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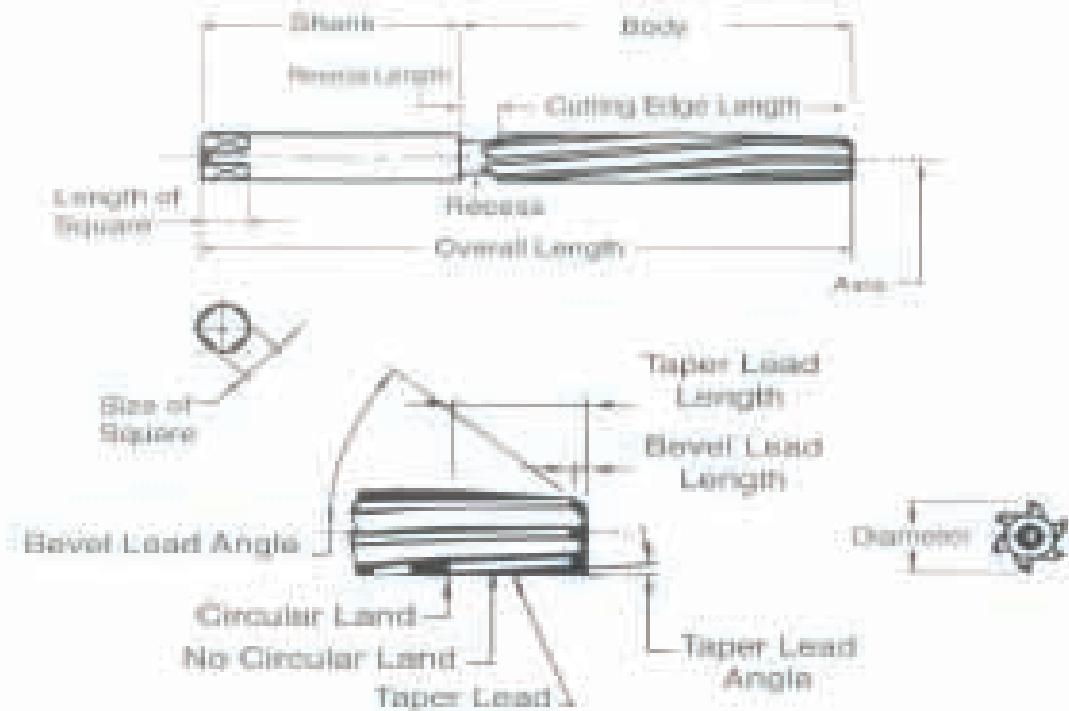
REAMERS

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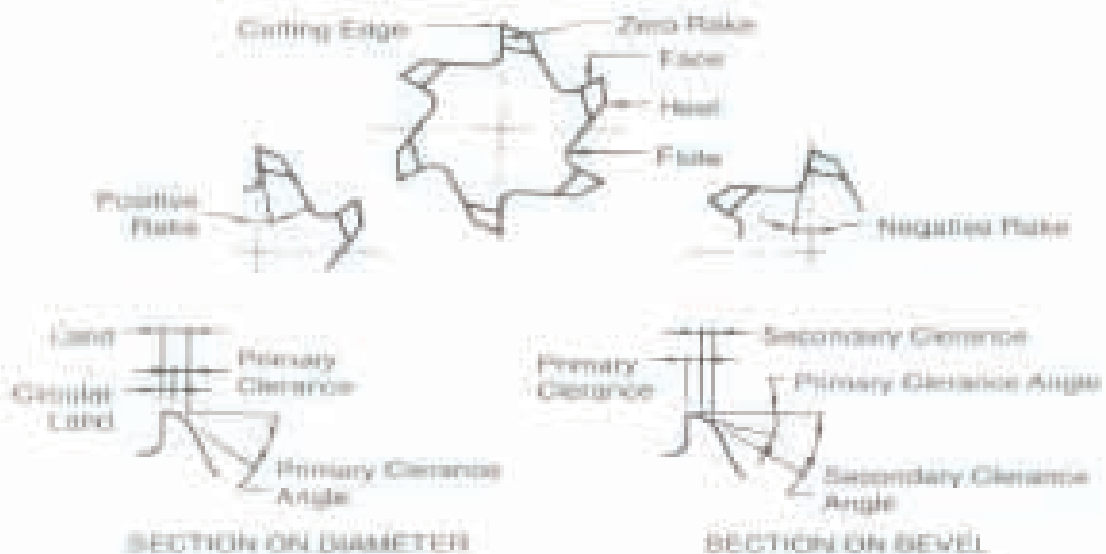
# CONTENTS

	Page No
Reamers - Nomenclature	66
Parallel Hand Reamers	67
Long Flute Machine Reamers	69
Machine Jig Reamers	70
Chucking Reamers with Parallel Shank	72
Chucking Reamers with Taper Shank	73
Shell Reamers	74
Shell Core Drills	77
Shell Drills	78
Parallel Shank Hand Socket Reamers	79
Taper Shank Machine Socket Reamers	79
Hand Taper Pin Reamers	80
Machine Taper Pin Reamers	82
Machine Bridge Reamers	84
Centre Reamers Included Angle 60° or 90°	85
Counter Bores with Morse Taper Shank and Detachable Pilots	86
Counter Bores	87
Counter Bores with Parallel Shank and Solid Pilots	88
Counter Sinks 90° with Parallel Shank and Solid Pilots	89
Counter Sinks 60°, 90° & 120° with Parallel Shank	90
Counter Sinks 60°, 90° & 120° with Morse Taper Shank	91
Counter Sinks with Taper Shank Included Angle 60° or 90°	92
Counter Sinks 60° to DIN 334	93
Counter Sinks 90° to DIN 335	95

## TERMS RELATING TO REAMERS



## TERMS RELATING TO CUTTING GEOMETRY OF REAMERS





## High Speed Steel PARALLEL HAND REAMERS

Specifications conform to  
IS 5444-1978  
ISO 236/1-1976  
DIN 206-1979  
BS 328 : Part 4: 1983  
Dimensions in mm / inch



Diameter		Cutting Edge Length	Overall Length
mm	inch		
3.0	-	31	62
-	1/8	33	66
3.5	-	35	71
4.0	5/32	38	76
4.5	-	41	81
5.0	3/16	44	87
5.5	7/32	47	93
6.0	-	47	93
-	1/4	50	100
7.0	9/32	54	107
8.0	5/16	58	115
9.0	11/32	62	124
10.0	3/8, 13/32	66	133
11.0	7/16	71	142
12.0	15/32	76	152
13.0	1/2	76	152
14.0	9/16	81	163
15.0	-	81	163
16.0	5/8	87	175
17.0	-	87	175
18.0	11/16	93	188
19.0	-	93	188

