

### Chucking Reamer Sets

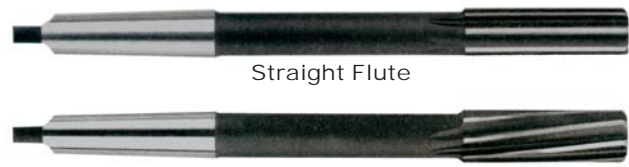
Straight Flute, Straight Shank,  
High Speed Steel



| Model No. | No. of Pieces | Range                        |
|-----------|---------------|------------------------------|
| RCS-29    | 29            | 1/16-1/2" (.0625-.5000")     |
| RCS-14A   | 14            | .1240-.5010"                 |
| RCS-14B   | 14            | .1230-.4995" (Dowel Pin Set) |

### Taper Shank Reamers High Speed Steel- Straight and Spiral Flute

- Use straight flute chucking reamers for most general purpose reaming
- Spiral flute is ideal for difficult-to-cut materials, interrupted cuts and chip removal from blind holes
- Shanks fit Morse Taper Holders



Straight Flute

Spiral Flute

| Size    | Morse Taper | Flute Length | Overall length | Model No.      |              |
|---------|-------------|--------------|----------------|----------------|--------------|
|         |             |              |                | Straight Flute | Spiral Flute |
| 1/4     | 1           | 1-1/2        | 6              | RTS-1/4        | RTSP-1/4     |
| 9/32    | 1           | 1-1/2        | 6              | RTS-9/32       | RTSP-9/32    |
| 5/16    | 1           | 1-1/2        | 6              | RTS-5/16       | RTSP-5/16    |
| 11/32   | 1           | 1-1/2        | 6              | RTS-11/32      | RTSP-11/32   |
| 3/8     | 1           | 1-3/4        | 7              | RTS-3/8        | RTSP-3/8     |
| 13/32   | 1           | 1-3/4        | 7              | RTS-13/32      | RTSP-13/32   |
| 7/16    | 1           | 1-3/4        | 7              | RTS-7/16       | RTSP-7/16    |
| 15/32   | 1           | 1-3/4        | 7              | RTS-15/32      | RTSP-15/32   |
| 1/2     | 1           | 2            | 8              | RTS-1/2        | RTSP-1/2     |
| 17/32   | 1           | 2            | 8              | RTS-17/32      | RTSP-17/32   |
| 9/16    | 1           | 2            | 8              | RTS-9/16       | RTSP-9/16    |
| 19/32   | 1           | 2            | 8              | RTS-19/32      | RTSP-19/32   |
| 5/8     | 2           | 2-1/4        | 9              | RTS-5/8        | RTSP-5/8     |
| 21/32   | 2           | 2-1/4        | 9              | RTS-21/32      | RTSP-21/32   |
| 11/16   | 2           | 2-1/4        | 9              | RTS-11/16      | RTSP-11/16   |
| 23/32   | 2           | 2-1/4        | 9              | RTS-23/32      | RTSP-23/32   |
| 3/4     | 2           | 2-1/2        | 9-1/2          | RTS-3/4        | RTSP-3/4     |
| 25/32   | 2           | 2-1/2        | 9-1/2          | RTS-25/32      | RTSP-25/32   |
| 13/16   | 2           | 2-1/2        | 9-1/2          | RTS-13/16      | RTSP-13/16   |
| 27/32   | 2           | 2-1/2        | 9-1/2          | RTS-27/32      | RTSP-27/32   |
| 7/8     | 2           | 2-5/8        | 10             | RTS-7/8        | RTSP-7/8     |
| 29/32   | 2           | 2-5/8        | 10             | RTS-29/32      | RTSP-29/32   |
| 15/16   | 3           | 2-5/8        | 10             | RTS-15/16      | RTSP-15/16   |
| 31/32   | 3           | 2-5/8        | 10             | RTS-31/32      | RTSP-31/32   |
| 1       | 3           | 2-3/4        | 10-1/2         | RTS-1          | RTSP-1       |
| 1-1/32  | 3           | 2-3/4        | 10-1/2         | RTS-1-1/32     | RTSP-1-1/32  |
| 1-1/16  | 3           | 2-3/4        | 10-1/2         | RTS-1-1/16     | RTSP-1-1/16  |
| 1-1/8   | 3           | 2-7/8        | 11             | RTS-1-1/8      | RTSP-1-1/8   |
| 1-3/16  | 3           | 2-7/8        | 11             | RTS-1-3/16     | RTSP-1-3/16  |
| 1-1/4   | 4           | 3            | 11-1/2         | RTS-1-1/4      | RTSP-1-1/4   |
| 1-5/16  | 4           | 3            | 11-1/2         | RTS-1-5/16     | RTSP-1-5/16  |
| 1-3/8   | 4           | 3-1/4        | 12             | RTS-1-3/8      | RTSP-1-3/8   |
| 1-7/16  | 4           | 3-1/4        | 12             | RTS-1-7/16     | RTSP-1-7/16  |
| 1-1/2   | 4           | 3-1/2        | 12-1/2         | RTS-1-1/2      | RTSP-1-1/2   |
| 1-9/16  | 4           | 3-1/2        | 12-1/2         | RTS-1-9/16     | RTSP-1-9/16  |
| 1-5/8   | 4           | 3-1/2        | 13             | RTS-1-5/8      | RTSP-1-5/8   |
| 1-11/16 | 4           | 4            | 13-1/2         | RTS-1-11/16    | RTSP-1-11/16 |
| 1-3/4   | 4           | 4            | 13-1/2         | RTS-1-3/4      | RTSP-1-3/4   |
| 2       | 4           | 4            | 14-1/2         | RTS-2          | RTSP-2       |

