1 ¹ / ₄	5	6	22170	
		5	.2055	.2016	1 ¹ / ₄	5	6	22171	
		4	.2090	.2016	1 ¹ / ₄	5	6	22172	
7 ¹ / ₃₂		3	.2130	.2075	1 ¹ / ₄	5	6	22173	
			.2187	.2075	1 ¹ / ₄	5	6	22174	
		2	.2210	.2173	1 ¹ / ₂	6	6	22175	
		1	.2280	.2173	1 ¹ / ₂	6	6	22176	
		A	.2340	.2265	1 ¹ / ₂	6	6	22177	
1 ⁵ / ₆₄			.2344	.2265	1 ¹ / ₂	6	6	22178	
		B	.2380	.2329	1 ¹ / ₂	6	6	22179	
		C	.2420	.2329	1 ¹ / ₂	6	6	22180	
1 ¹ / ₄		D	.2460	.2329	1 ¹ / ₂	6	6	22181	
			.2490	.2405	1 ¹ / ₂	6	6	22182	
		E	.2500	.2405	1 ¹ / ₂	6	6	22183	
			.2510	.2405	1 ¹ / ₂	6	6	22185	
		F	.2570	.2485	1 ¹ / ₂	6	6	22186	
1 ⁷ / ₆₄		G	.2610	.2485	1 ¹ / ₂	6	6	22187	
			.2656	.2485	1 ¹ / ₂	6	6	22188	
		H	.2660	.2485	1 ¹ / ₂	6	6	22189	
		I	.2720	.2485	1 ¹ / ₂	6	6	22190	
		J	.2770	.2485	1 ¹ / ₂	6	6	22191	
9 ¹ / ₃₂		K	.2810	.2485	1 ¹ / ₂	6	6	22192	
			.2812	.2485	1 ¹ / ₂	6	6	22193	
		L	.2900	.2792	1 ¹ / ₂	6	6	22194	
		M	.2950	.2792	1 ¹ / ₂	6	6	22195	
	1 ⁹ / ₆₄			.2969	.2792	1 ¹ / ₂	6	6	22196
		N	.3020	.2792	1 ¹ / ₂	6	6	22197	
			.3115	.2792	1 ¹ / ₂	6	6	22198	
5 ¹ / ₁₆			.3125	.2792	1 ¹ / ₂	6	6	22199	
			.3135	.2792	1 ¹ / ₂	6	6	22200	
		O	.3160	.2792	1 ¹ / ₂	6	6	22201	
2 ¹ / ₆₄		P	.3230	.2792	1 ¹ / ₂	6	6	22202	
			.3281	.2792	1 ¹ / ₂	6	6	22203	
		Q	.3320	.2792	1 ¹ / ₂	6	6	22204	
		R	.3390	.2792	1 ¹ / ₂	6	6	22205	
	1 ¹ / ₃₂			.3437	.2792	1 ¹ / ₂	6	6	22206
		S	.3480	.3105	1 ³ / ₄	7	6	22207	
		T	.3580	.3105	1 ³ / ₄	7	6	22208	
2 ³ / ₆₄			.3594	.3105	1 ³ / ₄	7	6	22209	

(continued)

Straight Shank Chucking Reamers (continued)

List No. 1655

Alésoir machine

Rima de máquina

Decimal Sizes: Pages 96-100
Dowel Pin Sizes: Page 100
Metric Sizes: Pages 94-95

Reamers

FRAC-TIONAL	SIZE		DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OAL	NO. OF FLUTES	EDP NO.
	LETTER	DECIMAL						
3/8	U	.3740	.3680	.3105	1 3/4	7	6	22210
			.3740	.3105	1 3/4	7	6	22211
	V	.3760	.3750	.3105	1 3/4	7	6	22212
			.3760	.3105	1 3/4	7	6	22213
25/64	W		.3770	.3105	1 3/4	7	6	22214
			.3860	.3105	1 3/4	7	6	22215
	X		.3906	.3105	1 3/4	7	6	22216
			.3970	.3105	1 3/4	7	6	22217
13/32	Y		.4040	.3105	1 3/4	7	6	22218
			.4062	.3105	1 3/4	7	6	22219
	Z		.4130	.3730	1 3/4	7	6	22220
			.4219	.3730	1 3/4	7	6	22221
7/16		.4365	.4365	.3730	1 3/4	7	6	22222
			.4375	.3730	1 3/4	7	6	22223
		.4385	.4385	.3730	1 3/4	7	6	22224
			.4531	.3730	1 3/4	7	6	22225
29/64	19/32		.4687	.3730	1 3/4	7	6	22226
			.4844	.4355	2	8	6	22227
	31/64	.4990	.4990	.4355	2	8	6	22228
			.5000	.4355	2	8	6	22229
1/2		.5010	.5010	.4355	2	8	6	22230
			.5312	.4355	2	8	6	22231
	9/16		.5625	.4355	2	8	8	22232
			.5937	.4355	2	8	8	22233
5/8	21/32		.6250	.5615	2 1/4	9	8	22234
			.6562	.5615	2 1/4	9	8	22235
	11/16		.6875	.5615	2 1/4	9	8	22236
			.7187	.5615	2 1/4	9	8	22237
3/4	23/32		.7500	.6240	2 1/2	9 1/2	8	22238
			.7812	.6240	2 1/2	9 1/2	8	22239
	13/16		.8125	.6240	2 1/2	9 1/2	8	22240
			.8437	.6240	2 1/2	9 1/2	8	22241
7/8	29/32		.8750	.7490	2 5/8	10	8	22242
			.9062	.7490	2 5/8	10	8	22243
	15/16		.9375	.7490	2 5/8	10	8	22244
			.9687	.7490	2 5/8	10	8	22245
1	11/16		1.0000	.8740	2 3/4	10 1/2	8	22246
			1.0625	.8740	2 3/4	10 1/2	8	22247
	1 1/8		1.1250	.8740	2 7/8	11	10	22248
			1.1875	.9990	2 7/8	11	10	22249
1 1/4	1 3/8		1.2500	.9990	3	11 1/2	10	22250
			1.3750	.9990	3 1/4	12	10	22251
			1.5000	1.2490	3 1/2	12 1/2	10	22252