Diameter		Cutting Edge Length	Overall Length
mm	inch		
20.0	3/4	100	201
21.0	13/16	100	201
22.0	7/8	107	215
23.0	-	107	215
24.0	15/16	115	231
25.0	1	115	231
26.0	-	115	231
27.0	1.1/16	124	247
28.0	1.1/8	124	247
30.0	-	124	247
32.0	1.3/16, 1.1/4, 1.5/16	133	265
34.0	-	142	284
35.0	1.3/8	142	284
36.0	1.7/16	142	284
38.0	1.1/2	152	305
40.0	-	152	305
42.0	1.5/8	152	305
44.0	1.3/4	163	326
45.0	-	163	326
46.0	-	163	326
48.0	1.7/8	174	347
50.0	2	174	347

A Reamer having virtually parallel cutting edges, with taper & bevel lead integral with a parallel shank of the nominal diameter of the cutting edges, and with a driving square on the end of the shank.

LH Helical flutes for RH Cutting shall be supplied unless otherwise specified.



## High Speed Steel PARALLEL HAND REAMERS

Specifications conform to  
IS 5444-1978  
ISO 236/1-1976  
DIN 206-1979  
BS 328 : Part 4: 1983  
Dimensions in mm / inch



Diameter		Cutting Edge Length	Overall Length
mm	inch		
52.0	2.1/16	174	347
55.0	2.1/8	184	367
56.0	2.3/16	184	367
58.0	2.1/4	184	367
60.0	2.5/16	184	367

Diameter		Cutting Edge Length	Overall Length
mm	Inch		
62.0	2.3/8, 2.7/16	194	387
63.0	2.1/2	194	387
67.0	-	194	387
71.0	-	203	406

Tolerance on Reamer diameter is 'm6' for IS, ISO & BS standards. 'm6' tolerance is expected to produce 'H8' holes. For DIN standard, Reamer size is to be calculated to suit 'H7' holes.



# High Speed Steel LONG FLUTE MACHINE REAMERS

Specifications conform to  
IS 5445-1978  
ISO 236/11-1976  
BS 328 : Part 4: 1983  
Dimensions in mm / inch



Diameter		Cutting Edge Length	Overall Length	Morse Taper No.
mm	Inch			
3.0	-	31	111	1
-	1/8	33	113	1
4.0	5/32	38	118	1
5.0	3/16	44	124	1
6.0	-	47	127	1
-	1/4	50	130	1
7.0	9/32	54	134	1
8.0	5/16	58	138	1
9.0	11/32	62	142	1
10.0	3/8, 13/32	66	146	1
11.0	7/16	71	151	1
12.0	15/32	76	156	1
13.0	1/2	76	156	1
14.0	-	81	161	1
15.0	9/16	81	181	2
16.0	5/8	87	187	2
17.0	-	87	187	2
18.0	11/16	93	193	2
19.0	-	93	193	2
20.0	3/4	100	200	2
21.0	13/16	100	200	2
22.0	7/8	107	207	2
23.0	-	107	207	2
24.0	15/16	115	242	3
25.0	1	115	242	3
26.0	-	115	242	3

Diameter		Cutting Edge Length	Overall Length	Morse Taper No.
mm	inch			
27.0	1.1/16	124	251	3
28.0	1.1/8	124	251	3
30.0	-	124	251	3
-	1.3/16, 1.1/4	133	260	3
32.0	1.5/16	133	293	4
34.0	-	142	302	4
35.0	1.3/8	142	302	4
36.0	1.7/16	142	302	4
38.0	1.1/2	152	312	4
40.0	-	152	312	4
42.0	1.5/8	152	312	4
44.0	-	163	323	4
45.0	1.3/4	163	323	4
46.0	-	163	323	4
48.0	1.7/8	174	334	4
50.0	2	174	334	4
52.0	-	174	371	5
55.0	-	184	381	5
56.0	-	184	381	5
58.0	2.1/4	184	381	5
60.0	-	184	381	5
62.0	-	194	391	5
63.0	2.1/2	194	391	5
67.0	-	194	391	5
71.0	-	203	400	5
-	3	212	409	5

A Reamer having virtually parallel cutting edges, with bevel lead, integral with a Morse Taper Shank.

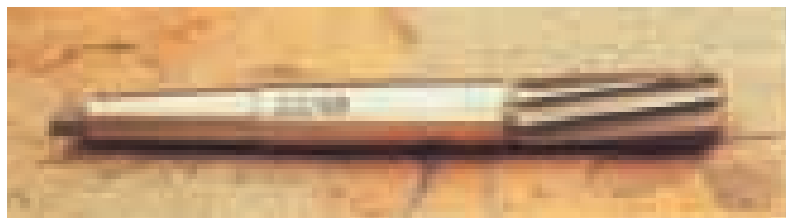
LH Helical flutes for RH Cutting shall be supplied unless otherwise specified.  
Reamers with 'm6' tolerance are expected to produce 'H8' Holes.



# High Speed Steel MACHINE JIG REAMERS

Specifications conform to  
IS 11002-1984

Dimensions in mm



Diameter m6 mm	Cutting Edge Length	Overall Length	Morse Taper No.
6.0	26	138	1
7.0	31	150	1
8.0	33	156	1
9.0	36	162	1
10.0	38	168	1
11.0	41	175	1
12.0	44	182	1
13.0	44	182	1
14.0	47	189	1
15.0	50	204	2
16.0	52	210	2
17.0	54	214	2
18.0	56	219	2
19.0	58	223	2
20.0	60	228	2
22.0	64	237	2
24.0	68	268	3

Diameter m 6 mm	Cutting Edge Length	Overall Length	Morse Taper No.
25.0	68	268	3
26.0	70	273	3
28.0	71	277	3
30.0	73	281	3
32.0	77	317	4
34.0	78	321	4
35.0	78	321	4
36.0	79	325	4
38.0	81	329	4
40.0	81	329	4
42.0	82	333	4
44.0	83	336	4
45.0	83	336	4
46.0	84	340	4
48.0	86	344	4
50.0	86	344	4

A Reamer having short, virtually parallel cutting edges with bevel lead and a guide between the shank and cutting edges, integral with a Morse Taper Shank.

LH Helical flutes for RH Cutting shall be supplied unless otherwise specified.  
Reamers with 'm6' tolerance are expected to produce 'H8' Holes.



