

Straight Shank Chucking Reamers

Straight Flute

- Right hand cutting direction,
- Designed for general purpose machine reaming in most materials, using screw machines, turret lathes, drill presses and machining centers.
- Precision engineered design for exceptional quality and accuracy.
- Ground with a 45 deg. Chamfer, suitable for reaming most materials.

Fractional Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
3/64"	1/2"	2-1/2"	331-1003	15/32"	1-3/4"	7"	331-1030	57/64"	2-5/8"	10"	331-1057
1/16	1/2	2-1/2	331-1004	31/64	2	8	331-1031	29/32	2-5/8	10	331-1058
5/64	3/4	3	331-1005	1/2	2	8	331-1032	59/64	2-5/8	10	331-1059
3/32	3/4	3	331-1006	33/64	2	8	331-1033	15/16	2-5/8	10	331-1060
7/64	7/8	3-1/2	331-1007	17/32	2	8	331-1034	61/64	2-5/8	10	331-1061
1/8	7/8	3-1/2	331-1008	35/64	2	8	331-1035	31/32	2-5/8	10	331-1062
9/64	1	4	331-1009	9/16	2	8	331-1036	63/64	2-3/4	10	331-1063
5/32	1	4	331-1010	37/64	2	8	331-1037	1	2-3/4	10-1/2	331-1100
11/64	1-1/8	4-1/2	331-1011	19/32	2	8	331-1038	1-1/32	2-3/4	10-1/2	331-1102
3/16	1-1/8	4-1/2	331-1012	39/64	2-1/4	9	331-1039	1-1/16	2-3/4	10-1/2	331-1104
13/64	1-1/4	5	331-1013	5/8	2-1/4	9	331-1040	1-3/32	2-7/8	10-1/2	331-1106
7/32	1-1/4	5	331-1014	41/64	2-1/4	9	331-1041	1-1/8	2-7/8	11	331-1108
15/64	1-1/2	6	331-1015	21/32	2-1/4	9	331-1042	1-5/32	2-7/8	11	331-1110
1/4	1-1/2	6	331-1016	43/64	2-1/4	9	331-1043	1-3/16	2-7/8	11	331-1112
17/64	1-1/2	6	331-1017	11/16	2-1/4	9	331-1044	1-7/32	2-7/8	11	331-1114
9/32	1-1/2	6	331-1018	45/64	2-1/4	9	331-1045	1-1/4	3	11-1/2	331-1116
19/64	1-1/2	6	331-1019	23/32	2-1/4	9	331-1046	1-9/32	3	11-1/2	331-1118
5/16	1-1/2	6	331-1020	47/64	2-1/2	9-1/2	331-1047	1-5/16	3	11-1/2	331-1120
21/64	1-1/2	6	331-1021	3/4	2-1/2	9-1/2	331-1048	1-3/8	3-1/4	12	331-1124
11/32	1-1/2	6	331-1022	49/64	2-1/2	9-1/2	331-1049	1-7/16	3-1/2	12-1/2	331-1128
23/64	1-3/4	7	331-1023	25/32	2-1/2	9-1/2	331-1050	1-1/2	3-1/2	12-1/2	331-1132
3/8	1-3/4	7	331-1024	51/64	2-1/2	9-1/2	331-1051	1-9/16	3-1/2	12-1/2	331-1136
25/64	1-3/4	7	331-1025	13/16	2-1/2	9-1/2	331-1052	1-5/8	3-1/2	13	331-1140
13/32	1-3/4	7	331-1026	53/64	2-1/2	9-1/2	331-1053	1-11/16	3-1/2	13	331-1144
27/64	1-3/4	7	331-1027	27/32	2-1/2	9-1/2	331-1054	1-3/4	4	13-1/2	331-1148
7/16	1-3/4	7	331-1028	55/64	2-5/8	9-1/2	331-1055	1-7/8	4	14	331-1156
29/64	1-3/4	7	331-1029	7/8	2-5/8	10	331-1056	2	4	14	331-1200

Number Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
No.1	1-1/2"	6"	331-0201	No.16	1-1/8"	4-1/2"	331-0216	No.31	7/8"	3-1/2"	331-0231	No.46	3/4"	3"	331-0246
No.2	1-1/2	6	331-0202	No.17	1-1/8	4-1/2	331-0217	No.32	7/8	3-1/2	331-0232	No.47	3/4	3	331-0247
No.3	1-1/4	5	331-0203	No.18	1-1/8	4-1/2	331-0218	No.33	7/8	3-1/2	331-0233	No.48	3/4	3	331-0248
No.4	1-1/4	5	331-0204	No.19	1-1/8	4-1/2	331-0219	No.34	7/8	3-1/2	331-0234	No.49	3/4	3	331-0249
No.5	1-1/4	5	331-0205	No.20	1-1/8	4-1/2	331-0220	No.35	7/8	3-1/2	331-0235	No.50	3/4	3	331-0250
No.6	1-1/4	5	331-0206	No.21	1-1/8	4-1/2	331-0221	No.36	7/8	3-1/2	331-0236	No.51	3/4	3	331-0251
No.7	1-1/4	5	331-0207	No.22	1	4	331-0222	No.37	7/8	3-1/2	331-0237	No.52	1/2	2-1/2	331-0252
No.8	1-1/4	5	331-0208	No.23	1	4	331-0223	No.38	7/8	3-1/2	331-0238	No.53	1/2	2-1/2	331-0253
No.9	1-1/4	5	331-0209	No.24	1	4	331-0224	No.39	7/8	3-1/2	331-0239	No.54	1/2	2-1/2	331-0254
No.10	1-1/4	5	331-0210	No.25	1	4	331-0225	No.40	7/8	3-1/2	331-0240	No.55	1/2	2-1/2	331-0255
No.11	1-1/4	5	331-0211	No.26	1	4	331-0226	No.41	7/8	3-1/2	331-0241	No.56	1/2	2-1/2	331-0256
No.12	1-1/8	4-1/2	331-0212	No.27	1	4	331-0227	No.42	3/4	3	331-0242	No.57	1/2	2-1/2	331-0257
No.13	1-1/8	4-1/2	331-0213	No.28	1	4	331-0228	No.43	3/4	3	331-0243	No.58	1/2	2-1/2	331-0258
No.14	1-1/8	4-1/2	331-0214	No.29	1	4	331-0229	No.44	3/4	3	331-0244	No.59	1/2	2-1/2	331-0259
No.15	1-1/8	4-1/2	331-0215	No.30	7/8	3-1/2	331-0230	No.45	3/4	3	331-0245	No.60	1/2	2-1/2	331-0260

Letter Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
A	1-1/2	6"	331-0001	J	1-1/2	6"	331-0010	S	1-3/4	7"	331-0019
B	1-1/2	6	331-0002	K	1-1/2	6	331-0011	T	1-3/4	7	331-0020
C	1-1/2	6	331-0003	L	1-1/2	6	331-0012	U	1-3/4	7	331-0021
D	1-1/2	6	331-0004	M	1-1/2	6	331-0013	V	1-3/4	7	331-0022
E	1-1/2	6	331-0005	N	1-1/2	6	331-0014	W	1-3/4	7	331-0023
F	1-1/2	6	331-0006	O	1-1/2	6	331-0015	X	1-3/4	7	331-0024
G	1-1/2	6	331-0007	P	1-1/2	6	331-0016	Y	1-3/4	7	331-0025
H	1-1/2	6	331-0008	Q	1-1/2	6	331-0017	Z	1-3/4	7	331-0026
I	1-1/2	6	331-0009	R	1-1/2	6	331-0018				

M35 Cobalt Straight Shank Chucking Reamers

Straight Flute

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- Precision engineered design for exceptional quality and accuracy.
- Ground with a 45 deg. Chamfer, suitable for reaming most materials.