Straight Shank Chucking Reamer Sets

High Speed Steel — Straight Flute
Right Hand Cut

SET NO.	PCS. PER SET	SIZE RANGE	EDP NO.
501	29	1/16 to 1/2 by 64ths	22301
502	26	A to Z	22302
503	60	Nos. 1 to 60	22303

Jeu d'alésoirs

Juego de rimas



List No. 1655
In Metal Indexed Case

Metric Straight Shank Chuckling Reamers

High Speed Steel
Straight Flute — Right Hand Cut

45° Chamfer for reaming of most materials.

MM SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OAL	NO. OF FLUTES	EDP NO.
1.0	.0394	.0394	½	2½	4	22350
1.5	.0591	.0510	½	2½	4	22351
2.0	.0787	.0720	¾	3	4	22352
2.5	.0984	.0928	¾	3½	4	22353
3.0	.1181	.1120	¾	3½	4	22354
3.5	.1378	.1350	1	4	4	22355
4.0	.1575	.1510	1	4	6	22356
4.5	.1772	.1704	1⅛	4½	6	22357
5.0	.1969	.1895	1¼	5	6	22358
5.5	.2165	.2075	1¼	5	6	22359
6.0	.2362	.2265	1½	6	6	22360
6.5	.2559	.2405	1½	6	6	22361
7.0	.2756	.2485	1½	6	6	22362
7.5	.2953	.2792	1½	6	6	22363
8.0	.3150	.2792	1½	6	6	22364
8.5	.3346	.2792	1½	6	6	22365
9.0	.3543	.3105	1¾	7	6	22366
9.5	.3740	.3105	1¾	7	6	22367
10.0	.3937	.3105	1¾	7	6	22368
10.5	.4134	.3730	1¾	7	6	22369
11.0	.4331	.3730	1¾	7	6	22370
11.5	.4528	.3730	1¾	7	6	22371
12.0	.4724	.4355	2	8	6	22372
12.5	.4921	.4355	2	8	6	22373
13.0	.5118	.4355	2	8	6	22374
13.5	.5315	.4355	2	8	6	22375

Alésoir machine

Rima de máquina



List No. 1655M

Diameter Tolerances (Inches)

up to 12.5 mm — +.0002/-0

13.0 mm to 15.5 mm — +.0003/-0

16.0 mm to 25.0 mm — +.0001/+0.0004

STANDARD PACKAGE All sizes — 1 each

MM SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OAL	NO. OF FLUTES	EDP NO.
14.0	.5512	.4355	2	8	8	22376
14.5	.5709	.4355	2	8	8	22377
15.0	.5906	.4355	2	8	8	22378
15.5	.6102	.5615	2¼	9	8	22379
16.0	.6299	.5615	2¼	9	8	22380
16.5	.6496	.5615	2¼	9	8	22381
17.0	.6693	.5615	2¼	9	8	22382
17.5	.6890	.5615	2¼	9	8	22383
18.0	.7087	.5615	2¼	9	8	22384
18.5	.7283	.6240	2½	9	8	22385
19.0	.7480	.6240	2½	9	8	22386
19.5	.7677	.6240	2½	9	8	22387
20.0	.7874	.6240	2½	9	8	22388
20.5	.8071	.6240	2½	9	8	22389
21.0	.8268	.6240	2½	9½	8	22390
21.5	.8465	.7490	2⅝	10	8	22391
22.0	.8661	.7490	2⅝	10	8	22392
22.5	.8858	.7490	2⅝	10	8	22393
23.0	.9055	.7490	2⅝	10	8	22394
23.5	.9252	.7490	2⅝	10	8	22395
24.0	.9449	.7490	2⅝	10	8	22396
24.5	.9646	.7490	2⅝	10	8	22397
25.0	.9843	.8740	2¾	10½	8	22398

Metric Straight Shank Chuckling Reamer Sets

High Speed Steel Straight Flute - Right Hand Cut

Jeu d'alésoirs

Juego de rimas



List No. 1655M

Over and Under Size Set

In Plastic Pouch

SIZES	PCS.	EDP NO.
.1565 .2766 .3927	14	23304
.1585 .3140 .3947		
.2352 .3160 .4714		
.2372 .3533 .4734		
.2746 .3553		



Standard Size Set

In Metal Indexed Case

SIZES	PIECES	EDP NO.
1.0mm to 13.0mm by .5mm	25	23305