# High Speed Steel MACHINE JIG REAMERS

Specifications conform to  
BS 122 : Part 2 : 1964  
Dimensions in inch



Diameter m6	Cutting Edge Length	Overall Length	Morse Taper No.
1/4	7/8	5.5/8	1
5/16	1	5.15/16	1
3/8	1.1/8	6.1/4	1
7/16	1.5/16	6.11/16	1
1/2	1.5/16	6.11/16	1
9/16	1.1/2	7.13/16	2
5/8	1.1/2	7.13/16	2
11/16	1.3/4	8.7/16	2
3/4	1.3/4	8.7/16	2
13/16	1.3/4	8.7/16	2
7/8	2	8.7/8	2
15/16	2	9.15/16	3
1	2	9.15/16	3

Diameter m6	Cutting Edge Length	Overall Length	Morse Taper No.
1.1/6	2.3/8	10.3/4	3
1.1/8	2.3/8	10.3/4	3
1.3/16	2.3/8	10.3/4	3
1.1/4	2.3/8	10.3/4	3
1.5/16	2.3/8	12	4
1.3/8	2.3/4	13.1/8	4
1.7/16	2.3/4	13.1/8	4
1.1/2	2.3/4	13.1/8	4
1.5/8	2.3/4	13.1/8	4
1.3/4	3.1/8	14.5/16	4
1.7/8	3.1/8	14.5/16	4
2	3.1/8	14.5/16	4

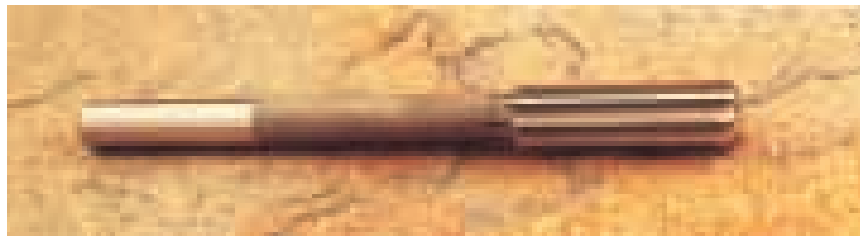
LH helical flutes for RH Cutting shall be supplied unless otherwise specified.  
Reamers with 'm6' tolerance are expected to produce 'H8' Holes.





## High Speed Steel CHUCKING REAMERS WITH PARALLEL SHANK

Specifications conform to  
 IS 5446 - 1978  
 ISO 521 - 1975  
 BS 328 : Part 4 : 1983  
 DIN 212 : Part 1 : 1979 (Type A)  
 DIN 212 : Part 2 : 1981 (Type C)  
 Dimensions in mm / inch



Diameter		Dia. of Shank	Cutting Edge Length	Overall Length
mm	inch			
3.0	-	3.0	15	61
-	1/8	3.175	16	65
3.2	-	3.2	16	65
3.5	-	3.5	18	70
4.0	5/32	4.0	19	75
4.5	-	4.5	21	80
5.0	3/16	5.0	23	86
5.5	7/32	5.6	26	93
6.0	-	5.6	26	93
-	1/4	6.3	28	101
7.0	9/32	7.1	31	109
8.0	5/16	8.0	33	117

Diameter		Dia. of Shank	Cutting Edge Length	Overall Length
mm	inch			
9.0	11/32	9.0	36	125
10.0	3/8, 13/32	10.0	38	133
11.0	7/16	10.0	41	142
12.0	15/32	10.0	44	151
13.0	1/2	10.0	44	151
14.0	-	12.5	47	160
15.0	9/16	12.5	50	162
16.0	5/8	12.5	52	170
17.0	-	14.0	54	175
18.0	-	14.0	56	182
19.0	-	16.0	58	189
20.0	-	16.0	60	195

Tolerance on Reamer diameter is 'm6' for IS, ISO & BS standards. 'm6' tolerance is expected to produce 'H8' holes. For DIN standard, Reamer size is to be calculated to suit 'H7' holes.

A reamer having short, virtually parallel cutting edges, with bevel lead, integral with a parallel shank.

Straight flutes for RH Cutting shall be supplied unless otherwise specified.



## High Speed Steel CHUCKING REAMERS WITH TAPER SHANK

Specifications conform to  
IS 5447 - 1978  
ISO 521 - 1975  
DIN 208 : 1981 (TYPE A)  
BS 328 : Part 4 : 1983  
Dimensions in mm / inch



Diameter		Cutting Edge Length	Overall Length	Morse Taper No.
mm	inch			
3.0	-	15	122	1
3.2	-	16	124	1
3.5	-	18	126	1
4.0	5/32	19	128	1
4.5	-	21	130	1
5.0	3/16	23	133	1
5.5	-	26	138	1
6.0	-	26	138	1
-	1/4	28	144	1
7.0	-	31	150	1
8.0	5/6	33	156	1
9.0	-	36	162	1
10.0	3/8	38	168	1
11.0	7/16	41	175	1
12.0	-	44	182	1
13.0	1/2	44	182	1
14.0	-	47	189	1
15.0	9/16	50	204	2
16.0	5/8	52	210	2
17.0	-	54	214	2
18.0	11/16	56	219	2
19.0	-	58	223	2

Diameter		Cutting Edge Length	Overall Length	Morse Taper No.
mm	inch			
20.0	3/4	60	228	2
-	13/16	62	232	2
22.0	7/8	64	237	2
24.0	15/16	68	268	3
25.0	-	68	268	3
26.0	1	70	273	3
28.0	1.1/16	71	277	3
30.0	1.1/8	73	281	3
-	1.3/16	75	285	3
-	1.1/4	77	290	3
32.0	1.5/16	77	317	4
34.0	-	78	321	4
35.0	1.3/8	78	321	4
36.0	1.7/16	79	325	4
38.0	1.1/2	81	329	4
40.0	-	81	329	4
42.0	1.5/8	82	333	4
44.0	-	83	336	4
45.0	1.3/4	83	336	4
46.0	-	84	340	4
48.0	1.7/8	86	344	4
50.0	2	86	344	4

Tolerance on Reamer diameter is 'm6' for IS, ISO & BS standards. 'm6' tolerance is expected to produce 'H8' holes. For DIN standard, Reamer size is to be calculated to suit 'H7' holes.

A reamer with short, virtually parallel, cutting edges with bevel lead & a long body recess between shank and cutting edges integral with Morse Taper Shank.

Straight flutes for RH Cutting shall be supplied unless otherwise specified.