Fractional Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
3/64"	1/2"	2-1/2"	331-1303	15/32"	1-3/4"	7"	331-1330	57/64"	2-5/8"	10"	331-1357
1/16	1/2	2-1/2	331-1304	31/64	2	8	331-1331	29/32	2-5/8	10	331-1358
5/64	3/4	3	331-1305	1/2	2	8	331-1332	59/64	2-5/8	10	331-1359
3/32	3/4	3	331-1306	33/64	2	8	331-1333	15/16	2-5/8	10	331-1360
7/64	7/8	3-1/2	331-1307	17/32	2	8	331-1334	61/64	2-5/8	10	331-1361
1/8	7/8	3-1/2	331-1308	35/64	2	8	331-1335	31/32	2-5/8	10	331-1362
9/64	1	4	331-1309	9/16	2	8	331-1336	63/64	2-3/4	10	331-1363
5/32	1	4	331-1310	37/64	2	8	331-1337	1	2-3/4	10-1/2	331-1364
11/64	1-1/8	4-1/2	331-1311	19/32	2	8	331-1338	1-1/32	2-3/4	10-1/2	331-1366
3/16	1-1/8	4-1/2	331-1312	39/64	2-1/4	9	331-1339	1-1/16	2-3/4	10-1/2	331-1368
13/64	1-1/4	5	331-1313	5/8	2-1/4	9	331-1340	1-3/32	2-7/8	10-1/2	331-1370
7/32	1-1/4	5	331-1314	41/64	2-1/4	9	331-1341	1-1/8	2-7/8	11	331-1372
15/64	1-1/2	6	331-1315	21/32	2-1/4	9	331-1342	1-5/32	2-7/8	11	331-1374
1/4	1-1/2	6	331-1316	43/64	2-1/4	9	331-1343	1-3/16	2-7/8	11	331-1376
17/64	1-1/2	6	331-1317	11/16	2-1/4	9	331-1344	1-7/32	2-7/8	11	331-1378
9/32	1-1/2	6	331-1318	45/64	2-1/4	9	331-1345	1-1/4	3	11-1/2	331-1380
19/64	1-1/2	6	331-1319	23/32	2-1/4	9	331-1346	1-9/32	3	11-1/2	331-1382
5/16	1-1/2	6	331-1320	47/64	2-1/2	9-1/2	331-1347	1-5/16	3	11-1/2	331-1384
21/64	1-1/2	6	331-1321	3/4	2-1/2	9-1/2	331-1348	1-3/8	3-1/4	12	331-1386
11/32	1-1/2	6	331-1322	49/64	2-1/2	9-1/2	331-1349	1-7/16	3-1/2	12-1/2	331-1388
23/64	1-3/4	7	331-1323	25/32	2-1/2	9-1/2	331-1350	1-1/2	3-1/2	12-1/2	331-1390
3/8	1-3/4	7	331-1324	51/64	2-1/2	9-1/2	331-1351	1-9/16	3-1/2	12-1/2	331-1392
25/64	1-3/4	7	331-1325	13/16	2-1/2	9-1/2	331-1352	1-5/8	3-1/2	13	331-1394
13/32	1-3/4	7	331-1326	53/64	2-1/2	9-1/2	331-1353	1-11/16	3-1/2	13	331-1396
27/64	1-3/4	7	331-1327	27/32	2-1/2	9-1/2	331-1354	1-3/4	4	13-1/2	331-1398
7/16	1-3/4	7	331-1328	55/64	2-5/8	9-1/2	331-1355	1-7/8	4	14	331-1199
29/64	1-3/4	7	331-1329	7/8	2-5/8	10	331-1356	2	4	14	331-1400

Number Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
No.1	1-1/2"	6"	331-1401	No.16	1-1/8"	4-1/2"	331-1416	No.31	7/8"	3-1/2"	331-1431	No.46	3/4"	3"	331-1446
No.2	1-1/2	6	331-1402	No.17	1-1/8	4-1/2	331-1417	No.32	7/8	3-1/2	331-1432	No.47	3/4	3	331-1447
No.3	1-1/4	5	331-1403	No.18	1-1/8	4-1/2	331-1418	No.33	7/8	3-1/2	331-1433	No.48	3/4	3	331-1448
No.4	1-1/4	5	331-1404	No.19	1-1/8	4-1/2	331-1419	No.34	7/8	3-1/2	331-1434	No.49	3/4	3	331-1449
No.5	1-1/4	5	331-1405	No.20	1-1/8	4-1/2	331-1420	No.35	7/8	3-1/2	331-1435	No.50	3/4	3	331-1450
No.6	1-1/4	5	331-1406	No.21	1-1/8	4-1/2	331-1421	No.36	7/8	3-1/2	331-1436	No.51	3/4	3	331-1451
No.7	1-1/4	5	331-1407	No.22	1	4	331-1422	No.37	7/8	3-1/2	331-1437	No.52	1/2	2-1/2	331-1452
No.8	1-1/4	5	331-1408	No.23	1	4	331-1423	No.38	7/8	3-1/2	331-1438	No.53	1/2	2-1/2	331-1453
No.9	1-1/4	5	331-1409	No.24	1	4	331-1424	No.39	7/8	3-1/2	331-1439	No.54	1/2	2-1/2	331-1454
No.10	1-1/4	5	331-1410	No.25	1	4	331-1425	No.40	7/8	3-1/2	331-1440	No.55	1/2	2-1/2	331-1455
No.11	1-1/4	5	331-1411	No.26	1	4	331-1426	No.41	7/8	3-1/2	331-1441	No.56	1/2	2-1/2	331-1456
No.12	1-1/8	4-1/2	331-1412	No.27	1	4	331-1427	No.42	3/4	3	331-1442	No.57	1/2	2-1/2	331-1457
No.13	1-1/8	4-1/2	331-1413	No.28	1	4	331-1428	No.43	3/4	3	331-1443	No.58	1/2	2-1/2	331-1458
No.14	1-1/8	4-1/2	331-1414	No.29	1	4	331-1429	No.44	3/4	3	331-1444	No.59	1/2	2-1/2	331-1459
No.15	1-1/8	4-1/2	331-1415	No.30	7/8	3-1/2	331-1430	No.45	3/4	3	331-1445	No.60	1/2	2-1/2	331-1460

Letter Sizes

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
A	1-1/2	6"	331-1501	J	1-1/2	6"	331-1510	S	1-3/4	7"	331-1519
B	1-1/2	6	331-1502	K	1-1/2	6	331-1511	T	1-3/4	7	331-1520
C	1-1/2	6	331-1503	L	1-1/2	6	331-1512	U	1-3/4	7	331-1521
D	1-1/2	6	331-1504	M	1-1/2	6	331-1513	V	1-3/4	7	331-1522
E	1-1/2	6	331-1505	N	1-1/2	6	331-1514	W	1-3/4	7	331-1523
F	1-1/2	6	331-1506	O	1-1/2	6	331-1515	X	1-3/4	7	331-1524
G	1-1/2	6	331-1507	P	1-1/2	6	331-1516	Y	1-3/4	7	331-1525
H	1-1/2	6	331-1508	Q	1-1/2	6	331-1517	Z	1-3/4	7	331-1526
I	1-1/2	6	331-1509	R	1-1/2	6	331-1518				

Spiral Flute Chucking Reamers

High Speed Steel, Straight Shank, Right Hand

- Provides better surface finish than straight flute reamers.
- Spiral flutes pull chips away from part, providing excellent chip removal, especially in blind holes.

- Right hand spiral – right hand cut.
- Use for difficult-to-ream materials.
- Best choice for interrupted cuts such as keyways or cross holes.



