

HELICAL TAPER PIN REAMERS

With Straight Shank

Schedule A1



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring. Our Taper Pin Reamers are ideal for reaming longer tapered holes and come in a variety of shank styles. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Straight
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
TPHS0090	9/0	0.025	0.041	0.75	2	0.125	1.75
TPHS0080	8/0	0.033	0.051	0.88	2	0.125	1.75
TPHS0070	7/0	0.046	0.067	1.00	2	0.125	1.75
TPHS0060	6/0	0.060	0.083	1.13	2	0.125	1.94
TPHS0050	5/0	0.070	0.098	1.38	2	0.125	2.19
TPHS0040	4/0	0.085	0.114	1.38	2	0.125	2.38
TPHS0030	3/0	0.100	0.131	1.50	2	0.141	2.63
TPHS0020	2/0	0.114	0.148	1.63	2	0.156	2.75
TPHS0000	0	0.128	0.170	2.00	2	0.172	3.13
TPHS0001	1	0.144	0.191	2.25	2	0.188	3.50
TPHS0002	2	0.160	0.212	2.50	2	0.203	3.75
TPHS0003	3	0.181	0.241	2.88	2	0.234	4.25
TPHS0004	4	0.206	0.271	3.13	2	0.266	4.75
TPHS0005	5	0.237	0.310	3.50	2	0.313	5.25
TPHS0006	6	0.274	0.365	4.38	2	0.359	6.13
TPHS0007	7	0.328	0.435	5.13	2	0.406	7.13
TPHS0008	8	0.394	0.521	6.13	2	0.438	8.50
TPHS0009	9	0.475	0.610	6.50	4	0.563	8.75
TPHS0010	10	0.567	0.727	7.69	4	0.625	10.19
TPHS0011	11	0.706	0.878	8.25	6	0.875	11.25
TPHS0012	12	0.842	1.050	10.00	6	1.000	13.00
TPHS0013	13	1.009	1.259	12.00	6	1.000	16.00
TPHS0014	14	1.250	1.541	14.00	6	1.000	18.25
TPHS0015	15	1.500	1.812	15.00	10	1.250	19.25
TPHS0016	16	1.750	2.083	16.00	12	1.500	20.25

Taper Pin Reamers can also be made as specials in duplex style, extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL TAPER PIN REAMERS

With Squared Shank

Schedule A2



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring. Our Taper Pin Reamers are ideal for reaming longer tapered holes and come in a variety of shank styles. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
TPHQ0090	9/0	0.025	0.041	0.75	2	0.125	1.75
TPHQ0080	8/0	0.033	0.051	0.88	2	0.125	1.75
TPHQ0070	7/0	0.046	0.067	1.00	2	0.125	1.75
TPHQ0060	6/0	0.060	0.083	1.13	2	0.125	1.94
TPHQ0050	5/0	0.070	0.098	1.38	2	0.125	2.19
TPHQ0040	4/0	0.085	0.114	1.38	2	0.125	2.38
TPHQ0030	3/0	0.100	0.131	1.50	2	0.141	2.63
TPHQ0020	2/0	0.114	0.148	1.63	2	0.157	2.75
TPHQ0000	0	0.128	0.170	2.00	2	0.172	3.13
TPHQ0001	1	0.144	0.191	2.25	2	0.188	3.50
TPHQ0002	2	0.160	0.212	2.50	2	0.203	3.75
TPHQ0003	3	0.181	0.241	2.88	2	0.234	4.25
TPHQ0004	4	0.206	0.271	3.13	2	0.266	4.75
TPHQ0005	5	0.237	0.310	3.50	2	0.313	5.25
TPHQ0006	6	0.274	0.365	4.38	2	0.359	6.13
TPHQ0007	7	0.328	0.435	5.13	2	0.406	7.13
TPHQ0008	8	0.394	0.521	6.13	2	0.438	8.50
TPHQ0009	9	0.475	0.610	6.50	4	0.563	8.75
TPHQ0010	10	0.567	0.727	7.69	4	0.625	10.19
TPHQ0011	11	0.706	0.878	8.25	6	0.875	11.25
TPHQ0012	12	0.842	1.050	10.00	6	1.000	13.00
TPHQ0013	13	1.009	1.259	12.00	6	1.000	16.00
TPHQ0014	14	1.250	1.541	14.00	6	1.000	18.25
TPHQ0015	15	1.500	1.812	15.00	10	1.250	19.25
TPHQ0016	16	1.750	2.083	16.00	12	1.500	20.25

Taper Pin Reamers can also be made as specials in duplex style, extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharping.