## High Speed Steel SHELL REAMERS

Specifications conform to  
 IS 5926 - 1970  
 ISO 2402 - 1972  
 DIN 219 - 1981(TYPE A)  
 Dimensions in mm



Diameter	Large End Dia. of Taper Bore	Cutting Edge Length	Overall Length
21	10	28	40
22	10	28	40
23	10	28	40
24	13	32	45
25	13	32	45
26	13	32	45
27	13	32	45
28	13	32	45
29	13	32	45
30	13	32	45
31	16	36	50
32	16	36	50
33	16	36	50
34	16	36	50
35	16	36	50
36	19	40	56
37	19	40	56
38	19	40	56
39	19	40	56
40	19	40	56
41	19	40	56
42	19	40	56

Diameter	Large End Dia. of Taper Bore	Cutting Edge Length	Overall Length
43	22	45	63
44	22	45	63
45	22	45	63
46	22	45	63
47	22	45	63
48	22	45	63
49	22	45	63
50	22	45	63
51	27	50	71
52	27	50	71
53	27	50	71
54	27	50	71
55	27	50	71
56	27	50	71
57	27	50	71
58	27	50	71
59	27	50	71
60	27	50	71
61	32	56	80
62	32	56	80
63	32	56	80
64	32	56	80

A short reamer with an axial taper hole generally 1:30 with a cross slot for use on an arbor, and having parallel cutting edges with bevel lead.

Reamers shall be supplied for Right Hand cutting with straight flutes unless otherwise specified.



## High Speed Steel SHELL REAMERS

Specifications conform to  
IS 5926 - 1970  
ISO 2402 - 1972  
DIN 219 - 1981 (TYPE A)  
Dimensions in mm



Diameter	Large End Dia. of Taper Bore	Cutting Edge Length	Overall Length
65	32	56	80
66	32	56	80
67	32	56	80
68	32	56	80
69	32	56	80
70	32	56	80
71	32	56	80
72	40	63	90
73	40	63	90
74	40	63	90
75	40	63	90
76	40	63	90
77	40	63	90
78	40	63	90
79	40	63	90
80	40	63	90
81	40	63	90
82	40	63	90

Diameter	Large End Dia. of Taper Bore	Cutting Edge Length	Overall Length
83	40	63	90
84	40	63	90
85	40	63	90
86	50	71	100
87	50	71	100
88	50	71	100
89	50	71	100
90	50	71	100
91	50	71	100
92	50	71	100
93	50	71	100
94	50	71	100
95	50	71	100
96	50	71	100
97	50	71	100
98	50	71	100
99	50	71	100
100	50	71	100

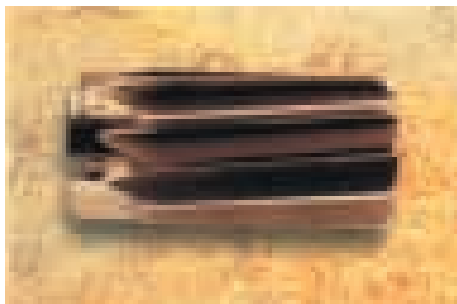
Tolerance on Reamer diameter is 'm6' for IS & ISO standards. 'm6' tolerance is expected to produce 'H8' holes. For DIN standard, Reamer size is to be calculated to suit 'H7' holes.



# High Speed Steel SHELL REAMERS

Specifications conform to  
BS 328 : Part 4 : 1983

Dimensions in inches



Diameter m6	Cutting Edge Length	Overall Length	Diameter of* large end of Taper Bore
1	2.1/4	2.3/4	0.625
1.1/16	2.1/4	2.3/4	0.625
1.1/8	2.1/4	2.3/4	0.625
1.3/16	2.1/4	2.3/4	0.625
1.1/4	2.1/4	2.3/4	0.625
1.5/16	2.3/8	3	0.750
1.3/8	2.3/8	3	0.750
1.7/16	2.3/8	3	0.750
1.1/2	2.3/8	3	0.750
1.9/16	2.3/8	3	0.750
1.5/8	2.3/8	3	0.750
1.11/16	2.3/4	3.1/2	1.000
1.3/4	2.3/4	3.1/2	1.000
1.13/16	2.3/4	3.1/2	1.000
1.7/8	2.3/4	3.1/2	1.000
1.15/16	2.3/4	3.1/2	1.000
2	2.3/4	3.1/2	1.000
2.1/16	3	3.3/4	1.250
2.1/8	3	3.3/4	1.250

Diameter m6	Cutting Edge Length	Overall Length	Diameter of* large end of Taper Bore
2.3/16	3	3.3/4	1.250
2.1/4	3	3.3/4	1.250
2.5/16	3	3.3/4	1.250
2.3/8	3	3.3/4	1.250
2.7/16	3	3.3/4	1.250
2.1/2	3.1/4	4	1.500
2.5/8	3.1/4	4	1.500
2.3/4	3.1/4	4	1.500
2.7/8	3.1/4	4	1.500
3	3.1/4	4	1.500
3.1/8	3.3/4	4.1/2	1.750
3.1/4	3.3/4	4.1/2	1.750
3.3/8	3.3/4	4.1/2	1.750
3.1/2	3.3/4	4.1/2	1.750
3.5/8	4.1/4	5	2.000
3.3/4	4.1/4	5	2.000
3.7/8	4.1/4	5	2.000
4	4.1/4	5	2.000

\*Taper of the bore is 1/8 inch per foot on diameter.

Reamers shall be supplied for Right Hand cutting with Left Hand Helical flutes unless otherwise specified. Reamers with 'm6' tolerance are expected to produce 'H8' Holes.



## High Speed Steel SHELL CORE DRILLS

Specifications conform to  
IS 7772 - 1975  
ISO 3314 - 1975  
DIN 222 - 1981  
Dimensions in mm



Diameter h8	Diameter of large end of Taper Bore	Overall Length
25	13	45
26	13	45
27	13	45
28	13	45
29	13	45
30	13	45
31	13	45
32	13	45
33	13	45
34	13	45
35	13	45
36	16	50
37	16	50
38	16	50
39	16	50
40	16	50
42	16	50
44	16	50
45	16	50

Diameter h8	Diameter of large end of Taper Bore	Overall Length
46	19	56
47	19	56
48	19	56
50	19	56
52	19	56
55	22	63
58	22	63
60	22	63
62	22	63
65	27	71
70	27	71
72	27	71
75	27	71
80	32	80
85	32	80
90	32	80
95	40	90
100	40	90

A Short Shell core drill with an axial taper hole generally 1 : 30 with cross slot for use on an arbor, the bevelled lead being provided with clearance for cutting purposes.

RH Helical flutes for RH cutting shall be supplied unless otherwise specified.