Fractional Sizes

Size	Decimal Size	Flute Length	Overall Length	No. of Flute	Order No.	Size	Decimal Size	Flute Length	Overall Length	No. of Flute	Order No.
1/8"	.1250"	7/8"	3-1/2"	4	241-2005	35/64"	.5469	2"	8"	6	241-2126
9/64	.1406	1	4	4	241-2010	9/16	.5625	2	8	6	241-2130
5/32	.1562	1	4	4	241-2015	37/64	.5781	2	8	6	241-2131
11/64	.1719	1-1/8	4-1/2	6	241-2020	19/32	.5938	2	8	6	241-2135
3/16	.1875	1-1/8	4-1/2	6	241-2025	39/64	.6094	2-1/4	9	8	241-2139
13/64	.2031	1-1/4	5	6	241-2030	5/8	.6250	2-1/4	9	8	241-2140
7/32	.2188	1-1/4	5	6	241-2035	41/64	.6406	2-1/4	9	8	241-2144
15/64	.2344	1-1/2	6	6	241-2040	21/32	.6562	2-1/4	9	8	241-2145
1/4	.2500	1-1/2	6	6	241-2045	11/16	.6875	2-1/4	9	8	241-2150
17/64	.2656	1-1/2	6	6	241-2050	23/32	.7188	2-1/4	9	8	241-2155
9/32	.2812	1-1/2	6	6	241-2055	3/4	.7500	2-1/2	9-1/2	8	241-2160
19/64	.2969	1-1/2	6	6	241-2060	25/32	.7812	2-1/2	9-1/2	8	241-2165
5/16	.3125	1-1/2	6	6	241-2065	13/16	.8125	2-1/2	9-1/2	8	241-2170
21/64	.3281	1-1/2	6	6	241-2070	27/32	.8438	2-1/2	9-1/2	8	241-2175
11/32	.3438	1-1/2	6	6	241-2075	7/8	.8750	2-5/8	10	8	241-2180
23/64	.3594	1-3/4	7	6	241-2080	29/32	.9062	2-5/8	10	8	241-2185
3/8	.3750	1-3/4	7	6	241-2085	15/16	.9375	2-5/8	10	8	241-2190
25/64	.3906	1-3/4	7	6	241-2090	31/32	.9688	2-5/8	10	8	241-2195
13/32	.4062	1-3/4	7	6	241-2095	1	1.0000	2-3/4	10-1/2	8	241-2200
27/64	.4219	1-3/4	7	6	241-2100	1-1/16	1.0625	2-3/4	10-1/2	10	241-2205
7/16	.3745	1-3/4	7	6	241-2101	1-1/8	1.1250	2-7/8	11	10	241-2210
29/64	.4531	1-3/4	7	6	241-2105	1-3/16	1.1875	2-7/8	11	10	241-2215
15/32	.4688	1-3/4	7	6	241-2110	1-1/4	1.2500	3	11-1/2	10	241-2220
31/64	.4844	2	8	6	241-2115	1-5/16	1.3125	3-1/4	12	10	241-2225
1/2	.5000	2	8	6	241-2120	1-3/8	1.3750	3-1/4	12	12	241-2230
33/64	.5156	2	8	6	241-2121	1-7/16	1.4375	3-1/2	12-1/2	12	241-2235
17/32	.5312	2	8	6	241-2125	1-1/2	1.5000	3-1/2	12-1/2	12	241-2240

Metric Chucking Reamers

DIN212/A, High Speed Steel, Straight Flute

Straight Shank



Size (mm)	Flute Length (mm)	Overall Length (mm)	Shank Dia. (mm)	No. of Flute	Order No.	Size (mm)	Flute Length (mm)	Overall Length (mm)	Shank Dia. (mm)	No. of Flute	Order No.
1.0	8	30	2	4	331-5010	13.5	44	151	10	6	331-5135
1.5	8	30	2	4	331-5015	14.0	47	160	12.5	6	331-5140
2.0	11	49	2	4	331-5020	14.5	50	162	12.5	6	331-5145
2.5	14	57	2.5	4	331-5025	15.0	50	162	12.5	6	331-5150
3.0	15	61	3	6	331-5030	15.5	52	170	12.5	8	331-5155
3.5	18	70	3.5	6	331-5035	16.0	52	170	12.5	8	331-5160
4.0	19	75	4	6	331-5040	16.5	54	175	14	8	331-5165
4.5	21	80	4.5	6	331-5045	17.0	54	175	14	8	331-5170
5.0	23	86	5	6	331-5050	17.5	56	182	14	8	331-5175
5.5	26	93	5.6	6	331-5055	18.0	56	182	14	8	331-5180
6.0	26	93	5.6	6	331-5060	18.5	58	189	16	8	331-5185
6.5	28	101	6.3	6	331-5065	19.0	58	189	16	8	331-5190
7.0	31	109	7.1	6	331-5070	19.5	60	195	16	8	331-5195
7.5	31	109	7.1	6	331-5075	20.0	60	195	16	8	331-5200
8.0	33	117	8	6	331-5080	20.5	60	215	18	8	331-5205
8.5	33	117	8	6	331-5085	21.0	60	215	18	8	331-5210
9.0	36	125	9	6	331-5090	21.5	60	225	18	8	331-5215
9.5	36	125	9	6	331-5095	22.0	60	225	18	8	331-5220
10.0	38	133	10	6	331-5100	22.5	60	230	18	8	331-5225
10.5	38	133	10	6	331-5105	23.0	60	230	18	8	331-5230
11.0	41	142	10	6	331-5110	23.5	60	240	20	8	331-5235
11.5	41	142	10	6	331-5115	24.0	60	240	20	8	331-5240
12.0	44	151	10	6	331-5120	24.5	60	245	20	8	331-5245
12.5	44	151	10	6	331-5125	25.0	60	245	20	8	331-5250
13.0	44	151	10	6	331-5130						

