



API
ALVORD-POLK TOOL

Aircraft Quality
Reamers and
Special Tooling

www.alvordpolk.com

Manufactured in the USA since 1881

Since 1881, Alvord-Polk has been a manufacturer of the Highest Quality Reamers and Special Cutting Tools in the industry.

Our reputation for quality is world renown and we continue to manufacture all of our cutting tools at our United States facilities. Alvord-Polk Tool has three manufacturing plants. Two facilities are located in Pennsylvania and another manufacturing facility is located in South Dakota. When it's marked Alvord-Polk Tool, you can count on the fact that we made it ourselves.



Alvord-Polk is still a family-held and family-run business. Your satisfaction is important to us and we will continue to do our best to earn your business with each and every order. If you have questions or need

support, please just give us a call. We still have real people at our support center and they would love to help you.

Quality is priority #1 at Alvord-Polk Tool. Alvord-Polk's quality system has been audited and found to be in compliance with the ISO 9001:2008 standard. We have successfully passed all of our audits since 2000.

Significant investment has been made the last 5 years on equipment, staffing and also inventory levels. Grinding capabilities have been dramatically expanded with the addition of several CNC grinders.



Additional shifts have been added specifically to increase our capacity to manufacture carbide tooling. Alvord-Polk now has three shifts and that has significantly improved our next day special grind down program. We have bolstered an already sizable inventory with heavier levels of standard tooling in both high speed steel and carbide. We also continue to maintain inventories in Chicago, Seattle and Anaheim to support our main inventory in Millersburg, PA.



"Your satisfaction is important to us and we will continue to do our best to earn your business with each and every order."

Terms and Conditions

RETURN GOODS POLICY

Alvord-Polk Tool will replace or apply full credit to your account for any tool that does not meet advertised catalog specifications for quality.

Alvord-Polk Tool will not accept as a return any tool that has been altered or modified from its original specifications.

A 15% re-stocking charge will be applied to any returned standard. This charge will be deducted from the credit that will be issued to your account.

Alvord-Polk Tool will not accept any return for a product that is purchased prior to one calendar year from the date of request for return.

All returns must be given a "Returned Goods Authorization".

Alvord-Polk Tool reserves the right to decline any return if the quantity desired to be returned cannot be reasonably re-sold within the next calendar year.

SPECIAL TOOLS POLICY

Cancellations of "special" tools are subject to a charge for raw material and work performed prior to the time of cancellation. Acceptable industry practice assumes a 10% over/under shipment is allowed on a special tool order. If no over/under shipment is allowed, the corresponding RFQ (Request For Quote) and PO (Purchase Order) should carry the appropriate instructions.

TERMS OF PAYMENT

Net 30 days, F.O.B. Millersburg, PA with minimum transportation charges prepaid or allowed on orders of \$1000.00 (Net) or more. Minimum order \$25.00 (Net). If order is under \$25.00 (Net), an additional charge will be added to meet the net minimum.

UNPAID ACCOUNTS POLICY

Accounts unpaid beyond 30 days are subject to a service charge of 1.5% per month. All accounts with unpaid balances beyond 60 days are put on Credit Hold and a HOLD is placed on current active orders to the same account.

SHIPPING

FOB Millersburg, PA – Freight pre-paid on orders over \$1,000.00 (Net USA only). A \$10.00 charge will be added for drop shipments.

OPEN ACCOUNT APPLICATIONS

Complete address and telephone and fax numbers of three trade references and your bank are required.

PRICES SUBJECT TO CHANGE

Catalog 27 prices effective January 2015.



Solid Carbide Reamers

NAS 898, Straight Flute, Stainless Steel, Carbide	898-A	
Straight Flute, Straight Shank, Carbide	827-0	5-8



Carbide Drill Reamers

Straight Flute	925-0	8
Right Hand Spiral	925-1	



Chucking Reamers

HIGH SPEED STEEL

Straight Shank Chucking Reamers	897-A-S, 897-A-R, 897-A-L	9-16
Fractional Sizes, Number Sizes, Letter Sizes, Metric Sizes Thousandths & Half-Thousandths Special Diameters		



COATED HIGH SPEED STEEL

TiN Coated, Right Hand Spiral	757-1	9-16
TiCN Coated, Right Hand Spiral	767-1	



COBALT

Straight Shank Chucking Reamers	897-B-S, 897-B-R	9-16
Fractional Sizes, Number Sizes, Letter Sizes, Metric Sizes Special Diameters Piloted, Straight Flute, Straight Shank		



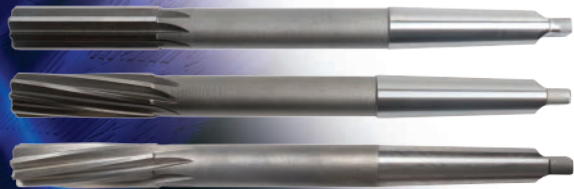
PILOTED

Straight Flute, Straight Shank	897-A-S	17
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Threaded Shank Reamers

Piloted Threaded Shank Reamers		18
HSS, Standard Length (2-1/8 OAL)	865-0	
Cobalt, Standard Length (2-1/8 OAL)	866-0	
Carbide, Standard Length (2-1/8 OAL)	829-0	



Taper Shank Chucking Reamers

HSS, Tapered Shank Chucking Reamers	131-0, 131-1, 131-2	19
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Jobber Reamers

HSS, Straight Flute, Tapered Shank	105-0	20
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Center Reamers

HSS, 60, 82, 90, 100, 110, 120 Degree Cutting Angles

179-0

20



Bridge Reamers

HSS, Straight Flute, Taper Shank

625-0

21



HSS, Left Hand Spiral, Taper Shank

627-2



Construction Reamers

HSS, Left Hand Spiral, Fast Helix, Straight Shank

650-H

22



HSS, Left Hand Spiral, Fast Helix,
Tri-Flats on Shank

650-F

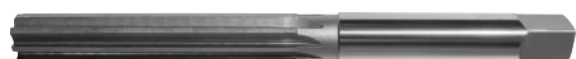


Metric Hand Reamers

HSS, Straight Flute

101-0

22



Hand Reamers

HSS, Straight Flute

101-0

23



HSS, Left Hand Spiral, Right Hand Cut

101-2



Taper Pin Reamers

HSS, Straight Flute

155-0

24



HSS, Left Hand Spiral

155-2



HSS, Helical

155-H



HSS, Metric Straight Flute

156-0

HSS, Metric Left Hand Spiral

156-2

HSS, Metric Helical

156-H



Steering & Suspension Reamers

HSS, Left Hand Spiral

259-2

24

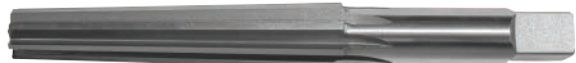


Morse Taper Reamers

HSS, Straight Flute, Right Hand Cut, Taper Shank

163-0

25



HSS, Straight Flute, Right Hand Cut, Square Shank

161-0



Brown & Sharpe Reamers

HSS, Straight Flute, Taper Socket Reamers

261-0

25



Taper Pipe Reamers

HSS, Left Hand Spiral, Right Hand Cut

207-2

25



Repairmen's Taper Reamers

HSS, Straight Flute, T-Handle

651-0, 652-0, 653-0

26



Repairmen's Deburring Reamers

HSS, Left Hand Spiral, Right Hand Cut

661, 662, 663

26



Core Drills

HSS, Straight Shank, 4 Flutes

8001

26

Fractional Sizes

Special Diameters



Threaded Shank Core Drills

LONG SERIES

HSS, Piloted, 18 Degree Helix

965-1

27



EXTRA LONG SERIES

HSS, Piloted, 18 Degree Helix

969-1



Cap screw Counterbores

HSS, Right Hand Cut, Helical Flute, Straight Shank

28-30



1/32 Oversize, 1/32 Oversize TiN Coated

300, 307

1/64 Oversize, 1/64 Oversize TiN Coated

400, 407

On Size, On Size TiN Coated

500, 507

Metric, Metric TiN

401, 471



TAPER SHANK CAPSCREW COUNTERBORES

1/32 Oversize, 30 Degree, Right Hand Spiral, 4 Flutes

350

Metric, 30 Degree, Right Hand Spiral, 4 Flutes

420

Cap screw Counterbore Sets

300, 400, 500, 401

307, 407, 507, 471



Adjustable Blade Tooling

CAPSCREW COUNTERBORES

31

Adjustable Blade, Straight Shank



Adjustable Blade, Tapered Shank

Replacement Blades



Reamer Sets

Chuckling Reamer Sets

897-A, 897-B

32-33

Taper Pin Reamer Sets

155-S

Repairmen's Reamer Sets

103-S, 104-S

Construction Reamer Sets

650-S

Taper Pipe Reamer Sets

207-S

Solid Carbide Reamers

SPECIFICATIONS

Straight Flute



898-A Straight Flute, Straight Shank, Carbide

# of Flutes	Range	Diameter/Type	Tolerances
4 Flutes	.0469-.1914 Dia.	.0280-.5000	+.0002-.0000
6 Flutes	.1915-.5311 Dia.	Dowel Pin (d-p)	+.0000-.0002
8 Flutes	.5312-.6250 Dia.		

Alvord-Polk Carbide Chucking Reamers meet NAS 898-A specifications for tolerance and concentricity.

EDP Number	Size	Dec. Equiv.	Flute Length	Overall Length	EDP Number	Size	Dec. Equiv.	Flute Length	Overall Length	EDP Number	Size	Dec. Equiv.	Flute Length	Overall Length
38018	3/64	0.0469	3/8	1-1/2	38075	#17	0.1730	7/8	2-3/4	38132	o/u	0.3135	1-1/2	3-1/2
38019	#55	0.0520	3/8	1-1/2	38076	#16	0.1770	7/8	2-3/4	38133	8mm	0.3150	1-1/2	3-1/2
38020	#54	0.0550	3/8	1-1/2	38077	4.5mm	0.1772	7/8	2-3/4	38134	O	0.3160	1-1/2	3-1/2
38021	1.5mm	0.0591	3/8	1-1/2	38078	#15	0.1800	7/8	2-3/4	38135	P	0.3230	1-1/2	3-1/2
38022	#53	0.0595	3/8	1-1/2	38079	#14	0.1820	7/8	2-3/4	38136	21/64	0.3281	1-1/2	3-1/2
38023	1/16	0.0625	3/8	1-1/2	38080	#13	0.1850	7/8	2-3/4	38137	Q	0.3320	1-1/2	3-1/2
38024	#52	0.0635	3/8	1-1/2	38081	d-p	0.1855	7/8	2-3/4	38138	8.5mm	0.3346	1-1/2	3-1/2
38025	#51	0.0670	1/2	2	38082	o/u	0.1865	7/8	2-3/4	38139	R	0.3390	1-1/2	3-1/2
38026	#50	0.0700	1/2	2	38083	d-p	0.1870	7/8	2-3/4	38140	11/32	0.3438	1-1/2	3-1/2
38027	#49	0.0730	1/2	2	38084	3/16	0.1875	7/8	2-3/4	38141	S	0.3480	1-1/2	3-1/2
38028	#48	0.0760	1/2	2	38085	o/u	0.1885	7/8	2-3/4	38142	9MM	0.3543	1-1/2	3-1/2
38029	5/64	0.0781	1/2	2	38086	#12	0.1890	1	3	38143	T	0.3580	1-1/2	3-1/2
38030	#47	0.0785	1/2	2	38087	#11	0.1910	1	3	38144	23/64	0.3594	1-1/2	3-1/2
38031	2MM	0.0787	1/2	2	38088	#10	0.1935	1	3	38145	U	0.3680	1-1/2	3-1/2
38032	#46	0.0810	1/2	2	38089	#9	0.1960	1	3	38146	d-p	0.3730	1-1/2	3-1/2
38033	#45	0.0820	1/2	2	38090	5mm	0.1968	1	3	38148	o/u 9.5mm	0.3740	1-1/2	3-1/2
38034	#44	0.0860	1/2	2	38091	#8	0.1990	1	3	38149	.3745	0.3745	1-1/2	3-1/2
38035	#43	0.0890	1/2	2	38092	#7	0.2010	1	3	38150	3/8	0.3750	1-1/2	3-1/2
38036	#42	0.0935	1/2	2	38093	13/64	0.2031	1	3	38151	o/u	0.3760	1-1/2	3-1/2
38037	3/32	0.0938	1/2	2	38094	#6	0.2040	1	3	38152	V	0.3770	2	4
38038	#41	0.0960	1/2	2	38095	#5	0.2055	1	3	38153	W	0.3860	2	4
38039	#40	0.0980	5/8	2-1/4	38096	#4	0.2090	1	3	38154	25/64	0.3906	2	4
38040	2.5mm	0.0984	5/8	2-1/4	38097	#3	0.2130	1	3	38155	10mm	0.3937	2	4
38041	#39	0.0995	5/8	2-1/4	38098	5.5mm	0.2165	1	3	38156	X	0.3970	2	4
38042	#38	0.1015	5/8	2-1/4	38099	7/32	0.2188	1	3	38157	Y	0.4040	2	4
38043	#37	0.1040	5/8	2-1/4	38100	#2	0.2210	1	3	38158	13/32	0.4062	2	4
38044	#36	0.1065	5/8	2-1/4	38101	#1	0.2280	1	3	38159	Z	0.4130	2	4
38045	7/64	0.1094	5/8	2-1/4	38102	A	0.2340	1	3	38160	10.5mm	0.4134	2	4
38046	#35	0.1100	5/8	2-1/4	38103	15/64	0.2344	1	3	38161	27/64	0.4219	2	4
38047	#34	0.1110	5/8	2-1/4	38104	6mm	0.2362	1	3	38162	11mm	0.4331	2	4
38048	#33	0.1130	5/8	2-1/4	38105	B	0.2380	1	3	38163	d-p	0.4355	2	4
38049	#32	0.1160	5/8	2-1/4	38106	C	0.2420	1	3	38164	o/u	0.4365	2	4
38050	3MM	0.1181	5/8	2-1/4	38107	D	0.2460	1	3	38165	d-p	0.4370	2	4
38051	#31	0.1200	5/8	2-1/4	38108	d-p	0.2480	1	3	38166	7/16	0.4375	2	4
38052	d-p	0.1230	5/8	2-1/4	38109	o/u	0.2490	1	3	38167	o/u	0.4385	2	4
38053	o/u	0.1240	5/8	2-1/4	38110	d-p	0.2495	1	3	38168	11.5mm	0.4528	2	4
38054	d-p	0.1247	5/8	2-1/4	38111	1/4 E	0.2500	1	3	38169	29/64	0.4531	2	4
38055	1/8	0.1250	5/8	2-1/4	38112	o/u	0.2510	1	3	38170	15/32	0.4688	2	4
38056	o/u	0.1260	5/8	2-1/4	38113	6.5mm	0.2559	1-1/4	3-1/4	38171	12mm	0.4724	2	4
38057	#30	0.1285	3/4	2-1/2	38114	F	0.2570	1-1/4	3-1/4	38172	31/64	0.4844	2	4
38058	#29	0.1360	3/4	2-1/2	38115	G	0.2610	1-1/4	3-1/4	38173	12.5mm	0.4921	2	4
38059	3.5mm	0.1378	3/4	2-1/2	38116	17/64	0.2656	1-1/4	3-1/4	38174	d-p	0.4980	2	4
38060	#28	0.1405	3/4	2-1/2	38117	H	0.2660	1-1/4	3-1/4	38175	o/u	0.4990	2	4
38061	9/64	0.1406	3/4	2-1/2	38118	I	0.2720	1-1/4	3-1/4	38176	d-p	0.4995	2	4
38062	#27	0.1440	3/4	2-1/2	38119	7mm	0.2756	1-1/4	3-1/4	38177	1/2	0.5000	2	4
38063	#26	0.1470	3/4	2-1/2	38120	J	0.2770	1-1/4	3-1/4	38178	o/u	0.5010	2	4
38064	#25	0.1495	3/4	2-1/2	38121	K	0.2810	1-1/4	3-1/4	38179	13.0mm	0.5118	2	4
38065	#24	0.1520	3/4	2-1/2	38122	9/32	0.2812	1-1/4	3-1/4	38180	17/32	0.5312	2	4
38066	#23	0.1540	3/4	2-1/2	38123	L	0.2900	1-1/2	3-1/2	38181	13.5mm	0.5315	2	4
38067	5/32	0.1562	3/4	2-1/2	38124	M	0.2950	1-1/2	3-1/2	38182	14.0mm	0.5512	2	4
38068	#22	0.1570	3/4	2-1/2	38125	7.5mm	0.2953	1-1/2	3-1/2	38183	9/16	0.5625	2	4
38069	4mm	0.1575	3/4	2-1/2	38126	19/64	0.2969	1-1/2	3-1/2	38184	14.5mm	0.5709	2	4
38070	#21	0.1590	3/4	2-1/2	38127	N	0.3020	1-1/2	3-1/2	38185	15.0mm	0.5906	2	4
38071	#20	0.1610	7/8	2-3/4	38128	d-p	0.3105	1-1/2	3-1/2	38186	19/32	0.5938	2	4
38072	#19	0.1660	7/8	2-3/4	38129	o/u	0.3115	1-1/2	3-1/2	38187	15.5mm	0.6102	2	4
38073	#18	0.1695	7/8	2-3/4	38130	d-p	0.3120	1-1/2	3-1/2	38188	5/8	0.6250	2	4
38074	11/64	0.1719	7/8	2-3/4	38131	5/16	0.3125	1-1/2	3-1/2					



Special Diameter Solid Carbide Reamers

898-A

Diameter Range	Flute Length	Overall Length
.0500 - .0669	3/8	1-1/2
.0670 - .0969	1/2	2
.0970 - .1110	5/8	2-1/4
.1111 - .1284	5/8	2-1/4
.1285 - .1590	3/4	2-1/2
.1591 - .1889	7/8	2-3/4
.1890 - .1914	1	3
.1915 - .2180	1	3
.2181 - .2549	1	3

Diameter Range	Flute Length	Overall Length
.2550 - .2899	1-1/4	3-1/4
.2900 - .3160	1-1/2	3-1/2
.3161 - .3430	1-1/2	3-1/2
.3431 - .3769	1-1/2	3-1/2
.3770 - .4062	2	4
.4063 - .4380	2	4
.4381 - .4688	2	4
.4689 - .5050	2	4



Solid Carbide Chucking Reamers

827-0

Straight Flute, Straight Shank 827-0 Series Has a Reduced Shank

EDP Number 827-0	Size	Decimal Equiv.	Diameter of Shank	Length of Flute Inches	Overall Length Inches
08018	3/64	0.0469	0.0317 - 0.0307	3/8	1-1/2
08019	#55	0.0520	0.0469 - 0.0459	3/8	1-1/2
08020	#54	0.0550	0.0469 - 0.0459	3/8	1-1/2
08021	1.5mm	0.0591	0.0469 - 0.0459	3/8	1-1/2
08022	#53	0.0595	0.0469 - 0.0459	3/8	1-1/2
08023	1/16	0.0625	0.0469 - 0.0459	3/8	1-1/2
08024	#52	0.0635	0.0469 - 0.0459	3/8	1-1/2
08025	#51	0.0670	0.0625 - 0.0615	1/2	2
08026	#50	0.0700	0.0625 - 0.0615	1/2	2
08027	#49	0.0730	0.0625 - 0.0615	1/2	2
08028	#48	0.0760	0.0625 - 0.0615	1/2	2
08029	5/64	0.0781	0.0625 - 0.0615	1/2	2
08030	#47	0.0785	0.0625 - 0.0615	1/2	2
08031	2MM	0.0787	0.0625 - 0.0615	1/2	2
08032	#46	0.0810	0.0781 - 0.0771	1/2	2
08033	#45	0.0820	0.0781 - 0.0771	1/2	2
08034	#44	0.0860	0.0781 - 0.0771	1/2	2
08035	#43	0.0890	0.0781 - 0.0771	1/2	2
08036	#42	0.0935	0.0781 - 0.0771	1/2	2
08037	3/32	0.0938	0.0781 - 0.0771	1/2	2
08038	#41	0.0960	0.0781 - 0.0771	1/2	2
08039	#40	0.0980	0.0938 - 0.0928	5/8	2-1/4
08040	2.5mm	0.0984	0.0938 - 0.0928	5/8	2-1/4
08041	#39	0.0995	0.0938 - 0.0928	5/8	2-1/4
08042	#38	0.1015	0.0938 - 0.0928	5/8	2-1/4
08043	#37	0.1040	0.0938 - 0.0928	5/8	2-1/4
08044	#36	0.1065	0.0938 - 0.0928	5/8	2-1/4
08045	7/64	0.1094	0.0938 - 0.0928	5/8	2-1/4
08046	#35	0.1100	0.0938 - 0.0928	5/8	2-1/4
08047	#34	0.1110	0.0938 - 0.0928	5/8	2-1/4
08048	#33	0.1130	0.1094 - 0.1084	5/8	2-1/4
08049	#32	0.1160	0.1094 - 0.1084	5/8	2-1/4
08050	3MM	0.1181	0.1094 - 0.1084	5/8	2-1/4
08051	#31	0.1200	0.1094 - 0.1084	5/8	2-1/4
08052	d-p	0.1230	0.1094 - 0.1084	5/8	2-1/4
08053	o/u	0.1240	0.1094 - 0.1084	5/8	2-1/4
08054	d-p	0.1247	0.1094 - 0.1084	5/8	2-1/4
08055	1/8	0.1250	0.1094 - 0.1084	5/8	2-1/4
08056	o/u	0.1260	0.1094 - 0.1084	5/8	2-1/4
08057	#30	0.1285	0.1250 - 0.1240	3/4	2-1/2
08058	#29	0.1360	0.1250 - 0.1240	3/4	2-1/2
08059	3.5mm	0.1378	0.1250 - 0.1240	3/4	2-1/2
08060	#28	0.1405	0.1250 - 0.1240	3/4	2-1/2
08061	9/64	0.1406	0.1250 - 0.1240	3/4	2-1/2
08062	#27	0.1440	0.1250 - 0.1240	3/4	2-1/2