HELICAL TAPER PIN REAMERS

With Morse Taper Shank

Schedule A3



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring. Our Taper Pin Reamers are ideal for reaming longer tapered holes and come in a variety of shank styles. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Morse Taper
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
TPHM0000	0	0.128	0.170	2.00	2	0	4.75
TPHM1001	1	0.144	0.191	2.25	2	1	5.19
TPHM1002	2	0.160	0.212	2.50	2	1	5.44
TPHM1003	3	0.181	0.241	2.88	2	1	5.81
TPHM1004	4	0.206	0.271	3.13	2	1	6.06
TPHM1005	5	0.237	0.310	3.50	2	1	6.44
TPHM1006	6	0.274	0.365	4.38	2	1	7.31
TPHM1007	7*	0.328	0.435	5.13	2	1	8.06
TPHM2007	7	0.328	0.435	5.13	2	2	8.75
TPHM1008	8*	0.394	0.521	6.13	2	1	9.06
TPHM2008	8	0.394	0.521	6.13	2	2	9.75
TPHM2009	9	0.475	0.610	6.50	4	2	10.13
TPHM2010	10	0.567	0.727	7.69	4	2	11.44
TPHM2011	11	0.706	0.878	8.25	6	2	12.00
TPHM3012	12	0.842	1.050	10.00	6	3	14.63
TPHM4013	13	1.009	1.259	12.00	6	4	17.63
TPHM4014	14	1.250	1.541	14.00	6	4	19.75
TPHM5015	15	1.500	1.812	15.00	10	5	22.00
TPHM5016	16	1.750	2.083	16.00	12	5	23.00

* Specify Morse Taper Shank Number when ordering size 7 or 8.

Taper Pin Reamers can also be made as specials in duplex style, extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL DIE MAKER REAMERS

With Straight Shank

.013" Taper Per Inch - .156' Taper Per Foot

Schedule D1



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal-reducing chatter, vibration and finish scoring.

Our Die Maker Reamers come in a variety of tapers and sizes and are ideal for a wide range of machining needs. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.



Flute *High Spiral, Left Hand*
 Cut *Right Hand*
 Shank *Straight*
 Material *High Speed Steel*

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
DMHS0005	5/A	0.036	0.047	0.88	2	0.125	2.00
DMHS0004	4/A	0.045	0.060	1.13	2	0.125	2.13
DMHS0003	3/A	0.055	0.070	1.13	2	0.125	2.25
DMHS0002	2/A	0.065	0.080	1.13	2	0.125	2.25
DMHS000A	A	0.075	0.090	1.13	2	0.125	2.25
DMHS000B	B	0.085	0.103	1.38	2	0.125	2.38
DMHS000C	C	0.095	0.113	1.38	2	0.125	2.50
DMHS000D	D	0.105	0.126	1.63	2	0.125	2.63
DMHS000E	E	0.115	0.136	1.63	2	0.125	2.75
DMHS000F	F	0.125	0.148	1.75	2	0.156	3.00
DMHS000G	G	0.135	0.158	1.75	2	0.188	3.00
DMHS000H	H	0.145	0.169	1.88	2	0.188	3.25
DMHS000I	I	0.160	0.184	1.88	2	0.188	3.25
DMHS000J	J	0.175	0.199	1.88	2	0.188	3.25
DMHS000K	K	0.190	0.219	2.25	2	0.188	3.50
DMHS000L	L	0.205	0.234	2.25	2	0.188	3.50
DMHS000M	M	0.220	0.252	2.50	2	0.250	4.00
DMHS000N	N	0.235	0.274	3.00	2	0.250	4.50
DMHS000O	O	0.250	0.296	3.50	2	0.250	5.00
DMHS000P	P	0.275	0.327	4.00	2	0.313	5.50
DMHS000Q	Q	0.300	0.358	4.50	2	0.313	6.00
DMHS000R	R	0.335	0.397	4.75	2	0.375	6.50
DMHS000S	S	0.370	0.435	5.00	2	0.375	6.75
DMHS000T	T	0.405	0.473	5.25	2	0.438	7.00
DMHS000U	U	0.440	0.511	5.50	2	0.500	7.25
DMHS000V	V	0.483	0.564	6.25	4	0.500	8.38
DMHS000W	W	0.525	0.613	6.75	4	0.500	8.75
DMHS000X	X	0.574	0.668	7.25	4	0.625	9.50
DMHS000Y	Y	0.629	0.730	7.75	4	0.625	10.00
DMHS000Z	Z	0.699	0.806	8.25	6	0.625	10.50