Special Decimal Chucking Reamers

High Speed Steel, Straight Shank, Straight Flute



Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
.0160"	1/2"	1-3/8"	339-0160	.1010"	7/8"	3-1/2"	339-1010	.1535"	1"	4"	339-1535
.0200	1/2	1-3/8	339-0200	.1020	7/8	3-1/2	339-1020	.1545	1	4	339-1545
.0210	1/2	1-3/8	339-0210	.1025	7/8	3-1/2	339-1025	.1550	1	4	339-1550
.0310	1/2	1-3/8	339-0310	.1030	7/8	3-1/2	339-1030	.1555	1	4	339-1555
.0327	1/2	1-3/8	339-0327	.1050	7/8	3-1/2	339-1050	.1557	1	4	339-1557
.0390	1/2	1-3/8	339-0390	.1055	7/8	3-1/2	339-1055	.1558	1	4	339-1558
.0415	1/2	1-3/8	339-0415	.1060	7/8	3-1/2	339-1060	.1565	1	4	339-1565
.0435	1/2	1-3/8	339-0435	.1070	7/8	3-1/2	339-1070	.1580	1	4	339-1580
.0445	1/2	1-3/8	339-0445	.1080	7/8	3-1/2	339-1080	.1595	1-1/8	4-1/2	339-1595
.0450	1/2	1-3/8	339-0450	.1090	7/8	3-1/2	339-1090	.1600	1-1/8	4-1/2	339-1600
.0460	1/2	1-3/8	339-0460	.1095	7/8	3-1/2	339-1095	.1605	1-1/8	4-1/2	339-1605
.0470	1/2	1-3/8	339-0470	.1105	7/8	3-1/2	339-1105	.1620	1-1/8	4-1/2	339-1620
.0485	1/2	1-3/8	339-0485	.1125	7/8	3-1/2	339-1125	.1630	1-1/8	4-1/2	339-1630
.0510	1/2	1-3/8	339-0510	.1135	7/8	3-1/2	339-1135	.1635	1-1/8	4-1/2	339-1635
.0570	1/2	1-3/8	339-0570	.1140	7/8	3-1/2	339-1140	.1645	1-1/8	4-1/2	339-1645
.0580	1/2	1-3/8	339-0580	.1150	7/8	3-1/2	339-1150	.1650	1-1/8	4-1/2	339-1650
.0585	1/2	1-3/8	339-0585	.1155	7/8	3-1/2	339-1155	.1655	1-1/8	4-1/2	339-1655
.0590	1/2	1-3/8	339-0590	.1190	7/8	3-1/2	339-1190	.1665	1-1/8	4-1/2	339-1665
.0600	1/2	1-3/8	339-0600	.1195	7/8	3-1/2	339-1195	.1675	1-1/8	4-1/2	339-1675
.0605	1/2	1-3/8	339-0605	.1205	7/8	3-1/2	339-1205	.1680	1-1/8	4-1/2	339-1680
.0610	1/2	1-3/8	339-0610	.1210	7/8	3-1/2	339-1210	.1685	1-1/8	4-1/2	339-1685
.0615	1/2	1-3/8	339-0615	.1211	7/8	3-1/2	339-1211	.1690	1-1/8	4-1/2	339-1690
.0620	1/2	1-3/8	339-0620	.1215	7/8	3-1/2	339-1215	.1700	1-1/8	4-1/2	339-1700
.0630	1/2	1-3/8	339-0630	.1220	7/8	3-1/2	339-1220	.1710	1-1/8	4-1/2	339-1710
.0640	1/2	1-3/8	339-0640	.1223	7/8	3-1/2	339-1223	.1719	1-1/8	4-1/2	339-1719
.0645	1/2	1-3/8	339-0645	.1225	7/8	3-1/2	339-1225	.1720	1-1/8	4-1/2	339-1720
.0650	1/2	1-3/8	339-0650	.1230	7/8	3-1/2	339-1230	.1724	1-1/8	4-1/2	339-1724
.0655	1/2	1-3/8	339-0655	.1235	7/8	3-1/2	339-1235	.1725	1-1/8	4-1/2	339-1725
.0665	1/2	1-3/8	339-0665	.1240	7/8	3-1/2	339-1240	.1735	1-1/8	4-1/2	339-1735
.0675	3/4	3	339-0675	.1245	7/8	3-1/2	339-1245	.1740	1-1/8	4-1/2	339-1740
.0680	3/4	3	339-0680	.1255	7/8	3-1/2	339-1255	.1745	1-1/8	4-1/2	339-1745
.0705	3/4	3	339-0705	.1260	7/8	3-1/2	339-1260	.1750	1-1/8	4-1/2	339-1750
.0710	3/4	3	339-0710	.1265	7/8	3-1/2	339-1265	.1760	1-1/8	4-1/2	339-1760
.0720	3/4	3	339-0720	.1270	7/8	3-1/2	339-1270	.1770	1-1/8	4-1/2	339-1770
.0735	3/4	3	339-0735	.1275	7/8	3-1/2	339-1275	.1775	1-1/8	4-1/2	339-1775
.0745	3/4	3	339-0745	.1280	7/8	3-1/2	339-1280	.1785	1-1/8	4-1/2	339-1785
.0750	3/4	3	339-0750	.1285	7/8	3-1/2	339-1285	.1790	1-1/8	4-1/2	339-1790
.0755	3/4	3	339-0755	.1290	7/8	3-1/2	339-1290	.1795	1-1/8	4-1/2	339-1795
.0765	3/4	3	339-0765	.1300	7/8	3-1/2	339-1300	.1800	1-1/8	4-1/2	339-1800
.0770	3/4	3	339-0770	.1310	7/8	3-1/2	339-1310	.1810	1-1/8	4-1/2	339-1810
.0780	3/4	3	339-0780	.1320	7/8	3-1/2	339-1320	.1815	1-1/8	4-1/2	339-1815
.0790	3/4	3	339-0790	.1330	7/8	3-1/2	339-1330	.1820	1-1/8	4-1/2	339-1820
.0800	3/4	3	339-0800	.1335	7/8	3-1/2	339-1335	.1825	1-1/8	4-1/2	339-1825
.0805	3/4	3	339-0805	.1340	7/8	3-1/2	339-1340	.1830	1-1/8	4-1/2	339-1830
.0815	3/4	3	339-0815	.1345	7/8	3-1/2	339-1345	.1832	1-1/8	4-1/2	339-1832
.0825	3/4	3	339-0825	.1350	7/8	3-1/2	339-1350	.1835	1-1/8	4-1/2	339-1835
.0830	3/4	3	339-0830	.1355	7/8	3-1/2	339-1355	.1840	1-1/8	4-1/2	339-1840
.0840	3/4	3	339-0840	.1370	1	4	339-1370	.1845	1-1/8	4-1/2	339-1845
.0845	3/4	3	339-0845	.1380	1	4	339-1380	.1850	1-1/8	4-1/2	339-1850
.0850	3/4	3	339-0850	.1385	1	4	339-1385	.1855	1-1/8	4-1/2	339-1855
.0865	3/4	3	339-0865	.1390	1	4	339-1390	.1860	1-1/8	4-1/2	339-1860
.0870	3/4	3	339-0870	.1395	1	4	339-1395	.1865	1-1/8	4-1/2	339-1865
.0885	3/4	3	339-0885	.1400	1	4	339-1400	.1867	1-1/8	4-1/2	339-1867
.0895	3/4	3	339-0895	.1410	1	4	339-1410	.1870	1-1/8	4-1/2	339-1870
.0900	3/4	3	339-0900	.1420	1	4	339-1420	.1875	1-1/8	4-1/2	339-1875
.0905	3/4	3	339-0905	.1425	1	4	339-1425	.1880	1-1/8	4-1/2	339-1880
.0910	3/4	3	339-0910	.1430	1	4	339-1430	.1885	1-1/8	4-1/2	339-1885
.0915	3/4	3	339-0915	.1435	1	4	339-1435	.1890	1-1/8	4-1/2	339-1890
.0920	3/4	3	339-0920	.1440	1	4	339-1440	.1892	1-1/8	4-1/2	339-1892
.0925	3/4	3	339-0925	.1445	1	4	339-1445	.1895	1-1/8	4-1/2	339-1895
.0930	3/4	3	339-0930	.1450	1	4	339-1450	.1900	1-1/8	4-1/2	339-1900
.0938	3/4	3	339-0938	.1460	1	4	339-1460	.1905	1-1/8	4-1/2	339-1905
.0940	3/4	3	339-0940	.1470	1	4	339-1470	.1910	1-1/4	5	339-1910
.0945	3/4	3	339-0945	.1475	1	4	339-1475	.1920	1-1/4	5	339-1920
.0950	3/4	3	339-0950	.1480	1	4	339-1480	.1925	1-1/4	5	339-1925
.0955	3/4	3	339-0955	.1485	1	4	339-1485	.1930	1-1/4	5	339-1930
.0965	7/8	3-1/2	339-0965	.1490	1	4	339-1490	.1945	1-1/4	5	339-1945
.0970	7/8	3-1/2	339-0970	.1505	1	4	339-1505	.1950	1-1/4	5	339-1950
.0975	7/8	3-1/2	339-0975	.1515	1	4	339-1515	.1965	1-1/4	5	339-1965
.0990	7/8	3-1/2	339-0990	.1520	1	4	339-1520	.1970	1-1/4	5	339-1970
.1000	7/8	3-1/2	339-1000	.1525	1	4	339-1525	.1975	1-1/4	5	339-1975
.1005	7/8	3-1/2	339-1005	.1530	1	4	339-1530	.1980	1-1/4	5	339-1980