EDP Number 827-0	Size	Decimal Equiv.	Diameter of Shank	Length of Flute Inches	Overall Length Inches
08063	#26	0.1470	0.1406 - 0.1396	3/4	2-1/2
08064	#25	0.1495	0.1406 - 0.1396	3/4	2-1/2
08065	#24	0.1520	0.1406 - 0.1396	3/4	2-1/2
08066	#23	0.1540	0.1406 - 0.1396	3/4	2-1/2
08067	5/32	0.1562	0.1406 - 0.1396	3/4	2-1/2
08068	#22	0.1570	0.1406 - 0.1396	3/4	2-1/2
08069	4mm	0.1575	0.1406 - 0.1396	3/4	2-1/2
08070	#21	0.1590	0.1406 - 0.1396	3/4	2-1/2
08071	#20	0.1610	0.1562 - 0.1552	7/8	2-3/4
08072	#19	0.1660	0.1562 - 0.1552	7/8	2-3/4
08073	#18	0.1695	0.1562 - 0.1552	7/8	2-3/4
08074	11/64	0.1719	0.1562 - 0.1552	7/8	2-3/4
08075	#17	0.1730	0.1562 - 0.1552	7/8	2-3/4
08076	#16	0.1770	0.1719 - 0.1709	7/8	2-3/4
08077	4.5mm	0.1772	0.1719 - 0.1709	7/8	2-3/4
08078	#15	0.1800	0.1719 - 0.1709	7/8	2-3/4
08079	#14	0.1820	0.1719 - 0.1709	7/8	2-3/4
08080	#13	0.1850	0.1719 - 0.1709	7/8	2-3/4
08081	d-p	0.1855	0.1719 - 0.1709	7/8	2-3/4
08082	o/u	0.1865	0.1719 - 0.1709	7/8	2-3/4
08083	d-p	0.1870	0.1719 - 0.1709	7/8	2-3/4
08084	3/16	0.1875	0.1719 - 0.1709	7/8	2-3/4
08085	o/u	0.1885	0.1719 - 0.1709	7/8	2-3/4
08086	#12	0.1890	0.1719 - 0.1709	7/8	2-3/4
08087	#11	0.1910	0.1719 - 0.1709	7/8	2-3/4
08088	#10	0.1935	0.1875 - 0.1865	1	3
08089	#9	0.1960	0.1875 - 0.1865	1	3
08090	5mm	0.1968	0.1875 - 0.1865	1	3
08091	#8	0.1990	0.1875 - 0.1865	1	3
08092	#7	0.2010	0.1875 - 0.1865	1	3
08093	13/64	0.2031	0.1875 - 0.1865	1	3
08094	#6	0.2040	0.1875 - 0.1865	1	3
08095	#5	0.2055	0.1875 - 0.1865	1	3
08096	#4	0.2090	0.1875 - 0.1865	1	3
08097	#3	0.2130	0.1875 - 0.1865	1	3
08098	5.5mm	0.2165	0.1875 - 0.1865	1	3
08099	7/32	0.2188	0.1875 - 0.1865	1	3
08100	#2	0.2210	0.1875 - 0.1865	1	3
08101	#1	0.2280	0.2188 - 0.2178	1	3
08102	A	0.2340	0.2188 - 0.2178	1	3
08103	15/64	0.2344	0.2188 - 0.2178	1	3
08104	6mm	0.2362	0.2188 - 0.2178	1	3
08105	B	0.2380	0.2188 - 0.2178	1	3
08106	C	0.2420	0.2188 - 0.2178	1	3
08107	D	0.2460	0.2188 - 0.2178	1	3

Solid Carbide Chucking Reamers

827-0



EDP Number 827-0	Size	Decimal Equiv.	Diameter of Shank	Length of Flute Inches	Overall Length Inches
08108	d-p	0.2480	0.2188 - 0.2178	1	3
08109	o/u	0.2490	0.2188 - 0.2178	1	3
08110	d-p	0.2495	0.2188 - 0.2178	1	3
08111	1/4 E	0.2500	0.2188 - 0.2178	1	3
08112	o/u	0.2510	0.2188 - 0.2178	1	3
08113	6.5mm	0.2559	0.2500 - 0.2490	1-1/8	3-1/4
08114	F	0.2570	0.2500 - 0.2490	1-1/8	3-1/4
08115	G	0.2610	0.2500 - 0.2490	1-1/8	3-1/4
08116	17/64	0.2656	0.2500 - 0.2490	1-1/8	3-1/4
08117	H	0.2660	0.2500 - 0.2490	1-1/8	3-1/4
08118	I	0.2720	0.2500 - 0.2490	1-1/8	3-1/4
08119	7mm	0.2756	0.2500 - 0.2490	1-1/8	3-1/4
08120	J	0.2770	0.2500 - 0.2490	1-1/8	3-1/4
08121	K	0.2810	0.2500 - 0.2490	1-1/8	3-1/4
08122	9/32	0.2812	0.2500 - 0.2490	1-1/8	3-1/4
08123	L	0.2900	0.2812 - 0.2802	1-1/8	3-1/4
08124	M	0.2950	0.2812 - 0.2802	1-1/8	3-1/4
08125	7.5mm	0.2953	0.2812 - 0.2802	1-1/8	3-1/4
08126	19/64	0.2969	0.2812 - 0.2802	1-1/8	3-1/4
08127	N	0.3020	0.2812 - 0.2802	1-1/8	3-1/4
08128	d-p	0.3105	0.2812 - 0.2802	1-1/8	3-1/4
08129	o/u	0.3115	0.2812 - 0.2802	1-1/8	3-1/4
08130	d-p	0.3120	0.2812 - 0.2802	1-1/8	3-1/4
08131	5/16	0.3125	0.2812 - 0.2802	1-1/8	3-1/4
08132	o/u	0.3135	0.2812 - 0.2802	1-1/8	3-1/4
08133	8mm	0.3150	0.2812 - 0.2802	1-1/8	3-1/4
08134	O	0.3160	0.2812 - 0.2802	1-1/8	3-1/4
08135	P	0.3230	0.3125 - 0.3115	1-1/4	3-1/2
08136	21/64	0.3281	0.3125 - 0.3115	1-1/4	3-1/2
08137	Q	0.3320	0.3125 - 0.3115	1-1/4	3-1/2
08138	8.5mm	0.3346	0.3125 - 0.3115	1-1/4	3-1/2
08139	R	0.3390	0.3125 - 0.3115	1-1/4	3-1/2
08140	11/32	0.3438	0.3125 - 0.3115	1-1/4	3-1/2
08141	S	0.3480	0.3125 - 0.3115	1-1/4	3-1/2
08142	9MM	0.3543	0.3438 - 0.3428	1-1/4	3-1/2

EDP Number 827-0	Size	Decimal Equiv.	Diameter of Shank	Length of Flute Inches	Overall Length Inches
08143	T	0.3580	0.3438 - 0.3428	1-1/4	3-1/2
08144	23/64	0.3594	0.3438 - 0.3428	1-1/4	3-1/2
08145	U	0.3680	0.3438 - 0.3428	1-1/4	3-1/2
08146	d-p	0.3730	0.3438 - 0.3428	1-1/4	3-1/2
08148	o/u 9.5mm	0.3740	0.3438 - 0.3428	1-1/4	3-1/2
08149	d-p	0.3745	0.3438 - 0.3428	1-1/4	3-1/2
08150	3/8	0.3750	0.3438 - 0.3428	1-1/4	3-1/2
08151	o/u	0.3760	0.3438 - 0.3428	1-1/4	3-1/2
08152	V	0.3770	0.3438 - 0.3428	1-1/4	3-1/2
08153	W	0.3860	0.3750 - 0.3740	1-1/2	4
08154	25/64	0.3906	0.3750 - 0.3740	1-1/2	4
08155	10mm	0.3937	0.3750 - 0.3740	1-1/2	4
08156	X	0.3970	0.3750 - 0.3740	1-1/2	4
08157	Y	0.4040	0.3750 - 0.3740	1-1/2	4
08158	13/32	0.4062	0.3750 - 0.3740	1-1/2	4
08159	Z	0.4130	0.4062 - 0.4052	1-1/2	4
08160	10.5mm	0.4134	0.4062 - 0.4052	1-1/2	4
08161	27/64	0.4219	0.4062 - 0.4052	1-1/2	4
08162	11mm	0.4331	0.4062 - 0.4052	1-1/2	4
08163	d-p	0.4355	0.4062 - 0.4052	1-1/2	4
08164	o/u	0.4365	0.4062 - 0.4052	1-1/2	4
08165	d-p	0.4370	0.4062 - 0.4052	1-1/2	4
08166	7/16	0.4375	0.4062 - 0.4052	1-1/2	4
08167	o/u	0.4385	0.4062 - 0.4052	1-1/2	4
08168	11.5mm	0.4528	0.4375 - 0.4365	1-1/2	4
08169	29/64	0.4531	0.4375 - 0.4365	1-1/2	4
08170	15/32	0.4688	0.4375 - 0.4365	1-1/2	4
08171	12mm	0.4724	0.4375 - 0.4365	1-1/2	4
08172	31/64	0.4844	0.4688 - 0.4678	1-1/2	4
08173	12.5mm	0.4921	0.4688 - 0.4678	1-1/2	4
08174	d-p	0.4980	0.4688 - 0.4678	1-1/2	4
08175	o/u	0.4990	0.4688 - 0.4678	1-1/2	4
08176	d-p	0.4995	0.4688 - 0.4678	1-1/2	4
08177	1/2	0.5000	0.4688 - 0.4678	1-1/2	4
08178	o/u	0.5010	0.4688 - 0.4678	1-1/2	4

Special Diameter Solid Carbide Chucking Reamers

827-0

EDP Number 827-0	Size	EDP Number 827-0	Size	EDP Number 827-0	Size	EDP Number 827-0	Size	EDP Number 827-0	Size	EDP Number 827-0	Size
08300	0.0620	08350	0.1295	08399	0.2020	08448	0.2630	08497	0.3310	08546	0.3930
08301	0.0630	08351	0.1300	08400	0.2050	08449	0.2640	08498	0.3330	08547	0.3940
08302	0.0675	08352	0.1310	08401	0.2080	08450	0.2650	08499	0.3340	08548	0.3950
08304	0.0680	08353	0.1320	08402	0.2100	08451	0.2700	08500	0.3350	08549	0.3960
08305	0.0725	08354	0.1335	08403	0.2140	08452	0.2750	08501	0.3360	08550	0.4000
08306	0.0745	08355	0.1340	08404	0.2150	08453	0.2780	08502	0.3370	08551	0.4050
08307	0.0750	08356	0.1350	08405	0.2160	08454	0.2800	08503	0.3380	08552	0.4060
08308	0.0765	08357	0.1370	08406	0.2170	08455	0.2820	08504	0.3400	08553	0.4100
08309	0.0770	08358	0.1400	08407	0.2180	08456	0.2830	08505	0.3410	08554	0.4120
08310	0.0775	08359	0.1420	08408	0.2185	08457	0.2840	08506	0.3420	08555	0.4150
08311	0.0780	08360	0.1460	08409	0.2190	08458	0.2850	08507	0.3430	08556	0.4180
08312	0.0800	08361	0.1490	08410	0.2200	08459	0.2860	08508	0.3440	08557	0.4290
08313	0.0805	08362	0.1500	08411	0.2220	08460	0.2870	08509	0.3450	08558	0.4300
08314	0.0830	08363	0.1530	08412	0.2230	08461	0.2890	08510	0.3460	08559	0.4320
08315	0.0840	08364	0.1550	08413	0.2240	08462	0.2910	08511	0.3470	08560	0.4330
08316	0.0850	08365	0.1555	08414	0.2250	08463	0.2920	08512	0.3490	08561	0.4350
08317	0.0870	08366	0.1560	08415	0.2260	08464	0.2930	08513	0.3500	08562	0.4360
08318	0.0880	08367	0.1565	08416	0.2270	08465	0.2940	08514	0.3510	08563	0.4380
08319	0.0900	08368	0.1580	08417	0.2290	08466	0.2960	08515	0.3520	08564	0.4390
08320	0.0910	08369	0.1585	08418	0.2300	08467	0.2970	08516	0.3530	08565	0.4400
08321	0.0920	08370	0.1600	08419	0.2310	08468	0.2980	08517	0.3540	08566	0.4410
08322	0.0930	08371	0.1605	08420	0.2320	08469	0.2990	08518	0.3550	08567	0.4420
08323	0.0940	08372	0.1620	08421	0.2350	08470	0.300	08519	0.3560	08568	0.4430
08324	0.0950	08373	0.1630	08422	0.2360	08471	0.3010	08520	0.3570	08569	0.4450
08325	0.0970	08374	0.1635	08423	0.2365	08472	0.3030	08521	0.3590	08570	0.4460
08326	0.0990	08375	0.1640	08424	0.2375	08473	0.3040	08522	0.3600	08571	0.4480
08327	0.1000	08376	0.1650	08425	0.2390	08474	0.3050	08523	0.3610	08572	0.4500
08328	0.1010	08377	0.1710	08426	0.2400	08475	0.3060	08524	0.3620	08573	0.4520
08329	0.1020	08378	0.1740	08427	0.2415	08476	0.3070	08525	0.3630	08574	0.4600
08330	0.1030	08379	0.1810	08428	0.2440	08477	0.3080	08526	0.3640	08575	0.4660
08331	0.1050	08380	0.1830	08429	0.2450	08478	0.3090	08527	0.3650	08576	0.4680
08332	0.1060	08381	0.1840	08430	0.2465	08479	0.3100	08528	0.3660	08577	0.4690
08333	0.1070	08382	0.1860	08431	0.2470	08480	0.3110	08529	0.3670	08578	0.4700
08334	0.1080	08383	0.1880	08432	0.2475	08481	0.3130	08530	0.3690	08579	0.4710
08335	0.1090	08384	0.1895	08433	0.2485	08482	0.3140	08531	0.3700	08580	0.4720
08336	0.1120	08385	0.1900	08434	0.2505	08483	0.3170	08532	0.3710	08581	0.4730
08337	0.1125	08386	0.1905	08435	0.2515	08484	0.3180	08533	0.3720	08582	0.4740
08338	0.1170	08387	0.1915	08436	0.2520	08485	0.3185	08534	0.3755	08583	0.4750
08339	0.1175	08388	0.1920	08437	0.2525	08486	0.3190	08535	0.3765	08584	0.4780
08340	0.1190	08389	0.1930	08438	0.2530	08487	0.3200	08536	0.3780	08585	0.4800
08341	0.1210	08390	0.1940	08439	0.2535	08488	0.3210	08537	0.3790	08586	0.4900
08342	0.1220	08391	0.1950	08440	0.2540	08489	0.3220	08538	0.3800	08587	0.4910
08343	0.1235	08392	0.1965	08441	0.2550	08490	0.3240	08539	0.3810	08588	0.4950
08344	0.1255	08393	0.1970	08442	0.2560	08491	0.3250	08540	0.3820	08589	0.4960
08345	0.1265	08394	0.1975	08443	0.2580	08492	0.3260	08541	0.3830	08590	0.4970
08346	0.1270	08395	0.1980	08444	0.2590	08493	0.3270	08542	0.3850	08591	0.5005
08347	0.1275	08396	0.1985	08445	0.2600	08494	0.3280	08543	0.3900	08592	0.5015
08348	0.1280	08397	0.1995	08446	0.2620	08495	0.3290	08544	0.3910	08593	0.5060
08349	0.1290	08398	0.2000	08447	0.2625	08496	0.3300	08545	0.3920		



925-0 Straight Flute



925-1 5° Right Hand Spiral

Carbide Drill Reamers

Series 925-0 and 925-1

Tolerances
+.0002-.0000

EDP Number 925-0	EDP Number 925-1	Size	Decimal Equiv. Inches	Length of Flute Inches	Overall Length Inches
93037	93237	3/32	.0937	1-1/2	3
93039	93239	#40	.0980	1-1/2	3
93055	93255	1/8	.1250	1-1/2	3
93057	93257	#30	.1285	1-1/2	3
93067	93267	5/32	.1562	2	4
93070	93270	#21	.1590	2	4
93071	93271	#20	.1610	2	4

EDP Number 925-0	EDP Number 925-1	Size	Decimal Equiv. Inches	Length of Flute Inches	Overall Length Inches
93084	93284	3/16	.1875	2	4
93087	93287	#11	.1910	2-1/2	6
93088	93288	#10	.1935	2-1/2	6
93089	93289	#9	.1960	2-1/2	6
93091	93291	#8	.1990	2-1/2	6
93111	93311	1/4	.2500	2-1/2	6

Chucking Reamers

SPECIFICATIONS

Flute Configuration for Series 897-A-S, 897-B-S, 897-A-R, 897-B-R, 897-A-L, 757-1 and 767-1 Straight Shank Chucking Reamers

# of Flutes	Range	Diameter/Type	Tolerances
2 Flutes	.0135-.0200 Dia.	.0135-.5000	+0.0002-.0000
3 Flutes	.0201-.0279 Dia.	.5001-.7500	+0.0003-.0000
4 Flutes	.0280-.1561 Dia.	.7501-1.5000	+0.0004-.0000
6 Flutes	.1562-.5220 Dia.	Dowel Pin (d-p)	+0.0000-.0002
8 Flutes	.5221-.8820 Dia.		
10 Flutes	.8821-1.1950 Dia.		
12 Flutes	1.1951-1.5000 Dia.		

Alvord-Polk 897 Series Chucking Reamers meet NAS 897 Specifications.



EDP# HSS 897-A-S	EDP# HSS 897-A-R	EDP# HSS 897-A-L	EDP# Cobalt 897-B-S	EDP# Cobalt 897-B-R	EDP# TiN 757-1	EDP# TiCN 767-1	Size	Decimal Equiv. Inches	Diameter Of Shank	Flute Length Inches	Overall Length Inches
94089	-	-	-	-	-	-	#80	0.0135	.0135-.0125	3/8	3/4
94090	-	-	-	-	-	-	#79	0.0145	.0145-.0135	3/8	3/4
94091	-	-	-	-	-	-	1/64	0.0156	.0156-.0146	3/8	3/4
94092	-	-	-	-	-	-	#78	0.0160	.0160-.0150	3/8	7/8
94093	-	-	-	-	-	-	#77	0.0180	.0180-.0170	3/8	7/8
94094	-	-	-	-	-	-	#76	0.0200	.0200-.0190	3/8	7/8
94095	-	-	-	-	-	-	#75	0.0210	.0210-.0200	1/2	1
94096	-	-	-	-	-	-	#74	0.0225	.0225-.0215	1/2	1
94097	-	-	-	-	-	-	#73	0.0240	.0240-.0230	1/2	1-1/8
94098	-	-	-	-	-	-	#72	0.0250	.0250-.0240	1/2	1-1/8
94099	-	-	-	-	-	-	#71	0.0260	.0260-.0250	1/2	1-1/4
00001	-	-	-	-	-	-	#70	0.0280	.0260-.0250	1/2	2-1/2
00002	-	-	-	-	-	-	#69	0.0292	.0260-.0250	1/2	2-1/2
00003	-	-	-	-	-	-	#68	0.0310	.0290-.0280	1/2	2-1/2
00004	-	-	-	-	75004	76004	1/32	0.0312	.0290-.0280	1/2	2-1/2
00005	-	-	-	-	-	-	#67	0.0320	.0290-.0280	1/2	2-1/2
00006	-	-	-	-	-	-	#66	0.0330	.0290-.0280	1/2	2-1/2
00007	-	-	-	-	-	-	#65	0.0350	.0320-.0310	1/2	2-1/2
00008	-	-	-	-	-	-	#64	0.0360	.0320-.0310	1/2	2-1/2
00009	-	-	-	-	-	-	#63	0.0370	.0350-.0340	1/2	2-1/2
00010	-	-	-	-	-	-	#62	0.0380	.0350-.0340	1/2	2-1/2
00011	-	-	-	-	-	-	#61	0.0390	.0350-.0340	1/2	2-1/2
00012	-	-	-	-	-	-	1mm	0.0394	.0350-.0340	1/2	2-1/2
00013	01013	02013	-	-	-	-	#60	0.0400	.0390-.0380	1/2	2-1/2
00014	01014	02014	-	-	-	-	#59	0.0410	.0390-.0380	1/2	2-1/2
00015	01015	02015	-	-	-	-	#58	0.0420	.0390-.0380	1/2	2-1/2
00016	01016	02016	-	-	-	-	#57	0.0430	.0390-.0380	1/2	2-1/2
00017	01017	02017	-	-	-	-	#56	0.0465	.0455-.0445	1/2	2-1/2
00018	01018	02018	00230	-	75018	76018	3/64	0.0469	.0455-.0445	1/2	2-1/2
00019	01019	02019	00231	-	-	-	#55	0.0520	.0510-.0500	1/2	2-1/2
00020	01020	02020	00232	-	-	-	#54	0.0550	.0510-.0500	1/2	2-1/2
00021	01021	02021	00233	-	-	-	1.5mm	0.0591	.0585-.0575	1/2	2-1/2
00022	01022	02022	00234	-	-	-	#53	0.0595	.0585-.0575	1/2	2-1/2
00023	01023	02023	00235	-	75023	76023	1/16	0.0625	.0585-.0575	1/2	2-1/2
00024	01024	02024	00236	-	-	-	#52	0.0635	.0585-.0575	1/2	2-1/2
00025	01025	02025	00237	-	-	-	#51	0.0670	.0660-.0650	3/4	3
00026	01026	02026	00238	-	-	-	#50	0.0700	.0660-.0650	3/4	3
00027	01027	02027	00239	-	-	-	#49	0.0730	.0660-.0650	3/4	3
00028	01028	02028	00240	-	-	-	#48	0.0760	.0720-.0710	3/4	3
00029	01029	02029	00241	-	75029	76029	5/64	0.0781	.0720-.0710	3/4	3
00030	01030	02030	00242	-	-	-	#47	0.0785	.0720-.0710	3/4	3
00031	01031	02031	00243	-	75031	76031	2mm	0.0787	.0720-.0710	3/4	3
00032	01032	02032	00244	-	-	-	#46	0.0810	.0720-.0710	3/4	3
00033	01033	02033	00245	-	-	-	#45	0.0820	.0771-.0761	3/4	3
00034	01034	02034	00246	-	-	-	#44	0.0860	.0771-.0761	3/4	3
00035	01035	02035	00247	-	-	-	#43	0.0890	.0810-.0800	3/4	3
00036	01036	02036	00248	-	-	-	#42	0.0935	.0880-.0870	3/4	3
00037	01037	02037	00249	-	75037	76037	3/32	0.0938	.0880-.0870	3/4	3
00038	01038	02038	00250	-	-	-	#41	0.0960	.0928-.0918	7/8	3-1/2
00039	01039	02039	00251	-	-	-	#40	0.0980	.0928-.0918	7/8	3-1/2
00040	01040	02040	00252	-	75040	76040	2.5mm	0.0984	.0928-.0918	7/8	3-1/2
00041	01041	02041	00253	-	-	-	#39	0.0995	.0928-.0918	7/8	3-1/2
00042	01042	02042	00254	-	-	-	#38	0.1015	.0950-.0940	7/8	3-1/2
00043	01043	02043	00255	-	-	-	#37	0.1040	.0950-.0940	7/8	3-1/2