### Helical Flute Bridge Reamers High Speed Steel

- Use to align bolt and rivet holes in structural iron and steel
- Features a long taper to provide easy entry in badly misaligned holes
- Helical construction prevents chips from packing in flutes and reduces breakage
- Free cutting at high speeds produces excellent finishes



Straight Flute

Spiral Flute

| Size   | M.T. Shank | Approx. Dia. at Point | Flute Length | Overall length | Model No.      |              |
|--------|------------|-----------------------|--------------|----------------|----------------|--------------|
|        |            |                       |              |                | Straight Flute | Spiral Flute |
| 7/16   | 2          | 17/64                 | 4-3/8        | 8-1/4          | RBS-7/16       | RBSP-7/16    |
| 15/32  | 2          | 9/32                  | 5-1/8        | 9              | RBS-15/32      | RBSP-15/32   |
| 1/2    | 2          | 5/16                  | 5-1/8        | 9              | RBS-1/2        | RBSP-1/2     |
| 17/32  | 2          | 11/32                 | 5-1/8        | 9              | RBS-17/32      | RBSP-17/32   |
| 9/16   | 2          | 3/8                   | 5-1/8        | 9              | RBS-9/16       | RBSP-9/16    |
| 5/8    | 2          | 25/64                 | 5-1/8        | 10             | RBS-5/8        | RBSP-5/8     |
| 11/16  | 3          | 23/32                 | 6-1/8        | 11-3/4         | RBS-11/16      | RBSP-11/16   |
| 3/4    | 3          | 23/32                 | 7-1/8        | 12             | RBS-3/4        | RBSP-3/4     |
| 13/16  | 3          | 35/64                 | 7-3/8        | 12             | RBS-13/16      | RBSP-13/16   |
| 7/8    | 3          | 39/64                 | 7-3/8        | 12             | RBS-7/8        | RBSP-7/8     |
| 15/16  | 3          | 43/64                 | 7-3/8        | 12             | RBS-15/16      | RBSP-15/16   |
| 1      | 3          | 47/64                 | 7-3/8        | 12             | RBS-1          | RBSP-1       |
| 1-1/16 | 3          | 13/16                 | 7-3/8        | 12             | RBS-1-1/16     | RBSP-1-1/16  |
| 1-1/8  | 3          | 55/64                 | 7-3/8        | 12             | RBS-1-1/8      | RBSP-1-1/8   |
| 1-3/16 | 3          | 59/64                 | 7-3/8        | 12             | RBS-1-3/16     | RBSP-1-3/16  |
| 1-1/4  | 4          | 63/64                 | 7-3/8        | 13             | RBS-1-1/4      | RBSP-1-1/4   |
| 1-5/16 | 4          | 1-1/16                | 7-3/8        | 13             | RBS-1-5/16     | RBSP-1-5/16  |

### Hand Reamers High Speed Steel

- Use for most general purpose hand reaming applications for final sizing of holes
- Long starting taper provides ease of entry and accurate alignment
- Square end on shank allows reamer to be held by either a wrench, tap wrench or vise



