



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



Diameters		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

Diameters		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.



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Diameters		Cutting Edge Length	Overall Length
mm	Inch		
52.00	2.1/16	174	347
55.00	2.1/8	184	367
56.00	2.3/16	184	367
58.00	2.1/4	184	367
60.00	2.5/16	184	367
62.00	2.3/8, 2.7/16	194	387
63.00	2.1/2	194	387
67.00	-	194	387
71.00	-	203	406

Tolerance on Reamer diameters is ± 0.005 for IS, ISO & BS Standards. ± 0.005 tolerance is expected to produce 'H7' holes. For DIN Standard, Reamer size is to be calculated to suit 'H7' holes.