Chuckling Reamers



- 897-A-S Straight Flute, Straight Shank, High Speed Steel
- 897-A-R Right Hand Spiral, Straight Shank, High Speed Steel
- 897-A-L Left Hand Spiral, Straight Shank, High Speed Steel
- 897-B-S Straight Flute, Straight Shank, 8% Cobalt
- 897-B-R Right Hand Spiral, Straight Shank, 8% Cobalt
- 757-1 TIN Coated, Right Hand Spiral, High Speed Steel
- 767-1 TiCN Coated, Right Hand Spiral, High Speed Steel

EDP# HSS 897-A-S	EDP# HSS 897-A-R	EDP# HSS 897-A-L	EDP# Cobalt 897-B-S	EDP# Cobalt 897-B-R	EDP# TIN 757-1	EDP# TiCN 767-1	Size	Decimal Equiv. Inches	Diameter Of Shank	Flute Length Inches	Overall Length Inches
00044	01044	02044	00256	-	-	-	#36	0.1065	.0950-.0940	7/8	3-1/2
00045	01045	02045	00257	-	75045	76045	7/64	0.1094	.1030-.1020	7/8	3-1/2
00046	01046	02046	00258	-	-	-	#35	0.1100	.1030-.1020	7/8	3-1/2
00047	01047	02047	00259	-	-	-	#34	0.1110	.1055-.1045	7/8	3-1/2
00048	01048	02048	00260	-	-	-	#33	0.1130	.1055-.1045	7/8	3-1/2
00049	01049	02049	00261	-	-	-	#32	0.1160	.1120-.1110	7/8	3-1/2
00050	01050	02050	00262	-	75050	76050	3mm	0.1181	.1120-.1110	7/8	3-1/2
00051	01051	02051	00263	-	-	-	#31	0.1200	.1120-.1110	7/8	3-1/2
00052	01052	02052	00264	-	-	-	d-p	0.1230	.1120-.1110	7/8	3-1/2
00053	01053	02053	00265	-	-	-	o/u	0.1240	.1190-.1180	7/8	3-1/2
00054	01054	02054	00266	-	-	-	d-p	0.1247	.1190-.1180	7/8	3-1/2
00055	01055	02055	00267	-	75055	76055	1/8	0.1250	.1190-.1180	7/8	3-1/2
00056	01056	02056	00268	-	-	-	o/u	0.1260	.1190-.1180	7/8	3-1/2
00057	01057	02057	00269	-	-	-	#30	0.1285	.1190-.1180	7/8	3-1/2
00058	01058	02058	00270	-	-	-	#29	0.1360	.1275-.1265	1	4
00059	01059	02059	00271	-	75059	76059	3.5mm	0.1378	.1275-.1265	1	4
00060	01060	02060	00272	-	-	-	#28	0.1405	.1350-.1340	1	4
00061	01061	02061	00273	-	75061	76061	9/64	0.1406	.1350-.1340	1	4
00062	01062	02062	00274	-	-	-	#27	0.1440	.1350-.1340	1	4
00063	01063	02063	00275	-	-	-	#26	0.1470	.1430-.1420	1	4
00064	01064	02064	00276	-	-	-	#25	0.1495	.1430-.1420	1	4
00065	01065	02065	00277	-	-	-	#24	0.1520	.1460-.1450	1	4
00066	01066	02066	00278	-	-	-	#23	0.1540	.1460-.1450	1	4
00067	01067	02067	00279	-	75067	76067	5/32	0.1562	.1510-.1500	1	4
00068	01068	02068	00280	-	-	-	#22	0.1570	.1510-.1500	1	4
00069	01069	02069	00281	-	75069	76069	4mm	0.1575	.1510-.1500	1	4
00070	01070	02070	00282	-	-	-	#21	0.1590	.1530-.1520	1-1/8	4-1/2
00071	01071	02071	00283	-	-	-	#20	0.1610	.1530-.1520	1-1/8	4-1/2
00072	01072	02072	00284	-	-	-	#19	0.1660	.1595-.1585	1-1/8	4-1/2
00073	01073	02073	00285	-	-	-	#18	0.1695	.1595-.1585	1-1/8	4-1/2
00074	01074	02074	00286	-	75074	76074	11/64	0.1719	.1645-.1635	1-1/8	4-1/2
00075	01075	02075	00287	-	-	-	#17	0.1730	.1645-.1635	1-1/8	4-1/2
00076	01076	02076	00288	-	-	-	#16	0.1770	.1704-.1694	1-1/8	4-1/2
00077	01077	02077	00289	-	75077	76077	4.5mm	0.1772	.1704-.1694	1-1/8	4-1/2
00078	01078	02078	00290	-	-	-	#15	0.1800	.1755-.1745	1-1/8	4-1/2
00079	01079	02079	00291	-	-	-	#14	0.1820	.1755-.1745	1-1/8	4-1/2
00080	01080	02080	00292	-	-	-	#13	0.1850	.1805-.1795	1-1/8	4-1/2
00081	01081	02081	00293	-	-	-	d-p	0.1855	.1805-.1795	1-1/8	4-1/2
00082	01082	02082	00294	-	-	-	o/u	0.1865	.1805-.1795	1-1/8	4-1/2
00083	01083	02083	00295	-	-	-	d-p	0.1870	.1805-.1795	1-1/8	4-1/2
00084	01084	02084	00296	-	75084	76084	3/16	0.1875	.1805-.1795	1-1/8	4-1/2
00085	01085	02085	00297	-	-	-	o/u	0.1885	.1805-.1795	1-1/8	4-1/2
00086	01086	02086	00298	-	-	-	#12	0.1890	.1805-.1795	1-1/8	4-1/2
00087	01087	02087	00299	-	-	-	#11	0.1910	.1860-.1850	1-1/4	5
00088	01088	02088	00300	-	-	-	#10	0.1935	.1860-.1850	1-1/4	5
00089	01089	02089	00301	-	-	-	#9	0.1960	.1895-.1885	1-1/4	5
00090	01090	02090	00302	-	75090	76090	5mm	0.1968	.1895-.1885	1-1/4	5
00091	01091	02091	00303	-	-	-	#8	0.1990	.1895-.1885	1-1/4	5
00092	01092	02092	00304	-	-	-	#7	0.2010	.1945-.1935	1-1/4	5
00093	01093	02093	00305	-	75093	76093	13/64	0.2031	.1945-.1935	1-1/4	5
00094	01094	02094	00306	-	-	-	#6	0.2040	.1945-.1935	1-1/4	5
00095	01095	02095	00307	-	-	-	#5	0.2055	.2016-.2006	1-1/4	5
00096	01096	02096	00308	-	-	-	#4	0.2090	.2016-.2006	1-1/4	5
00097	01097	02097	00309	-	-	-	#3	0.2130	.2075-.2065	1-1/4	5
00098	01098	02098	00310	-	75098	76098	5.5mm	0.2165	.2075-.2065	1-1/4	5
00099	01099	02099	00311	-	75099	76099	7/32	0.2188	.2075-.2065	1-1/4	5
00100	01100	02100	00312	-	-	-	#2	0.2210	.2173-.2163	1-1/2	6
00101	01101	02101	00313	-	-	-	#1	0.2280	.2173-.2163	1-1/2	6
00102	01102	02102	00314	-	-	-	A	0.2340	.2265-.2255	1-1/2	6
00103	01103	02103	00315	-	75103	76103	15/64	0.2344	.2265-.2255	1-1/2	6
00104	01104	02104	00316	-	75104	76104	6mm	0.2362	.2265-.2255	1-1/2	6
00105	01105	02105	00317	-	-	-	B	0.2380	.2329-.2319	1-1/2	6
00106	01106	02106	00318	-	-	-	C	0.2420	.2329-.2319	1-1/2	6

Chucking Reamers



- 897-A-S Straight Flute, Straight Shank, High Speed Steel
- 897-A-R Right Hand Spiral, Straight Shank, High Speed Steel
- 897-A-L Left Hand Spiral, Straight Shank, High Speed Steel
- 897-B-S Straight Flute, Straight Shank, 8% Cobalt

- 897-B-R Right Hand Spiral, Straight Shank, 8% Cobalt
- 757-1 TiN Coated, Right Hand Spiral, High Speed Steel
- 767-1 TiCN Coated, Right Hand Spiral, High Speed Steel

EDP# HSS 897-A-S	EDP# HSS 897-A-R	EDP# HSS 897-A-L	EDP# Cobalt 897-B-S	EDP# Cobalt 897-B-R	EDP# TiN 757-1	EDP# TiCN 767-1	Size	Decimal Equiv. Inches	Diameter Of Shank	Flute Length Inches	Overall Length Inches
00107	01107	02107	00319	-	-	-	D	0.2460	.2329-.2319	1-1/2	6
00108	01108	02108	00320	-	-	-	d-p	0.2480	.2329-.2319	1-1/2	6
00109	01109	02109	00321	-	-	-	o/u	0.2490	.2405-.2395	1-1/2	6
00110	01110	02110	00322	-	-	-	d-p	0.2495	.2405-.2395	1-1/2	6
00111	01111	02111	00323	-	75111	76111	E,1/4	0.2500	.2405-.2395	1-1/2	6
00112	01112	02112	00324	-	-	-	o/u	0.2510	.2405-.2395	1-1/2	6
00113	01113	02113	00325	-	75113	76113	6.5mm	0.2559	.2405-.2395	1-1/2	6
00114	01114	02114	00326	-	-	-	F	0.2570	.2405-.2395	1-1/2	6
00115	01115	02115	00327	-	-	-	G	0.2610	.2485-.2475	1-1/2	6
00116	01116	02116	00328	-	75116	76116	17/64	0.2656	.2485-.2475	1-1/2	6
00117	01117	02117	00329	-	-	-	H	0.2660	.2485-.2475	1-1/2	6
00118	01118	02118	00330	-	-	-	I	0.2720	.2485-.2475	1-1/2	6
00119	01119	02119	00331	-	75119	76119	7mm	0.2756	.2485-.2475	1-1/2	6
00120	01120	02120	00332	-	-	-	J	0.2770	.2485-.2475	1-1/2	6
00121	01121	02121	00333	-	-	-	K	0.2810	.2485-.2475	1-1/2	6
00122	01122	02122	00334	-	75122	76122	9/32	0.2812	.2485-.2475	1-1/2	6
00123	01123	02123	00335	-	-	-	L	0.2900	.2792-.2782	1-1/2	6
00124	01124	02124	00336	-	-	-	M	0.2950	.2792-.2782	1-1/2	6
00125	01125	02125	00337	-	75125	76125	7.5mm	0.2953	.2792-.2782	1-1/2	6
00126	01126	02126	00338	-	75126	76126	19/64	0.2969	.2792-.2782	1-1/2	6
00127	01127	02127	00339	-	-	-	N	0.3020	.2792-.2782	1-1/2	6
00128	01128	02128	00340	-	-	-	d-p	0.3105	.2792-.2782	1-1/2	6
00129	01129	02129	00341	-	-	-	o/u	0.3115	.2792-.2782	1-1/2	6
00130	01130	02130	00342	-	-	-	d-p	0.3120	.2792-.2782	1-1/2	6
00131	01131	02131	00343	-	75131	76131	5/16	0.3125	.2792-.2782	1-1/2	6
00132	01132	02132	00344	-	-	-	o/u	0.3135	.2792-.2782	1-1/2	6
00133	01133	02133	00345	-	75133	76133	8mm	0.3150	.2792-.2782	1-1/2	6
00134	01134	02134	00346	-	-	-	O	0.3160	.2792-.2782	1-1/2	6
00135	01135	02135	00347	-	-	-	P	0.3230	.2792-.2782	1-1/2	6
00136	01136	02136	00348	-	75136	76136	21/64	0.3281	.2792-.2782	1-1/2	6
00137	01137	02137	00349	-	-	-	Q	0.3320	.2792-.2782	1-1/2	6
00138	01138	02138	00350	-	75138	76138	8.5mm	0.3346	.2792-.2782	1-1/2	6
00139	01139	02139	00351	-	-	-	R	0.3390	.2792-.2782	1-1/2	6
00140	01140	02140	00352	-	75140	76140	11/32	0.3438	.2792-.2782	1-1/2	6
00141	01141	02141	00353	-	-	-	S	0.3480	.3105-.3095	1-3/4	7
00142	01142	02142	00354	-	75142	76142	9mm	0.3543	.3105-.3095	1-3/4	7
00143	01143	02143	00355	-	-	-	T	0.3580	.3105-.3095	1-3/4	7
00144	01144	02144	00356	-	75144	76144	23/64	0.3594	.3105-.3095	1-3/4	7
00145	01145	02145	00357	-	-	-	U	0.3680	.3105-.3095	1-3/4	7
00146	01146	02146	00358	-	-	-	d-p	0.3730	.3105-.3095	1-3/4	7
00148	01148	02148	00360	-	75148	76148	9.5mm	0.3740	.3105-.3095	1-3/4	7
00148	01148	02148	00360	-	-	-	o/u	0.3740	.3105-.3095	1-3/4	7
00149	01149	02149	00361	-	-	-	d-p	0.3745	.3105-.3095	1-3/4	7
00150	01150	02150	00362	-	75150	76150	3/8	0.3750	.3105-.3095	1-3/4	7
00151	01151	02151	00363	-	-	-	o/u	0.3760	.3105-.3095	1-3/4	7
00152	01152	02152	00364	-	-	-	V	0.3770	.3105-.3095	1-3/4	7
00153	01153	02153	00365	-	-	-	W	0.3860	.3105-.3095	1-3/4	7
00154	01154	02154	00366	-	75154	76154	25/64	0.3906	.3105-.3095	1-3/4	7
00155	01155	02155	00367	-	75155	76155	10mm	0.3937	.3105-.3095	1-3/4	7
00156	01156	02156	00368	-	-	-	X	0.3970	.3105-.3095	1-3/4	7
00157	01157	02157	00369	-	-	-	Y	0.4040	.3105-.3095	1-3/4	7
00158	01158	02158	00370	-	75158	76158	13/32	0.4062	.3730-.3720	1-3/4	7
00159	01159	02159	00371	-	-	-	Z	0.4130	.3730-.3720	1-3/4	7
00160	01160	02160	00372	-	75160	76160	10.5mm	0.4134	.3730-.3720	1-3/4	7
00161	01161	02161	00373	-	75161	76161	27/64	0.4219	.3730-.3720	1-3/4	7
00162	01162	02162	00374	-	75162	76162	11mm	0.4331	.3730-.3720	1-3/4	7
00163	01163	02163	00375	-	-	-	d-p	0.4355	.3730-.3720	1-3/4	7
00164	01164	02164	00376	-	-	-	o/u	0.4365	.3730-.3720	1-3/4	7
00165	01165	02165	00377	-	-	-	d-p	0.4370	.3730-.3720	1-3/4	7
00166	01166	02166	00378	-	75166	76166	7/16	0.4375	.3730-.3720	1-3/4	7
00167	01167	02167	00379	-	-	-	o/u	0.4385	.3730-.3720	1-3/4	7
00168	01168	02168	00380	-	75168	76168	11.5mm	0.4528	.3730-.3720	1-3/4	7
00169	01169	02169	00381	-	75169	76169	29/64	0.4531	.3730-.3720	1-3/4	7

Chucking Reamers



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EDP# HSS 897-A-S	EDP# HSS 897-A-R	EDP# HSS 897-A-L	EDP# Cobalt 897-B-S	EDP# Cobalt 897-B-R	EDP# TiN 757-1	EDP# TiCN 767-1	Size	Decimal Equiv. Inches	Diameter Of Shank	Flute Length Inches	Overall Length Inches
00170	01170	02170	00382	-	75170	76170	15/32	0.4688	.3730-.3720	1-3/4	7
00171	01171	02171	00383	-	75171	76171	12mm	0.4724	.4355-.4345	2	8
00172	01172	02172	00384	-	75172	76172	31/64	0.4844	.4355-.4345	2	8
00173	01173	02173	00385	-	75173	76173	12.5mm	0.4921	.4355-.4345	2	8
00174	01174	02174	00386	-	-	-	d-p	0.4980	.4355-.4345	2	8
00175	01175	02175	00387	-	-	-	o/u	0.4990	.4355-.4345	2	8
00176	01176	02176	00388	-	-	-	d-p	0.4995	.4355-.4345	2	8
00177	01177	02177	00389	-	75177	76177	1/2	0.5000	.4355-.4345	2	8
22001	-	-	-	-	-	-	d-p	0.5005	.4355-.4345	2	8
00178	01178	02178	00390	-	-	-	o/u	0.5010	.4355-.4345	2	8
00179	01179	02179	-	-	75179	76179	13mm	0.5118	.4355-.4345	2	8
00400	-	-	-	-	-	-	33/64	0.5118	.4355-.4345	2	8
00180	01180	02180	00452	-	75180	76180	17/32	0.5312	.4355-.4345	2	8
00181	01181	02181	-	-	75181	76181	13.5mm	0.5315	.4355-.4345	2	8
00401	-	-	-	-	-	-	35/64	0.5469	.4355-.4345	2	8
00182	01182	02182	-	-	75182	76182	14mm	0.5512	.4355-.4345	2	8
00183	01183	02183	00453	-	75183	76183	9/16	0.5625	.4355-.4345	2	8
00184	01184	02184	-	-	75187	76187	14.5mm	0.5709	.4355-.4345	2	8
00402	-	-	-	-	-	-	37/64	0.5781	.4355-.4345	2	8
00185	01185	02185	-	-	75185	76185	15mm	0.5906	.4355-.4345	2	8
00186	01186	02186	00454	-	75186	76186	19/32	0.5938	.4355-.4345	2	8
00403	-	-	-	-	-	-	39/64	0.6094	.4355-.4345	2	8
00187	01187	02187	00454	-	75186	76186	15.5mm	0.6102	.4355-.4345	2	8
00188	01188	02188	00455	01419	-	-	5/8	0.6250	.5620-5605	2-1/4	9
22052	-	-	-	-	-	-	o/u	0.6260	.5620-5605	2-1/4	9
22053	-	-	-	-	-	-	-	0.6270	.5620-5605	2-1/4	9
00189	-	-	-	-	-	-	16mm	0.6299	.5620-5605	2-1/4	9
00404	-	-	-	-	-	-	41/64	0.6406	.5620-5605	2-1/4	9
00190	01190	02190	-	-	75190	76190	16.5mm	0.6496	.5620-5605	2-1/4	9
00191	01191	02191	00456	-	75191	76191	21/32	0.6562	.5620-5605	2-1/4	9
00192	01192	02192	-	-	75192	76192	17mm	0.6693	.5620-5605	2-1/4	9
00405	-	-	-	-	-	-	43/64	0.6719	.5620-5605	2-1/4	9
00193	01193	02193	00457	-	75193	76193	11/16	0.6875	.5620-5605	2-1/4	9
00194	01194	02194	-	-	75194	76194	17.5mm	0.6890	.5620-5605	2-1/4	9
00406	-	-	-	-	-	-	45/64	0.7031	.5620-5605	2-1/4	9
00195	01195	02195	-	-	75195	76195	18mm	0.7087	.5620-5605	2-1/4	9
00196	01196	02196	00458	-	75196	76196	23/32	0.7188	.5620-5605	2-1/4	9
00197	01197	02197	-	-	75197	76197	18.5mm	0.7283	.6245-.6230	2-1/2	9-1/2
00407	-	-	-	-	-	-	47/64	0.7344	.6245-.6230	2-1/2	9-1/2
00198	01198	02198	-	-	75198	76198	19mm	0.7480	.6245-.6230	2-1/2	9-1/2
22498	-	-	-	-	-	-	o/u	0.7490	.6245-.6230	2-1/2	9-1/2
22092	-	-	-	-	-	-	d-p	0.7495	.6245-.6230	2-1/2	9-1/2
00199	01199	02199	00459	-	75199	76199	3/4	0.7500	.6245-.6230	2-1/2	9-1/2
22093	-	-	-	-	-	-	d-p	0.7505	.6245-.6230	2-1/2	9-1/2
22502	-	-	-	-	-	-	o/u	0.7510	.6245-.6230	2-1/2	9-1/2
00408	-	-	-	-	-	-	49/64	0.7656	.6245-.6230	2-1/2	9-1/2
00200	01200	02200	-	-	75200	76200	19.5mm	0.7677	.6245-.6230	2-1/2	9-1/2
00201	01201	02201	00460	-	-	-	25/32	0.7812	.6245-.6230	2-1/2	9-1/2
00202	01202	02202	-	-	75202	76202	20mm	0.7874	.6245-.6230	2-1/2	9-1/2
00409	-	-	-	-	-	-	51/64	0.7969	.6245-.6230	2-1/2	9-1/2
00203	01203	02203	-	-	75203	76203	20.5mm	0.8071	.6245-.6230	2-1/2	9-1/2
00204	01204	02204	00461	-	-	-	13/16	0.8125	.6245-.6230	2-1/2	9-1/2
00205	01205	02205	-	-	75205	76205	21mm	0.8268	.6245-.6230	2-1/2	9-1/2
00410	-	-	-	-	-	-	53/64	0.8281	.6245-.6230	2-1/2	9-1/2
00206	01206	02206	00462	-	-	-	27/32	0.8438	.6245-.6230	2-1/2	9-1/2
00207	01207	02207	-	-	75207	76207	21.5mm	0.8465	.6245-.6230	2-1/2	9-1/2
00411	-	-	-	-	-	-	55/64	0.8594	.7495-.7480	2-5/8	10
00208	01208	02208	-	-	75208	76208	22mm	0.8661	.7495-.7480	2-5/8	10
22798	-	-	-	-	-	-	o/u	0.8740	.7495-.7480	2-5/8	10
14073	-	-	-	-	-	-	d-p	0.8745	.7495-.7480	2-5/8	10
00209	01209	02209	00463	-	-	-	7/8	0.8750	.7495-.7480	2-5/8	10
14143	-	-	-	-	-	-	d-p	0.8755	.7495-.7480	2-5/8	10
22752	-	-	-	-	-	-	o/u	0.8760	.7495-.7480	2-5/8	10