Straight Flute

| Size   | Flute Length | Overall length | Model No.      |              |
|--------|--------------|----------------|----------------|--------------|
|        |              |                | Straight Flute | Spiral Flute |
| 1/8    | 1-1/2        | 3              | RH-1/8         | RHSP-1/8     |
| 5/32   | 1-5/8        | 3-1/4          | RH-5/32        | RHSP-5/32    |
| 3/16   | 1-3/4        | 3-1/2          | RH-3/16        | RHSP-3/16    |
| 7/32   | 1-7/8        | 3-3/4          | RH-7/32        | RHSP-7/32    |
| 1/4    | 2            | 4              | RH-1/4         | RHSP-1/4     |
| 9/32   | 2-1/8        | 4-1/4          | RH-9/32        | RHSP-9/32    |
| 5/16   | 2-1/4        | 4-1/2          | RH-5/16        | RHSP-5/16    |
| 11/32  | 2-3/8        | 4-3/4          | RH-11/32       | RHSP-11/32   |
| 3/8    | 2-1/2        | 5              | RH-3/8         | RHSP-3/8     |
| 13/32  | 2-5/8        | 5-1/4          | RH-13/32       | RHSP-13/32   |
| 7/16   | 2-3/4        | 5-1/2          | RH-7/16        | RHSP-7/16    |
| 15/32  | 2-7/8        | 5-3/4          | RH-15/32       | RHSP-15/32   |
| 1/2    | 3            | 6              | RH-1/2         | RHSP-1/2     |
| 17/32  | 3-1/8        | 6-1/4          | RH-17/32       | RHSP-17/32   |
| 9/16   | 3-1/4        | 6-1/2          | RH-9/16        | RHSP-9/16    |
| 19/32  | 3-3/8        | 6-3/4          | RH-19/32       | RHSP-19/32   |
| 5/8    | 3-1/2        | 7              | RH-5/8         | RHSP-5/8     |
| 21/32  | 3-11/16      | 7-3/8          | RH-21/32       | RHSP-21/32   |
| 11/16  | 3-7/8        | 7-3/4          | RH-11/16       | RHSP-11/16   |
| 23/32  | 4-1/16       | 8-1/8          | RH-23/32       | RHSP-23/32   |
| 3/4    | 4-3/16       | 8-1/8          | RH-3/4         | RHSP-3/4     |
| 25/32  | 4-3/8        | 8-3/4          | RH-25/32       | RHSP-25/32   |
| 13/16  | 4-9/16       | 9-1/8          | RH-13/16       | RHSP-13/16   |
| 27/32  | 4-11/16      | 9-3/8          | RH-27/32       | RHSP-27/32   |
| 7/8    | 4-7/8        | 9-3/4          | RH-7/8         | RHSP-7/8     |
| 29/32  | 5            | 10             | RH-29/32       | RHSP-29/32   |
| 15/16  | 5-1/8        | 10-1/4         | RH-15/16       | RHSP-15/16   |
| 31/32  | 5-5/16       | 10-5/8         | RH-31/32       | RHSP-31/32   |
| 1      | 5-7/16       | 10-7/8         | RH-1           | RHSP-1       |
| 1-1/16 | 5-5/8        | 11-1/4         | RH-1-1/16      | RHSP-1-1/16  |
| 1-1/8  | 5-13/16      | 11-5/8         | RH-1-1/8       | RHSP-1-1/8   |
| 1-3/16 | 6            | 12             | RH-1-3/16      | RHSP-1-3/16  |
| 1-1/4  | 6-1/8        | 12-1/4         | RH-1-1/4       | RHSP-1-1/4   |
| 1-5/16 | 6-1/4        | 12-1/2         | RH-1-5/16      | RHSP-1-5/16  |
| 1-3/8  | 6-5/16       | 12-5/8         | RH-1-3/8       | RHSP-1-3/8   |
| 1-7/16 | 6-7/16       | 12-7/8         | RH-1-7/16      | RHSP-1-7/16  |
| 1-1/2  | 6-1/2        | 13             | RH-1-1/2       | RHSP-1-1/2   |

### Hand Taps High Speed Steel-Ground Thread

Can be used for hand tapping or general machine and CNC tapping in a wide variety of materials



