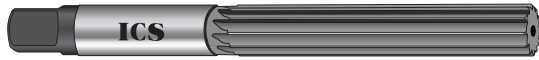


# HIGH SPEED STEEL HAND REAMERS

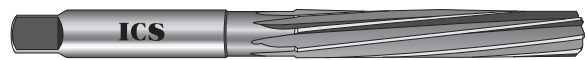
**ICS** **WIS**

**GENERAL PURPOSE**

**RIGHT HAND CUT**



STRAIGHT FLUTE (PARALLEL FLUTE)  
(General Purpose Reaming)



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

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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				STRAIGHT FLUTE	HELICAL FLUTE
				HRSF	HRHF
1/16	.0625	1	2	\$35.00	\$36.96
5/64	.0781	1	2	35.00	35.46
3/32	.0938	1-1/8	2-1/4	35.00	27.66
7/64	.0194	1-7/32	2-7/16	35.00	28.92
1/8	.1250	1-5/16	2-5/8	21.52	23.44
9/64	.1406	1-3/8	2-13/16	-	25.24
5/32	.1562	1-1/2	3	21.08	22.94
11/64	.1719	1-5/8	3-3/16	21.08	25.78
3/16	.1875	1-3/4	3-7/16	21.08	22.94
13/64	.2031	1-3/4	3-7/16	-	27.42
7/32	.2188	1-7/8	3-11/16	22.94	24.72
15/64	.2344	1-7/8	3-11/16	-	29.04
1/4	.2500	2	3-15/16	22.94	24.72
17/64	.2656	2-1/8	4-3/16	-	30.46
9/32	.2812	2-1/8	4-3/16	24.72	26.30
19/64	.2969	2-1/4	4-1/2	-	32.36
5/16	.3125	2-1/4	4-1/2	24.72	26.30
21/64	.3281	2-1/4	4-1/2	-	33.72
11/32	.3438	2-7/16	4-7/8	27.98	31.60
23/64	.3594	2-7/16	4-7/8	-	36.96
3/8	.3750	2-5/8	5-1/4	27.98	31.60
25/64	.3906	2-5/8	5-1/4	27.98	37.96
13/32	.4062	2-5/8	5-1/4	29.82	34.96
27/64	.4219	2-13/16	5-5/8	-	40.52
7/16	.4375	2-13/16	5-5/8	29.82	34.96
29/64	.4531	2-13/16	5-5/8	-	43.44
15/32	.4688	3	6	34.96	38.64
31/64	.4844	3	6	34.96	46.80
1/2	.5000	3	6	34.96	38.64
33/64	.5156	3	6	-	65.16
17/32	.5312	3-3/16	6-7/16	37.98	42.18
35/64	.5469	3-3/16	6-7/16	76.76	80.56
9/16	.5625	3-3/16	6-7/16	37.98	42.18
37/64	.5781	3-3/16	6-7/16	87.96	80.56
19/32	.5938	3-7/16	6-7/8	40.32	45.54
39/64	.6094	3-7/16	6-7/8	87.96	85.66
5/8	.6250	3-7/16	6-7/8	40.32	45.54
41/64	.6406	3-7/16	6-7/8	82.90	85.66
21/32	.6562	3-7/16	6-7/8	43.68	49.24
43/64	.6719	3-11/16	7-7/16	96.30	105.38
11/16	.6875	3-11/16	7-7/16	43.68	49.24
45/64	.7031	3-11/16	7-7/16	91.00	105.38
23/32	.7188	3-11/16	7-7/16	47.38	52.60

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				STRAIGHT FLUTE	HELICAL FLUTE
				HRSF	HRHF
47/64	.7344	3-11/16	7-7/16	\$ -	\$119.02
3/4	.7500	3-15/16	7-15/16	47.38	52.60
49/64	.7656	3-15/16	7-15/16	-	135.38
25/32	.7812	3-15/16	7-15/16	50.92	56.12
51/64	.7969	3-15/16	7-15/16	110.00	84.00
13/16	.8125	3-15/16	7-15/16	50.92	56.12
53/64	.8281	3-15/16	7-15/16	118.00	146.08
27/32	.8438	4-3/16	8-1/2	56.12	61.16
55/64	.8594	4-3/16	8-1/2	-	146.08
7/8	.8750	4-3/16	8-1/2	56.12	61.16
57/64	.8906	4-3/16	8-1/2	118.00	146.08
29/32	.9062	4-3/16	8-1/2	61.16	69.90
59/64	.9219	4-3/16	8-1/2	133.00	146.08
15/16	.9315	4-1/2	9-1/16	61.16	69.90
61/64	.9531	4-1/2	9-1/16	135.00	150.14
31/32	.9688	4-1/2	9-1/16	68.40	76.12
63/64	.9844	4-1/2	9-1/16	-	179.60
1	1.0000	4-1/2	9-1/16	68.40	76.12
1-1/32	1.0312	4-1/2	9-1/16	-	168.88
1-1/16	1.0625	4-7/8	9-3/4	76.12	83.00
1-3/32	1.0938	4-7/8	9-3/4	-	183.64
1-1/8	1.1250	4-7/8	9-3/4	84.00	91.74
1-5/32	1.1562	4-7/8	9-3/4	-	214.48
1-3/16	1.1875	5-1/4	10-7/16	94.60	103.34
1-7/32	1.2188	5-1/4	10-7/16	-	248.00
1-1/4	1.2500	5-1/4	10-7/16	103.34	114.76
1-9/32	1.2812	5-1/4	10-7/16	-	238.58
1-5/16	1.3125	5-1/4	10-7/16	113.58	125.18
1-11/32	1.3438	5-5/8	11-3/16	-	-
1-3/8	1.3750	6-5/16	12-5/8	122.32	136.42
1-13/32	1.4062	5-5/8	11-3/16	-	-
1-7/16	1.4375	5-5/8	11-3/16	134.58	148.52
1-15/32	1.4688	5-5/8	11-3/16	-	-
1-1/2	1.5000	6	12	145.84	160.80
1-9/16	1.5625	6	12	-	276.46
1-5/8	1.6250	6	12	-	253.84
1-11/16	1.6875	6-7/16	12-13/16	303.00	349.34
1-3/4	1.7500	6-7/16	12-13/16	-	326.76
1-13/16	1.8125	6-7/16	12-13/16	415.84	402.12
1-7/8	1.8750	6-7/8	13-11/16	-	374.50
1-15/16	1.9375	6-7/8	13-11/16	450.00	459.96
2	2.0000	6-7/8	13-11/16	541.66	422.26

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