Chucking Reamers



- 897-A-S Straight Flute, Straight Shank, High Speed Steel
- 897-A-R Right Hand Spiral, Straight Shank, High Speed Steel
- 897-A-L Left Hand Spiral, Straight Shank, High Speed Steel
- 897-B-S Straight Flute, Straight Shank, 8% Cobalt

- 897-B-R Right Hand Spiral, Straight Shank, 8% Cobalt
- 757-1 TiN Coated, Right Hand Spiral, High Speed Steel
- 767-1 TiCN Coated, Right Hand Spiral, High Speed Steel

EDP# HSS 897-A-S	EDP# HSS 897-A-R	EDP# HSS 897-A-L	EDP# Cobalt 897-B-S	EDP# Cobalt 897-B-R	EDP# TiN 757-1	EDP# TiCN 767-1	Size	Decimal Equiv. Inches	Diameter Of Shank	Flute Length Inches	Overall Length Inches
14074	-	-	-	-	-	-	-	0.8770	.7495-.7480	2-5/8	10
00210	01210	02210	-	-	75210	76210	22.5mm	0.8858	.7495-.7480	2-5/8	10
00412	-	-	-	-	-	-	57/64	0.8906	.7495-.7480	2-5/8	10
00211	01211	02211	-	-	75211	76211	23mm	0.9055	.7495-.7480	2-5/8	10
00212	01212	02212	00464	-	-	-	29/32	0.9062	.7495-.7480	2-5/8	10
00413	-	-	-	-	-	-	59/64	0.9219	.7495-.7480	2-5/8	10
00213	01213	02213	-	-	75213	76213	23.5mm	0.9252	.7495-.7480	2-5/8	10
00214	01214	02214	00465	-	-	-	15/16	0.9375	.7495-.7480	2-5/8	10
00215	01215	02215	-	-	75215	76215	24mm	0.9449	.7495-.7480	2-5/8	10
00414	-	-	-	-	-	-	61/64	0.9531	.7495-.7480	2-5/8	10
00216	01216	02216	-	-	75216	76216	24.5mm	0.9646	.7495-.7480	2-5/8	10
00217	01217	02217	00466	-	-	-	31/32	0.9688	.7495-.7480	2-5/8	10
00218	01218	02218	-	-	75218	76218	25mm	0.9843	.8745-.8730	2-3/4	10-1/2
00415	-	-	-	-	-	-	63/64	0.9844	.8745-.8730	2-3/4	10-1/2
00219	01219	02219	00467	-	-	-	1	1.0000	.8745-.8730	2-3/4	10-1/2
00220	01220	02220	00468	-	-	-	1-1/16	1.0625	.8745-.8730	2-3/4	10-1/2
00221	01221	02221	00469	-	-	-	1-1/8	1.1250	.8745-.8730	2-3/4	11
00222	01222	02222	00470	-	-	-	1-3/16	1.1875	.9995-.9980	2-3/4	11
00223	01223	02223	00471	-	-	-	1-1/4	1.2500	.9995-.9980	3	11-1/2
00224	01224	02224	00472	-	-	-	1-5/16	1.3125	.9995-.9980	3	11-1/2
00225	01225	02225	00473	-	-	-	1-3/8	1.3750	.9995-.9980	3-1/4	12
00226	01226	02226	00474	-	-	-	1-7/16	1.4375	1.2495-1.2480	3-1/4	12
00227	01227	02227	00475	-	-	-	1-1/2	1.5000	1.2495-1.2480	3-1/2	12-1/2

Chucking Reamers, Decimal Sizes



HIGH SPEED STEEL

897-A-S Straight Flute, Right Hand Cut

PRECISION GROUND BETWEEN CENTERS TO +.0002 - .0000

EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size
00001	0.0280	10027	0.0415	10052	0.0540	10075	0.0655	10102	0.0790	10129	0.0925
10001	0.0285	00015	0.0420	10053	0.0545	10076	0.0660	10103	0.0795	10130	0.0930
10002	0.0290	10029	0.0425	00020	0.0550	10077	0.0665	10104	0.0800	14003	0.0932
10003	0.0295	00016	0.0430	10055	0.0555	00025	0.0670	10105	0.0805	00036	0.0935
10004	0.0300	10031	0.0435	10056	0.0560	10079	0.0675	00032	0.0810	10132	0.0940
10005	0.0305	10032	0.0440	10057	0.0565	10080	0.0680	10107	0.0815	10133	0.0945
00003	0.0310	10033	0.0445	10058	0.0570	10081	0.0685	00033	0.0820	10134	0.0950
10007	0.0315	00947	0.0448	10059	0.0575	10082	0.0690	10109	0.0825	10135	0.0955
00005	0.0320	10034	0.0450	10060	0.0580	10083	0.0695	10110	0.0830	00038	0.0960
10009	0.0325	10035	0.0455	10061	0.0585	00026	0.0700	10111	0.0835	10137	0.0965
00006	0.0330	10036	0.0460	10062	0.0590	10085	0.0705	10112	0.0840	10138	0.0970
10011	0.0335	00017	0.0465	00022	0.0595	10086	0.0710	10113	0.0845	10139	0.0975
10012	0.0340	10038	0.0470	10064	0.0600	10087	0.0715	10114	0.0850	00039	0.0980
10013	0.0345	10039	0.0475	10065	0.0605	10088	0.0720	10115	0.0855	10141	0.0985
00007	0.0350	10040	0.0480	10066	0.0610	10089	0.0725	00034	0.0860	10142	0.0990
10015	0.0355	10041	0.0485	10067	0.0615	00027	0.0730	10117	0.0865	00041	0.0995
00008	0.0360	10042	0.0490	10068	0.0620	10091	0.0735	10118	0.0870	10144	0.1000
10017	0.0365	10043	0.0495	14001	0.0622	10092	0.0740	10119	0.0875	10148	0.1005
00009	0.0370	10044	0.0500	14002	0.0623	10093	0.0745	10120	0.0880	10149	0.1010
10019	0.0375	00948	0.0503	00023	0.0625	10094	0.0750	10121	0.0885	00042	0.1015
00010	0.0380	10045	0.0505	00949	0.0628	10095	0.0755	00035	0.0890	10151	0.1020
10021	0.0385	10046	0.0510	00950	0.0629	00028	0.0760	10123	0.0895	10152	0.1025
00011	0.0390	10047	0.0515	10070	0.0630	10097	0.0765	10124	0.0900	10153	0.1030
10023	0.0395	00019	0.0520	00024	0.0635	10098	0.0770	10125	0.0905	10154	0.1035
00013	0.0400	10049	0.0525	10072	0.0640	10099	0.0775	10126	0.0910	00043	0.1040
10025	0.0405	10050	0.0530	10073	0.0645	10100	0.0780	10127	0.0915	10156	0.1045
00014	0.0410	10051	0.0535	10074	0.0650	00030	0.0785	10128	0.0920	10157	0.1050

Chucking Reamers, Decimal Sizes

HIGH SPEED STEEL

897-A-S Straight Flute, Right Hand Cut

PRECISION GROUND BETWEEN CENTERS TO +.0002 - .0000

EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size
10158	0.1055	10216	0.1345	00072	0.1660	00091	0.1990	10412	0.2320	10472	0.2620
10159	0.1060	10217	0.1350	10280	0.1665	10346	0.1995	10413	0.2325	10473	0.2625
00044	0.1065	10218	0.1355	10281	0.1670	10347	0.2000	10414	0.2330	10474	0.2630
10161	0.1070	00058	0.1360	10282	0.1675	10348	0.2005	10415	0.2335	10475	0.2635
10162	0.1075	10220	0.1365	10283	0.1680	00092	0.2010	10417	0.2345	10476	0.2640
10163	0.1080	10221	0.1370	10284	0.1685	10350	0.2015	10418	0.2350	10477	0.2645
10164	0.1085	10222	0.1375	10285	0.169	10351	0.2020	10419	0.2355	10478	0.2650
10165	0.1090	10223	0.1380	00073	0.1695	10352	0.2025	14016	0.2357	10479	0.2655
10166	0.1095	10224	0.1385	10287	0.1700	10353	0.2030	10420	0.2360	00117	0.2660
00046	0.1100	10225	0.1390	10288	0.1705	10354	0.2035	10421	0.2365	10481	0.2665
10168	0.1105	10226	0.1395	10289	0.1710	00094	0.2040	14017	0.2367	10482	0.2670
00047	0.1110	10227	0.1400	10290	0.1715	10356	0.2045	10422	0.2370	10483	0.2675
10170	0.1115	00060	0.1405	10291	0.1720	10357	0.2050	10423	0.2375	10484	0.2680
10171	0.1120	10229	0.1410	10292	0.1725	00095	0.2055	10425	0.2385	10485	0.2685
10172	0.1125	10230	0.1415	00075	0.1730	10359	0.2060	10426	0.2390	10486	0.2690
00048	0.1130	10231	0.1420	10293	0.1735	10360	0.2065	10427	0.2395	10487	0.2695
10174	0.1135	10232	0.1425	10295	0.1740	10362	0.2070	10428	0.2400	10488	0.2700
10175	0.1140	10233	0.1430	10296	0.1745	10363	0.2075	10429	0.2405	10489	0.2705
10176	0.1145	10234	0.1435	10297	0.1750	10364	0.2080	10430	0.2410	10490	0.2710
10177	0.1150	00062	0.1440	10298	0.1755	10365	0.2085	10431	0.2415	10491	0.2715
10178	0.1155	10236	0.1445	10299	0.1760	00096	0.2090	00106	0.2420	00118	0.2720
00049	0.1160	10237	0.1450	10300	0.1765	10367	0.2095	10433	0.2425	10493	0.2725
10180	0.1165	10238	0.1455	00076	0.1770	10368	0.2100	10434	0.2430	10494	0.2730
10181	0.1170	10239	0.1460	10302	0.1775	10369	0.2105	10435	0.2435	10495	0.2735
10182	0.1175	10240	0.1465	10303	0.1780	10370	0.2110	10436	0.2440	10496	0.2740
10183	0.1180	00063	0.1470	10304	0.1785	10371	0.2115	10437	0.2445	10497	0.2745
10184	0.1185	10242	0.1475	10305	0.1790	10372	0.2120	10438	0.2450	10498	0.2750
14004	0.1186	10243	0.1480	10306	0.1795	10373	0.2125	10439	0.2455	10499	0.2755
10185	0.1190	10244	0.1485	00078	0.1800	00097	0.2130	00107	0.2460	10500	0.2760
10186	0.1195	10245	0.1490	10308	0.1805	10375	0.2135	10441	0.2465	10501	0.2765
00051	0.1200	00064	0.1495	10309	0.1810	10376	0.2140	10442	0.2470	00120	0.2770
10188	0.1205	10247	0.1500	10310	0.1815	10377	0.2145	10443	0.2475	10503	0.2775
10189	0.1210	10248	0.1505	00079	0.1820	10378	0.2150	10444	0.2480	10504	0.2780
10190	0.1215	10249	0.1510	10312	0.1825	10379	0.2155	10445	0.2485	10505	0.2785
10191	0.1220	10250	0.1515	10313	0.1830	10380	0.2160	00109	0.2490	10506	0.2790
10192	0.1225	00065	0.1520	10314	0.1835	10382	0.2170	14018	0.2493	10507	0.2795
10193	0.1230	10252	0.1525	10315	0.1840	10383	0.2175	10447	0.2495	10508	0.2800
10194	0.1235	10253	0.1530	10316	0.1845	10384	0.2180	14019	0.2497	10509	0.2805
00053	0.1240	10254	0.1535	00080	0.1850	10385	0.2185	14020	0.2498	00121	0.2810
14005	0.1243	00066	0.1540	10318	0.1855	10386	0.2190	00111	0.2500	10511	0.2815
10196	0.1245	10256	0.1545	10319	0.1860	10387	0.2195	14021	0.2502	10512	0.2820
14006	0.1248	10257	0.1550	10321	0.1870	10388	0.2200	14022	0.2503	10513	0.2825
00055	0.1250	14011	0.1552	14014	0.1872	10389	0.2205	10449	0.2505	10514	0.2830
14007	0.1252	10258	0.1555	14015	0.1878	00100	0.2210	00112	0.2510	10515	0.2835
14008	0.1253	14012	0.1557	10323	0.1880	10391	0.2215	10451	0.2515	10516	0.2840
10198	0.1255	10259	0.1560	00086	0.1890	10392	0.2220	10452	0.2520	10517	0.2845
14009	0.1256	10260	0.1565	10326	0.1895	10393	0.2225	10453	0.2525	10518	0.2850
14010	0.1257	00068	0.1570	10327	0.1900	10394	0.2230	10454	0.2530	10519	0.2855
00056	0.1260	14013	0.1572	10328	0.1905	10395	0.2235	10455	0.2535	10520	0.2860
10200	0.1265	10263	0.1580	00087	0.1910	10396	0.2240	10456	0.2540	10521	0.2865
10201	0.1270	10264	0.1585	10330	0.1915	10397	0.2245	10457	0.2545	10522	0.2870
10202	0.1275	00070	0.1590	10331	0.1920	10398	0.2250	10458	0.2550	10523	0.2875
10203	0.1280	10266	0.1595	10332	0.1925	10399	0.2255	10459	0.2555	10524	0.2880
00057	0.1285	10267	0.1600	10333	0.1930	10400	0.2260	10460	0.2560	10525	0.2885
10205	0.1290	10268	0.1605	00088	0.1935	10401	0.2265	10461	0.2565	10526	0.2890
10206	0.1295	00071	0.1610	10335	0.1940	10402	0.2270	00114	0.2570	10527	0.2895
10207	0.1300	10270	0.1615	10336	0.1945	10404	0.2275	10463	0.2575	00123	0.2900
10208	0.1305	10271	0.1620	10337	0.1950	00101	0.2280	10464	0.2580	10529	0.2905
10209	0.1310	10272	0.1625	10338	0.1955	10405	0.2285	10465	0.2585	10530	0.2910
10210	0.1315	10273	0.1630	00089	0.1960	10406	0.2290	10466	0.2590	10531	0.2915
10211	0.1320	10274	0.1635	10340	0.1965	10407	0.2295	10467	0.2595	10532	0.2920
10212	0.1325	10275	0.1640	10341	0.1970	10408	0.2300	10468	0.2600	10533	0.2925
10213	0.1330	10276	0.1645	10342	0.1975	10409	0.2305	10469	0.2605	10534	0.2930
10214	0.1335	10277	0.1650	10343	0.1980	10410	0.2310	00115	0.2610	10535	0.2935
10215	0.1340	10278	0.1655	10344	0.1985	10411	0.2315	10471	0.2615	10536	0.2940



Chucking Reamers, Decimal Sizes



HIGH SPEED STEEL

897-A-S Straight Flute, Right Hand Cut

PRECISION GROUND BETWEEN CENTERS TO +.0002 - .0000

EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size
10537	0.2945	10601	0.3265	10666	0.3590	10729	0.3905	10792	0.4220
00124	0.2950	10602	0.3270	10667	0.3595	10730	0.3910	10793	0.4225
10539	0.2955	10603	0.3275	10668	0.3600	10731	0.3915	10794	0.4230
10540	0.2960	10604	0.3280	10669	0.3605	10732	0.3920	10795	0.4235
10541	0.2965	10605	0.3285	10670	0.3610	10733	0.3925	10796	0.4240
10542	0.2970	10606	0.3290	10671	0.3615	10734	0.3930	10797	0.4245
10543	0.2975	10607	0.3295	10672	0.3620	14026	0.3932	10798	0.4250
10544	0.2980	10608	0.3300	10673	0.3625	10735	0.3935	10799	0.4255
10545	0.2985	10609	0.3305	10674	0.3630	10736	0.3940	10800	0.4260
10546	0.2990	10610	0.3310	10675	0.3635	10737	0.3945	10801	0.4265
10547	0.2995	10611	0.3315	10676	0.3640	14090	0.3947	10802	0.4270
10548	0.3000	00137	0.3320	10677	0.3645	10738	0.3950	10803	0.4275
10549	0.3005	10613	0.3325	10678	0.3650	10739	0.3955	10804	0.4280
10550	0.3010	10614	0.3330	10679	0.3655	10740	0.3960	10805	0.4285
10551	0.3015	10615	0.3335	10680	0.3660	10741	0.3965	10806	0.4290
00127	0.3020	10616	0.3340	10681	0.3665	00156	0.3970	10807	0.4295
10553	0.3025	10617	0.3345	10682	0.3670	10743	0.3975	10808	0.4300
10554	0.3030	10618	0.3350	10683	0.3675	10744	0.3980	10809	0.4305
10555	0.3035	10619	0.3355	00145	0.3680	10745	0.3985	10810	0.4310
10556	0.3040	10620	0.3360	10685	0.3685	10746	0.3990	10811	0.4315
10557	0.3045	10621	0.3365	10686	0.3690	10747	0.3995	10812	0.4320
10558	0.3050	10622	0.3370	10687	0.3695	10748	0.4000	10813	0.4325
10559	0.3055	10623	0.3375	10688	0.3700	10749	0.4005	10814	0.4330
10560	0.3060	10624	0.3380	10689	0.3705	10750	0.4010	10815	0.4335
10561	0.3065	10625	0.3385	10690	0.3710	10751	0.4015	10816	0.4340
10562	0.3070	00139	0.3390	10691	0.3715	10752	0.4020	10817	0.4345
10563	0.3075	10627	0.3395	10692	0.3720	10753	0.4025	10818	0.4350
10564	0.3080	10628	0.3400	10693	0.3725	10754	0.4030	10819	0.4355
10565	0.3085	10629	0.3405	10694	0.3730	10755	0.4035	10820	0.4360
10566	0.3090	10630	0.3410	10695	0.3735	00157	0.4040	00164	0.4365
10567	0.3095	10631	0.3415	00148	0.3740	10757	0.4045	10822	0.4370
10568	0.3100	10632	0.3420	10697	0.3745	10758	0.4050	00166	0.4375
10569	0.3105	10633	0.3425	00150	0.3750	10759	0.4055	10824	0.4380
10570	0.3110	10634	0.3430	14024	0.3752	10760	0.4060	00167	0.4385
00129	0.3115	10635	0.3435	10699	0.3755	10761	0.4065	10826	0.4390
10572	0.3120	10636	0.3440	14025	0.3757	10762	0.4070	10827	0.4395
00131	0.3125	10637	0.3445	00151	0.3760	10763	0.4075	10828	0.4400
10574	0.3130	10638	0.3450	10701	0.3765	10764	0.4080	10829	0.4405
00132	0.3135	10639	0.3455	00152	0.3770	10765	0.4085	10830	0.4410
10576	0.3140	10640	0.3460	10703	0.3775	10766	0.4090	10831	0.4415
14023	0.3144	10641	0.3465	10704	0.3780	10767	0.4095	10832	0.4420
10577	0.3145	10642	0.3470	10705	0.3785	10768	0.4100	10833	0.4425
00133	0.3150	10643	0.3475	10706	0.3790	10769	0.4105	10834	0.4430
10579	0.3155	00141	0.3480	10707	0.3795	10770	0.4110	10835	0.4435
00134	0.3160	10645	0.3485	10708	0.3800	10771	0.4115	10836	0.4440
10581	0.3165	10646	0.3490	10709	0.3805	10772	0.4120	10837	0.4445
10582	0.3170	10647	0.3495	10710	0.3810	10773	0.4125	10838	0.4450
10583	0.3175	10648	0.3500	10711	0.3815	00159	0.4130	10839	0.4455
10584	0.3180	10649	0.3505	10712	0.3820	10775	0.4135	10840	0.4460
10585	0.3185	10650	0.3510	10713	0.3825	10776	0.4140	10841	0.4465
10586	0.3190	10651	0.3515	10714	0.3830	10777	0.4145	10842	0.4470
10587	0.3195	10652	0.3520	10715	0.3835	10778	0.4150	10843	0.4475
10588	0.3200	10653	0.3525	10716	0.3840	10779	0.4155	10844	0.4480
10589	0.3205	10654	0.3530	10717	0.3845	10780	0.4160	10845	0.4485
10590	0.3210	10655	0.3535	10718	0.3850	10781	0.4165	10846	0.4490
10591	0.3215	10656	0.3540	10719	0.3855	10782	0.4170	10847	0.4495
10592	0.3220	10657	0.3545	00153	0.3860	10783	0.4175	10848	0.4500
10593	0.3225	10658	0.3550	10721	0.3865	10784	0.4180	10849	0.4505
00135	0.3230	10659	0.3555	10722	0.3870	10785	0.4185	10850	0.4510
10595	0.3235	10660	0.3560	10723	0.3875	10786	0.4190	10851	0.4515
10596	0.3240	10661	0.3565	10724	0.3880	10787	0.4195	10852	0.4520
10597	0.3245	10662	0.3570	10725	0.3885	10788	0.4200	10853	0.4525
10598	0.3250	10663	0.3575	10726	0.3890	10789	0.4205	10854	0.4530
10599	0.3255	00143	0.3580	10727	0.3895	10790	0.4210	10855	0.4535
10600	0.3260	10665	0.3585	10728	0.3900	10791	0.4215	10856	0.4540