Inch

| Size  | Threads Per Inch | No. of Flutes | Ground Thread Limit | Model No.     |               |               |
|-------|------------------|---------------|---------------------|---------------|---------------|---------------|
|       |                  |               |                     | Taper         | Plug          | Bottoming     |
| 0     | 80               | 2             | H1                  | TSHT-0/80     | TSHP-0/80     | TSHB-0/80     |
| 1     | 64               | 2             | H1                  | TSHT-1/64     | TSHP-1/64     | TSHB-1/64     |
| 1     | 72               | 2             | H1                  | TSHT-1/72     | TSHP-1/72     | TSHB-1/72     |
| 2     | 56               | 3             | H2                  | TSHT-2/56     | TSHP-2/56     | TSHB-2/56     |
| 2     | 64               | 3             | H2                  | TSHT-2/64     | TSHP-2/64     | TSHB-2/64     |
| 3     | 48               | 3             | H2                  | TSHT-3/48     | TSHP-3/48     | TSHB-3/48     |
| 3     | 56               | 3             | H2                  | TSHT-3/56     | TSHP-3/56     | TSHB-3/56     |
| 4     | 40               | 3             | H2                  | TSHT-4/40     | TSHP-4/40     | TSHB-4/40     |
| 4     | 48               | 3             | H2                  | TSHT-4/48     | TSHP-4/48     | TSHB-4/48     |
| 5     | 40               | 3             | H2                  | TSHT-5/40     | TSHP-5/40     | TSHB-5/40     |
| 5     | 44               | 3             | H2                  | TSHT-5/44     | TSHP-5/44     | TSHB-5/44     |
| 6     | 32               | 3             | H3                  | TSHT-6/32     | TSHP-6/32     | TSHB-6/32     |
| 6     | 40               | 3             | H3                  | TSHT-6/40     | TSHP-6/40     | TSHB-6/40     |
| 8     | 32               | 4             | H3                  | TSHT-8/32     | TSHP-8/32     | TSHB-8/32     |
| 8     | 36               | 4             | H3                  | TSHT-8/36     | TSHP-8/36     | TSHB-8/36     |
| 10    | 24               | 4             | H3                  | TSHT-10/24    | TSHP-10/24    | TSHB-10/24    |
| 10    | 32               | 4             | H3                  | TSHT-10/32    | TSHP-10/32    | TSHB-10/32    |
| 12    | 24               | 4             | H3                  | TSHT-12/24    | TSHP-12/24    | TSHB-12/24    |
| 12    | 28               | 4             | H3                  | TSHT-12/28    | TSHP-12/28    | TSHB-12/28    |
| 1/4   | 20               | 4             | H3                  | TSHT-1/4/20   | TSHP-1/4/20   | TSHB-1/4/20   |
| 1/4   | 28               | 4             | H3                  | TSHT-1/4/28   | TSHP-1/4/28   | TSHB-1/4/28   |
| 5/16  | 18               | 4             | H3                  | TSHT-5/16/18  | TSHP-5/16/18  | TSHB-5/16/18  |
| 5/16  | 24               | 4             | H3                  | TSHT-5/16/24  | TSHP-5/16/24  | TSHB-5/16/24  |
| 3/8   | 16               | 4             | H3                  | TSHT-3/8/16   | TSHP-3/8/16   | TSHB-3/8/16   |
| 3/8   | 24               | 4             | H3                  | TSHT-3/8/24   | TSHP-3/8/24   | TSHB-3/8/24   |
| 7/16  | 14               | 4             | H3                  | TSHT-7/16/14  | TSHP-7/16/14  | TSHB-7/16/14  |
| 7/16  | 20               | 4             | H3                  | TSHT-7/16/20  | TSHP-7/16/20  | TSHB-7/16/20  |
| 1/2   | 13               | 4             | H3                  | TSHT-1/2/13   | TSHP-1/2/13   | TSHB-1/2/13   |
| 1/2   | 20               | 4             | H3                  | TSHT-1/2/20   | TSHP-1/2/20   | TSHB-1/2/20   |
| 9/16  | 12               | 4             | H3                  | TSHT-9/16/12  | TSHP-9/16/12  | TSHB-9/16/12  |
| 9/16  | 18               | 4             | H3                  | TSHT-9/16/18  | TSHP-9/16/18  | TSHB-9/16/18  |
| 5/8   | 11               | 4             | H3                  | TSHT-5/8/11   | TSHP-5/8/11   | TSHB-5/8/11   |
| 5/8   | 18               | 4             | H3                  | TSHT-5/8/18   | TSHP-5/8/18   | TSHB-5/8/18   |
| 11/16 | 11               | 4             | H3                  | TSHT-11/16/11 | TSHP-11/16/11 | TSHB-11/16/11 |
| 11/16 | 16               | 4             | H3                  | TSHT-11/16/16 | TSHP-11/16/16 | TSHB-11/16/16 |
| 3/4   | 10               | 4             | H3                  | TSHT-3/4/10   | TSHP-3/4/10   | TSHB-3/4/10   |
| 3/4   | 16               | 4             | H3                  | TSHT-3/4/16   | TSHP-3/4/16   | TSHB-3/4/16   |
| 7/8   | 9                | 4             | H4                  | TSHT-7/8/9    | TSHP-7/8/9    | TSHB-7/8/9    |
| 7/8   | 14               | 4             | H4                  | TSHT-7/8/14   | TSHP-7/8/14   | TSHB-7/8/14   |
| 1     | 8                | 4             | H4                  | TSHT-1/8      | TSHP-1/8      | TSHB-1/8      |
| 1     | 12               | 4             | H4                  | TSHT-1/12     | TSHP-1/12     | TSHB-1/12     |
| 1     | 14               | 4             | H4                  | TSHT-1/14     | TSHP-1/14     | TSHB-1/14     |
| 1-1/8 | 7                | 4             | H4                  | TSHT-1-1/8/7  | TSHP-1-1/8/7  | TSHB-1-1/8/7  |
| 1-1/8 | 12               | 4             | H4                  | TSHT-1-1/8/12 | TSHP-1-1/8/12 | TSHB-1-1/8/12 |
| 1-1/4 | 7                | 4             | H4                  | TSHT-1-1/4/7  | TSHP-1-1/4/7  | TSHB-1-1/4/7  |
| 1-1/4 | 12               | 4             | H4                  | TSHT-1-1/4/12 | TSHP-1-1/4/12 | TSHB-1-1/4/12 |
| 1-3/8 | 6                | 4             | H4                  | TSHT-1-3/8/6  | TSHP-1-3/8/6  | TSHB-1-3/8/6  |
| 1-3/8 | 12               | 4             | H4                  | TSHT-1-3/8/12 | TSHP-1-3/8/12 | TSHB-1-3/8/12 |
| 1-1/2 | 6                | 4             | H4                  | TSHT-1-1/2/6  | TSHP-1-1/2/6  | TSHB-1-1/2/6  |
| 1-1/2 | 12               | 4             | H4                  | TSHT-1-1/2/12 | TSHP-1-1/2/12 | TSHB-1-1/2/12 |