Special Decimal Chucking Reamers Continued

High Speed Steel, Straight Shank, Straight Flute



Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
.1985"	1-1/4"	5"	339-1985	2.455"	1-1/2"	6"	339-2455	.3075"	1-1/2"	6"	339-3075
.1995	1-1/4	5	339-1995	.2470	1-1/2	6	339-2470	.3080	1-1/2	6	339-3080
.2000	1-1/4	5	339-2000	.2475	1-1/2	6	339-2475	.3090	1-1/2	6	339-3090
.2005	1-1/4	5	339-2005	.2480	1-1/2	6	339-2480	.3100	1-1/2	6	339-3100
.2015	1-1/4	5	339-2015	.2485	1-1/2	6	339-2485	.3105	1-1/2	6	339-3105
.2020	1-1/4	5	339-2020	.2490	1-1/2	6	339-2490	.3110	1-1/2	6	339-3110
.2025	1-1/4	5	339-2025	.2495	1-1/2	6	339-2495	.3115	1-1/2	6	339-3115
.2045	1-1/4	5	339-2045	.2501	1-1/2	6	339-2501	.3120	1-1/2	6	339-3120
.2050	1-1/4	5	339-2050	.2505	1-1/2	6	339-2505	.3130	1-1/2	6	339-3130
.2060	1-1/4	5	339-2060	.2510	1-1/2	6	339-2510	.3135	1-1/2	6	339-3135
.2070	1-1/4	5	339-2070	.2515	1-1/2	6	339-2515	.3140	1-1/2	6	339-3140
.2080	1-1/4	5	339-2080	.2520	1-1/2	6	339-2520	.3145	1-1/2	6	339-3145
.2085	1-1/4	5	339-2085	.2525	1-1/2	6	339-2525	.3150	1-1/2	6	339-3150
.2090	1-1/4	5	339-2090	.2530	1-1/2	6	339-2530	.3165	1-1/2	6	339-3165
.2100	1-1/4	5	339-2100	.2535	1-1/2	6	339-2535	.3170	1-1/2	6	339-3170
.2105	1-1/4	5	339-2105	.2540	1-1/2	6	339-2540	.3180	1-1/2	6	339-3180
.2110	1-1/4	5	339-2110	.2550	1-1/2	6	339-2550	.3190	1-1/2	6	339-3190
.2115	1-1/4	5	339-2115	.2560	1-1/2	6	339-2560	.3200	1-1/2	6	339-3200
.2120	1-1/4	5	339-2120	.2570	1-1/2	6	339-2570	.3205	1-1/2	6	339-3205
.2125	1-1/4	5	339-2125	.2575	1-1/2	6	339-2575	.3210	1-1/2	6	339-3210
.2126	1-1/4	5	339-2126	.2580	1-1/2	6	339-2580	.3220	1-1/2	6	339-3220
.2135	1-1/4	5	339-2135	.2585	1-1/2	6	339-2585	.3225	1-1/2	6	339-3225
.2140	1-1/4	5	339-2140	.2590	1-1/2	6	339-2590	.3235	1-1/2	6	339-3235
.2150	1-1/4	5	339-2150	.2600	1-1/2	6	339-2600	.3240	1-1/2	6	339-3240
.2155	1-1/4	5	339-2155	.2620	1-1/2	6	339-2620	.3250	1-1/2	6	339-3250
.2157	1-1/4	5	339-2157	.2630	1-1/2	6	339-2630	.3255	1-1/2	6	339-3255
.2160	1-1/4	5	339-2160	.2640	1-1/2	6	339-2640	.3260	1-1/2	6	339-3260
.2170	1-1/4	5	339-2170	.2650	1-1/2	6	339-2650	.3270	1-1/2	6	339-3270
.2180	1-1/4	5	339-2180	.2655	1-1/2	6	339-2655	.3280	1-1/2	6	339-3280
.2185	1-1/4	5	339-2185	.2660	1-1/2	6	339-2660	.3290	1-1/2	6	339-3290
.2190	1-1/4	5	339-2190	.2680	1-1/2	6	339-2680	.3300	1-1/2	6	339-3300
.2195	1-1/4	5	339-2195	.2690	1-1/2	6	339-2690	.3310	1-1/2	6	339-3310
.2200	1-1/4	5	339-2200	.2700	1-1/2	6	339-2700	.3330	1-1/2	6	339-3330
.2205	1-1/4	5	339-2205	.2725	1-1/2	6	339-2725	.3340	1-1/2	6	339-3340
.2210	1-1/2	6	339-2210	.2740	1-1/2	6	339-2740	.3350	1-1/2	6	339-3350
.2215	1-1/2	6	339-2215	.2745	1-1/2	6	339-2745	.3360	1-1/2	6	339-3360
.2220	1-1/2	6	339-2220	.2750	1-1/2	6	339-2750	.3370	1-1/2	6	339-3370
.2225	1-1/2	6	339-2225	.2755	1-1/2	6	339-2755	.3380	1-1/2	6	339-3380
.2230	1-1/2	6	339-2230	.2760	1-1/2	6	339-2760	.3400	1-1/2	6	339-3400
.2235	1-1/2	6	339-2235	.2765	1-1/2	6	339-2765	.3410	1-1/2	6	339-3410
.2340	1-1/2	6	339-2340	.2790	1-1/2	6	339-2790	.3420	1-1/2	6	339-3420
.2245	1-1/2	6	339-2245	.2800	1-1/2	6	339-2800	.3425	1-1/2	6	339-3425
.2250	1-1/2	6	339-2250	.2814	1-1/2	6	339-2814	.3430	1-1/2	6	339-3430
.2255	1-1/2	6	339-2255	.2815	1-1/2	6	339-2815	.3434	1-1/2	6	339-3434
.2265	1-1/2	6	339-2265	.2818	1-1/2	6	339-2818	.3435	1-1/2	6	339-3435
.2270	1-1/2	6	339-2270	.2820	1-1/2	6	339-2820	.3440	1-1/2	6	339-3440
.2275	1-1/2	6	339-2275	.2830	1-1/2	6	339-2830	.3443	1-1/2	6	339-3443
.2280	1-1/2	6	339-2280	.2840	1-1/2	6	339-2840	.3445	1-1/2	6	339-3445
.2285	1-1/2	6	339-2285	.2850	1-1/2	6	339-2850	.3450	1-1/2	6	339-3450
.2290	1-1/2	6	339-2290	.2860	1-1/2	6	339-2860	.3455	1-1/2	6	339-3455
.2295	1-1/2	6	339-2295	.2870	1-1/2	6	339-2870	.3460	1-1/2	6	339-3460
.2320	1-1/2	6	339-2320	.2875	1-1/2	6	339-2875	.3470	1-1/2	6	339-3470
.2325	1-1/2	6	339-2325	.2890	1-1/2	6	339-2890	.3474	1-1/2	6	339-3474
.2330	1-1/2	6	339-2330	.2898	1-1/2	6	339-2898	.3475	1-1/2	6	339-3475
.2335	1-1/2	6	339-2335	.2900	1-1/2	6	339-2900	.3490	1-3/4	7	339-3490
.2350	1-1/2	6	339-2350	.2910	1-1/2	6	339-2910	.3500	1-3/4	7	339-3500
.2355	1-1/2	6	339-2355	.2920	1-1/2	6	339-2920	.3520	1-3/4	7	339-3520
.2360	1-1/2	6	339-2360	.2940	1-1/2	6	339-2940	.3530	1-3/4	7	339-3530
.2365	1-1/2	6	339-2365	.2960	1-1/2	6	339-2960	.3535	1-3/4	7	339-3535
.2370	1-1/2	6	339-2370	.2961	1-1/2	6	339-2961	.3540	1-3/4	7	339-3540
.2375	1-1/2	6	339-2375	.2965	1-1/2	6	339-2965	.3555	1-3/4	7	339-3555
.2380	1-1/2	6	339-2380	.2969	1-1/2	6	339-2969	.3560	1-3/4	7	339-3560
.2385	1-1/2	6	339-2385	.2970	1-1/2	6	339-2970	.3600	1-3/4	7	339-3600
.2390	1-1/2	6	339-2390	.2975	1-1/2	6	339-2975	.3615	1-3/4	7	339-3615
.2395	1-1/2	6	339-2395	.2980	1-1/2	6	339-2980	.3620	1-3/4	7	339-3620
.2400	1-1/2	6	339-2400	.3000	1-1/2	6	339-3000	.3650	1-3/4	7	339-3650
.2410	1-1/2	6	339-2410	.3010	1-1/2	6	339-3010	.3660	1-3/4	7	339-3660
.2415	1-1/2	6	339-2415	.3030	1-1/2	6	339-3030	.3690	1-3/4	7	339-3690
.2425	1-1/2	6	339-2425	.3040	1-1/2	6	339-3040	.3700	1-3/4	7	339-3700
.2430	1-1/2	6	339-2430	.3050	1-1/2	6	339-3050	.3710	1-3/4	7	339-3710
.2440	1-1/2	6	339-2440	.3060	1-1/2	6	339-3060	.3715	1-3/4	7	339-3715
.2445	1-1/2	6	339-2445	.3070	1-1/2	6	339-3070	.3720	1-3/4	7	339-3720