Chucking Reamers, Decimal Sizes

HIGH SPEED STEEL

PRECISION GROUND BETWEEN CENTERS TO +.0002 - .0000

897-A-S Straight Flute, Right Hand Cut

EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size	EDP Number 897-A-S	Size
10922	0.4870	22020	0.5100	00859	0.5640	00870	0.6290	00893	0.7360	14071	0.8650
10923	0.4875	14029	0.5110	14115	0.5645	14051	0.6295	14061	0.7400	00915	0.8670
10924	0.4880	14030	0.5120	14042	0.5650	14052	0.6300	14135	0.7405	14072	0.8730
10925	0.4885	14031	0.5130	14043	0.5660	14053	0.6302	14062	0.7450	22748	0.8740
10926	0.4890	22021	0.5140	22033	0.5670	00871	0.6310	00894	0.7470	14073	0.8745
10927	0.4895	14032	0.5150	14044	0.5680	14054	0.6330	14063	0.7485	14143	0.8755
10928	0.4900	00850	0.5170	00860	0.5690	14055	0.6350	22498	0.7490	22752	0.8760
10929	0.4905	14033	0.5180	14116	0.5710	00872	0.6390	22092	0.7495	14074	0.8770
10930	0.4910	22022	0.5190	00861	0.5720	14056	0.6400	22093	0.7505	14144	0.8795
10931	0.4915	14034	0.5200	14117	0.5730	14057	0.6410	22502	0.7510	14075	0.8810
10932	0.4920	14101	0.5205	22035	0.5750	00873	0.6420	22094	0.7520	00916	0.8840
10933	0.4925	14102	0.5220	00862	0.5770	14125	0.6440	14064	0.7530	14076	0.8850
10934	0.4930	14035	0.5230	14045	0.5780	14058	0.6450	14065	0.7550	00917	0.8870
10935	0.4935	14103	0.5240	00863	0.5790	00874	0.6480	14066	0.7570	00918	0.8920
10936	0.4940	22024	0.5250	14046	0.5800	14126	0.6500	14136	0.7580	00919	0.9040
10937	0.4945	14104	0.5265	22038	0.5830	00875	0.6510	14067	0.7600	00920	0.9070
10938	0.4950	22026	0.5270	22039	0.5850	14127	0.6530	14137	0.7620	00921	0.9200
10939	0.4955	14105	0.5285	14118	0.5860	00876	0.6550	00895	0.7640	00922	0.9220
10940	0.4960	00851	0.5300	00864	0.5890	14128	0.6565	00896	0.7670	00923	0.9240
10941	0.4965	14106	0.5310	00865	0.5910	00877	0.6570	00897	0.7680	00924	0.9260
10942	0.4970	00852	0.5320	00866	0.5920	00878	0.6680	14138	0.7730	00925	0.9360
10943	0.4975	14036	0.5350	14119	0.5930	14129	0.6690	14068	0.7750	00926	0.9390
10944	0.4980	14107	0.5390	14120	0.5935	14059	0.6700	00898	0.7800	00927	0.9430
10945	0.4985	14037	0.5430	14121	0.5940	00879	0.6710	00899	0.7820	00928	0.9460
00175	0.4990	14108	0.5440	00867	0.5950	00880	0.6730	14139	0.7850	00929	0.9520
10947	0.4995	00853	0.5450	14122	0.5960	14130	0.6770	00900	0.7860	00930	0.9540
00177	0.5000	22028	0.5460	14047	0.6000	22076	0.6850	14140	0.7870	00931	0.9630
14027	0.5002	14038	0.5470	14048	0.6020	00881	0.6860	00901	0.7880	00932	0.9660
14028	0.5003	14109	0.5475	00868	0.6080	22034	0.6865	14069	0.7900	00933	0.9670
22001	0.5005	00854	0.5480	14123	0.6090	14131	0.6870	00902	0.7950	00934	0.9700
00178	0.5010	14110	0.5490	00869	0.6110	00193	0.6875	00903	0.7980	00935	0.9830
22002	0.5015	00855	0.5500	22042	0.6120	00882	0.6880	14070	0.8000	00936	0.9850
22004	0.5020	00856	0.5510	14124	0.6140	00883	0.6900	00904	0.8060	14077	0.9980
22005	0.5025	00857	0.5520	22043	0.6150	14132	0.6945	00905	0.8080	22998	0.9990
22006	0.5030	14111	0.5530	14049	0.6200	14060	0.7000	00906	0.8110	14145	0.9995
22007	0.5035	14112	0.5540	22045	0.6220	00884	0.7020	00907	0.8140	23002	1.0010
22008	0.5040	22029	0.5550	22046	0.6230	00885	0.7040	14141	0.8210	14078	1.0050
22009	0.5045	14113	0.5570	14050	0.6235	00886	0.7070	00908	0.8250	14079	1.0100
22010	0.5050	22030	0.5580	22048	0.6240	14133	0.7085	14142	0.8265	14146	1.0312
22011	0.5055	14039	0.5600	22049	0.6245	00887	0.7100	00909	0.8290	14147	1.2490
22012	0.5060	00858	0.5610	22050	0.6255	00889	0.7200	00910	0.8420		
22013	0.5065	22032	0.5615	22052	0.6260	00890	0.7270	00911	0.8450		
22014	0.5070	14114	0.5620	14091	0.6265	00891	0.7300	00912	0.8470		
22016	0.5080	14040	0.5630	22053	0.6270	00892	0.7330	00913	0.8580		
22018	0.5090	14041	0.5635	22054	0.6280	14134	0.7340	00914	0.8610		

Piloted Chucking Reamers



HIGH SPEED STEEL

897-A-S Piloted, Straight Flute, Straight Shank

EDP # 897-A-S Piloted	Decimal Equiv.	Pilot Diameter	Flute Length	Pilot Length	Overall Length Inches
15000	0.1610	0.1250	1-1/8	5/16	4-1/2
15001	0.1850	0.1600	1-1/8	5/16	4-1/2
15002	0.1860	0.1540	1-1/8	5/16	4-1/2
15003	0.1870	0.1600	1-1/8	5/16	4-1/2
15004	0.1870	0.1740	1-1/8	5/16	4-1/2
15005	0.1875	0.1600	1-1/8	5/16	4-1/2
15006	0.1985	0.1845	1-1/4	3/8	5
15007	0.1985	0.1850	1-1/4	3/8	5
15008	0.1985	0.1945	1-1/4	3/8	5
15009	0.2000	0.1870	1-1/4	3/8	5
15010	0.2031	0.1875	1-1/4	3/8	5
15011	0.2130	0.1950	1-1/4	3/8	5
15012	0.2130	0.1985	1-1/4	3/8	5
15013	0.2140	0.1970	1-1/4	3/8	5
15014	0.2158	0.2000	1-1/4	3/8	5
15015	0.2160	0.1980	1-1/4	3/8	5
15016	0.2188	0.2031	1-1/4	3/8	5
15017	0.2314	0.2158	1-1/2	1/2	6
15018	0.2330	0.2140	1-1/2	1/2	6
15019	0.2340	0.2130	1-1/2	1/2	6
15020	0.2344	0.2180	1-1/2	1/2	6
15021	0.2435	0.2340	1-1/2	1/2	6
15022	0.2455	0.2340	1-1/2	1/2	6
15023	0.2460	0.2330	1-1/2	1/2	6
15024	0.2470	0.2314	1-1/2	1/2	6
15025	0.2500	0.2344	1-1/2	1/2	6
15026	0.2600	0.2460	1-1/2	1/2	6
15027	0.2610	0.2310	1-1/2	1/2	6
15028	0.2610	0.2450	1-1/2	1/2	6
15029	0.2620	0.2470	1-1/2	1/2	6
15030	0.2621	0.2470	1-1/2	1/2	6
15031	0.2656	0.2500	1-1/2	1/2	6
15032	0.2755	0.2600	1-1/2	1/2	6
15033	0.2770	0.2610	1-1/2	1/2	6
15034	0.2780	0.2620	1-1/2	1/2	6
15035	0.2782	0.2621	1-1/2	1/2	6
15036	0.2810	0.2670	1-1/2	1/2	6
15037	0.2812	0.2656	1-1/2	1/2	6
15038	0.2910	0.2755	1-1/2	1/2	6
15039	0.2920	0.2770	1-1/2	1/2	6
15040	0.2939	0.2782	1-1/2	1/2	6
15041	0.2969	0.2812	1-1/2	1/2	6
15042	0.3075	0.2910	1-1/2	1/2	6
15043	0.3090	0.2939	1-1/2	1/2	6
15044	0.3100	0.2920	1-1/2	1/2	6

EDP # 897-A-S Piloted	Decimal Equiv.	Pilot Diameter	Flute Length	Pilot Length	Overall Length Inches
15045	0.3125	0.2969	1-1/2	1/2	6
15046	0.3225	0.3075	1-1/2	1/2	6
15047	0.3230	0.3100	1-1/2	1/2	6
15048	0.3251	0.3090	1-1/2	1/2	6
15049	0.3281	0.3125	1-1/2	1/2	6
15050	0.3380	0.3225	1-1/2	1/2	6
15051	0.3390	0.3230	1-1/2	1/2	6
15052	0.3390	0.3350	1-1/2	1/2	6
15053	0.3407	0.3251	1-1/2	1/2	6
15054	0.3438	0.3281	1-1/2	1/2	6
15055	0.3535	0.3380	1-3/4	1/2	7
15056	0.3594	0.3438	1-3/4	1/2	7
15057	0.3700	0.3535	1-3/4	1/2	7
15058	0.3710	0.3550	1-3/4	1/2	7
15059	0.3750	0.3494	1-3/4	1/2	7
15060	0.3750	0.3594	1-3/4	1/2	7
15061	0.3850	0.3700	1-3/4	1/2	7
15062	0.3860	0.3720	1-3/4	1/2	7
15063	0.3906	0.3750	1-3/4	1/2	7
15064	0.4005	0.3850	1-3/4	1/2	7
15065	0.4010	0.3860	1-3/4	1/2	7
15066	0.4062	0.3906	1-3/4	1/2	7
15067	0.4160	0.4005	1-3/4	1/2	7
15068	0.4219	0.4062	1-3/4	1/2	7
15069	0.4325	0.4160	1-3/4	1/2	7
15070	0.4375	0.4219	1-3/4	1/2	7
15071	0.4485	0.4325	1-3/4	1/2	7
15072	0.4531	0.4375	1-3/4	1/2	7
15073	0.4640	0.4405	1-3/4	1/2	7
15074	0.4688	0.4531	1-3/4	1/2	7
15075	0.4795	0.4640	2	1/2	8
15076	0.4844	0.4688	2	1/2	8
15077	0.4950	0.4795	2	1/2	8
15078	0.5000	0.4844	2	1/2	8
15079	0.5110	0.4950	2	1/2	8
15080	0.5156	0.5000	2	1/2	8
15081	0.5265	0.5110	2	1/2	8
15082	0.5312	0.5156	2	1/2	8
15083	0.5469	0.5312	2	1/2	8
15084	0.5625	0.5469	2	1/2	8
15085	0.5781	0.5625	2	1/2	8
15086	0.5938	0.5781	2	1/2	8
15087	0.6094	0.5938	2	1/2	9
15088	0.6250	0.6094	2-1/4	1/2	9



*Overall length is measured from seating angle to tip.

Piloted, Threaded Shank Reamers

• 865-0 High Speed Steel

STOCKED

Long Series, Threaded Shank Reamers
Piloted, Straight Flute, Right Hand Cut

EDP # HSS 865-0	Decimal Equiv. Inches	Pilot Diameter Inches	Piloted Length Inches	Flute Length Inches	Overall Length Inches
21800	0.1610	0.1250	1/2	1-1/2	2-1/8
21801	0.1610	0.1520	1/2	1-1/2	2-1/8
21802	0.1719	0.1640	1/2	1-1/2	2-1/8
21803	0.1850	0.1600	1/2	1-1/2	2-1/8
21804	0.1850	0.1750	1/2	1-1/2	2-1/8
21805	0.1860	0.1540	1/2	1-1/2	2-1/8
21806	0.1870	0.1600	1/2	1-1/2	2-1/8
21807	0.1870	0.1740	1/2	1-1/2	2-1/8
21808	0.1875	0.1600	1/2	1-1/2	2-1/8
21809	0.1875	0.1780	1/2	1-1/2	2-1/8
21810	0.1890	0.1800	1/2	1-1/2	2-1/8
21811	0.1910	0.1800	1/2	1-1/2	2-1/8
21812	0.1935	0.1830	1/2	1-1/2	2-1/8
21813	0.1985	0.1850	1/2	1-1/2	2-1/8
21814	0.1985	0.1945	1/2	1-1/2	2-1/8
21815	0.2000	0.1870	1/2	1-1/2	2-1/8
21816	0.2031	0.1875	1/2	1-1/2	2-1/8
21817	0.2031	0.1940	1/2	1-1/2	2-1/8
21818	0.2130	0.1950	1/2	1-1/2	2-1/8
21819	0.2130	0.1980	1/2	1-1/2	2-1/8
21820	0.2140	0.1970	1/2	1-1/2	2-1/8
21821	0.2158	0.2000	1/2	1-1/2	2-1/8
21822	0.2160	0.1980	1/2	1-1/2	2-1/8
21823	0.2188	0.2031	1/2	1-1/2	2-1/8
21824	0.2188	0.2070	1/2	1-1/2	2-1/8
21825	0.2314	0.2158	1/2	1-1/2	2-1/8
21826	0.2330	0.2140	1/2	1-1/2	2-1/8
21827	0.2340	0.2130	1/2	1-1/2	2-1/8
21828	0.2344	0.2180	1/2	1-1/2	2-1/8
21829	0.2344	0.2260	1/2	1-1/2	2-1/8
21830	0.2455	0.2340	1/2	1-1/2	2-1/8
21831	0.2460	0.2330	1/2	1-1/2	2-1/8
21832	0.2470	0.2314	1/2	1-1/2	2-1/8
21833	0.2500	0.2344	1/2	1-1/2	2-1/8
21834	0.2500	0.2400	1/2	1-1/2	2-1/8
21835	0.2600	0.2310	1/2	1-1/2	2-1/8

EDP # HSS 865-0	Decimal Equiv. Inches	Pilot Diameter Inches	Piloted Length Inches	Flute Length Inches	Overall Length Inches
21836	0.2600	0.2460	1/2	1-1/2	2-1/8
21837	0.2610	0.2450	1/2	1-1/2	2-1/8
21838	0.2620	0.2470	1/2	1-1/2	2-1/8
21839	0.2621	0.2470	1/2	1-1/2	2-1/8
21840	0.2656	0.2500	1/2	1-1/2	2-1/8
21841	0.2656	0.2550	1/2	1-1/2	2-1/8
21842	0.2755	0.2600	1/2	1-1/2	2-1/8
21843	0.2770	0.2610	1/2	1-1/2	2-1/8
21844	0.2780	0.2620	1/2	1-1/2	2-1/8
21845	0.2782	0.2621	1/2	1-1/2	2-1/8
21846	0.2810	0.2656	1/2	1-1/2	2-1/8
21847	0.2812	0.2700	1/2	1-1/2	2-1/8
21848	0.2920	0.2770	1/2	1-1/2	2-1/8
21849	0.2939	0.2782	1/2	1-1/2	2-1/8
21850	0.2969	0.2812	1/2	1-1/2	2-1/8
21851	0.2969	0.2880	1/2	1-1/2	2-1/8
21852	0.3090	0.2939	1/2	1-1/2	2-1/8
21853	0.3100	0.2920	1/2	1-1/2	2-1/8
21854	0.3125	0.2969	1/2	1-1/2	2-1/8
21855	0.3125	0.3000	1/2	1-1/2	2-1/8
21856	0.3230	0.3100	1/2	1-1/2	2-1/8
21857	0.3251	0.3090	1/2	1-1/2	2-1/8
21858	0.3281	0.3125	1/2	1-1/2	2-1/8
21859	0.3390	0.3230	1/2	1-1/2	2-1/8
21860	0.3390	0.3350	1/2	1-1/2	2-1/8
21861	0.3407	0.3251	1/2	1-1/2	2-1/8
21862	0.3438	0.3281	1/2	1-1/2	2-1/8
21863	0.3595	0.3438	1/2	1-1/2	2-1/8
21864	0.3710	0.3550	1/2	1-1/2	2-1/8
21865	0.3750	0.3594	1/2	1-1/2	2-1/8
21866	0.3906	0.3750	1/2	1-1/2	2-1/8
21867	0.4005	0.3850	1/2	1-1/2	2-1/8
21868	0.4010	0.3860	1/2	1-1/2	2-1/8
21869	0.4062	0.3906	1/2	1-1/2	2-1/8
21870	0.4219	0.4062	1/2	1-1/2	2-1/8



*Overall length is measured from seating angle to tip.

Piloted, Threaded Shank Reamers

• 865-0 High Speed Steel

• 866-0 M42 Cobalt Steel

• 829-0 Carbide

PRECISION GROUND

Long Series, Threaded Shank Reamers
Piloted, Straight Flute, Right Hand Cut

EDP# HSS 865-0	EDP# Cobalt 866-0	EDP# Carbide 829-0	Size Range Inches	*Overall Length Inches	Min. Pilot Dia. Inches	Neck Dia. Inches	Thread Length Inches	Hex Size Inches
21000	21200	82900	.1500-.1632	2-1/8	0.125	Body	0.250	5/16
21001	21201	82901	.1633-.1789	2-1/8	0.137	Body	0.250	5/16
21002	21202	82902	.1790-.1945	2-1/8	0.150	Body	0.250	5/16
21003	21203	82903	.1946-.2101	2-1/8	0.162	Body	0.250	5/16
21004	21204	82904	.2102-.2258	2-1/8	0.174	0.205	0.250	5/16
21005	21205	82905	.2259-.2414	2-1/8	0.187	0.220	0.250	5/16
21006	21206	82906	.2415-.2570	2-1/8	0.200	0.235	0.250	5/16
21007	21207	82907	.2571-.2720	2-1/8	0.212	0.245	0.250	5/16
21008	21208	82908	.2721-.2880	2-1/8	0.225	0.250	0.250	5/16
21009	21209	82909	.2881-.3040	2-1/8	0.237	0.280	0.250	5/16
21010	21210	82910	.3041-.3190	2-1/8	0.256	0.280	0.250	5/16
21011	21211	82911	.3191-.3350	2-1/8	0.262	0.280	0.250	3/8
21012	21212	82912	.3351-.3479	2-1/8	0.275	0.280	0.250	3/8
21013	21213	82913	.3480-.3660	2-1/8	0.278	0.307	0.250	3/8
21014	21214	82914	.3661-.3820	2-1/8	0.300	0.307	0.250	3/8
21015	21215	82915	.3821-.3980	2-1/8	0.312	0.307	0.250	3/8
21016	21216	82916	.3981-.4219	2-1/8	0.324	0.307	0.250	3/8

Taper Shank Chucking Reamers

HIGH SPEED STEEL - Fractional Sizes

131-0 Straight Flute, 131-1 Right Hand Spiral,
131-2 Left Hand Spiral, Right Hand Cut

# of Flute	Range
4 Flutes	.0280-.1561 Dia.
6 Flutes	.1562-.5220 Dia.
8 Flutes	.5221-.8820 Dia.
10 Flutes	.8821-1.195 Dia.
12 Flutes	1.1951-1.5000 Dia.

Flute Configuration For
Series 131 Taper Shank
Chucking Reamers.



EDP Number 131-0	EDP Number 131-1	EDP Number 131-2	Fractional Size Inches	Decimal Equiv. Inches	Overall Length Inches	Flute Length Inches	Taper Shank No.
00500	01500	02500	1/4	0.2500	6	1-1/2	1
00501	01501	02501	9/32	0.2812	6	1-1/2	1
00502	01502	02502	5/16	0.3125	6	1-1/2	1
00503	01503	02503	11/32	0.3438	6	1-1/2	1
00504	01504	02504	3/8	0.3750	7	1-3/4	1
00505	01505	02505	13/32	0.4062	7	1-3/4	1
00506	01506	02506	7/16	0.4375	7	1-3/4	1
00507	01507	02507	15/32	0.4688	7	1-3/4	1
00508	01508	02508	1/2	0.5000	8	2	1
00509	01509	02509	17/32	0.5312	8	2	1
00510	01510	02510	9/16	0.5625	8	2	1
00511	01511	02511	19/32	0.5938	8	2	1
00512	01512	02512	5/8	0.6250	9	2-1/4	2
00513	01513	02513	21/32	0.6562	9	2-1/4	2
00514	01514	02514	11/16	0.6875	9	2-1/4	2
00515	01515	02515	23/32	0.7188	9	2-1/4	2
00516	01516	02516	3/4	0.7500	9-1/2	2-1/2	2
00517	01517	02517	25/32	0.7812	9-1/2	2-1/2	2
00518	01518	02518	13/16	0.8125	9-1/2	2-1/2	2
00519	01519	02519	27/32	0.8438	9-1/2	2-1/2	2
00520	01520	02520	7/8	0.8750	10	2-5/8	2
00521	01521	02521	29/32	0.9062	10	2-5/8	2
00522	01522	02522	15/16	0.9375	10	2-5/8	3
00523	01523	02523	31/32	0.9688	10	2-5/8	3
00524	01524	02524	1	1.0000	10-1/2	2-3/4	3
00525	01525	02525	1-1/16	1.0625	10-1/2	2-3/4	3
00526	01526	02526	1-1/8	1.1250	11	2-7/8	3
00527	01527	02527	1-3/16	1.1875	11	2-7/8	3
00528	01528	02528	1-1/4	1.2500	11-1/2	3	4
00529	01529	02529	1-5/16	1.3125	11-1/2	3	4
00530	01530	02530	1-3/8	1.3750	12	3-1/4	4
00531	01531	02531	1-7/16	1.4375	12	3-1/4	4
00532	01532	02532	1-1/2	1.5000	12-1/2	3-1/2	4



Jobber Reamers

HIGH SPEED STEEL - Fractional Sizes
Taper Shank

105-0 Straight Flute

EDP Number 105-0	Size	Decimal Equiv. Inches	Overall Length Inches	Length of Flute Inches	Taper Shank No.
12600	1/4	0.2500	5-3/16	2	1
12601	9/32	0.2812	5-5/16	2-1/8	1
12602	5/16	0.3125	5-1/2	2-1/4	1
12603	11/32	0.3438	5-5/8	2-3/8	1
12604	3/8	0.3750	5-13/16	2-1/2	1
12605	13/32	0.4062	5-15/16	2-5/8	1
12606	7/16	0.4375	6-1/8	2-3/4	1
12607	15/32	0.4688	6-1/4	2-7/8	1
12608	1/2	0.5000	6-7/16	3	1
12609	17/32	0.5312	6-9/16	3-1/8	1
12610	9/16	0.5625	6-3/4	3-1/4	1
12611	19/32	0.5938	6-7/8	3-3/8	1
12612	5/8	0.6250	7-9/16	3-1/2	2
12613	21/32	0.6562	7-3/4	3-11/16	2
12614	11/16	0.6875	8	3-7/8	2
12615	23/32	0.7188	8-3/16	4-1/16	2
12616	3/4	0.7500	8-3/8	4-3/16	2
12617	13/16	0.8125	8-13/16	4-9/16	2
12618	7/8	0.8750	9-3/16	4-7/8	2
12619	15/16	0.9375	10-3/16	5-1/8	3
12620	1	1.0000	10-9/16	5-7/16	3
12621	1-1/16	1.0625	10-13/16	5-5/8	3
12622	1-1/8	1.1250	11-1/16	5-13/16	3
12623	1-3/16	1.1875	11-5/16	6	3
12624	1-1/4	1.2500	12-1/2	6-1/8	4
12625	1-5/16	1.3125	12-11/16	6-1/4	4
12626	1-3/8	1.3750	12-13/16	6-5/16	4
12627	1-7/16	1.4375	13	6-7/16	4
12628	1-1/2	1.5000	13-1/8	6-1/2	4



Center Reamers

HIGH SPEED STEEL
179-0 Center Reamer

60°, 82°, 90°, 100°, and 120°, Include Angle, 3 Flutes
*Specify Angle and Shank Sizes When Ordering.