# High Speed Steel SHELL DRILLS

Specifications conform to  
BS 122 : Part 2 : 1964

Dimensions in Inches



Diameter h8	Cutting Edge Length	Overall Length	Diameter of* large end of Taper Bore
1	2.1/4	2.3/4	0.625
1.1/16	2.1/4	2.3/4	0.625
1.1/8	2.1/4	2.3/4	0.625
1.3/16	2.1/4	2.3/4	0.625
1.1/4	2.1/4	2.3/4	0.625
1.5/16	2.3/8	3	0.750
1.3/8	2.3/8	3	0.750
1.7/16	2.3/8	3	0.750
1.1/2	2.3/8	3	0.750
1.9/16	2.3/8	3	0.750
1.5/8	2.3/8	3	0.750
1.11/16	2.3/4	3.1/2	1.000
1.3/4	2.3/4	3.1/2	1.000
1.13/16	2.3/4	3.1/2	1.000
1.7/8	2.3/4	3.1/2	1.000
1.15/16	2.3/4	3.1/2	1.000
2	2.3/4	3.1/2	1.000
2.1/16	3	3.3/4	1.250
2.1/8	3	3.3/4	1.250

Diameter h8	Cutting Edge Length	Overall Length	Diameter of* large end of Taper Bore
2.3/16	3	3.3/4	1.250
2.1/4	3	3.3/4	1.250
2.5/16	3	3.3/4	1.250
2.3/8	3	3.3/4	1.250
2.7/16	3	3.3/4	1.250
2.1/2	3.1/4	4	1.500
2.5/8	3.1/4	4	1.500
2.3/4	3.1/4	4	1.500
2.7/8	3.1/4	4	1.500
3	3.1/4	4	1.500
3.1/8	3.3/4	4.1/2	1.750
3.1/4	3.3/4	4.1/2	1.750
3.3/8	3.3/4	4.1/2	1.750
3.1/2	3.3/4	4.1/2	1.750
3.5/8	4.1/4	5	2.000
3.3/4	4.1/4	5	2.000
3.7/8	4.1/4	5	2.000
4	4.1/4	5	2.000

\* Taper of the bore is 1/8 inch per foot on diameter

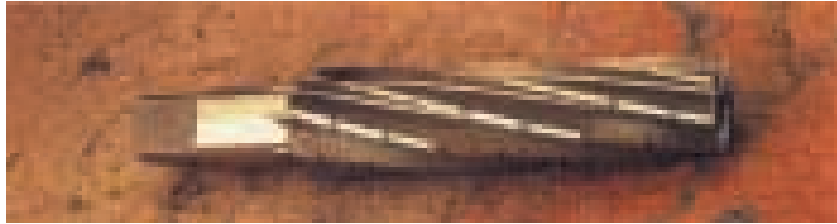
RH Helical flutes for RH cutting shall be supplied unless otherwise specified.



## High Speed Steel PARALLEL SHANK HAND SOCKET REAMERS

Specifications conform to  
BS 328 : Part 4 : 1983  
IS 5882 : 1970

Dimensions in mm



Designation	Cutting Edge Length	Overall Length	Dia. of Shank
Morse No. 0	61	93	8
Morse No. 1	66	102	10
Morse No. 2	79	121	14
Morse No. 3	96	146	20

Designation	Cutting Edge Length	Overall Length	Dia. of Shank
Morse No. 4	119	179	25.0
Morse No. 5	150	222	31.5
Morse No. 6	208	300	45.0

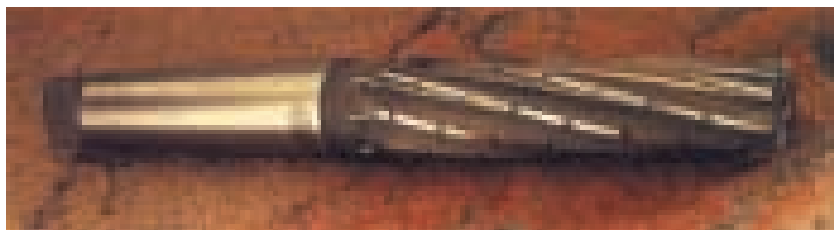
Roughing Reamers shall be supplied with RH Helix and RH cutting with nicking.  
Finishing Reamers shall be supplied with LH Helix and RH Cutting without nicking.



## High Speed Steel TAPER SHANK MACHINE SOCKET REAMERS

Specifications conform to  
BS 328 : Part 4 : 1983  
IS 5907 : 1970

Dimensions in mm



Designation	Cutting Edge Length	Length	Morse Taper No.
Morse No. 0	61	137	1
Morse No. 1	66	142	1
Morse No. 2	79	173	2
Morse No. 3	96	212	3

Designation	Cutting Edge Length	Overall Length	Morse Taper No.
Morse No. 4	119	263	4
Morse No. 5	150	331	5
Morse No. 6	208	389	5

Roughing Reamers shall be supplied with RH Helix and RH cutting with nicking.  
Finishing Reamers shall be supplied with LH Helix and RH Cutting without nicking.





# High Speed Steel HAND TAPER PIN REAMERS

Specifications conform to  
IS 5881 - 1984  
ISO 3465 - 1975  
DIN 9-1975

Dimensions in mm



Nom. Diameter	Cutting Edge Length	Overall Length
3	58	80
4	68	93
5	73	100
6	105	135
8	145	180
10	175	215
12	210	255

Nom. Diameter	Cutting Edge Length	Overall Length
16	230	280
20	250	310
25	300	370
30	320	400
40	340	430
50	360	460

A reamer having tapered cutting edges for holes to suit pins with a taper of 1:50 on diameter integral with a parallel shank with driving square at the end.

Reamers with straight flutes and RH cutting shall be supplied unless otherwise specified.



# High Speed Steel HAND TAPER PIN REAMERS

Specifications conform to  
BS 328 : Part 4 : 1983

Dimensions in inches



Nom. Diameter	Cutting Edge Length	Overall Length	Large End Dia and Dia of Shank	Small End Dia.
1/8	1.3/4	2.3/4	0.127	0.0905
9/64	1.7/8	2.7/8	0.143	0.1039
5/32	2	3	0.158	0.1163
11/64	2.1/4	3.1/2	0.174	0.1271
3/16	2.3/4	4	0.195	0.1377
7/32	2.3/4	4	0.220	0.1627
1/4	3.3/8	4.5/8	0.253	0.1827
9/32	4.1/8	5.5/8	0.292	0.2061
5/16	4.1/8	5.5/8	0.316	0.2301
11/32	4.1/2	6	0.347	0.2533
3/8	5	6.1/2	0.381	0.2768
13/32	5.3/4	7.1/2	0.412	0.2922
7/16	5.3/4	7.1/2	0.443	0.3232
1/2	6.1/2	8.1/4	0.506	0.3706
9/16	6.3/4	8.1/2	0.571	0.4304
5/8	7.1/2	9.1/4	0.633	0.4768
3/4	8.3/4	10.3/4	0.760	0.5777
7/8	9.1/2	12	0.885	0.6871

Taper on diameter 1 in 48

Straight flutes for RH cutting shall be supplied unless otherwise specified.



