

## Expansion Chucking Reamers

### High Speed Steel, Straight Flute

- ▣ An economical, general purpose high production reamer designed to maintain initial size by compensating for wear on the cutting edge.
- ▣ Expansion feature allows resharping with retaining the original size.
- ▣ Expand by tightening the end adjusting screw and regrind to original size.



**Straight Shank**

Size	Shank Dia.	Flute Length	Overall Length	Straight Shank Order No.
3/8"	5/16"	3/4"	7"	331-9202
13/32	5/16	3/4	7	331-9204
7/16	3/8	7/8	7	331-9206
15/32	3/8	7/8	7	331-9208
1/2	7/16	1	8	331-9210
17/32	7/16	1	8	331-9212
9/16	7/16	1-1/8	8	331-9214
19/32	7/16	1-1/8	8	331-9216
5/8	9/16	1-1/4	9	331-9218
21/32	9/16	1-1/4	9	331-9220
11/16	9/16	1-1/4	9	331-9222
23/32	9/16	1-1/4	9	331-9224
3/4	5/8	1-3/8	9-1/2	331-9226
25/32	5/8	1-3/8	9-1/2	331-9228
13/16	5/8	1-3/8	9-1/2	331-9230
27/32	5/8	1-3/8	9-1/2	331-9232
7/8	3/4	1-1/2	10	331-9234
29/32	3/4	1-1/2	10	331-9236
15/16	3/4	1-1/2	10	331-9238
31/32	3/4	1-1/2	10	331-9240
1	7/8	1-5/8	10-1/2	331-9242
1-1/32	7/8	1-5/8	10-1/2	331-9244
1-1/16	7/8	1-5/8	10-1/2	331-9246
1-3/32	7/8	1-5/8	10-1/2	331-9248
1-1/8	7/8	1-3/4	11	331-9250
1-5/32	7/8	1-3/4	11	331-9252
1-3/16	1	1-3/4	11	331-9254
1-7/32	1	1-3/4	11	331-9256
1-1/4	1	1-7/8	11-1/2	331-9258
1-5/16	1	1-7/8	11-1/2	331-9260
1-3/8	1	2	12	331-9262
1-7/16	1-1/4	2	12	331-9264
1-1/2	1-1/4	2-1/8	12-1/2	331-9266
1-9/16	1-1/4	2-1/8	12-1/2	331-9268
1-5/8	1-1/4	2-1/4	13	331-9270
1-11/16	1-1/4	2-1/4	13	331-9272
1-3/4	1-1/4	2-3/8	13-1/2	331-9274
1-13/16	1-1/2	2-3/8	13-1/2	331-9276
1-7/8	1-1/2	2-1/2	14	331-9278
1-15/16	1-1/2	2-1/2	14	331-9280
2	1-1/2	2-1/2	14	331-9282
2-1/8	1-1/2	2-3/4	14-1/2	331-9284
2-1/4	1-3/4	2-3/4	14-1/2	331-9286
2-1/2	1-3/4	3	15	331-9288



**Taper Shank**

Size	Flute Length	Overall Length	Shank Taper	Taper Shank Order No.
3/8"	3/4"	7"	MT1	331-9302
13/32	3/4	7	MT1	331-9304
7/16	7/8	7	MT1	331-9306
15/32	7/8	7	MT1	331-9308
1/2	1	8	MT1	331-9310
17/32	1	8	MT1	331-9312
9/16	1-1/8	8	MT1	331-9314
19/32	1-1/8	8	MT1	331-9316
5/8	1-1/4	9	MT2	331-9318
21/32	1-1/4	9	MT2	331-9320
11/16	1-1/4	9	MT2	331-9322
23/32	1-1/4	9	MT2	331-9324
3/4	1-3/8	9-1/2	MT2	331-9326
25/32	1-3/8	9-1/2	MT2	331-9328
13/16	1-3/8	9-1/2	MT2	331-9330
27/32	1-3/8	9-1/2	MT2	331-9332
7/8	1-1/2	10	MT2	331-9334
29/32	1-1/2	10	MT2	331-9336
15/16	1-1/2	10	MT3	331-9338
31/32	1-1/2	10	MT3	331-9340
1	1-5/8	10-1/2	MT3	331-9342
1-1/32	1-5/8	10-1/2	MT3	331-9344
1-1/16	1-5/8	10-1/2	MT3	331-9346
1-3/32	1-5/8	10-1/2	MT3	331-9348
1-1/8	1-3/4	11	MT3	331-9350
1-5/32	1-3/4	11	MT3	331-9352
1-3/16	1-3/4	11	MT3	331-9354
1-7/32	1-3/4	11	MT3	331-9356
1-1/4	1-7/8	11-1/2	MT4	331-9358
1-5/16	1-7/8	11-1/2	MT4	331-9360
1-3/8	2	12	MT4	331-9362
1-7/16	2	12	MT4	331-9364
1-1/2	2-1/8	12-1/2	MT4	331-9366
1-5/8	2-1/4	13	MT4	331-9370
1-3/4	2-3/8	13-1/2	MT5	331-9374
1-7/8	2-1/2	14	MT5	331-9378
2	2-1/2	14	MT5	331-9382
2-1/8	2-3/4	14-1/2	MT5	331-9384
2-1/4	2-3/4	14-1/2	MT5	331-9385
2-3/8	3	15	MT5	331-9386
2-1/2	3	15	MT5	331-9388

## Morse Taper Reamers

### High Speed Steel

- ▣ Each morse taper reamer set consists of one finishing and one roughing reamer.



**Hand Use, Straight Shank**

Size	Dia. of		Flute Length	Overall Length	Roughing Finishing		
	Small End	Large End			Reamer Order No.	Reamer Order No.	2 Pcs/set Order No.
MT0	.2503"	.3674"	2-1/4"	3-3/4"	337-6100	337-6200	337-6500
MT1	.3674	.5170	3	5	337-6110	337-6210	337-6510
MT2	.5696	.7441	3-1/2	6	337-6120	337-6220	337-6520
MT3	.7448	.9881	4-1/4	7-1/4	337-6130	337-6230	337-6530
MT4	1.0167	1.2893	5-1/4	8-1/2	337-6140	337-6240	337-6540
MT5	1.4717	1.8005	6-1/4	9-3/4	337-6150	337-6250	337-6550
MT6	2.1119	2.5550	8-1/2	12-1/4	337-6160	337-6260	337-6560



**Machine Use, Taper Shank**

Size	Dia. of		Flute Length	Overall Length	Roughing Finishing		
	Small End	Large End			Reamer Order No.	Reamer Order No.	2 Pcs/set Order No.
MT0	.2503"	.3674"	2-1/4"	3-3/4"	337-6300	337-6400	337-6600
MT1	.3674	.5170	3	5	337-6310	337-6410	337-6610
MT2	.5696	.7441	3-1/2	6	337-6320	337-6420	337-6620
MT3	.7448	.9881	4-1/4	7-1/4	337-6330	337-6430	337-6630
MT4	1.0167	1.2893	5-1/4	8-1/2	337-6340	337-6440	337-6640
MT5	1.4717	1.8005	6-1/4	9-3/4	337-6350	337-6450	337-6650
MT6	2.1119	2.5550	8-1/2	12-1/4	337-6360	337-6460	337-6660