

# HIGH SPEED STEEL EXPANSION CHUCKING REAMERS

ICS USA

GENERAL PURPOSE

RIGHT HAND CUT



STRAIGHT SHANK - STRAIGHT FLUTE

TAPER SHANK - STRAIGHT FLUTE

High Speed Steel Expansion Chucking Reamers are designed to maintain the initial size by compensating for wear on the cutting end. When the reamer has been worn undersize, it may be expanded oversize by tightening the adjusting screw then reground to size and resharpened on the bevel cutting lead. They should not be considered an adjustable reamer to provide holes of different sizes.

SIZE	DEC EQUIV	FLUTE LENGTH	OVERALL LENGTH	STRAIGHT SHANK		TAPER SHANK		
				ITEM NO.	PRICE	MORSE TAPER	ITEM NO.	PRICE
3/8	.3750	3/4	7	XCRSFSS024	51.12	1	XCRSFTS024	58.60
13/32	.4062	3/4	7	XCRSFSS026	54.46	1	XCRSFTS026	62.04
7/16	.4375	7/8	7	XCRSFSS028	54.46	1	XCRSFTS028	62.04
15/32	.4688	7/8	7	XCRSFSS030	56.56	1	XCRSFTS030	63.52
1/2	.5000	1	8	XCRSFSS032	57.54	1	XCRSFTS032	64.76
17/32	.5312	1	8	XCRSFSS034	59.98	1	XCRSFTS034	67.36
9/16	.5625	1-1/8	8	XCRSFSS036	60.42	1	XCRSFTS036	66.14
19/32	.5938	1-1/8	8	XCRSFSS038	61.34	1	XCRSFTS038	68.54
5/8	.6250	1-1/4	9	XCRSFSS040	63.22	2	XCRSFTS040	71.00
21/32	.6562	1-1/4	9	XCRSFSS042	65.74	2	XCRSFTS042	72.96
11/16	.6875	1-1/4	9	XCRSFSS044	66.20	2	XCRSFTS044	73.40
23/32	.7188	1-1/4	9	XCRSFSS046	70.48	2	XCRSFTS046	78.30
3/4	.7500	1-3/8	9-1/2	XCRSFSS048	72.92	2	XCRSFTS048	80.76
25/32	.7812	1-3/8	9-1/2	XCRSFSS050	77.20	2	XCRSFTS050	84.42
13/16	.8125	1-3/8	9-1/2	XCRSFSS052	80.16	2	XCRSFTS052	85.68
27/32	.8438	1-3/8	9-1/2	XCRSFSS054	84.44	2	XCRSFTS054	90.68
7/8	.8750	1-1/2	10	XCRSFSS056	86.86	2	XCRSFTS056	94.26
29/32	.9062	1-1/2	10	XCRSFSS058	90.56	2	XCRSFTS058	99.16
15/16	.9375	1-1/2	10	XCRSFSS060	94.78	3	XCRSFTS060	101.64
31/32	.9688	1-1/2	10	XCRSFSS062	99.06	3	XCRSFTS062	105.90
1	1.0000	1-5/8	10-1/2	XCRSFSS100	104.50	3	XCRSFTS100	112.02
1-1/16	1.0312	1-5/8	10-1/2	XCRSFSS104	115.50	3	XCRSFTS104	121.88
1-1/8	1.1250	1-3/4	11	XCRSFSS108	126.40	3	XCRSFTS108	131.70
1-3/16	1.1875	1-3/4	11	XCRSFSS112	133.12	3	XCRSFTS112	142.62
1-1/4	1.2500	1-7/8	11-1/2	XCRSFSS116	143.48	4	XCRSFTS116	154.96
1-5/16	1.3125	1-7/8	11-1/2	XCRSFSS120	148.26	4	XCRSFTS120	161.02
1-3/8	1.3750	2	12	XCRSFSS124	153.72	4	XCRSFTS124	167.68
1-7/16	1.4375	2	12	XCRSFSS128	159.82	4	XCRSFTS128	177.52
1-1/2	1.5000	2-1/8	12-1/2	XCRSFSS132	166.56	4	XCRSFTS132	183.60
1-9/16	1.5625	2-1/8	12-1/2	XCRSFSS136	225.22	4	XCRSFTS136	246.02
1-5/8	1.6250	2-1/4	13	XCRSFSS140	228.70	4	XCRSFTS140	249.48
1-11/16	1.6875	2-1/4	13	XCRSFSS144	242.56	4	XCRSFTS144	263.34
1-3/4	1.7500	2-3/8	13-1/2	XCRSFSS148	275.82	5	XCRSFTS148	303.54
1-13/16	1.8125	2-3/8	13-1/2	XCRSFSS152	294.52	5	XCRSFTS152	325.72
1-7/8	1.8750	2-1/2	14	XCRSFSS156	332.64	5	XCRSFTS156	363.82
1-15/16	1.9375	2-1/2	14	XCRSFSS160	341.26	5	XCRSFTS160	367.50
2	2.0000	2-1/2	14	XCRSFSS200	349.96	5	XCRSFTS200	384.62
2-1/8	2.1250	2-3/4	14			5	XCRSFTS208	460.84
2-1/4	2.2500	2-3/4	14-1/2			5	XCRSFTS216	483.00
2-3/8	2.3750	2-3/4	15			5	XCRSFTS224	519.76
2-1/2	2.5000	3	15			5	XCRSFTS232	550.94
3	3.0000	3	15			5	XCRSFTS300	1036.04

Maximum expansion to 1/2" - approximately .006, to 1" - approximately .010  
 Maximum expansion to 1-1/2" - approximately .012, to 3" - approximately .015