EDP Number 60°	EDP Number 82°	EDP Number 90°	EDP Number 100°	EDP Number 110°	EDP Number 120°	Diameter Body Inches	Diameter Shank Inches	Overall Length Inches	Length Shank Inches
05000	05010	05020	05030	05040	05050	1/4	3/16	1-1/2	3/4
05001	05011	05021	05031	05041	05051	3/8	1/4	1-3/4	7/8
05002	05012	05022	05032	05042	05052	*1/2	1/4	2	1
05003	05013	05023	05033	05043	05053	*1/2	3/8	2	1
05004	05014	05024	05034	05044	05054	5/8	3/8	2-1/4	1
05005	05015	05025	05035	05045	05055	3/4	1/2	2-5/8	1-1/4
05006	05016	05026	05036	05046	05056	1	1/2	3	1-1/4

Bridge Reamers

HIGH SPEED STEEL - Straight Flute, Taper Shank

625-0 Straight Flute



EDP Number 625-0	Size	Decimal Equiv. Inches	Flute Length Inches	Overall Length Inches	Taper Shank No.
60800	3/8	0.3750	2-3/4	5-11/16	1
60801	7/16	0.4375	4-3/8	8-1/4	2
60802	1/2	0.5000	5-1/8	9	2
60803	9/16	0.5625	5-1/8	9	2
60804	5/8	0.6250	6-1/8	10	2
60805	11/16	0.6875	7-1/8	11-3/4	3
60806	3/4	0.7500	7-3/8	12	3
60807	13/16	0.8125	7-3/8	12	3
60808	7/8	0.8750	7-3/8	12	3
60809	15/16	0.9375	7-3/8	12	3
60810	1	1.0000	7-3/8	12	3
60811	1-1/16	1.0625	7-3/8	12	3
60812	1-1/8	1.1250	7-3/8	12	3
60813	1-1/4	1.2500	7-3/8	13	4
60814	1-3/8	1.3750	7-3/8	13	4
60815	1-1/2	1.5000	7-3/8	13	4

Bridge Reamers

HIGH SPEED STEEL - Left Hand Spiral, Taper Shank

627-2 Left Hand Spiral



EDP Number 627-2	Size	Decimal Equiv. Inches	Flute Length Inches	Overall Length Inches	Taper Shank No.
60900	3/8	0.3750	2-3/4	5-11/16	1
60901	7/16	0.4375	4-3/8	8-1/4	2
60902	1/2	0.5000	5-1/8	9	2
60903	9/16	0.5625	5-1/8	9	2
60904	5/8	0.6250	6-1/8	10	2
60905	11/16	0.6875	7-1/8	11-3/4	3
60906	3/4	0.7500	7-3/8	12	3
60907	13/16	0.8125	7-3/8	12	3
60908	7/8	0.8750	7-3/8	12	3
60909	15/16	0.9375	7-3/8	12	3
60910	1	1.0000	7-3/8	12	3
60911	1-1/16	1.0625	7-3/8	12	3
60912	1-1/8	1.1250	7-3/8	12	3
60913	1-1/4	1.2500	7-3/8	13	4
60914	1-3/8	1.3750	7-3/8	13	4
60915	1-1/2	1.5000	7-3/8	13	4

Construction Reamers

HIGH SPEED STEEL - Straight Shank, Left Hand Spiral

650-H Fast Helix, 650-F Fast Helix, Tri-Flats on Shank



650-H Fast Helix

650-F Fast Helix, Tri-Flats on Shank

EDP Number 650-H	EDP Number 650-F	Fractional Size Inches	Actual Size Inches	Length Shank Inches	Dia. Shank Inches	Overall Length Inches
00744	01744	3/16	0.1905	1-1/2	0.2500	3-1/2
00745	01745	7/32	0.2218	1-1/2	0.2500	3-1/2
00746	01746	1/4	0.2530	1-1/2	0.2500	4
00747	01747	9/32	0.2842	1-1/2	0.2500	4
00748	01748	5/16	0.3155	1-1/2	0.2500	4-1/2
00749	01749	11/32	0.3468	1-1/2	0.2500	4-1/2
00750	01750	3/8	0.3780	1-1/2	0.3750	5
00751	01751	7/16	0.4405	1-1/2	0.4375	5-1/4
00752	01752	1/2	0.5030	1-1/2	0.5000	5-15/16
00757	01757	9/16	0.5655	1-1/2	0.5000	6-1/4
00753	01753	5/8	0.6280	1-1/2	0.5000	6-9/16
00758	01758	11/16	0.6905	1-1/2	0.5000	7
00754	01754	3/4	0.7530	1-1/2	0.5000	7
00759	01759	13/16	0.8155	1-1/2	0.5000	7-1/4
00755	01755	7/8	0.8780	1-1/2	0.5000	7-1/4
00760	01760	15/16	0.9405	1-1/2	0.5000	7-1/4
00756	01756	1	1.0030	1-1/2	0.5000	7-1/4
00761	01761	1-1/16	1.0655	1-1/2	0.5000	7-1/4
00762	01762	1-1/8	1.1280	1-1/2	0.5000	7-1/4
00763	01763	1-3/16	1.1950	1-1/2	0.5000	7-1/4
00764	01764	1-1/4	1.2530	1-1/2	0.5000	7-1/2
00765	01765	1-5/16	1.3155	1-1/2	0.5000	7-1/2
00766	01766	1-3/8	1.3780	1-1/2	0.5000	7-1/2
00767	01767	1-7/16	1.4405	1-1/2	0.5000	7-1/2
00768	01768	1-1/2	1.5030	1-1/2	0.5000	7-1/2

Metric Hand Reamers

HIGH SPEED STEEL - Straight Flute

Series 101-0



EDP Number 101-0	Metric Size	Decimal Equiv. Inches	Flute Size Inches	Overall Length Inches
20650	3mm	0.1181	1-1/2	3
20651	4mm	0.1575	1-5/8	3-1/4
20652	5mm	0.1968	1-7/8	3-3/4
20653	6mm	0.2362	2	4
20654	7mm	0.2756	2-1/8	4-1/4
20655	8mm	0.3150	2-1/4	4-1/2
20656	9mm	0.3543	2-1/2	5
20657	10mm	0.3937	2-5/8	5-1/4
20658	12mm	0.4724	3	6
20659	13mm	0.5118	3-1/8	6-1/4
20660	14mm	0.5512	3-1/4	6-1/2
20661	16mm	0.6299	3-1/2	7
20662	18mm	0.7087	4-1/16	8-1/8
20663	20mm	0.7874	4-9/16	9-1/8

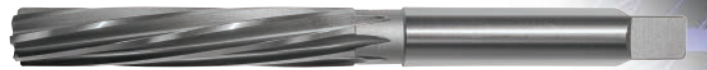
Hand Reamers

HIGH SPEED STEEL - Fractional Sizes

101-0 Straight Flute, 101-2 Left Hand Spiral, Right Hand Cut



101-0 Straight Flute



101-2 Left Hand Spiral

EDP Number 101-0	EDP Number 101-2	Fractional Size Inches	Decimal Equiv. Inches	Overall Length Inches	Length of Flute Inches
00600	02600	1/8	0.1250	3	1-1/2
00601	02601	9/64	0.1406	3-1/4	1-5/8
00602	02602	5/32	0.1562	3-1/4	1-5/8
00603	02603	1/64	0.1719	3-1/2	1-3/4
00604	02604	3/16	0.1875	3-1/2	1-3/4
00605	02605	13/64	0.2031	3-3/4	1-7/8
00606	02606	7/32	0.2188	3-3/4	1-7/8
00607	02607	15/64	0.2344	4	2
00608	02608	1/4	0.2500	4	2
00609	02609	17/64	0.2656	4-1/4	2-1/8
00610	02610	9/32	0.2812	4-1/4	2-1/8
00611	02611	19/64	0.2969	4-1/2	2-1/4
00612	02612	5/16	0.3125	4-1/2	2-1/4
00613	02613	21/64	0.3281	4-3/4	2-3/8
00614	02614	11/32	0.3438	4-3/4	2-3/8
00615	02615	23/64	0.3594	5	2-1/2
00616	02616	3/8	0.3750	5	2-1/2
00617	02617	25/64	0.3906	5-1/4	2-5/8
00618	02618	13/32	0.4062	5-1/4	2-5/8
00619	02619	27/64	0.4219	5-1/2	2-3/4
00620	02620	7/16	0.4375	5-1/2	2-3/4
00621	02621	29/64	0.4531	5-3/4	2-7/8
00622	02622	15/32	0.4688	5-3/4	2-7/8
00623	02623	31/64	0.4844	6	3
00624	02624	1/2	0.5000	6	3
00625	02625	17/32	0.5312	6-1/4	3-1/8
00626	02626	9/16	0.5625	6-1/2	3-1/4
00627	02627	19/32	0.5938	6-3/4	3-3/8
00628	02628	5/8	0.6250	7	3-1/2
00629	02629	21/32	0.6562	7-3/8	3-11/16
00630	02630	11/16	0.6875	7-3/4	3-7/8
00631	02631	23/32	0.7188	8-1/8	4-1/16
00632	02632	3/4	0.7500	8-3/8	4-3/16
00633	02633	25/32	0.7812	8-3/4	4-3/8
00634	02634	13/16	0.8125	9-1/8	4-9/16
00635	02635	27/32	0.8438	9-3/8	4-11/16
00636	02636	7/8	0.8750	9-3/4	4-7/8
00637	02637	29/32	0.9062	10	5
00638	02638	15/16	0.9375	10-1/4	5-1/8
00639	02639	31/32	0.9688	10-5/8	5-5/16
00640	02640	1	1.0000	10-7/8	5-7/16
00641	02641	1-1/16	1.0625	11-1/4	5-5/8
00642	02642	1-1/8	1.1250	11-5/8	5-13/16
00643	02643	1-3/16	1.1875	12	6
00644	02644	1-1/4	1.2500	12-1/4	6-1/8
00645	02645	1-5/16	1.3125	12-1/2	6-1/4
00646	02646	1-3/8	1.3750	12-5/8	6-5/16
00647	02647	1-7/16	1.4375	12-7/8	6-7/16
00648	02648	1-1/2	1.5000	13	6-1/2

Taper Pin Reamers

HIGH SPEED STEEL

155-0 Straight Flute, 155-2 Left Hand Spiral, 155-H Helical



155-0 Straight Flute

155-2 Left Hand Spiral

155-H Helical

EDP Number 155-0	EDP Number 155-2	EDP Number 155-H	Size Number	Shank Dia. Inches	Dia. Small End Inches	Dia. Large End Inches	Overall Length Inches	Flute Length Inches
00800	02800	03800	7/0	5/64	0.0497	0.0666	1-13/16	13/16
00801	02801	03801	6/0	3/32	0.0611	0.0806	1-15/16	15/16
00802	02802	03802	5/0	7/64	0.0719	0.0966	2-3/16	1-3/16
00803	02803	03803	4/0	1/8	0.0869	0.1142	2-5/16	1-5/16
00804	02804	03804	3/0	9/64	0.1029	0.1302	2-5/16	1-5/16
00805	02805	03805	2/0	5/32	0.1137	0.1462	2-9/16	1-9/16
00806	02806	03806	0	11/64	0.1287	0.1638	2-15/16	1-11/16
00807	02807	03807	1	3/16	0.1447	0.1798	2-15/16	1-11/16
00808	02808	03808	2	13/64	0.1605	0.2008	3-3/16	1-15/16
00809	02809	03809	3	15/64	0.1813	0.2294	3-11/16	2-5/16
00810	02810	03810	4	17/64	0.2071	0.2604	4-1/16	2-9/16
00811	02811	03811	5	5/16	0.2409	0.2994	4-5/16	2-13/16
00812	02812	03812	6	23/64	0.2773	0.3540	5-7/16	3-11/16
00813	02813	03813	7	13/32	0.3297	0.4220	6-5/16	4-7/16
00814	02814	03814	8	7/16	0.3971	0.5050	7-3/16	5-3/16
00815	02815	03815	9	9/16	0.4805	0.6066	8-5/16	6-1/16
00816	02816	03816	10	5/8	0.5799	0.7216	9-5/16	6-13/16
00817	02817	03817	11	3/4	0.7060	0.8780	11-1/4	8-1/4
00818	02818	03818	12	7/8	0.8420	1.0500	13-3/8	10
00819	02819	03819	13	1	1.0090	1.2590	16	12
00820	02820	03820	14	1-1/4	1.2500	1.5417	18-1/4	14

Metric Taper Pin Reamers

HIGH SPEED STEEL

156-0 Straight Flute, 156-2 Left Hand Spiral, 156-H Helical

EDP Number 156-0	EDP Number 156-2	EDP Number 156-H	Size Number	Shank Dia. Inches	Dia. Small End Inches	Dia. Large End Inches	Overall Length Inches	Flute Length Inches
09600	09700	09800	2mm	0.1240	0.0748	0.1126	2.875	1.889
09601	09701	09801	2.5mm	0.1240	0.0945	0.1362	3.093	2.086
09602	09702	09802	3mm	0.1552	0.1142	0.1638	3.468	2.480
09603	09703	09803	4mm	0.2021	0.1535	0.2126	3.937	2.952
09604	09704	09804	5mm	0.2490	0.1929	0.2614	4.531	3.425
09605	09705	09805	6mm	0.3115	0.2323	0.3260	5.906	4.685
09606	09706	09806	8mm	0.4052	0.3110	0.4220	6.968	5.551
09607	09707	09807	10mm	0.4365	0.3898	0.5181	8.026	6.417
09608	09708	09808	12mm	0.5615	0.4669	0.6197	9.437	7.637
09609	09709	09809	13mm	0.6240	0.5063	0.6590	9.437	7.637



259-2

Steering & Suspension Reamers

HIGH SPEED STEEL

259-2

EDP Number	Diameter of Reamer Sm. End In.	Diameter of Reamer Lg. End In.	Overall Length Inches	Flute Length Inches	Shank Diameter Inches	Number of Flutes
74301	0.4375	0.8125	5-1/2	3	1/2	6
74302	0.7500	1.3125	7	4-1/2	1/2	8

Morse Taper Reamers

Socket Reamers, Taper Shank

HIGH SPEED STEEL - Finishing Reamer, Taper Shank
163-0 Straight Flute, Right Hand Cut

EDP Number 163-0	Size No. of Morse Taper	Diameter of Reamer Sm. End In.	Diameter of Reamer Lg. End In.	Overall Length Inches	Length of Flute Inches	Taper per Foot Inches	Taper Shank Number
12506	0	0.250	0.367	5-11/32	2-1/4	0.6246	0
12507	1	0.367	0.517	6-5/16	3	0.5985	1
12508	2	0.570	0.744	7-3/8	3-1/2	0.5994	2
12509	3	0.775	0.988	8-7/8	4-1/4	0.6023	3
12510	4	1.017	1.289	10-7/8	5-1/4	0.6232	4
12511	5	1.472	1.800	13-1/8	6-1/4	0.6315	5

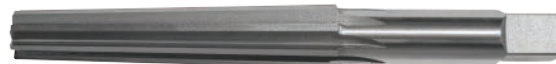


Morse Taper Reamers

Socket Reamers, Square Shank

HIGH SPEED STEEL - Finishing Reamer, Square Shank
161-0 Straight Flute, Right Hand Cut

EDP Number 161-0	Size No. of Morse Taper	Diameter of Reamer Sm. End In.	Diameter of Reamer Lg. End In.	Overall Length Inches	Length of Flute Inches	Taper per Foot Inches
12500	0	0.250	0.367	3-3/4	2-1/4	0.6246
12501	1	0.367	0.517	5	3	0.5985
12502	2	0.570	0.744	6	3-1/2	0.5994
12503	3	0.775	0.988	7-1/4	4-1/4	0.6023
12504	4	1.017	1.289	8-1/2	5-1/4	0.6232
12505	5	1.472	1.800	9-3/4	6-1/4	0.6315

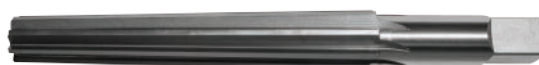


Brown & Sharpe Reamers

Taper Socket Reamers

HIGH SPEED STEEL - Taper Socket Reamers
261-0 Straight Flute, Right Hand Cut

EDP Number 261-0	Number of Taper	Dia. of Rmr. Small End Inches	Length Large End Inches	Overall Length Inches	Length of Flute Inches
18060	1	0.1974	0.3176	4-3/4	2-7/8
18061	2	0.2474	0.3781	5-1/8	3-1/8
18062	3	0.3099	0.4510	5-1/2	3-3/8
18063	4	0.3474	0.5017	5-7/8	3-11/16
18064	5	0.4474	0.6145	6-3/8	4
18065	6	0.4974	0.6808	6-7/8	4-3/8
18066	7	0.5974	0.8011	7-1/2	4-7/8
18067	8	0.7474	0.9770	8-1/8	5-1/2
18068	9	0.8974	1.1530	8-7/8	6-1/8
18069	10	1.0420	1.3376	9-3/4	6-7/8



Finishing Reamers are designed for Brown & Sharpe Standard Tapers.