Special Decimal Chucking Reamers continued

High Speed Steel, Straight Shank, Straight Flute



Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
.3725"	1-3/4"	7"	339-3725	.4530"	1-3/4"	7"	339-4530	.6245"	2-1/4"	9"	339-2645
.3730	1-3/4	7	339-3730	.4550	1-3/4	7	339-4550	.6255	2-1/4	9	339-6255
.3735	1-3/4	7	339-3735	.4560	1-3/4	7	339-4560	.6260	2-1/4	9	339-6260
.3740	1-3/4	7	339-3740	.4580	1-3/4	7	339-4580	.6270	2-1/4	9	339-6270
.3745	1-3/4	7	339-3745	.4590	1-3/4	7	339-4590	.6280	2-1/4	9	339-6280
.3752	1-3/4	7	339-3752	.4600	1-3/4	7	339-4600	.6300	2-1/4	9	339-6300
.3755	1-3/4	7	339-3755	.4610	1-3/4	7	339-4610	.6330	2-1/4	9	339-6330
.3760	1-3/4	7	339-3760	.4650	1-3/4	7	339-4650	.6350	2-1/4	9	339-6350
.3765	1-3/4	7	339-3765	.4660	1-3/4	7	339-4660	.6870	2-1/4	9	339-6870
.3770	1-3/4	7	339-3770	.4670	1-3/4	7	339-4670	.6905	2-1/4	9	339-6905
.3780	1-3/4	7	339-3780	.4680	1-3/4	7	339-4680	.7070	2-1/4	9	339-7070
.3790	1-3/4	7	339-3790	.4690	1-3/4	7	339-4690	.7120	2-1/4	9	339-7120
.3800	1-3/4	7	339-3800	.4700	1-3/4	7	339-4700	.7235	2-1/2	9-1/2	339-7235
.3810	1-3/4	7	339-3810	.4710	1-3/4	7	339-4710	.7470	2-1/2	9-1/2	339-7470
.3820	1-3/4	7	339-3820	.4720	1-3/4	7	339-4720	.7495	2-1/2	9-1/2	339-7495
.3830	1-3/4	7	339-3830	.4725	2	8	339-4725	.7500	2-1/2	9-1/2	339-7500
.3840	1-3/4	7	339-3840	.4730	2	8	339-4730	.7505	2-1/2	9-1/2	339-7505
.3850	1-3/4	7	339-3850	.4735	2	8	339-4735	.7510	2-1/2	9-1/2	339-7510
.3860	1-3/4	7	339-3860	.4740	2	8	339-4740	.7520	2-1/2	9-1/2	339-7520
.3870	1-3/4	7	339-3870	.4750	2	8	339-4750	.7530	2-1/2	9-1/2	339-7530
.3880	1-3/4	7	339-3880	.4760	2	8	339-4760	.7550	2-1/2	9-1/2	339-7550
.3885	1-3/4	7	339-3885	.4770	2	8	339-4770	.8080	2-1/2	9-1/2	339-8080
.3900	1-3/4	7	339-3900	.4780	2	8	339-4780	.8115	2-5/8	10	339-8115
.3910	1-3/4	7	339-3910	.4800	2	8	339-4800	.8130	2-5/8	10	339-8130
.3920	1-3/4	7	339-3920	.4820	2	8	339-4820	.8275	2-5/8	10	339-8275
.3925	1-3/4	7	339-3925	.4830	2	8	339-4830	.8530	2-5/8	10	339-8530
.3930	1-3/4	7	339-3930	.4870	2	8	339-4870	.8745	2-5/8	10	339-8745
.3940	1-3/4	7	339-3940	.4890	2	8	339-4890	.8760	2-5/8	10	339-8760
.3950	1-3/4	7	339-3950	.4900	2	8	339-4900	.8780	2-5/8	10	339-8780
.3955	1-3/4	7	339-3955	.4910	2	8	339-4910	.8950	2-5/8	10	339-8950
.3960	1-3/4	7	339-3960	.4920	2	8	339-4920	.9595	2-3/4	10-1/2	339-9595
.3980	1-3/4	7	339-3980	.4930	2	8	339-4930	.9915	2-3/4	10-1/2	339-9915
.4000	1-3/4	7	339-4000	.4940	2	8	339-4940	.9950	2-3/4	10-1/2	339-9950
.4030	1-3/4	7	339-4030	.4950	2	8	339-4950	.9960	2-3/4	10-1/2	339-9960
.4050	1-3/4	7	339-4050	.4960	2	8	339-4960	.9970	2-3/4	10-1/2	339-9970
.4060	1-3/4	7	339-4060	.4970	2	8	339-4970	.9980	2-3/4	10-1/2	339-9980
.4070	1-3/4	7	339-4070	.4980	2	8	339-4980	.9990	2-3/4	10-1/2	339-9990
.4090	1-3/4	7	339-4090	.4990	2	8	339-4990	.9995	2-3/4	10-1/2	339-9995
.4100	1-3/4	7	339-4100	.4995	2	8	339-4995	1.0010	2-3/4	10-1/2	339-0010
.4110	1-3/4	7	339-4110	.5005	2	8	339-5005	1.0020	2-3/4	10-1/2	339-0020
.4120	1-3/4	7	339-4120	.5015	2	8	339-5015	1.0030	2-3/4	10-1/2	339-0030
.4210	1-3/4	7	339-4210	.5020	2	8	339-5020	1.0100	2-3/4	10-1/2	339-0100
.4250	1-3/4	7	339-4250	.5030	2	8	339-5030				
.4270	1-3/4	7	339-4270	.5040	2	8	339-5040				
.4280	1-3/4	7	339-4280	.5050	2	8	339-5050				
.4285	1-3/4	7	339-4285	.5060	2	8	339-5060				
.4295	1-3/4	7	339-4295	.5070	2	8	339-5070				
.4300	1-3/4	7	339-4300	.5080	2	8	339-5080				
.4310	1-3/4	7	339-4310	.5090	2	8	339-5090				
.4320	1-3/4	7	339-4320	.5100	2	8	339-5100				
.4340	1-3/4	7	339-4340	.5110	2	8	339-5110				
.4350	1-3/4	7	339-4350	.5120	2	8	339-5120				
.4355	1-3/4	7	339-4355	.5130	2	8	339-5130				
.4360	1-3/4	7	339-4360	.5140	2	8	339-5140				
.4370	1-3/4	7	339-4370	.5150	2	8	339-5150				
.4371	1-3/4	7	339-4371	.5160	2	8	339-5160				
.4373	1-3/4	7	339-4373	.5170	2	8	339-5170				
.4374	1-3/4	7	339-4374	.5180	2	8	339-5180				
.4380	1-3/4	7	339-4380	.5200	2	8	339-5200				
.4385	1-3/4	7	339-4385	.5210	2	8	339-5210				
.4390	1-3/4	7	339-4390	.5250	2	8	339-5250				
.4400	1-3/4	7	339-4400	.5300	2	8	339-5300				
.4410	1-3/4	7	339-4410	.5615	2	8	339-5615				
.4420	1-3/4	7	339-4420	.5635	2	8	339-5635				
.4425	1-3/4	7	339-4425	.5950	2	8	339-5950				
.4430	1-3/4	7	339-4430	.6005	2	8	339-6005				
.4450	1-3/4	7	339-4450	.6125	2-1/4	9	339-6125				
.4460	1-3/4	7	339-4460	.6160	2-1/4	9	339-6160				
.4480	1-3/4	7	339-4480	.6200	2-1/4	9	339-6200				
.4500	1-3/4	7	339-4500	.6220	2-1/4	9	339-6220				
.4510	1-3/4	7	339-4510	.6230	2-1/4	9	339-6230				
.4520	1-3/4	7	339-4520	.6240	2-1/4	9	339-6240				

Straight Shank Chucking Reamer Sets

Pieces	Description	Order No.
26	A to Z	331-0000
29	1/16" to 1/2" by 64ths	331-1000
60	No. 1-60	331-0200



Carbide Tipped Chucking Reamers

C2 Grade, Straight Flute, Right Hand Cutting

- Special steel cutting tool geometry: positive radial rake (behind center).



Straight Shank

Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.	Size	Flute Length	Overall Length	Order No.
3/16"	1-1/18"	4-1/2"	241-1012	15/32"	1-3/4"	7"	241-1030	3/4"	2-1/2"	9-1/2"	241-1048	1-1/16"	2-3/4"	10-1/2"	241-1068
7/32	1-1/4	5	241-1014	1/2	2	8	241-1032	25/32	2-1/2	9-1/2	241-1050	1-1/8	2-7/8	11	241-1072
1/4	1-1/2	6	241-1016	17/32	2	8	241-1034	13/16	2-1/2	9-1/2	241-1052	1-3/16	2-7/8	11	241-1076
9/32	1-1/2	6	241-1018	9/16	2	8	241-1036	27/32	2-1/2	9-1/2	241-1054	1-1/4	3	11-1/2	241-1080
5/16	1-1/2	6	241-1020	19/32	2	8	241-1038	7/8	2-5/8	10	241-1056	1-5/16	3	11-1/2	241-1084
11/32	1-1/2	6	241-1022	5/8	2-1/4	9	241-1040	29/32	2-5/8	10	241-1058	1-3/8	3-1/4	12	241-1088
3/8	1-3/4	7	241-1024	21/32	2-1/4	9	241-1042	15/16	2-5/8	10	241-1060	1-7/16	3-1/4	12	241-1092
13/32	1-3/4	7	241-1026	11/16	2-1/4	9	241-1044	31/32	2-5/8	10	241-1062	1-1/2	3-1/2	12-1/2	241-1096
7/16	1-3/4	7	241-1028	23/32	2-1/4	9	241-1046	1	2-3/4	10-1/2	241-1064				



