

# HIGH SPEED STEEL CHUCKING REAMERS - STRAIGHT SHANK

ICS

WIS

GENERAL PURPOSE

RIGHT HAND CUT



STRAIGHT FLUTE

## Wire Gauge Sizes (Straight Shank) #1 To #60 Dia.

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	HSS CRSF
1	.2280	.2173	1-1/2	6	\$14.70
2	.2210	.2173	1-1/2	6	14.70
3	.2130	.2075	1-1/4	5	14.70
4	.2090	.2016	1-1/4	5	14.70
5	.2055	.2016	1-1/4	5	14.70
6	.2040	.1945	1-1/4	5	14.70
7	.2010	.1945	1-1/4	5	14.70
8	.1990	.1895	1-1/4	5	14.70
9	.1960	.1895	1-1/4	5	14.70
10	.1935	.1860	1-1/4	5	14.70
11	.1910	.1860	1-1/4	5	14.70
12	.1890	.1805	1-1/8	4-1/2	12.50
13	.1850	.1805	1-1/8	4-1/2	13.76
14	.1820	.1755	1-1/8	4-1/2	13.76
15	.1800	.1755	1-1/8	4-1/2	13.76
16	.1770	.1704	1-1/8	4-1/2	12.50
17	.1730	.1645	1-1/8	4-1/2	12.50
18	.1695	.1595	1-1/8	4-1/2	11.68
19	.1660	.1595	1-1/8	4-1/2	11.68
20	.1610	.1530	1-1/8	4-1/2	11.68
21	.1590	.1530	1-1/8	4-1/2	11.56
22	.1570	.1510	1	4	11.56
23	.1549	.1460	1	4	11.56
24	.1520	.1460	1	4	11.56
25	.1490	.1430	1	4	11.56
26	.1470	.1430	1	4	11.56
27	.1440	.1350	1	4	11.72
28	.1405	.1350	1	4	11.72
29	.1360	.1275	1	4	11.56
30	.1285	.1190	7/8	3-1/2	8.76

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	HSS CRSF
31	.1200	.1120	7/8	3-1/2	\$9.78
32	.1160	.1120	7/8	3-1/2	9.78
33	.1130	.1055	7/8	3-1/2	9.78
34	.1110	.1055	7/8	3-1/2	9.78
35	.1100	.1030	7/8	3-1/2	9.78
36	.1055	.1030	7/8	3-1/2	9.78
37	.1040	.0950	7/8	3-1/2	9.78
38	.1010	.0950	7/8	3-1/2	9.78
39	.0995	.0928	7/8	3-1/2	9.78
40	.0980	.0928	7/8	3-1/2	9.78
41	.0960	.0928	7/8	3-1/2	9.78
42	.0935	.0880	3/4	3	9.78
43	.0890	.0810	3/4	3	9.78
44	.0860	.0810	3/4	3	9.78
45	.0820	.0771	3/4	3	9.78
46	.0810	.0771	3/4	3	9.78
47	.0785	.0720	3/4	3	9.78
48	.0760	.0720	3/4	3	9.78
49	.0730	.0660	3/4	3	9.78
50	.0700	.0660	3/4	3	9.78
51	.0670	.0660	3/4	3	11.08
52	.0635	.0585	1/2	2-1/2	11.08
53	.0595	.0585	1/2	2-1/2	11.56
54	.0550	.0510	1/2	2-1/2	11.56
55	.0520	.0510	1/2	2-1/2	11.56
56	.0465	.0455	1/2	2-1/2	11.56
57	.0430	.0390	1/2	2-1/2	11.56
58	.0420	.0390	1/2	2-1/2	11.56
59	.0410	.0390	1/2	2-1/2	11.56
60	.0400	.0390	1/2	2-1/2	11.56

## Letter Sizes (Straight Shank) "A" To "Z" Dia.

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	HSS CRSF
A	.234	.2265	1-1/2	6	\$18.48
B	.238	.2329	1-1/2	6	18.48
C	.242	.2329	1-1/2	6	18.48
D	.246	.2329	1-1/2	6	18.48
E	.250	.2405	1-1/2	6	14.24
F	.257	.2485	1-1/2	6	12.88
G	.261	.2485	1-1/2	6	12.88
H	.266	.2485	1-1/2	6	20.72
I	.272	.2485	1-1/2	6	20.72
J	.277	.2485	1-1/2	6	20.72
K	.281	.2485	1-1/2	6	20.72
L	.291	.2792	1-1/2	6	20.72
M	.295	.2792	1-1/2	6	20.72

SIZE	DEC. EQUIV.	SHANK DIA.	FLUTE LENGTH	OVERALL LENGTH	HSS CRSF
N	.302	.2792	1-1/2	6	\$20.72
O	.316	.2792	1-1/2	6	21.56
P	.323	.2792	1-1/2	6	21.96
Q	.332	.2792	1-1/2	6	21.96
R	.339	.2792	1-1/2	6	21.96
S	.348	.3105	1-3/4	7	21.96
T	.358	.3105	1-3/4	7	21.96
U	.368	.3105	1-3/4	7	21.96
V	.377	.3105	1-3/4	7	24.58
W	.386	.3105	1-3/4	7	24.58
X	.397	.3105	1-3/4	7	24.58
Y	.404	.3105	1-3/4	7	25.32
Z	.413	.3735	1-3/4	7	25.32

**TOLERANCES**

# 1 - #60 dia.: +.0002 - .0000"  
A - Z dia.: +.0002 - .0000"