Taper Pipe Reamers

HIGH SPEED STEEL
207-2 Left Hand Spiral, Right Hand Cut

EDP Number 207-2	Size	Diameter of Reamer Sm. End In.	Diameter of Reamer Lg. End In.	Diameter of Reamer Shank In.	Overall Length Inches	Length of Flute Inches
18040	1/8	0.316	0.362	0.4375	2-1/8	3/4
18041	1/4	0.406	0.472	0.5625	2-7/16	1-1/16
18042	3/8	0.540	0.606	0.7000	2-9/16	1-1/16
18043	1/2	0.665	0.751	0.6875	3-1/8	1-3/8
18044	3/4	0.876	0.962	0.9063	3-1/4	1-3/8
18045	1	1.103	1.212	1.1250	3-1/4	1-3/4
18046	1-1/4	1.444	1.553	1.3125	4	1-3/4
18047	1-1/2	1.684	1.793	1.5000	4-1/4	1-3/4
18048	2	2.159	2.268	1.8750	4-1/2	1-3/4



Morse, Brown & Sharpe and Taper Reamers

Repairmen's Taper Reamers

HIGH SPEED STEEL - Straight Flute

651 Brace Shank, 103 T-Handle, 653 Round Shank



103 T-Handle

EDP Number 651-653	Point Diameter Inches	L.E. Diameter Inches	Length of Cut	Overall Length Inches	Shank Diameter Inches
Type I Bit Brace Shank					
04010	1/8	1/2	3-5/8	5-9/16	N/A
04011	3/8	1	4-1/2	6-1/2	N/A
Type II T-Handle Shank					
04000	1/8	3/8	3-5/8	5-9/16	11/32
04001	1/8	1/2	3-5/8	5-9/16	3/8
04002	3/8	3/4	3-5/8	5-9/16	1/2
Type III Round Shank					
04013	1/8	1/2	3-5/8	5-9/16	3/8
04014	3/8	1	4-1/2	6-1/2	1/2

Repairmen's Deburring Reamers

HIGH SPEED STEEL - Left Hand Spiral, Right Hand Cut

661 Brace Shank, 662 T-Handle, 663 Round Shank



661 Brace Shank



662 T-Handle



663 Round Shank

EDP Number 661-663	Point Diameter Inches	L.E. Diameter Inches	Length of Cut	Overall Length Inches	Shank Diameter Inches	Pipe Capacity
Type I Bit Brace Shank						
04020	3/16	47/64	1-3/8	3-35/64	N/A	1/8-1/2
04021	3/16	1-1/4	2-7/8	5-3/64	N/A	1/8-1
04022	1/4	1-15/32	3	5	N/A	1/4-1-1/4
04023	1/4	2-17/64	3-7/8	5-7/8	N/A	1/4-2
Type II T-Handle Shank						
04024	1/4	2-17/64	3-7/8	5-7/8	1-7/16	1/4-2
04025	1-1/2	3-5/8	3-7/8	5-7/8	1-1/2	1-1/2-3-1/2
Type III Round Shank						
04027	1/4	1-15/32	3	5	1/2	1/4-1-1/4
04028	1/4	2-17/64	3-7/8	5-7/8	1/2	1/4-2

Core Drills

HIGH SPEED STEEL - Straight Shank, 4 Flutes

8001 Right Hand Spiral, Right Hand Cut



EDP Number 8001	Size	Decimal Equiv. Inches	Flute Size Inches	Overall Length Inches
47000	1/8	0.1250	2-3/4	5-1/8
47001	9/64	0.1406	3	5-3/8
47002	5/62	0.1562	3	5-3/8
47003	11/64	0.1719	3-3/8	5-3/4
47004	3/16	0.1875	3-3/8	5-3/4
47005	13/64	0.2031	3-5/8	6
47006	7/32	0.2187	3-5/8	6
47007	15/64	0.2344	3-3/4	6-1/8
47008	1/4	0.2500	3-3/4	6-1/8
47009	17/64	0.2656	3-3/4	6-1/8
47010	9/32	0.2812	3-7/8	6-1/4
47011	19/64	0.2969	3-7/8	6-1/4
47012	5/16	0.3125	4	6-3/8
47013	21/64	0.3281	4	6-3/8
47014	11/32	0.3438	4-1/8	6-1/2
47015	23/64	0.3594	4-1/8	6-1/2
47016	3/8	0.3750	4-1/8	6-3/4
47017	25/64	0.3906	4-1/8	6-3/4
47018	13/32	0.4062	4-3/8	7
47019	27/64	0.4219	4-3/8	7
47020	7/16	0.4375	4-5/8	7-1/4
47021	29/64	0.4531	4-5/8	7-1/4
47022	15/32	0.4688	4-3/4	7-1/2
47023	31/64	0.4844	4-3/4	7-1/2
47024	1/2	0.5000	4-3/4	7-3/4

EDP Number 8001	Size	Decimal Equiv. Inches	Flute Size Inches	Overall Length Inches
47025	17/32	0.5312	4-3/4	8
47026	9/16	0.5625	4-7/8	8-1/4
47027	19/32	0.5937	4-7/8	8-3/4
47028	5/8	0.6250	4-7/8	8-3/4
47029	21/32	0.6562	5-1/8	9
47030	11/16	0.6875	5-3/8	9-1/4
47031	23/32	0.7187	5-5/8	9-1/2
47032	3/4	0.7500	5-7/8	9-3/4
47033	25/32	0.7812	6	9-7/8
47034	13/16	0.8125	6-1/8	10
47035	27/32	0.8437	6-1/8	10
47036	7/8	0.8750	6-1/8	10
47037	29/32	0.9062	6-1/8	10
47038	15/16	0.9375	6-1/8	10-3/4
47039	31/32	0.9687	6-3/8	11
47040	1	1.0000	6-3/8	11
47041	1-1/32	1.0312	6-1/2	11-1/8
47042	1-1/16	1.0625	6-5/8	11-1/4
47043	1-3/32	1.0937	6-7/8	11-1/4
47044	1-1/8	1.1250	7-1/8	11-3/4
47045	1-5/32	1.1562	7-1/4	11-7/8
47046	1-3/16	1.1875	7-3/8	12
47047	1-7/32	1.2187	7-1/2	12-1/8
47048	1-1/4	1.2500	7-7/8	12-1/2

Threaded Shank Core Drills

HIGH SPEED STEEL - 965-1

Long Series, Threaded Shank Core Drills

Piloted, 18 Degree Helix



EDP Number 965-1	Size Range Inches	Overall Length Inches	Min. Pilot Dia. Inches	Thread Length Inches	Hex Size Inches
21400	.1500-.1632	2-1/8	0.117	.250	5/16
21401	.1633-.1789	2-1/8	0.128	.250	5/16
21402	.1790-.1945	2-1/8	0.140	.250	5/16
21403	.1946-.2101	2-1/8	0.152	.250	5/16
21404	.2102-.2258	2-1/8	0.163	.250	5/16
21405	.2259-.2414	2-1/8	0.175	.250	5/16
21406	.2415-.2570	2-1/8	0.187	.250	5/16
21407	.2571-.2720	2-1/8	0.198	.250	5/16
21408	.2721-.2880	2-1/8	0.211	.250	5/16
21409	.2881-.3040	2-1/8	0.222	.250	5/16
21410	.3041-.3190	2-1/8	0.234	.250	5/16
21411	.3191-.3350	2-1/8	0.246	.250	3/8
21412	.3351-.3479	2-1/8	0.257	.250	3/8
21413	.3480-.3660	2-1/8	0.269	.250	3/8
21414	.3661-.3820	2-1/8	0.281	.250	3/8
21415	.3821-.3980	2-1/8	0.292	.250	1/2
21416	.3981-.4129	2-1/8	0.304	.250	1/2

Threaded Shank Core Drills

HIGH SPEED STEEL - 969-1

Extra Long Series, Threaded Shank Core Drills

Piloted, 18 Degree Helix



EDP Number 969-1	Size Range Inches	Overall Length Inches	Min. Pilot Dia. Inches	Thread Length Inches	Hex Size Inches
21500	.1500-.1632	3-1/8	0.117	.250	5/16
21501	.1633-.1789	3-1/8	0.128	.250	5/16
21502	.1790-.1945	3-1/8	0.140	.250	5/16
21503	.1946-.2101	3-1/8	0.152	.250	5/16
21504	.2102-.2258	3-1/8	0.163	.250	5/16
21505	.2259-.2414	3-1/8	0.175	.250	5/16
21506	.2415-.2570	3-1/8	0.187	.250	5/16
21507	.2571-.2720	3-1/8	0.198	.250	5/16
21508	.2721-.2880	3-1/8	0.211	.250	5/16
21509	.2881-.3040	3-1/8	0.222	.250	5/16
21510	.3041-.3190	3-1/8	0.234	.250	5/16
21511	.3191-.3350	3-1/8	0.246	.250	3/8
21512	.3351-.3479	3-1/8	0.257	.250	3/8
21513	.3480-.3660	3-1/8	0.269	.250	3/8
21514	.3661-.3820	3-1/8	0.281	.250	3/8
21515	.3821-.3980	3-1/8	0.292	.250	1/2
21516	.3981-.4129	3-1/8	0.304	.250	1/2



300 Series

307 Series, TIN Coated

Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute, Straight Shank

1/32 Oversize

30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting

300 Series (1/32 Oversize)
307 Series, TIN Coated (1/32 Oversize)

EDP Number 300	EDP Number 307	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Shank Diameter Inches	Overall Length Inches
03002	33002	4-40	0.1430	5/32	0.2180	11/16	.1562	3-7/8
03005	33005	5-40	0.1560	3/16	0.2370	11/16	.1875	4-1/8
03008	33008	6-32	0.1690	7/32	0.2600	7/8	.2188	4-5/8
03011	33011	8-32	0.1950	1/4	0.3040	15/16	.2500	5
03014	33014	10-32	0.2210	9/32	0.3460	1-1/8	.2812	5-1/4
03017	33017	1/4	0.2810	5/16	0.4140	1-5/16	.3125	5-5/8
03020	33020	5/16	0.3430	3/8	0.5070	1-5/16	.3750	6-1/8
03023	33023	3/8	0.4060	1/2	0.6040	1-5/8	.5000	6-1/2
03026	33026	7/16	0.4680	1/2	0.6950	1-11/16	.5000	7
03029	33029	1/2	0.5310	1/2	0.7890	2	.5000	7-1/2
03032	33032	5/8	0.6560	5/8	0.9770	2	.6250	7-5/8
03035	33035	3/4	0.7810	3/4	1.1650	2-1/8	.7500	7-3/4
03038	33038	7/8	0.9060	7/8	1.3540	2-1/8	.8750	8-1/8
03041	33041	1	1.0310	1	1.5420	2-1/4	1.0000	8-1/2

Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute, Straight Shank

1/64 Oversize

30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting

400 Series (1/64 Oversize)
407 Series, TIN Coated (1/64 Oversize)

EDP Number 400	EDP Number 407	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Shank Diameter Inches	Overall Length Inches
03001	33001	4-40	0.1270	5/32	0.2020	11/16	.1562	3-7/8
03004	33004	5-40	0.1400	3/16	0.2210	11/16	.1875	4-1/8
03007	33007	6-32	0.1530	7/32	0.2440	7/8	.2188	4-5/8
03010	33010	8-32	0.1790	1/4	0.2880	15/16	.2500	5
03013	33013	10-32	0.2050	9/32	0.3300	1-1/8	.2812	5-1/4
03016	33016	1/4	0.2650	5/16	0.3980	1-5/16	.3125	5-5/8
03019	33019	5/16	0.3280	3/8	0.4910	1-5/16	.3750	6-1/8
03022	33022	3/8	0.3900	1/2	0.5880	1-5/8	.5000	6-1/2
03025	33025	7/16	0.4520	1/2	0.6790	1-11/16	.5000	7
03028	33028	1/2	0.5150	1/2	0.7730	2	.5000	7-1/2
03031	33031	5/8	0.6400	5/8	0.9610	2	.6250	7-5/8
03034	33034	3/4	0.7650	3/4	1.1490	2-1/8	.7500	7-3/4
03037	33037	7/8	0.8910	7/8	1.3380	2-1/8	.8750	8-1/8
03040	33040	1	1.0150	1	1.5260	2-1/4	1.0000	8-1/2

Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute, Straight Shank

500 Series (On Size)
507 Series, TiN Coated (On Size)

On Size
30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting



EDP Number 500	EDP Number 507	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Shank Diameter Inches	Overall Length Inches
03000	33000	4-40	0.1120	5/32	0.1860	11/16	0.1562	3-7/8
03003	33003	5-40	0.1250	3/16	0.2050	11/16	0.1875	4-1/8
03006	33006	6-32	0.1380	7/32	0.2280	7/8	0.2188	4-5/8
03009	33009	8-32	0.1640	1/4	0.2720	15/16	0.2500	5
03012	33012	10-32	0.1900	9/32	0.3140	1-1/8	0.2812	5-1/4
03015	33015	1/4	0.2500	5/16	0.3820	1-5/16	0.3125	5-5/8
03018	33018	5/16	0.3125	3/8	0.4750	1-5/16	0.3750	6-1/8
03021	33021	3/8	0.3750	1/2	0.5720	1-5/8	0.5000	6-1/2
03024	33024	7/16	0.4375	1/2	0.6630	1-11/16	0.5000	7
03027	33027	1/2	0.5000	1/2	0.7570	2	0.5000	7-1/2
03030	33030	5/8	0.6250	5/8	0.9450	2	0.6250	7-5/8
03033	33033	3/4	0.7500	3/4	1.1330	2-1/8	0.7500	7-3/4
03036	33036	7/8	0.8750	7/8	1.3220	2-1/8	0.8750	8-1/8
03039	33039	1	1.0000	1	1.5100	2-1/4	1.0000	8-1/2

Metric Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute, Straight Shank

401 Series (Metric)
471 Series, TiN Coated (Metric)

Metric
30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting

EDP Number 401	EDP Number 471	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Shank Diameter Inches	Overall Length Inches
03080	33080	3mm	0.1378	0.2180	0.2362	7/8	0.1875	4-1/2
03081	33081	4mm	0.1772	0.2500	0.2953	15/16	0.2500	5
03082	33082	5mm	0.2165	0.2810	0.3543	1-1/8	0.3125	5-5/8
03083	33083	6mm	0.2559	0.3120	0.4134	1-5/16	0.3125	5-5/8
03084	33084	8mm	0.3346	0.3750	0.5315	1-5/16	0.5000	6-1/2
03085	33085	10mm	0.4134	0.5000	0.6496	1-11/16	0.5000	7
03086	33086	12mm	0.4921	0.5000	0.7283	1-11/16	0.5000	7-1/8
03087	33087	14mm	0.5709	0.5620	0.8465	2	0.6250	7-1/2
03088	33088	16mm	0.6496	0.6250	0.9646	2	0.6250	7-5/8
03089	33089	20mm	0.8071	0.7500	1.2008	2-1/8	0.8750	8-1/8



350 Series, Taper Shank

Taper Shank Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute

1/32 Oversize

30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting

350 Series (1/32 Oversize)

EDP Number 350	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Morse Taper Shank	Overall Length Inches
03102	4-40	0.1430	5/32	0.2180	11/16	1	5-15/16
03105	5-40	0.1560	3/16	0.2370	11/16	1	6-3/16
03108	6-32	0.1690	7/32	0.2600	7/8	1	6-11/16
03111	8-32	0.1950	1/4	0.3040	15/16	1	7-1/16
03114	10-32	0.2210	9/32	0.3460	1-1/8	1	7-5/16
03117	1/4	0.2810	5/16	0.4140	1-5/16	1	7-11/16
03120	5/16	0.3430	3/8	0.5070	1-5/16	1	8
03123	3/8	0.4060	1/2	0.6040	1-5/8	2	9
03126	7/16	0.4680	1/2	0.6950	1-11/16	2	9
03129	1/2	0.5310	1/2	0.7890	2	2	9-1/2
03132	5/8	0.6560	5/8	0.9770	2	3	10-1/2
03135	3/4	0.7810	3/4	1.1650	2-1/8	3	11
03138	7/8	0.9060	7/8	1.3540	2-1/8	4	12
03141	1	1.0310	1	1.5420	2-1/4	4	12-1/2

Metric Taper Shank Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Helical Flute

Metric

30 Degree Right Hand Spiral, 4 Flutes
Designed for Fast Feeds and Easy Cutting

420 Series (Metric)

EDP Number 350	Size	Pilot Diameter Inches	Pilot Length Inches	Flute Size Inches	Flute Length Inches	Morse Taper Shank	Overall Length Inches
53180	3mm	0.1378	0.2180	0.2362	7/8	1MT	6-9/16
53181	4mm	0.1772	0.2500	0.2953	15/16	1MT	7-1/16
53182	5mm	0.2165	0.2810	0.3543	1-1/8	1MT	7-11/16
53183	6mm	0.2559	0.3120	0.4134	1-5/16	1MT	7-11/16
53184	8mm	0.3346	0.3750	0.5315	1-5/16	1MT	8
53185	10mm	0.4134	0.5000	0.6496	1-11/16	2MT	9
53186	12mm	0.4921	0.5000	0.7283	1-11/16	2MT	9
53187	14mm	0.5709	0.5620	0.8465	2	2MT	9-1/2
53188	16mm	0.6496	0.6250	0.9646	2	3MT	10-1/2
53189	20mm	0.8071	0.7500	1.2008	2-1/8	3MT	11
53190	24mm	0.9646	0.8750	1.4370	2-1/4	4MT	12

Capscrew Counterbore Sets

HIGH SPEED STEEL - Right Hand Cut, Helical Flute

300 Series (1/32 Oversize)
400 Series (1/64 Oversize)
500 Series (On Size)
401 Series (Metric)

307 Series (1/32 Oversize), TiN Coated
407 Series (1/64 Oversize), TiN Coated
507 Series (On Size), TiN coated
471 Series (Metric), TiN Coated



EDP Number Sets	EDP Number Coated	Range	Number of Tools	Standard Series Number	Coated Series Number
29130	29140	4-40 thru 1/2	10	300	307
29131	29141	4-40 thru 1/2	10	400	407
29132	29142	4-40 thru 1/2	10	500	507
29133	29143	3mm thru 14mm	8	401	471

Adjustable Blade Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut
Straight Shank



Adjustable Blade, Straight Shank

EDP Number	Part Number	Hole Diameter Range	Shank Size	Pilot Hole Diameter	Replacement Blade Number
61000	C-ACBSS-01	1-1-1/4	1/2	7/16	01
61001	C-ACBSS-02	1-1/4-1-5/8	1/2	9/16	02
61002	C-ACBSS-03	1-5/8-2-1/8	1	5/8	03
61003	C-ACBSS-04	2-1/8-2-7/8	1-1/2	3/4	04

Adjustable Blade Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut,
Taper Shank



Adjustable Blade, Taper Shank

EDP Number	Part Number	Hole Diameter Range	Shank Size	Pilot Hole Diameter	Replacement Blade Number
61004	C-ACBTS-01	1-1-1/4	2MT	7/16	01
61005	C-ACBTS-02	1-1/4-1-5/8	2MT	9/16	02
61006	C-ACBTS-03	1-1/4-1-5/8	3MT	9/16	02
61007	C-ACBTS-04	1-5/8-2-1/8	3MT	5/8	03
61008	C-ACBTS-05	2-1/8-2-7/8	3MT	3/4	04
61009	C-ACBTS-06	2-7/8-4	4 MT	1	05

Replacement Blades Capscrew Counterbores

HIGH SPEED STEEL - Right Hand Cut,
For Use With Adjustable Blade Capscrew Counterbores



EDP Number Blades	Part Number	Description of Replacement Blades
60150	ACBRB-01	Counterbore Blades-01
60152	ACBRB-02	Counterbore Blades-02
60154	ACBRB-03	Counterbore Blades-03
60156	ACBRB-04	Counterbore Blades-04
60158	ACBRB-05	Counterbore Blades-05



Chucking Reamer Sets

HIGH SPEED STEEL
897-A Sets

EDP Number 897-A	List Number	Range	Number of Reamers	Type Case	Flute
09050	897-A-01	1/16 thru 1/4 by 1/64	13	Steel	RH Spiral
09051	897-A-02	1/16 thru 1/2 by 1/64	29	Steel	RH Spiral
09052	897-A-03	1/16 thru 1/2 by 1/64	29	Steel	LH Spiral
09053	897-A-04	1/16 thru 1/4 by 1/64	13	Steel	Straight
09054	897-A-05	1/16 thru 1/2 by 1/64	29	Steel	Straight
09055	897-A-06	1/16 thru 1/4 by 1/64	13	Steel	LH Spiral
09056	897-A-07	1/16 thru 3/8 by 1/64	21	Steel	Straight
09057	897-A-08	1/16 thru 3/8 by 1/64	21	Steel	RH Spiral
09058	897-A-09	1/16 thru 1/2 by 1/32	15	Steel	Straight
09059	897-A-10	1/16 thru 1/2 by 1/32	15	Steel	RH Spiral
09060	897-A-11	#1 thru #60	60	Steel	RH Spiral
09061	897-A-12	#1 thru #60	60	Steel	LH Spiral
09062	897-A-13	#1 thru #60	60	Steel	Straight
09063	897-A-14	A thru Z	26	Steel	RH Spiral
09064	897-A-15	A thru Z	26	Steel	LH Spiral
09065	897-A-16	A thru Z	26	Steel	Straight
09066	897-A-17	over/under .1240-.5010	14	Steel	RH Spiral
09067	897-A-18	over/under .1240-.5010	14	Steel	LH Spiral
09068	897-A-19	over/under .1240-.5010	14	Steel	Straight
09069	897-A-20	Dowel Pin .1230-.4995	14	Steel	Straight
09070	897-A-21	Dowel Pin .1230-.4995	14	Steel	RH Spiral
09071	897-A-22	Dowel Pin .1230-.4995	14	Steel	LH Spiral
09072	897-A-30	1-13mm by .5mm	25	Steel	Straight

Alvord-Polk Tool carries a large selection of reamer sets to address the needs of tool & die shops, repair facilities and field repairmen. If your requirements are not seen on these pages, call your Alvord-Polk Tool representative or Alvord-Polk Tool sales office and ask for a quotation to meet your needs.

Chucking Reamer Sets

Cobalt
897-B Sets

EDP Number 897-B	List Number	Range	Number of Reamers	Case	Flute
09152	897-B-04	1/16 thru 1/4 by 1/64	13	Steel	Straight
09153	897-B-05	1/16 thru 1/2 by 1/64	29	Steel	Straight
09156	897-B-07	1/16 thru 3/8 by 1/64	21	Steel	Straight
09158	897-B-09	1/16 thru 1/2 by 1/32	15	Steel	Straight
09162	897-B-13	#1 thru #60	60	Steel	Straight
09165	897-B-16	A thru Z	26	Steel	Straight
09168	897-B-19	over/under .1240-.5010	14	Steel	Straight
09169	897-B-20	Dowel Pin .1230-.4995	14	Steel	Straight
09172	897-B-30	1-13mm by .5mm	25	Steel	Straight

Taper Pin Reamer Sets

155-S Taper Pin



EDP Number 155-S	List Number	Range	Flute	Number of Reamers	Case
09080	155-S-01	#0-#10	STR	11	Wood
09081	155-S-02	#0-#10	LHS	11	Wood
09082	155-S-03	#0-#10	HELICAL	11	Wood
09083	155-S-04	7/0-#0	STR	7	Wood
09084	155-S-05	7/0-#0	LHS	7	Wood
09085	155-S-06	7/0-#0	HELICAL	7	Wood
09086	155-S-07	#0-#5	STR	6	Wood
09087	155-S-08	#0-#5	LHS	6	Wood
09088	155-S-09	#0-#5	HELICAL	6	Wood

Repairmen's Reamer Sets

103-S T-Handle
104-S File Handle



EDP Number Sets	List Number	Range	Flute	Number of Reamers	Case
09100	103-S	3/8,1/2,3/4	STR	3	Wood

Construction Reamer Sets

650-S Construction



EDP Number 650-S	List Number	Range	Flute	Number of Reamers	Case
09105	650-S-01	3/8,7/16,1/2	LHS	3	Wood
09106	650-S-02	3/8,7/16,1/2, 5/8,3/4,7/8,1	LHS	7	Wood
09107	650-S-03	1/2,5/8,3/4, & 1/4 drill	LHS	3	Wood

Taper Pipe Reamer Sets

207-S Taper Pipe



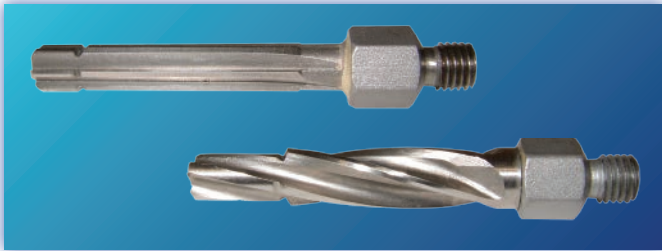
EDP Number 155-S	List Number	Range	Flute	Number of Reamers	Case
09120	207-S-01	1/8,1/4,3/8,1/2	LHS	4	Wood
09121	207-S-02	3/4,1,1-1/2	LHS	3	Wood

Specifications For Special Reamers and Core Drills

We Manufacture Aircraft Special Reamers and Core Drills

Some manufacturers shy away from these challenging tools that have demanding tolerances and complicated drawings. Alvord-Polk Tool has built its reputation for quality on just that type of work. Before we began manufacturing standards in volume, we were and still are a "Specials House." We enjoy working with engineers in developing solutions to reaming problems. These jobs take a little more time and special attention, but with an experienced work force the "special" is produced without a hitch.