Taper Shank

Size	Flute Length	Overall Length	Shank Taper	Order No.	Size	Flute Length	Overall Length	Shank Taper	Order No.	Size	Flute Length	Overall Length	Shank Taper	Order No.
1/2"	2"	8"	MT1	241-1132	11/16	2-1/4	9	MT2	241-1144	7/8	2-5/8	10	MT2	241-1156
9/16	2	8	MT1	241-1136	3/4	2-1/2	9-1/2	MT2	241-1148	15/16	2-5/8	10	MT3	241-1160
5/8	2-1/4	9	MT2	241-1140	13/16	2-1/2	9-1/2	MT2	241-1152	1	2-3/4	10-1/2	MT3	241-1164

Taper Pin & Die Maker Reamers

High Speed Steel



Size	Small End Dia.	Large End Dia.	Flute Length	Overall Length	Straight Flute Order No.	Spiral Flute Order No.	Size	Small End Dia.	Large End Dia.	Flute Length	Overall Length	Straight Flute Order No.	Spiral Flute Order No.
7/0	.0497"	.0666"	13/16"	1-13/16"	331-8200	331-8300	5	.2409"	.2994"	2-13/16"	4-5/16"	331-8222	331-8322
6/0	.0611	.0806	15/16	1-15/16	331-8202	331-8302	6	.2773	.354	3-11/16	5-7/16	331-8224	331-8324
5/0	.0719	.0966	1-3/16	2-3/16	331-8204	331-8304	7	.3297	.422	4-7/16	6-5/16	331-8226	331-8326
4/0	.0869	.1142	1-5/16	2-5/16	331-8206	331-8306	8	.3971	.505	5-3/16	7-3/16	331-8228	331-8328
3/0	.1029	.1302	1-5/16	2-5/16	331-8208	331-8308	9	.4805	.6066	6-1/16	8-5/16	331-8230	331-8330
2/0	.1137	.1462	1-9/16	2-9/16	331-8210	331-8310	10	.5799	.7216	6-13/16	9-5/16	331-8232	331-8332
0	.1287	.1638	1-11/16	2-15/16	331-8212	331-8312	11	.7060	.8780	8-1/4	11-1/4	331-8234	331-8334
1	.1447	.1798	1-11/16	2-15/16	331-8214	331-8314	12	.8420	1.0500	10	13-5/8	331-8236	331-8336
2	.1605	.2008	1-15/16	3-3/16	331-8216	331-8316	13	1.0090	1.2590	12	16	331-8238	331-8338
3	.1813	.2294	2-5/16	3-11/16	331-8218	331-8318	14	1.2500	1.5420	14	18-1/4	331-8240	331-8340
4	.2071	.2604	2-9/16	4-1/16	331-8220	331-8320							

HSS Taper Pin Reamer Sets

Pieces	Description	Straight Flute Order No.	Spiral Flute Order No.
6	0-5#	331-8250	331-8350
11	0-10#	331-8255	331-8355

Brown & Sharpe Taper Finishing Reamers

High Speed Steel

- Right hand(clockwise rotation) Cutting Direction.
- Available as hand style reamers.
- Hand reamers have straight shanks and square siving area.



B & S Taper	Small End Diameter	Large End Diameter	Shank Diameter	Flute Length	Overall Length	HSS Order No.	B & S Taper	Small End Diameter	Large End Diameter	Shank Diameter	Flute Length	Overall Length	HSS Order No.
1#	0.200"	0.320"	9/32"	2-7/8"	4-3/4"	337-6801	7#	0.600"	0.803"	3/4"	4-7/8"	7-1/2"	337-6807
2	0.250	0.380	11-32	3-1/8	5-1/8	337-6802	8	0.750	0.979	13/16	5-1/2	8-1/8	337-6808
3	0.312	0.453	13-32	3-3/8	5-1/2	337-6803	9	0.900	1.155	1	6-1/8	8-7/8	337-6809
4	0.350	0.504	6/7	3-11/16	5-7/8	337-6804	10	1.045	1.340	1-1/8	6-7/8	9-3/4	337-6810
5	0.450	0.617	6/16	4	6-3/8	337-6805	11	1.250	1.568	1-1/3	7-5/8	10-5/8	337-6811
6	0.500	0.682	5/8	4-3/8	6-7/8	337-6806	12	1.500	1.844	1-9/16	8-1/4	11-3/8	337-6812

Taper Shank Chucking Reamers

High Speed Steel, Right Hand,Spiral & Straight Flute

Fractional Sizes



Size	Flute Length	Overall Length	Shank Taper	Straight Flute Order No.	Spiral Flute Order No.	Size	Flute Length	Overall Length	Shank Taper	Straight Flute Order No.	Spiral Flute Order No.
1/4"	1-1/2"	6"	MT1	241-3005	241-4005	15/16"	2-5/8"	10"	MT3	241-3115	241-4115
9/32	1-1/2	6	MT1	241-3010	241-4010	31/32	2-5/8	10	MT3	241-3120	241-4120
5/16	1-1/2	6	MT1	241-3015	241-4015	1	2-3/4	10-1/2	MT3	241-3125	241-4125
11/32	1-1/2	6	MT1	241-3020	241-4020	1-1/32	2-3/4	10-1/2	MT3	241-3127	241-4127
3/8	1-3/4	7	MT1	241-3025	241-4025	1-1/16	2-3/4	10-1/2	MT3	241-3130	241-4130
13/32	1-3/4	7	MT1	241-3030	241-4030	1-3/32	2-3/4	10-1/2	MT3	241-3132	241-4132
7/16	1-3/4	7	MT1	241-3035	241-4035	1-1/8	2-7/8	11	MT3	241-3135	241-4135
15/32	1-3/4	7	MT1	241-3040	241-4040	1-5/32	2-7/8	11	MT3	241-3137	241-4137
1/2	2	8	MT1	241-3045	241-4045	1-3/16	2-7/8	11	MT3	241-3140	241-4140
17/32	2	8	MT1	241-3050	241-4050	1-1/4	3	11-1/2	MT4	241-3145	241-4145
9/16	2	8	MT1	241-3055	241-4055	1-9/32	3	11-1/2	MT4	241-3147	241-4147
19/32	2	8	MT1	241-3060	241-4060	1-5/16	3	11-1/2	MT4	241-3150	241-4150
5/8	2-1/4	9	MT2	241-3065	241-4065	1-3/8	3-1/4	12	MT4	241-3155	241-4155
21/32	2-1/4	9	MT2	241-3070	241-4070	1-7/16	3-1/4	12	MT4	241-3160	241-4160
11/16	2-1/4	9	MT2	241-3075	241-4075	1-1/2	3-1/2	12-1/2	MT4	241-3165	241-4165
23/32	2-1/4	9	MT2	241-3080	241-4080	1-9/16	3-1/2	12-1/2	MT4	241-3170	241-4170
3/4	2-1/2	9-1/2	MT2	241-3085	241-4085	1-5/8	3-1/2	13	MT4	241-3175	241-4175
25/32	2-1/2	9-1/2	MT2	241-3090	241-4090	1-11/16	4	13-1/2	MT4	241-3180	241-4180
13/16	2-1/2	9-1/2	MT2	241-3095	241-4095	1-3/4	4	13-1/2	MT4	241-3185	241-4185
27/32	2-1/2	9-1/2	MT2	241-3100	241-4100	1-7/8	4	14	MT4	241-3190	241-4190
7/8	2-5/8	10	MT2	241-3105	241-4105	2	4	14-1/2	MT4	241-3195	241-4195
29/32	2-5/8	10	MT2	241-3110	241-4110						

