




# HIGH SPEED STEEL TAPER PIN REAMERS

**ICS** **WIS**

**SPECIAL PURPOSE**

**RIGHT HAND CUT**

Taper Pin Reamers are manufactured with a taper of 1/4" per foot. They are used to ream holes into which standard taper pins will fit. The point of each reamer will enter hole reamed by next smaller size. Hole to be reamed should be a few thousandths smaller than the small diameter of the finished reamed hole.

ITEM NO.	FLUTE STYLE	DESIGN USE	REAMING APPLICATION
<b>TPRSF</b>	 Straight (Right Hand) Flute	Hand	For use in easy to ream materials.
<b>TPRSP</b>	 Spiral (Left Hand) Flute	Hand	For use in hard to ream materials and where the reamer tends to wedge itself.
<b>TPRHF</b>	 Helical (Left Hand) Flute	Machine	For machine reaming of holes for taper pins on a production basis. Helical design throws the chips forward to alleviate packing of the flutes.

SIZE	PIN SIZE NO.	DIAMETER		FLUTE LENGTH	OVERALL LENGTH	NO. OF FLUTES	PRICE EACH		
		SMALL END	LARGE END				STRAIGHT FLUTE	SPIRAL FLUTE	HELICAL FLUTE
							<b>TPRSF</b>	<b>TPRSP</b>	<b>TPRHF</b>
5/64	7/0	.0497	.0666	13/16	1-13/16	4	\$21.82	\$25.48	\$22.84
3/32	6/0	.0611	.0806	15/16	1-15/16	4	21.82	25.48	21.26
7/64	5/0	.0719	.0966	1-3/16	2-3/16	4	22.38	24.44	24.73
1/8	4/0	.0869	.1142	1-5/16	2-5/16	4	22.38	24.00	22.02
9/64	3/0	.1029	.1302	1-5/16	2-5/16	4	22.38	24.44	19.90
5/32	2/0	.1137	.1462	1-9/16	2-9/16	4	20.00	21.34	19.14
11/64	0	.1287	.1638	1-11/16	2-15/16	6	19.18	20.56	19.90
3/16	1	.1447	.1798	1-11/16	2-15/16	6	18.72	20.78	21.02
13/64	2	.1605	.2008	1-15/16	3-3/16	6	18.72	21.08	23.94
15/64	3	.1813	.2294	2-5/16	3-11/16	6	18.72	21.08	24.62
17/64	4	.2071	.2604	2-9/16	4-1/16	6	20.78	22.56	29.98
5/16	5	.2409	.2994	2-13/16	4-5/16	6	22.38	24.30	32.08
23/64	6	.2773	.3540	3-11/16	5-7/16	6	26.94	29.84	37.66
13/32	7	.3297	.4220	4-7/16	6-5/16	6	34.64	37.52	45.28
7/16	8	.3971	.5050	5-3/16	7-3/16	6	44.24	48.48	52.30
9/16	9	.4805	.6066	6-1/16	8-5/16	6	53.82	58.60	56.22
5/8	10	.5799	.7216	6-13/16	9-5/16	6	59.16	65.00	74.74

# HIGH SPEED STEEL TAPER PIN DRILL/REAMERS

**ICS** **WIS**

**SPECIAL PURPOSE**

**118° POINT**

**DUAL PURPOSE**



**TAPERED FLUTES**

Taper Pin Drill/Reamers are designed to drill and ream tapered holes in metal to fit taper pins in one operation. They are made with an included taper of 1 in 48 (1/4" per foot) and have chip breakers along the cutting edge.

SIZE	DIAMETER		FLUTE LENGTH	OVERALL LENGTH	FOR NO. SIZE	PRICE
	SMALL END	LARGE END				TAPERED FLUTES
						<b>TPD/R</b>
3/32	.0664	.095	1-3/8	2-9/16	5/0	\$ 51.88
7/64	.0772	.111	1-5/8	2-7/8	4/0	51.88
1/8	.0879	.127	1-7/8	3-1/8	3/0	41.42
9/64	.1013	.143	2	3-1/4	2/0	66.70
5/32	.1137	.158	2-1/8	3-3/8	0	47.40
11/64	.1245	.174	2-3/8	3-3/4	1	76.50
3/16	.1325	.195	3	4-3/8	2	63.70
7/32	.1575	.220	3	4-1/2	3	97.96
1/4	.1775	.253	3-5/8	5-1/4	4	72.68
9/32	.1983	.292	4-1/2	6-1/4	5	122.90
5/16	.2223	.316	4-1/2	6-3/8	-	102.36
11/32	.2455	.347	4-7/8	6-7/8	6	178.54
3/8	.2664	.381	5-1/2	7-3/4	-	126.06
13/32	.2818	.412	6-1/4	8-1/2	7	197.48
7/16	.3128	.443	6-1/4	8-7/8	-	159.56
1/2	.3600	.506	7	9-3/4	8	197.48
5/8	.4638	.633	8-1/8	11-3/8	9	394.96
3/4	.5647	.760	9-3/8	12-7/8	10	444.86