Our Die Maker Reamers can also be made as specials in duplex style, extra length, end cutting, special helix angles, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.



HELICAL DIE MAKER REAMERS

With Straight Shank

.005" Taper Per Inch - .060' Taper Per Foot

Schedule D2

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
DMHS5AA1	5AA1	0.045	0.051	1.13	2	0.125	2.13
DMHS5AA2	5AA2	0.049	0.055	1.13	2	0.125	2.13
DMHS5AA3	5AA3	0.053	0.059	1.13	2	0.125	2.13
DMHS5AA4	5AA4	0.057	0.063	1.13	2	0.125	2.13
DMHS5AA5	5AA5	0.061	0.067	1.13	2	0.125	2.13
DMHS5AA6	5AA6	0.065	0.071	1.13	2	0.125	2.13
DMHS5AA7	5AA7	0.069	0.075	1.13	2	0.125	2.13
DMHS5AA8	5AA8	0.073	0.079	1.13	2	0.125	2.13
DMHS05A1	5A1	0.077	0.083	1.13	2	0.125	2.13
DMHS05A2	5A2	0.081	0.088	1.38	2	0.125	2.50
DMHS05B1	5B1	0.086	0.093	1.38	2	0.125	2.50
DMHS05B2	5B2	0.091	0.099	1.50	2	0.125	2.63
DMHS05C1	5C1	0.097	0.105	1.50	2	0.125	2.63
DMHS05C2	5C2	0.103	0.111	1.50	2	0.125	2.75
DMHS05D1	5D1	0.109	0.117	1.50	2	0.125	2.75
DMHS05E1	5E1	0.115	0.123	1.63	2	0.125	2.88
DMHS05F1	5F1	0.121	0.130	1.75	2	0.125	3.00
DMHS05F2	5F2	0.127	0.136	1.75	2	0.125	3.00
DMHS05G1	5G1	0.133	0.142	1.88	2	0.156	3.25
DMHS05G2	5G2	0.140	0.149	1.88	2	0.156	3.25
DMHS05H1	5H1	0.147	0.156	1.88	2	0.156	3.25
DMHS05H2	5H2	0.154	0.163	1.88	2	0.156	3.25
DMHS05I1	5I1	0.161	0.170	1.88	2	0.156	3.25
DMHS05I2	5I2	0.168	0.177	1.88	2	0.188	3.25
DMHS05J1	5J1	0.175	0.184	1.88	2	0.188	3.25
DMHS05J2	5J2	0.182	0.193	2.25	2	0.188	3.63
DMHS05K1	5K1	0.191	0.202	2.25	2	0.188	3.63
DMHS05K2	5K2	0.200	0.211	2.25	2	0.219	3.63
DMHS05L1	5L1	0.209	0.220	2.25	2	0.219	3.63
DMHS05M1	5M1	0.218	0.231	2.50	2	0.219	4.13
DMHS05M2	5M2	0.228	0.241	2.50	2	0.250	4.13
DMHS05N1	5N1	0.238	0.253	3.00	2	0.250	4.75
DMHS05O1	5O1	0.250	0.269	3.75	2	0.250	5.50
DMHS05O2	5O2	0.266	0.285	3.75	2	0.281	5.50
DMHS05PA	5PA	0.282	0.302	4.00	2	0.313	5.75
DMHS05P2	5P2	0.298	0.321	4.50	2	0.313	6.25
DMHS05Q1	5Q1	0.317	0.340	4.50	2	0.344	6.25
DMHS05R1	5R1	0.336	0.360	4.75	2	0.344	6.56
DMHS05R2	5R2	0.356	0.380	4.75	2	0.375	6.56
DMHS05S1	5S1	0.376	0.401	5.00	2	0.375	6.75
DMHS05S2	5S2	0.397	0.423	5.25	2	0.375	7.00
DMHS05T1	5T1	0.419	0.445	5.25	2	0.438	7.00
DMHS05U1	5U1	0.440	0.469	5.75	2	0.438	7.625
DMHS05U2	5U2	0.464	0.493	5.75	2	0.500	7.63
DMHS05V1	5V1	0.488	0.519	6.25	4	0.500	8.38
DMHS05W1	5W1	0.514	0.548	6.75	4	0.500	8.75
DMHS05W2	5W2	0.543	0.577	6.75	4	0.563	8.75
DMHS05X1	5X1	0.572	0.608	7.25	4	0.563	9.50
DMHS05X2	5X2	0.603	0.639	7.25	4	0.625	9.50
DMHS05Y1	5Y1	0.634	0.672	7.75	4	0.625	10.00
DMHS05Y2	5Y2	0.667	0.708	8.25	4	0.688	10.50