Metric Taper Shank Chucking Reamers

DIN208/A, High Speed Steel, Straight Flute



Size (mm)	Flute Length (mm)	Overall Length (mm)	Shank Taper	Order No.	Size (mm)	Flute Length (mm)	Overall Length (mm)	Shank Taper	Order No.
5	23	133	MT1	337-1050	23	66	241	MT2	337-1230
6	26	138	MT1	337-1060	24	68	268	MT3	337-1240
7	31	150	MT1	337-1070	25	68	268	MT3	337-1250
8	33	156	MT1	337-1080	26	70	273	MT3	337-1260
9	36	162	MT1	337-1090	27	71	277	MT3	337-1270
10	38	168	MT1	337-1100	28	71	277	MT3	337-1280
11	41	175	MT1	337-1110	29	73	281	MT3	337-1290
12	44	185	MT1	337-1120	30	73	281	MT3	337-1300
13	44	182	MT1	337-1130	31	75	285	MT3	337-1310
14	47	189	MT1	337-1140	32	77	317	MT4	337-1320
15	50	204	MT2	337-1150	33	77	317	MT4	337-1330
16	52	210	MT2	337-1160	34	78	321	MT4	337-1340
17	54	214	MT2	337-1170	35	78	321	MT4	337-1350
18	56	219	MT2	337-1180	36	79	325	MT4	337-1360
19	58	223	MT2	337-1190	37	79	325	MT4	337-1370
20	60	228	MT2	337-1200	38	81	329	MT4	337-1380
21	62	232	MT2	337-1210	40	81	329	MT4	337-1400
22	64	237	MT2	337-1220					

Expansion Chucking Reamers

High Speed Steel, Straight Flute

- An economical, general purpose high production reamer designed to maintain initial size by compensating for wear on the cutting edge.
- Expansion feature allows resharpener with retaining the original size.
- Expand by tightening the end adjusting screw and regrind to original size.



Straight Shank

Size	Shank Dia.	Flute Length	Overall Length	Straight Shank Order No.
3/8"	5/16"	3/4"	7"	331-9202
13/32	5/16	3/4	7	331-9204
7/16	3/8	7/8	7	331-9206
15/32	3/8	7/8	7	331-9208
1/2	7/16	1	8	331-9210
17/32	7/16	1	8	331-9212
9/16	7/16	1-1/8	8	331-9214
19/32	7/16	1-1/8	8	331-9216
5/8	9/16	1-1/4	9	331-9218
21/32	9/16	1-1/4	9	331-9220
11/16	9/16	1-1/4	9	331-9222
23/32	9/16	1-1/4	9	331-9224
3/4	5/8	1-3/8	9-1/2	331-9226
25/32	5/8	1-3/8	9-1/2	331-9228
13/16	5/8	1-3/8	9-1/2	331-9230
27/32	5/8	1-3/8	9-1/2	331-9232
7/8	3/4	1-1/2	10	331-9234
29/32	3/4	1-1/2	10	331-9236
15/16	3/4	1-1/2	10	331-9238
31/32	3/4	1-1/2	10	331-9240
1	7/8	1-5/8	10-1/2	331-9242
1-1/32	7/8	1-5/8	10-1/2	331-9244
1-1/16	7/8	1-5/8	10-1/2	331-9246
1-3/32	7/8	1-5/8	10-1/2	331-9248
1-1/8	7/8	1-3/4	11	331-9250
1-5/32	7/8	1-3/4	11	331-9252
1-3/16	1	1-3/4	11	331-9254
1-7/32	1	1-3/4	11	331-9256
1-1/4	1	1-7/8	11-1/2	331-9258
1-5/16	1	1-7/8	11-1/2	331-9260
1-3/8	1	2	12	331-9262
1-7/16	1-1/4	2	12	331-9264
1-1/2	1-1/4	2-1/8	12-1/2	331-9266
1-9/16	1-1/4	2-1/8	12-1/2	331-9268
1-5/8	1-1/4	2-1/4	13	331-9270
1-11/16	1-1/4	2-1/4	13	331-9272
1-3/4	1-1/4	2-3/8	13-1/2	331-9274
1-13/16	1-1/2	2-3/8	13-1/2	331-9276
1-7/8	1-1/2	2-1/2	14	331-9278
1-15/16	1-1/2	2-1/2	14	331-9280
2	1-1/2	2-1/2	14	331-9282
2-1/8	1-1/2	2-3/4	14-1/2	331-9284
2-1/4	1-3/4	2-3/4	14-1/2	331-9286
2-1/2	1-3/4	3	15	331-9288



Taper Shank

Size	Flute Length	Overall Length	Shank Taper	Taper Shank Order No.
3/8"	3/4"	7"	MT1	331-9302
13/32	3/4	7	MT1	331-9304
7/16	7/8	7	MT1	331-9306
15/32	7/8	7	MT1	331-9308
1/2	1	8	MT1	331-9310
17/32	1	8	MT1	331-9312
9/16	1-1/8	8	MT1	331-9314
19/32	1-1/8	8	MT1	331-9316
5/8	1-1/4	9	MT2	331-9318
21/32	1-1/4	9	MT2	331-9320
11/16	1-1/4	9	MT2	331-9322
23/32	1-1/4	9	MT2	331-9324
3/4	1-3/8	9-1/2	MT2	331-9326
25/32	1-3/8	9-1/2	MT2	331-9328
13/16	1-3/8	9-1/2	MT2	331-9330
27/32	1-3/8	9-1/2	MT2	331-9332
7/8	1-1/2	10	MT2	331-9334
29/32	1-1/2	10	MT2	331-9336
15/16	1-1/2	10	MT3	331-9338
31/32	1-1/2	10	MT3	331-9340
1	1-5/8	10-1/2	MT3	331-9342
1-1/32	1-5/8	10-1/2	MT3	331-9344
1-1/16	1-5/8	10-1/2	MT3	331-9346
1-3/32	1-5/8	10-1/2	MT3	331-9348
1-1/8	1-3/4	11	MT3	331-9350
1-5/32	1-3/4	11	MT3	331-9352
1-3/16	1-3/4	11	MT3	331-9354
1-7/32	1-3/4	11	MT3	331-9356
1-1/4	1-7/8	11-1/2	MT4	331-9358
1-5/16	1-7/8	11-1/2	MT4	331-9360
1-3/8	2	12	MT4	331-9362
1-7/16	2	12	MT4	331-9364
1-1/2	2-1/8	12-1/2	MT4	331-9366
1-5/8	2-1/4	13	MT4	331-9370
1-3/4	2-3/8	13-1/2	MT5	331-9374
1-7/8	2-1/2	14	MT5	331-9378
2	2-1/2	14	MT5	331-9382
2-1/8	2-3/4	14-1/2	MT5	331-9384
2-1/4	2-3/4	14-1/2	MT5	331-9385
2-3/8	3	15	MT5	331-9386
2-1/2	3	15	MT5	331-9388

Morse Taper Reamers

High Speed Steel

- Each morse taper reamer set consists of one finishing and one roughing reamer.



Hand Use, Straight Shank

Size	Dia. of		Flute Length	Overall Length	Roughing		2 Pcs/set
	Small End	Large End			Reamer Order No.	Reamer Order No.	
MT0	.2503"	.3674"	2-1/4"	3-3/4"	337-6100	337-6200	337-6500
MT1	.3674	.5170	3	5	337-6110	337-6210	337-6510
MT2	.5696	.7441	3-1/2	6	337-6120	337-6220	337-6520
MT3	.7448	.9881	4-1/4	7-1/4	337-6130	337-6230	337-6530
MT4	1.0167	1.2893	5-1/4	8-1/2	337-6140	337-6240	337-6540
MT5	1.4717	1.8005	6-1/4	9-3/4	337-6150	337-6250	337-6550
MT6	2.1119	2.5550	8-1/2	12-1/4	337-6160	337-6260	337-6560



Machine Use, Taper Shank

Size	Dia. of		Flute Length	Overall Length	Roughing		2 Pcs/set
	Small End	Large End			Reamer Order No.	Reamer Order No.	
MT0	.2503"	.3674"	2-1/4"	3-3/4"	337-6300	337-6400	337-6600
MT1	.3674	.5170	3	5	337-6310	337-6410	337-6610
MT2	.5696	.7441	3-1/2	6	337-6320	337-6420	337-6620
MT3	.7448	.9881	4-1/4	7-1/4	337-6330	337-6430	337-6630
MT4	1.0167	1.2893	5-1/4	8-1/2	337-6340	337-6440	337-6640
MT5	1.4717	1.8005	6-1/4	9-3/4	337-6350	337-6450	337-6650
MT6	2.1119	2.5550	8-1/2	12-1/4	337-6360	337-6460	337-6660