

Expansion Chucking Reamers

Carbide Tipped

- For general purpose reaming in all materials
- Expansion reamers should not be considered as adjustable or for use in producing holes of various sizes
- They should be ordered to the exact finished size required
- As the diameter wears the reamer can be expanded by tightening the adjustment screw then reground to its original size
- After repetitive sharpening the tool's back taper may become inadequate due to wear on the margin. Proper sharpening techniques should be employed

DIAMETER TOLERANCE: +0.0003"/-0.0000"

NUMBER OF FLUTES: 0.2501" to 0.5030" have 4 flutes
 0.5031" to 0.9410" have 6 flutes
 0.9411" and larger have 8 flutes

Straight Shank



Decimal Size	Tool Size	Flute Length	Overall Length	Shank Size	Morse Taper	Code	Decimal Size	Tool Size	Flute Length	Overall Length	Shank Size	Morse Taper	Code
0.3750	3/8	1	7	5/16	1	568102	0.8438	27/32	1-3/8	9-1/2	5/8	2	568132
0.4062	13/32	1	7	5/16	1	568104	0.8750	7/8	1-1/2	10	3/4	2	568134
0.4375	7/16	1	7	3/8	1	568106	0.9063	29/32	1-1/2	10	3/4	2	568136
0.4688	15/32	1	7	3/8	1	568108	0.9375	15/16	1-1/2	10	3/4	3	568138
0.5000	1/2	1	8	7/16	1	568110	0.9688	31/32	1-1/2	10	3/4	3	568140
0.5312	17/32	1	8	7/16	1	568112	1.0000	1	1-5/8	10-1/2	7/8	3	568142
0.5625	9/16	1-1/8	8	7/16	1	568114	1.0625	1-1/16	1-5/8	10-1/2	7/8	3	568144
0.5938	19/32	1-1/8	8	7/16	1	568116	1.1250	1-1/8	1-3/4	11	7/8	3	568146
0.6250	5/8	1-1/8	9	9/16	2	568118	1.1875	1-3/16	1-3/4	11	1	3	568148
0.6562	21/32	1-1/4	9	9/16	2	568120	1.2500	1-1/4	1-7/8	11-1/2	1	4	568150
0.6875	11/16	1-1/4	9	9/16	2	568122	1.3750	1-3/8	2	12	1	4	568154
0.7188	23/32	1-1/4	9	9/16	2	568124	1.5000	1-1/2	2-1/8	13-1/2	1-1/4	4	568158
0.7500	3/4	1-3/8	9-1/2	5/8	2	568126	1.6250	1-5/8	2-1/4	13	1-1/4	4	568160
0.7813	25/32	1-3/8	9-1/2	5/8	2	568128	1.7500	1-3/4	2-3/8	13-1/2	1-1/4	4	568162
0.8125	13/16	1-3/8	9-1/2	5/8	2	568130	2.0000	2	2-1/2	14	1-1/2	4	568164

Taper Shank



Decimal Size	Tool Size	Flute Length	Overall Length	Shank Size	Morse Taper	Code	Decimal Size	Tool Size	Flute Length	Overall Length	Shank Size	Morse Taper	Code
0.3750	3/8	1	7	5/16	1	568202	0.8438	27/32	1-3/8	9-1/2	5/8	2	568232
0.4062	13/32	1	7	5/16	1	568204	0.8750	7/8	1-1/2	10	3/4	2	568234
0.4375	7/16	1	7	3/8	1	568206	0.9063	29/32	1-1/2	10	3/4	2	568236
0.4688	15/32	1	7	3/8	1	568208	0.9375	15/16	1-1/2	10	3/4	3	568238
0.5000	1/2	1	8	7/16	1	568210	1.0000	1	1-5/8	10-1/2	7/8	3	568242
0.5312	17/32	1	8	7/16	1	568212	1.0625	1-1/16	1-5/8	10-1/2	7/8	3	568244
0.5625	9/16	1-1/8	8	7/16	1	568214	1.1250	1-1/8	1-3/4	11	7/8	3	568246
0.5938	19/32	1-1/8	8	7/16	1	568216	1.1875	1-3/16	1-3/4	11	1	3	568248
0.6250	5/8	1-1/8	9	9/16	2	568218	1.2500	1-1/4	1-7/8	11-1/2	1	4	568250
0.6562	21/32	1-1/4	9	9/16	2	568220	1.3750	1-3/8	2	12	1	4	568254
0.6875	11/16	1-1/4	9	9/16	2	568222	1.5000	1-1/2	2-1/8	13-1/2	1-1/4	4	568258
0.7188	23/32	1-1/4	9	9/16	2	568224	1.6250	1-5/8	2-1/4	13	1-1/4	4	568260
0.7500	3/4	1-3/8	9-1/2	5/8	2	568226	1.7500	1-3/4	2-3/8	13-1/2	1-1/4	4	568262
0.7813	25/32	1-3/8	9-1/2	5/8	2	568228	2.0000	2	2-1/2	14	1-1/2	4	568264
0.8125	13/16	1-3/8	9-1/2	5/8	2	568230							