

Series 500, 550

Chucking Reamers | 4 - 6 FL | Straight | Helical

			Inches Per Revolution (IPR)						
			Cutting Diameter						
Material	Hardness	SFM	0.0280-0.0625"	0.0626-0.1250"	0.1251-0.2500"	0.2501-0.5000"	0.5001-0.7500"		
			P	Steel	Free Machining & Low Carbon: 10XX, 11XX, 12XX, A36	≤ 28 Rc	200-300	0.0005 - 0.0030	0.0020 - 0.0060
Steel	Medium/High Carbon, 1030, 4140, 5115	28-38 Rc		125-200	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
Die Steels	A2, H13, L6, P20, S7	28-44 Rc		50-125	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
M	Stainless Steels	Easy to Machine, 430F, 301, 303, 410, 416 Annealed, 420F, 430, 430F	≤ 28 Rc	120-190	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Stainless Steels	Moderately Difficult to Machine, Nitronic 50, 301, 303, 304, 304L, 316, 316L, 321, 347	≤ 28 Rc	80-120	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Stainless Steels	Difficult to Machine, 302B, 304B, 309, 310, 316, 316Ti, PH13-8Mo	> 28 Rc	60-100	0.0002 - 0.0020	0.0010 - 0.0040	0.0020 - 0.0060	0.0040 - 0.0100	0.0060 - 0.0100
S	Super Alloys	Inconel	<40 Rc	40-70	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
	Super Alloys	High Temp, Nimonics, Inconel, Monel, Hastelloy	<40 Rc	30-45	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0200
	Super Alloys	Titanium: Ti 3Al-2.5V, Ti 6Al-4V Ti 10V-2Fe-3Al	<40 Rc	35-50	0.0002 - 0.0020	0.0010 - 0.0040	0.0020 - 0.0060	0.0040 - 0.0100	0.0060 - 0.0200
H	Hardened Steels	Die Steel, Alloy Steels 23-32 Rc	23-32 Rc	125-200	0.0002 - 0.0020	0.0010 - 0.0040	0.0020 - 0.0060	0.0040 - 0.0100	0.0060 - 0.0200
	Hardened Steels	Die Steel, Alloy Steels 32-43 Rc	32-43 Rc	50-125	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Hardened Steels	Die Steel, Alloy Steels 43-52 Rc	43-52 Rc	35-50	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
	Hardened Steels	Die Steels, Tool Steel	> 50 Rc	15-35	5 0.0005 - 0.0030	0.0020 - 0.0060	0.0040 - 0.0100	0.0060 - 0.0150	0.0100 - 0.0300
K	Cast Iron	Gray: SAE J431, ASTM A48	≤ 240 HB	150-250	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Cast Iron	Ductile & Malleable, ASTM A536, ASTM 897, ASTM A47, ASTM A220	> 240 HB	125-200	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Cast Iron	Martensitic (Hard)	> 240 HB	50-75	5 0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
N	Non-Ferrous	Aluminum, Aluminum Alloys	> 240 HB	500-1000	0.0005 - 0.0020	0.0020 - 0.0060	0.0040 - 0.0100	0.0060 - 0.0150	0.0100 - 0.0300
	Non-Ferrous	Brass, Bronze (Free Machining)	> 240 HB	250-400	0.0005 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100	0.0100 - 0.0200
	Non-Ferrous	Brass, Bronze (Soft)	> 240 HB	150-250	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
	Non-Ferrous	Copper, Bronze (Hard)	> 240 HB	100-150	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100
	Non-Ferrous	Magnesium, Magnesium Alloys, Plastics	> 240 HB	500-1000	0.0002 - 0.0010	0.0010 - 0.0020	0.0020 - 0.0040	0.0040 - 0.0060	0.0060 - 0.0100

Hole Size Parameters			Drill Diameter								
			0.30135	0.0290/0.0280	0.0550/0.0520	0.1130	0.2380	0.3594	0.4844	0.6094	0.7344
			Reamer Diameter								
			0.0150	0.0320	0.0625	0.1250	0.2500	0.3750	0.5000	0.625	0.75
Material			TOTAL STOCK ALLOWANCE								
P	Steel	Free Machining & Low Carbon: 10XX, 11XX, 12XX, A36	0.0012	0.0025	0.0049	0.0089	0.0100	0.0120	0.0130	0.0150	
	Steel	Medium/High Carbon Steels, Alloy Steels: 13XX, 41XX, 43XX, 86XX	0.0013	0.0028	0.0055	0.0099	0.0110	0.0130	0.0140	0.0160	0.0170
	Die Steels	A2, H13, L6, P20, S7	0.0012	0.0025	0.0049	0.0089	0.0100	0.0120	0.0130	0.0150	
M	Stainless Steels	Easy to Machine, 430F, 301, 303, 410, 416 Annealed, 420F, 430, 430F	0.0012	0.0025	0.0049	0.0089	0.0100	0.0120	0.0130	0.0150	0.0160
S	Super Alloys	Soft	0.0012	0.0025	0.0049	0.0089	0.0100	0.0110	0.0130	0.0140	0.0160
	Super Alloys	Hard	0.0010	0.0023	0.0044	0.0081	0.0090	0.0100	0.0120	0.0130	0.0140
	Super Alloys	Titanium: Ti 3Al-2.5V, Ti 6Al-4V Ti 10V-2Fe-3Al	0.0013	0.0028	0.0055	0.0099	0.0110	0.0130	0.0140	0.0160	0.0170
H	Hardened Steels	-	0.0009	0.0020	0.0040	0.0072	0.0080	0.0100	0.0110	0.0130	0.0140
K	Cast Iron	Cast								0.0160	0.0180
	Cast Iron	Ductile	0.0013	0.0028	0.0055	0.0099	0.0110	0.0130	0.0140	0.0150	0.0170
N	Non-Ferrous	Magnesium						0.0150	0.0160	0.0180	0.0200
	Non-Ferrous	Aluminum ≥ 5% Si	0.0014	0.0030	0.0060	0.0110	0.0120				
	Non-Ferrous	Aluminum ≤ 5% S									
	Non-Ferrous	Brass							0.0130	0.0150	0.0160
Non-Ferrous	Bronze, Copper							0.0140	0.0150	0.0170	0.0190