# High Speed Steel MACHINE TAPER PIN REAMERS

Specifications conform to  
IS 5918 - 1984  
ISO 3467 - 1975  
DIN 2180 - 1975  
Dimensions in mm



Nom. Diameter	Cutting Edge Length	Overall Length	Morse Taper No.
3	58	140	1
4	68	150	1
5	73	155	1
6	105	187	1
8	145	227	1
10	175	257	1
12	210	315	2

Nom. Diameter	Cutting Edge Length	Overall Length	Morse Taper No.
16	230	335	2
20	250	377	3
25	300	427	3
30	320	475	4
40	340	495	4
50	360	550	5

Nom. diameter 3 & 4 are not covered in IS, ISO & DIN standard.

A reamer having tapered cutting edges for holes to suit pins with a taper of 1:50 on diameter integral with a Morse Taper Shank.

LH Helical flutes for RH cutting shall be supplied unless otherwise specified.



# High Speed Steel MACHINE TAPER PIN REAMERS

Specifications conform to  
BS 328 : Part 4 : 1983

Dimensions in Inches



Nom. Diameter	Cutting Edge Length	Overall Length	Large End Dia	Small End Dia.	Morse Taper No.
3/16	3.1/8	6.1/16	0.199	0.1337	1
7/32	3.3/16	6.1/8	0.225	0.1581	1
1/4	3.7/8	6.13/16	0.258	0.1775	1
9/32	4.5/8	7.5/8	0.297	0.2009	1
5/16	4.5/8	7.5/8	0.321	0.2249	1
11/32	5.3/32	8.3/32	0.353	0.2471	1
3/8	5.13/16	8.7/8	0.389	0.2683	1
13/32	6.9/16	9.5/8	0.420	0.2837	1
7/16	6.11/16	9.3/4	0.453	0.3134	1
1/2	7.7/16	10.1/2	0.516	0.3608	1
9/16	7.3/4	11.1/2	0.581	0.4200	2
5/8	8.1/2	12.1/4	0.643	0.4664	2
3/4	9.3/4	13.1/2	0.770	0.5673	2
7/8	10.1/2	14.1/4	0.895	0.6767	2

Taper on diameter 1 : 48

Left Hand Helical Flutes for Right Hand cutting shall be supplied unless otherwise specified.



# High Speed Steel MACHINE BRIDGE REAMERS

Specifications conform to  
 IS 5919 - 1978  
 ISO 2238 - 1972  
 DIN 311 - 1975  
 BS 328 : Part 4 : 1983  
 Dimensions in mm / inch



Diameter k 11		Cutting Edge Length	Overall Length	Morse Taper No.
mm	inch			
6.4	1/4	75	151	1
7.4	-	80	156	1
8.4	-	85	161	1
11.0	7/16	100	176	1
13.0	1/2	105	199	2
15.0	9/16	125	219	2
-	5/8	135	229	2
17.0	-	135	251	3
19.0	11/16	145	261	3
21.0	3/4, 13/16	155	271	3
23.0	7/8	165	281	3
25.0	15/16, 1	180	296	3
28.0	1.1/16, 1.1/8	195	311	3
31.0	1.3/16	210	326	3
-	1.1/4, 1.5/16	210	354	4
34.0	1.3/8	220	364	4
37.0	-	220	364	4
40.0	1.1/2	230	374	4
43.0	-	240	384	4
49.0	-	250	394	4

A reamer having parallel cutting edges with a long taper lead, integral with a Morse Taper Shank.

LH helical flutes for RH cutting shall be supplied unless otherwise specified.

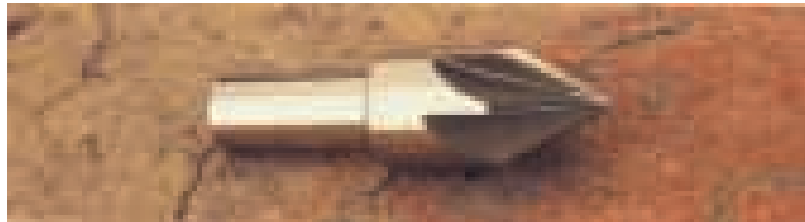


# High Speed Steel CENTRE REAMERS

Included Angle  $60^{\circ}$  or  $90^{\circ}$

Specifications conform to  
BS 122 : Part 2:1964

Dimensions in Inches



Body Diameter	Overall Length	Length of Shank	Diameter of Shank
1/4	1.1/2	3/4	3/16
3/8	1.3/4	7/8	1/4
1/2	2	1	3/8

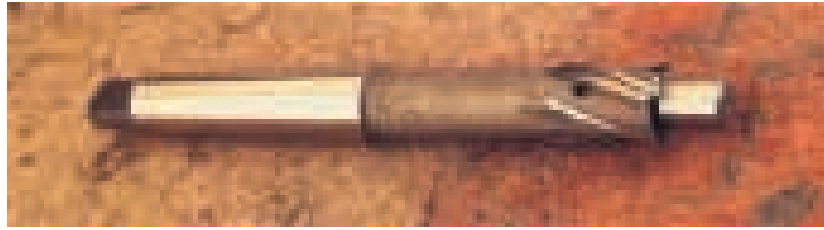
Body Diameter	Overall Length	Length of Shank	Diameter of Shank
5/8	2.1/4	1	3/8
3/4	2.5/8	1.1/4	1/2

A cutter with teeth on the conical cutting face, integral with a parallel shank, designed for reaming a preformed centre or for producing a conical seating.



# High Speed Steel COUNTERBORES WITH MORSE TAPER SHANKS AND DETACHABLE PILOTS

Specifications conform to  
IS 5710 - 1988  
ISO 4207 - 1977  
DIN 375 - 1975  
Dimensions in mm



Diameter z9	Cutting Edge Length	Overall Length	Morse Taper No.	Pilot Diameter
13.5	22	132	2	5.0 to11.2
14.5	22	132	2	5.0 to12.5
16.5	25	140	2	6.3 to14.0
17.5	25	140	2	6.3 to14.0
19.5	25	140	2	6.3 to16.0
20	25	140	2	6.3 to18.0
22	30	150	2	8.0 to18.0
23	30	150	2	8.0 to20.0
25	30	150	2	8.0 to22.4
26	35	180	3	10.0 to22.4
28	35	180	3	10.0 to22.4
29	35	180	3	10.0 to25.0
31	35	180	3	10.0 to 25.0
33	40	190	3	12.5 to28.0
34	40	190	3	12.5 to28.0

Diameter z9	Cutting Edge Length	Overall Length	Morse Taper No.	Pilot Diameter
36	40	190	3	12.5 to 31.5
37	40	190	3	12.5 to 31.5
39	40	190	3	12.5 to 31.5
41	50	236	4	16.0 to 35.5
43	50	236	4	16.0 to 35.5
46	50	236	4	16.0 to 40.0
48	50	236	4	16.0 to 40.0
51	63	250	4	20.0 to 40.0
53	63	250	4	20.0 to 45.0
55	63	250	4	20.0 to 45.0
57	63	250	4	20.0 to 50.0
59	63	250	4	20.0 to 50.0
61	63	250	4	20.0 to 50.0
63	63	250	4	20.0 to 56.0

A cutter with teeth on the periphery and the end, integral with a Morse Taper Shank, and having a detachable pilot. The cutter is intended for producing a flat seating for the accommodation of the head of a bolt set screw etc. and is located by means of the pilot with relation to a centre hole.