Metric

| Size | Pitch | Model No.   |             |             |
|------|-------|-------------|-------------|-------------|
|      |       | Taper       | Plug        | Bottoming   |
| 1.8  | .35   | THT-1.8-.35 | THP-1.8-.35 | THB-1.8-.35 |
| 2.0  | .40   | THT-2.0-.40 | THP-2.0-.40 | THB-2.0-.40 |
| 2.2  | .45   | THT-2.2-.45 | THP-2.2-.45 | THB-2.2-.45 |
| 2.3  | .40   | THT-2.3-.40 | THP-2.3-.40 | THB-2.3-.40 |
| 2.5  | .45   | THT-2.5-.45 | THP-2.5-.45 | THB-2.5-.45 |
| 2.6  | .45   | THT-2.6-.45 | THP-2.6-.45 | THB-2.6-.45 |
| 3.0  | .50   | THT-3.0-.50 | THP-3.0-.50 | THB-3.0-.50 |
| 3.5  | .60   | THT-3.5-.60 | THP-3.5-.60 | THB-3.5-.60 |
| 4.0  | .50   | THT-4.0-.50 | THP-4.0-.50 | THB-4.0-.50 |
| 4.0  | .70   | THT-4.0-.70 | THP-4.0-.70 | THB-4.0-.70 |
| 4.0  | .75   | THT-4.0-.75 | THP-4.0-.75 | THB-4.0-.75 |
| 4.5  | .75   | THT-4.5-.75 | THP-4.5-.75 | THB-4.5-.75 |
| 5.0  | .50   | THT-5.0-.50 | THP-5.0-.50 | THB-5.0-.50 |
| 5.0  | .80   | THT-        |             |             |