Many variables will determine the reamer's performance. Speeds, feeds, rake, reliefs, material to be removed, stock removal, rigidity of the setup, and the condition of the machine used for the reaming all affect the potential performance of the custom reamer required.



With so many performance factors, it is critical that a capable manufacturer be chosen to produce your tooling. At Alvord-Polk Tool, quality is built into our tools, not added on. The process begins with the purchase of high quality steel produced in the United States. Experience proven salt bath heat treating gives our reamers their strength and superior wear characteristics. National aerospace standards are followed for geometric specifications. Flute diameter, O.D. relief, and chamfer relief are all ground between lapped centers. This provides consistent margin widths, concentricity between chamfer and O.D. and the capacity to resharpen between centers.

Reamers that are centerless ground to size do not exhibit the same uniformity of margin or the degree of concentricity between O.D. and chamfer as a reamer ground between centers. Furthermore, reamers centerless ground to size do not allow for easy size alterations or resharpening.

For over 130 years, Alvord-Polk Tool has provided excellence in the reamer industry. We're proud of the craftsmen that have made this possible and those craftsmen that will continue to keep our reputation for QUALITY intact into the next century.

Helpful Hints:

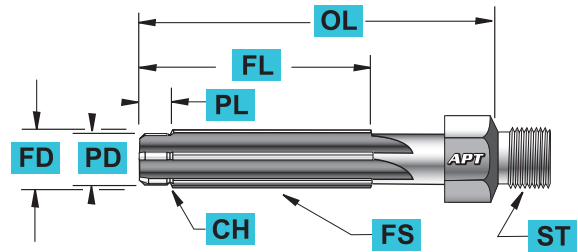
Our experienced engineering staff will be prompt in replying to your inquiries. Specifying only the tool requirements that you absolutely need for your reaming operation will allow us to provide the most economical price and best delivery schedule.

Listed below are some questions to consider prior to requesting a quotation. Flexibility on any of these points could save time and money on your tools.

- Could your requirement be met by altering a catalog tool?
- Could you be flexible on minimum or maximum flute length?
- Can you be flexible on the number of flutes?
- Can you be flexible on the shank diameter?
- Can you use either external or internal centers?
- Can you use a tool without centers?

Required Information:

To obtain the price of a "Special" or "Custom" Aircraft Reamer, simply provide the basic specifications. At a minimum, the following information is required:



- OL** Overall Length
- FL** Flute Length
- FD** Flute Diameter
- PL** Pilot Length
- PD** Pilot Diameter
- CH** Chamfer
- FS** Flute Spiral
- ST** Shank Type

Tool Material Type:

- High Speed Steel
- Cobalt (8%)
- Carbide (Solid)

Tool Geometry:

Flutes _____

	Diameter	Length
<input type="checkbox"/> Straight Flute	_____	_____
<input type="checkbox"/> Left Hand Spiral	_____	_____
<input type="checkbox"/> Right Hand Spiral	_____	_____

	Diameter	Length
<input type="checkbox"/> Pilot	_____	_____
<input type="checkbox"/> Cutting Pilot		<input type="checkbox"/> Non-Cutting Pilot

Shank _____

	Diameter	Thread Size
<input type="checkbox"/> Straight Flute	_____	
<input type="checkbox"/> Threaded Shank		<input type="checkbox"/> 1/4-28
		<input type="checkbox"/> 5/16-24
<input type="checkbox"/> Flats (2)	_____	
<input type="checkbox"/> Flats (3)	_____	
<input type="checkbox"/> Flats (4)	_____	
<input type="checkbox"/> Adapted Shanks		<input type="checkbox"/> Long
		<input type="checkbox"/> Short

Overall Length of Reamer _____

Special Notes:

Geometry not specified will conform to NAS 897 Specifications. Flute Diameter Tolerances, Concentricity and Hardness specifications are all NAS 897 unless otherwise specified.

Specifications For Special Reamers



Straight Flute



Right Hand Spiral



Left Hand Spiral



Piloted Flute

FLUTE SPECIFICATIONS

The greater the detail provided when requesting a special reamer, the greater our ability to provide the right tool for the job. The following flute specifications will allow us to provide an accurate and timely quotation.

- Flute Diameter
- Pilot Diameter
- Flute Length
- Pilot Length
- Cutting or Non-Cutting Pilot
- Number of Flutes
- Rake Angle
- Flute Depth
- Margin Diameter

If many of the listed items are unknown, we will quote using standard NAS 897 or 898 Specifications.

SHANK SPECIFICATIONS

The following shank specifications will allow us to provide an accurate and timely quotation.

- Shank Diameter
- Shank Type
- Shank Hardness
- Shank Finish
- One or Two Piece Construction
- Overall Tool Length

If many of the listed items are unknown, we will quote using standard NAS 897 or 898 Specifications.

Straight Shank



Threaded Shank (1/4-28 Hex)



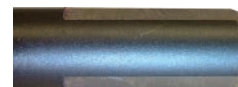
Threaded Shank (5/16-24 Hex)



Flats (2)



Flats (3)



Flats (4)/Square



Adapted Long Shank



Adapted Short Shank



Ordering Custom Cutting Tools

The production of superior custom cutting tools depends upon the skill of the manufacturer. There are many factors to be considered in order to determine the final specifications.

This portion of our catalog has been designed to serve as a guide and a checklist to assure that any cutting tool required for special applications is of the highest quality and performance.

We suggest you read through the following information carefully before placing your order.

If you find that you need additional information, quotations or samples, please call or e-mail.

Specifications

The ten specifications listed below are provided as a checklist for ordering custom tools. When these specifications are not available, cutting tools are manufactured according to NAS 897 or NAS 898 standards and Alvord-Polk Tool specifications.

1. Reamer diameter
2. Overall length
3. Flute length
4. Shank diameter and style
5. Number of flutes
6. Straight or spiral flutes (if spiral flutes, specify helix)
7. Hand of cut
8. Pilot diameter and length
9. End feature configuration (see styles 1 thru 4)
10. Tang thickness and length

Variables

The following variables will determine a reamer's performance.

1. Speeds
2. Feeds
3. Rake
4. Relief
5. Material to be removed
6. Stock removal
7. Rigidity of the set-up
8. The condition of the machine used for the reaming

With the variables listed above it is possible to evaluate the potential performance of the custom reamer you have in mind. We offer the following suggestions as points of departure for your specific job.

Speeds

Speeds listed below are suggested as a guide only. Each set-up may differ depending upon final application.

Material	SFM
Aluminum	230
Brass & ordinary brass	165
Bronze, high tensile	60
Cast iron, chilled	25
Cast iron, hard	60
Cast iron, soft	85
Magnesium	230
Monel metal	30
Plastics	85
Stainless steel	25-30
Steel, alloy	35
300-400 Brinell	25
Steel, annealed	45
Steel, forgings	35
Steel machinery	60
Steel, high tensile	20-25
Titanium	25

Feeds

When reaming, a good starting point for establishing your feed rate would be .0025" to .003" per flute per revolution. See trouble shooting guide for problems resulting from improper feed rates.

Suggested Rake Angles

Materials	Rake (in degrees)
Aluminum	6-8
Brass	3-5
Bronze	2-4
Cast Iron	0-3
Magnesium	6-8
Malleable iron	3-5
Monel metal	3-5
Plastics	0-3
Stainless steel	6-8
Steel	3-5
Titanium	3-5

Ordering Custom Cutting Tools

Stock Removal

Machine Reaming

To 3/32"	.003-.006
Above 3/32" to 1/4" incl.	.008-.010
Above 1/4" to 1/2" incl.	.012-.015
Above 1/2" to 1" incl.	.017-.020
Above 1" to 2" incl.	.020-.025
Above 2"	.030-.035

Hand Reaming

All Sizes	.002-.004
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Performance Factors

The prime functions to be considered in evaluating the performance of a reamer are:

1. The reamer's ability to produce a reamed hole within the specified tolerance.
2. The reamer's ability to produce the finish necessary in the reamed hole.

Trouble-Shooting Guide

Hole Oversized

- a. improper size reamer
- b. misalignment of reamer to hole
- c. spindle or holder runs out
- d. drilled hole too large: not enough stock for removal on all sides
- e. feed rate too high
- f. speed too low

Hole Egg Shaped

- a. misalignment of reamer to hole
- b. spindle or holder runs out
- c. set-up not rigid enough
- d. hole drilled off center with not enough stock for removal from all sides

Hole Bell Shaped

- a. misalignment of reamer to hole
- b. spindle or holder runs out
- c. set-up not rigid enough

Hole Glazed

- a. feed rate too low
- b. speed rate too high
- c. improper coolant flow

Hole Chattered

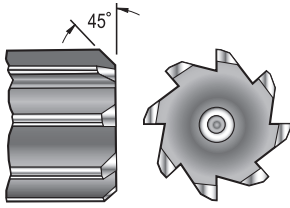
- a. uneven lip height on reamer
- b. improper speed
- c. improper feed
- d. misalignment of reamer to hole
- e. spindle or holder runs out
- f. set-up not rigid enough
- g. improper coolant flow

Reamer Broken

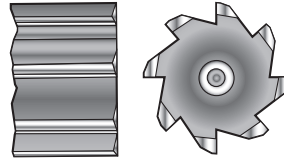
- a. reamer bottomed in blind hole
- b. too much stock removal
- c. excessive feed rate
- d. excessive speed rate
- e. improper coolant flow
- f. lack of space in reamer for chip flow



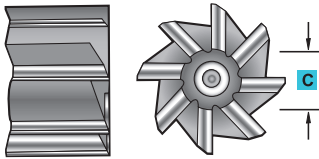
Specifications for End-Cutting Reamers



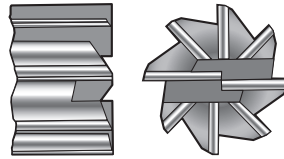
STYLE NO. 1
End Cutting on 45 Degree Chamfer, Standard Reamer Chamfer



STYLE NO. 2
180 Degree End Cutting to Bottom of Flute



STYLE NO. 3
180 Degree End Cutting to Diameter C

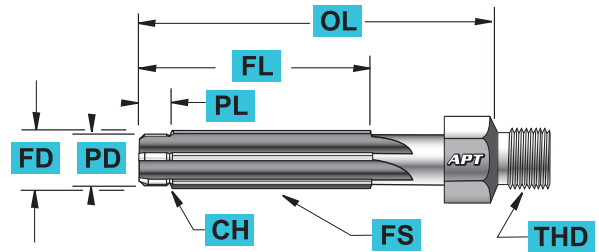


STYLE NO. 4
180 Degree End Cut Across Center

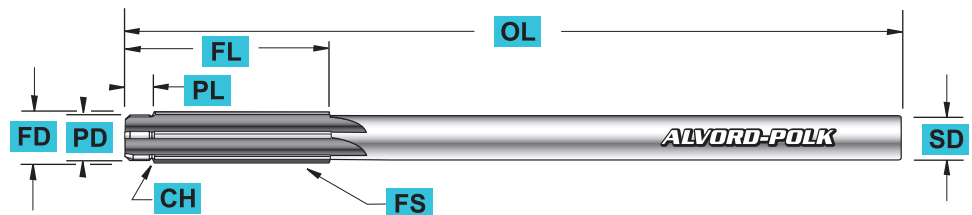
Specifications for Special Reamers

- OL** Overall Length
- FL** Flute Length
- FD** Flute Diameter
- FS** Flute Spiral
- PL** Pilot Length
- PD** Pilot Diameter
- TF** Taper per Foot
- SE** Small End Diameter
- LE** Large End Diameter
- CH** Chamfer
- SD** Shank Diameter
- THD** Thread Shank Style
- MTS** Morse Taper Shank

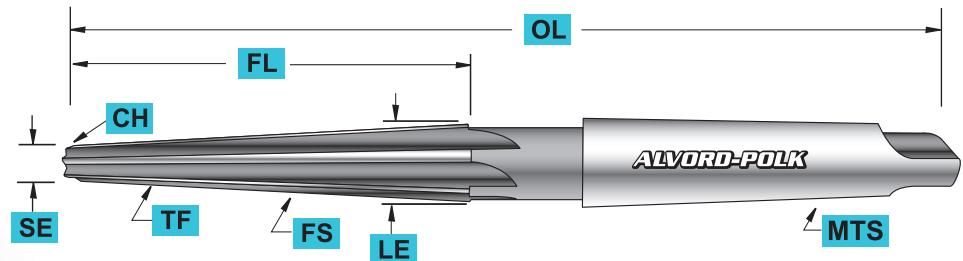
Piloted Threaded Shank Reamer



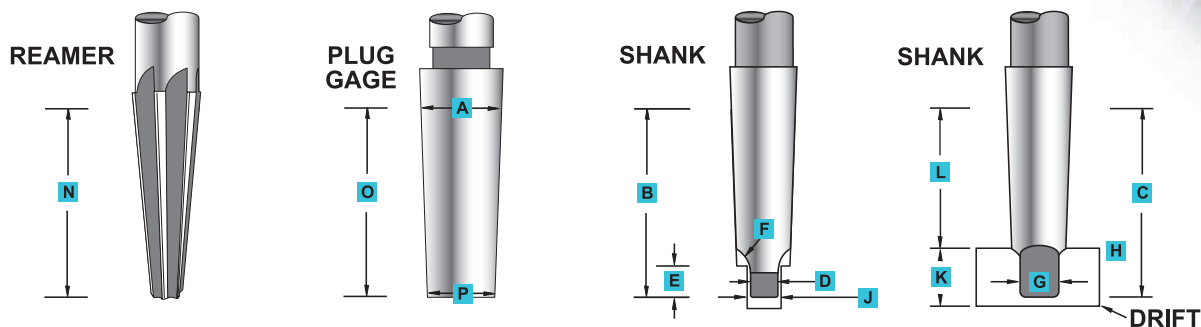
Piloted Chucking Reamer



Tapered Reamer with Taper Shank



Detailed Dimensions of Shank and Sockets



American Standard Tapers (Morse)

Number of Taper (#)	Dia. of Plug at Small End	Dia. at Gage Line	SHANK		Depth of Reamed Hole	Standard Plug Depth	TANG					TANG SLOT		End of Socket to Tang Slot	Taper per Inch (T/in.)	Taper per Foot (T/ft.)
			Whole Length	Depth			Thickness	Length	Radius	Diameter	Radius	Width	Length			
	P	A	B	C	N	O	D	E	F	G	H	J	K	L		
0	.252	.356	2-11/32	2-7/32	2-1/32	2	.156	1/4	5/32	15/64	3/64	.166	9/16	1-15/16	.052000	.62400
1	.369	.475	2-9/16	2-7/16	2-5/32	2-1/8	.203	3/8	3/16	11/32	3/64	.213	3/4	1-1/16	.049882	.59858
2	.572	.700	3-1/8	2-15/16	2-39/64	2-9/16	.250	7/16	1/4	17/32	1/16	.260	7/8	2-1/2	.049951	.59941
3	.778	.938	3-7/8	3-11/16	3-1/4	3-3/16	.312	9/16	9/32	23/32	5/64	.322	1-3/16	3-1/16	.050196	.60235
4	1.020	1.231	4-7/8	4-5/8	4-1/8	4-1/16	.469	5/8	5/16	31/32	3/32	.479	1-1/4	3-7/8	.051938	.62326
5	1.475	1.748	6-1/8	5-7/8	5-1/4	5-3/16	.625	3/4	3/8	1-13/32	1/8	.635	1-1/2	4-15/16	.052626	.63151
6	2.116	2.494	8-9/16	8-1/4	7-21/64	7-1/4	.750	1-1/8	1/2	2	5/32	.760	1-3/4	7	.052137	.62565
7	2.750	3.270	11-5/8	11-1/4	10-5/64	10	1.125	1-3/8	3/4	2-5/8	3/16	1.135	2-5/8	9-1/2	.052000	.62400

Brown & Sharpe Tapers

#	P	A	B	C	N	O	D	E	F	G	H	J	K	L	T/in.	T/ft.
*4	.3500	.4023	1-3/4	1-21/32	1-3/8	1-1/4	7/32	11/32	5/16	.320	.050	.228	11/16	1-13/64	.0419	.5024
*5	.4500	.5231	2-9/32	2-3/16	1-7/8	1-3/4	1/4	3/8	5/16	.420	.060	.260	3/4	1-11/16	.0418	.5016
*6	.5000	.5996	2-31/32	2-7/8	2-1/2	2-3/8	9/32	7/16	5/16	.460	.060	.291	7/8	2-19/64	.0419	.5033
7.	.6000	.7254	3-5/8	3-17/32	3-1/8	3	5/16	15/32	3/8	.560	.070	.322	15/16	2-29/32	.0418	.5015
8	.7500	.8987	4-1/4	4-1/8	3-11/16	3-9/16	11/32	1/2	3/8	.710	.080	.353	1	3-29/64	.0418	.5010
9	.9001	1.0670	4-3/4	4-5/8	4-1/8	4	3/8	9/16	7/16	.860	.100	.385	1-1/8	3-7/8	.0417	.5008
10	1.0446	1.2892	6-17/32	6-13/32	5-13/16	5-11/16	7/16	21/32	7/16	1.010	.110	.447	1-5/16	5-17/32	.0430	.5161
11	1.2500	1.5318	7-19/32	7-15/32	6-7/8	6-3/4	7/16	21/32	1/2	1.210	.130	.447	1-5/16	6-19/32	.0418	.5010
12	1.5001	1.7968	8-1/16	7-15/16	7-1/4	7-1/8	1/2	3/4	1/2	1.460	.150	.510	1-1/2	6-15/16	.0416	.4997
13	1.7500	2.0730	8-11/16	8-9/16	7-7/8	7-3/4	1/2	3/4	5/8	1.710	.170	.510	1-1/2	7-9/16	.0417	.5002
14	2.0000	2.3437	9-9/32	9-5/32	8-3/8	8-1/4	9/16	27/32	3/4	1.960	.190	.572	1-11/16	8-1/32	.0417	.5000
15	2.2500	2.6146	9-25/32	9-21/32	8-7/8	8-3/4	9/16	27/32	7/8	2.210	.210	.572	1-11/16	8-17/32	.0417	.5000
16	2.5000	2.8854	10-3/8	10-1/4	9-3/8	9-1/4	5/8	15/16	1	2.450	.230	.635	1-7/8	9	.0417	.5000
17	2.7500	3.1562	-	-	9-7/8	9-3/4	-	-	-	-	-	-	-	-	.0417	.5000
18	3.0000	3.4271	-	-	10-3/8	10-1/4	-	-	-	-	-	-	-	-	.0417	.5000

*No. 4, No. 5, No. 6 Brown & Sharpe Taper Shanks usually made without tang.

Comply With Accepted Safety Requirements

While all Alvord-Polk Tool tooling is manufactured to exacting specification designed to provide safe, optimum life under normal usage, it is important for the user to adhere to generally accepted tool use practices. The most important practice is safety.

1. Wear Safety glasses or shield when performing any drilling or reaming operations.
2. Do not exceed generally accepted feeds and speeds of any cutting tool.

Safety and Warranty Information

Limited Warranty

Alvord-Polk Tool does not give any warranty on its products, except as follows:

Alvord-Polk Tool warrants to original equipment manufacturers, distributors and industrial and commercial users of its products that each new product which it manufactures or supplies is free from defects in material and workmanship. Its sole obligation under this warranty is limited to furnishing, without additional charge, a replacement for, or, at our option, repairing or issuing credit for such product which shall, within 30 days from the date of sale by Alvord-Polk Tool, be returned freight prepaid to the plant designated by an Alvord-Polk Tool representative and which, upon inspection, is determined by Alvord-Polk Tool to be defective in materials or workmanship. The provisions of this warranty shall not apply to any product which has been subjected to misuse, improper operating conditions, machine setup or which has been repaired or altered, if such would adversely affect performance of the product. Complete written information with respect to all such matters must be furnished to Alvord-Polk Tool as a prerequisite to its consideration of any claim or complaint under this warranty. The repair, replacement or issuance of credit for parts provided for this warranty constitutes the Buyer's EXCLUSIVE REMEDY.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Alvord-Polk Tool shall have no liability or responsibility on any claim of any kind, whether in contract, tort, or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein. IN NO EVENT SHALL ALVORD-POLK TOOL BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Alvord-Polk Tool makes no other warranty, express or implied, except as set forth above: and Alvord-Polk Tool neither assumes nor authorizes any other person or entity to assume for it any other obligation or liability in connection with any of its products.



Aerospace Tooling



Automotive Tooling



Industrial Tooling

Aircraft Quality Reamers
and Special Tooling

Alvord-Polk Quality

Our product offering has changed significantly over the years and so has our catalog. We have added a NAS898

Solid Carbide Standard Reamer series of tools and have significantly increased our special decimal size offering of our 827-0 Solid



Carbide series. Both lines are manufactured from a quality NAS898 compliant micro grain carbide substrate.

We have added several lines of standard piloted reamers to our offering as well. Next day availability has become critical to serve the growing needs of our aerospace customers. A Piloted Straight Flute, Straight Shank Chucking Reamer and also a Piloted 1/4-28 Threaded Shank Chucking Reamer series are now available as standards.

One change is our 127 and 128 Standard Chucking Reamer series to NAS897 nomenclature. The former 127 and 128 Series are fully compliant to the NAS897 specifications and we felt it's marking and designation should be as well.

Your business is important to us and we will do our best each and every time you order to provide you with the highest quality cuttings tools available...Aircraft Quality!





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Aircraft Quality Reamers and Special Tooling