## High Speed Steel COUNTER BORES

Specifications conform to  
BS 122 : Part 2 : 1964

Dimensions in Inches



Diameter	Cutting Edge Length	Overall Length	Morse Taper No.	Pilot Dia.
1/4	3/8	3.3/4	1	1/8
5/16	7/16	4	1	3/16
3/8	1/2	4.1/4	1	7/32
7/16	5/8	4.1/2	1	1/4
1/2	3/4	4.3/4	1	5/16
9/16	13/16	5.3/8	2	3/8
5/8	7/8	5.5/8	2	7/16
11/16	15/16	5.7/8	2	7/16
3/4	1	5.15/16	2	1/2
13/16	1.1/16	6.3/16	2	9/16
7/8	1.1/8	6.7/16	2	5/8
15/16	1.1/4	7.7/16	3	5/8
1	1.3/8	7.1/2	3	3/4
1.1/8	1.1/2	7.3/4	3	3/4
1.1/4	1.5/8	8	3	3/4
1.3/8	1.3/4	9	4	13/16
1.1/2	1.7/8	9	4	7/8
1.5/8	2	9	4	15/16
1.3/4	2.1/8	9	4	1
1.7/8	2.1/4	9	4	1.1/8
2	2.1/2	9	4	1.1/4

Counterbores of size upto and including 1/2" dia are supplied with solid pilot.

Tolerance on dia.of counterbores:	
Sizes from 1/4" upto & including 3/4"	= + 0.010" /+0.005"
Over 3/4" upto & including 2"	= + 0.015" /+0.010"





**High Speed Steel  
COUNTERBORES WITH  
PARALLEL SHANKS AND SOLID PILOTS**

Specifications conform to  
IS 5704 - 1988  
ISO 4206 - 1977  
DIN 373 - 1975  
Dimensions in mm



Diameter z9	Dia. of Shank h9	Cutting Edge Length	Overall Length
6	5	14	71
7	5	14	71
8	5	14	71
9	8	18	80
10	8	18	80
11	8	18	80
12	8	18	80
12.5	8	18	80

Diameter z9	Dia. of Shank h9	Cutting Edge Length	Overall Length
13	12.5	22	100
14	12.5	22	100
15	12.5	22	100
16	12.5	22	100
17	12.5	22	100
18	12.5	22	100
19	12.5	22	100
20	12.5	22	100

Pilot Diameter: To be specified to suit pilot hole diameter when ordering. (minimum possible pilot diameter is equal to 1/3rd of counter bore diameter.) Tolerance on pilot diameter is e8.

A cutter with teeth on the periphery and end, integral with a parallel shank, and having a pilot. The cutter is intended for producing a flat seating for the accommodation of the head of a bolt set screw etc. and is located by means of the pilot with relation to a centre hole.



High Speed Steel  
**COUNTER SINKS 90°**  
 WITH PARALLEL SHANKS AND SOLID PILOTS

Specifications conform to  
 IS 5693 - 1988  
 ISO 4205 - 1977  
 DIN 1866 - 1975  
 Dimensions in mm



Diameter z9	Did. of Shank h9	Cutting Edge Length	Overall Length
10.0	8.0	18	80
11.0	8.0	18	80
12.0	8.0	18	80
12.5	8.0	18	80
13.0	12.5	22	100
14.0	12.5	22	100

Diameter z9	Did. of Shank h9	Cutting Edge Length	Overall Length
15	12.5	22	100
16	12.5	22	100
17	12.5	22	100
18	12.5	22	100
19	12.5	22	100
20	12.5	22	100

Pilot Diameter: To be specified to suit pilot hole diameter when ordering. (minimum possible pilot diameter is equal to 1/3rd of counter sink diameter.) Tolerance on pilot diameter is e8.

A cutter with teeth on conical cutting faces, integral with a parallel shank, designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.



## High Speed Steel COUNTERSINKS 60°, 90° AND 120° WITH PARALLEL SHANK

Specifications conform to  
IS 13304 - 1992  
ISO 3294 - 1975  
BS 328 : Part 5 : 1983  
Dimensions in mm



Nominal size	Small Dia.	Overall Length		Body Length		Shank Dia. h9
		$\alpha=60^\circ$	$\alpha=90^\circ \& 120^\circ$	$\alpha=60^\circ$	$\alpha=90^\circ \& 120^\circ$	
8.0	1.6	48	44	-	-	8
10.0	2.0	50	46	18	14	8
12.5	2.5	52	48	20	16	8
16.0	3.2	60	56	24	20	10
20.0	4.0	64	60	28	24	10
25.0	7.0	69	65	33	29	10

A cutter with teeth on the conical cutting faces, integral with a parallel shank designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.

RH. cutting with straight teeth shall be supplied unless otherwise specified.



## High Speed Steel COUNTERSINKS 60° , 90° AND 120° WITH MORSE TAPER SHANK

Specifications conform to  
IS 13303 - 1992  
ISO 3293 - 1975  
BS 328 : Part 5 : 1983  
Dimensions in mm



Nominal size	Small Dia .	Overall Length		Body Length		Morse Taper No.
		$\alpha=60^\circ$	$\alpha=90^\circ \& 120^\circ$	$\alpha=60^\circ$	$\alpha=90^\circ \& 120^\circ$	
16.0	3.2	97	93	24	20	1
20.0	4.0	120	116	28	24	2
25.0	7.0	125	121	33	29	2
31.5	9.0	132	124	40	32	2
40.0	12.5	160	150	45	35	3
50.0	16.0	165	153	50	38	3
63.0	20.0	200	185	58	43	4
80.0	25.0	215	196	73	54	4

A cutter with teeth on the conical cutting faces, integral with a Morse Taper Shank designed to produce a conical seating to accommodate the conical head of a component such as screw or rivet.

R.H. cutting with straight teeth shall be supplied unless otherwise specified.



