Taper Pin Reamers

High Speed Steel – Straight Shank
Right Hand Cut
1/4″ Taper Per Foot

Alésoir conique à goupilles Rima para agujeros cónicos

For reaming holes for standard taper pins. **Straight Flute** for hand reaming of most materials. **Helical Flute** for machine reaming of most materials. **Spiral Flute** for hand reaming of difficult-to-ream materials.

STANDARD PACKAGE All sizes —1 each

List No. 1680 Straight Flute Hand Reamers

List No. 1683 Helical Flute Machine Reamers
Left Hand Helix

List No. 1684 Spiral Flute Hand Reamers
Left Hand Helix

SIZE	SHANK DIA.	DIA. SMALL END	DIA. LARGE END	FLUTE LENGTH	OAL	1680 EDP NO.	NO. OF FLUTES	1683 EDP NO.	NO. OF FLUTES	1684 EDP NO.	NO. OF FLUTES
7/0	5/64	.0497	.0666	13/16	1 13/16	22581	4	22611	2	22641	4
6/0	3/32	.0611	.0806	15/16	1 15/16	22582	4	22612	2	22642	4
5/0	7/64	.0719	.0966	1 3/16	2 3/16	22583	4	22613	2	22643	4
4/0	1/8	.0869	.1142	1 5/16	2 5/16	22584	4	22614	3	22644	4
3/0	9/64	.1029	.1302	1 5/16	2 5/16	22585	4	22615	3	22645	4
2/0	5/32	.1137	.1462	1 9/16	2 9/16	22586	4	22616	3	22646	4
0	11/64	.1287	.1638	1 11/16	2 15/16	22587	4	22617	3	22647	4
1	3/16	.1447	.1798	1 11/16	2 15/16	22588	6	22618	3	22648	6
2	13/64	.1605	.2008	1 15/16	3 3/16	22589	6	22619	3	22649	6
3	15/64	.1813	.2294	2 5/16	3 11/16	22590	6	22620	3	22650	6
4	17/64	.2071	.2604	2 9/16	4 1/16	22591	6	22621	3	22651	6
5	5/16	.2409	.2994	2 13/16	4 5/16	22592	6	22622	3	22652	6
6	23/64	.2773	.3540	3 11/16	5 7/16	22593	6	22623	3	22653	6
7	13/32	.3297	.4220	4 7/16	6 5/16	22594	6	22624	3	22654	6
8	7/16	.3971	.5050	5 3/16	7 3/16	22595	6	22625	3	22655	6
9	9/16	.4805	.6066	6 1/16	8 5/16	22596	6	22626	4	22656	6
10	5/8	.5799	.7219	6 13/16	9 5/16	22597	6	22627	4	22657	6

High Speed Steel Reamers Speed and Feed Recommendations

REAMER CUTTING SPEED – SFM

For machine reaming, the recommended starting point is **2/3 the speed used for drilling** in the same material.

REAMER FEED RATE – IPR

For machine reaming, the recommended starting point is **2 to 3 times the feed rate used for drilling** in the same material. It is important that the feed rate be high enough so that the reamer actually cuts rather than just rubbing or burnishing.

DRILLING SPEEDS & FEEDS are located on **Page #88** for reference.

NOTE

The speeds and feeds shown are suggested starting points only and may be increased or decreased depending on the actual material and machining conditions. Start conservatively and adjust speed and feed until the reaming cycle is optimized while producing the required surface finish and hole accuracy.