



**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	-	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' tolerances 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	5/16	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
44.00	-	83	336	4
45.00	1,3/4	83	336	4
46.00	-	84	340	4
48.00	1,7/8	86	344	4
50.00	2	86	344	4

Tolerance on Reamers is 'm6' for IS, ISO & BS Standards. 'm6' tolerances 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 & along body recess between shank and cutting edges integral with Morse Taper Shank.

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