High Speed Steel  
**COUNTERSINKS WITH TAPER SHANKS**  
 Included Angle 60° or 90°

Specifications conform to  
 BS 122 : Part 2 : 1964

Dimensions in Inches



Body Diameter	Overall Length	Small Diameter	Morse Taper No.
1/2	3.1/2	5/32	1
5/8	3.5/8	3/16	1
3/4	4.1/4	1/4	2
7/8	4.1/4	9/32	2
1	4.3/8	5/16	2
1.1/8	4.1/2	3/8	2
1.1/4	5.3/8	13/32	3
1.3/8	5.3/8	7/16	3

Body Diameter	Overall Length	Small Diameter	Morse Taper No.
1.1/2	5.1/2	1/2	3
1.3/4	6.3/4	9/16	4
2	7	21/32	4
2.1/4	7.1/4	3/4	4
2.1/2	7.3/4	13/16	4
2.3/4	8	7/8	4
3	8.1/4	1	4

Tolerance on body dia:  
 Sizes upto and incl. 1" = -0.001" /- 0.003"  
 Over 1" = -0.002" /- 0.005"  
 RH cutting with straight flutes shall be supplied unless otherwise specified.



## High Speed Steel COUNTER SINKS 60°

Specifications conform to  
DIN 334 - 1979

Dimensions in mm

### Form'A - Straight Shank



Nominal size	Shank dia	Small end dia	Overall Length	Body Length
8.0	-	-	50	-
12.5	8	2.0	50	18
16.0	10	3.2	60	24
20.0	10	5.0	63	27

### Form'B' - Morse Taper Shank



Nominal size	Small end dia	Overall Length	Body Length	Morse Taper No.
16.0	3.2	100	24	1
25.0	7.0	125	33	2
31.5	9.0	132	40	2
40.0	12.0	160	45	3
50.0	16.0	170	50	3
63.0	20.0	200	58	4
80.0	25.0	215	73	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified



## High Speed Steel COUNTER SINKS 60°

Specifications conform to  
DIN 334 - 1979

Dimensions in mm

Form 'C' - Straight Shank with 3 cutting edges



Nominal size	Shank dia	Small end dia	Overall Length	Body Length
6.3	5	1.6	45	6.3
8.0	6	2.0	50	8.0
12.5	8	3.2	56	11.2
16.0	10	4.0	63	14.0
20.0	10	5.0	67	17.0
25.0	10	6.3	71	20.0

Form 'D' - Morse Taper Shank with 3 cutting edges



Nominal size	Small end dia	Overall Length	Body Length	Morse Taper No.
16.0	4.0	90	14.0	1
20.0	5.0	106	17.0	2
25.0	6.3	112	20.0	2
31.5	10.0	118	22.4	2
40.0	12.5	150	28.0	3
50.0	16.0	160	35.5	3
63.0	20.0	190	42.5	4
80.0	25.0	200	53.0	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified



## High Speed Steel COUNTER SINKS 90°

Specifications conform to  
DIN 335 - 1979

Dimensions in mm

### Form 'A' - Straight Shank



Nominal size	Shank dia	Small end dia	Overall Length	Body Length
8.0	-	-	48	-
12.5	8	2	48	16
16.0	10	3.2	56	20
20.0	10	5	60	24

### Form 'B' - Morse Taper Shank



Nominal size	Small end dia	Overall Length	Body Length	Morse Taper No
16.0	3.2	95	20	1
25.0	7.0	118	26	2
31.5	9.0	122	30	2
40.0	12.0	150	35	3
50.0	16.0	155	38	3
63.0	20.0	185	43	4
80.0	25.0	196	54	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified





## High Speed Steel COUNTER SINKS 90°

Specifications conform to  
DIN 335 - 1979

Dimensions in mm

Form 'C' - Straight Shank with 3 cutting edges

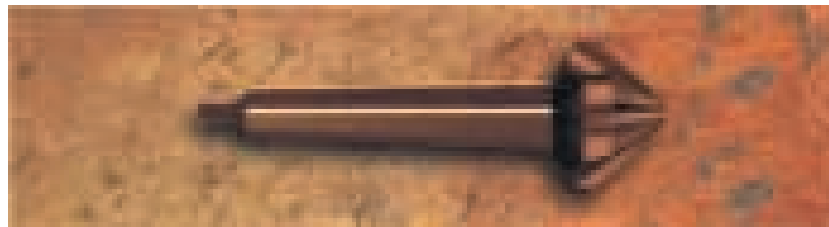


Nominal Size	Shank dia	Small End dia.	Overall Length	Body Length
4.3	4	1.3	40	3.5
5.0	4	1.5	40	4.0
5.3	4	1.5	40	4.0
5.8	5	1.5	45	4.5
6.0	5	1.5	45	4.5
6.3	5	1.5	45	5.0
7.0	6	1.8	50	5.0
7.3	6	1.8	50	5.6
8.0	6	2.0	50	5.6
8.3	6	2.0	50	6.0
9.4	6	2.2	50	6.7
10.0	6	2.5	50	7.1
10.4	6	2.5	50	7.1

Nominal Size	Shank dia	Small End dia.	Overall Length	Body Length
11.5	8	2.8	56	7.5
12.4	8	2.8	56	8.0
13.4	8	2.9	56	8.5
15.0	10	3.2	60	9.0
16.5	10	3.2	60	10.0
19.0	10	3.5	63	11.2
20.5	10	3.5	63	12.5
23.0	10	3.8	67	13.2
25.0	10	3.8	67	15.0
26.0	10	3.8	67	15.0
28.0	12	4.0	71	16.0
30.0	12	4.2	71	18.0
31.0	12	4.2	71	18.0

R.H. Cutting with straight teeth shall be supplied unless otherwise specified

Form 'D' - Morse Taper Shank with 3 cutting edges



Nominal Size	Small End dia.	Overall Length	Body Length	Morse Taper No.
15.0	3.2	85	9.0	1
16.5	3.2	85	10.0	1
19.0	3.5	100	11.2	2
20.5	3.5	100	12.5	2
23.0	3.8	106	13.2	2
25.0	3.8	106	15.0	2
26.0	3.8	106	15.0	2
28.0	4.0	112	16.0	2

Nominal Size	Small End dia.	Overall Length	Body Length	Morse Taper No.
30	4.2	112	18.0	2
31	4.2	112	18.0	2
34	4.5	118	19.0	2
37	4.8	118	21.2	2
40	10.0	140	20.0	3
50	14.0	150	23.6	3
63	16.0	180	28.0	4
80	22.0	190	35.5	4

R.H. Cutting with straight teeth shall be supplied unless otherwise specified