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal-reducing chatter, vibration and finish scoring.

Our Die Maker Reamers come in a variety of tapers and sizes and are ideal for a wide range of machining needs. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.

Our Die Maker Reamers can also be made as specials in duplex style, extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL DIE MAKER REAMERS

With Straight Shank

.0087" Taper Per Inch - .104' Taper Per Foot

Schedule D3



Fast spiral fluted reamers provide the most accurate and best finished holes. The high helix design allows for the maximum surface contact and easier chip removal-reducing chatter, vibration and finish scoring.

Our Die Maker Reamers come in a variety of tapers and sizes and are ideal for a wide range of machining needs. Precision design provides exceptional quality and accuracy. We have the largest size range of HSS tools in stock.



Flute *High Spiral, Left Hand*
 Cut *Right Hand*
 Shank *Straight*
 Material *High Speed Steel*

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
DMHS8AA1	8AA1	0.045	0.054	1.13	2	0.125	2.13
DMHS8AA2	8AA2	0.053	0.063	1.13	2	0.125	2.13
DMHS8AA3	8AA3	0.061	0.071	1.13	2	0.125	2.13
DMHS008A	8A	0.069	0.079	1.13	2	0.125	2.13
DMHS008B	8B	0.077	0.087	1.13	2	0.125	2.13
DMHS008C	8C	0.085	0.097	1.38	2	0.125	2.50
DMHS008D	8D	0.095	0.108	1.50	2	0.125	2.63
DMHS008E	8E	0.106	0.119	1.50	2	0.125	2.75
DMHS008F	8F	0.117	0.131	1.63	2	0.125	2.88
DMHS008G	8G	0.128	0.143	1.75	2	0.125	3.00
DMHS008H	8H	0.141	0.157	1.88	2	0.156	3.25
DMHS008I	8I	0.155	0.171	1.88	2	0.156	3.25
DMHS008J	8J	0.167	0.183	1.88	2	0.188	3.25
DMHS008K	8K	0.181	0.197	1.88	2	0.188	3.25
DMHS008L	8L	0.195	0.215	2.25	2	0.219	3.63
DMHS008M	8M	0.213	0.235	2.50	2	0.219	4.13
DMHS008N	8N	0.233	0.259	3.00	2	0.250	4.75
DMHS008O	8O	0.257	0.290	3.75	2	0.281	5.50
DMHS008P	8P	0.288	0.323	4.00	2	0.313	5.75
DMHS008Q	8Q	0.319	0.358	4.50	2	0.344	6.25
DMHS008R	8R	0.355	0.396	4.75	2	0.375	6.56
DMHS008S	8S	0.393	0.437	5.00	2	0.438	6.75
DMHS008T	8T	0.434	0.480	5.25	2	0.438	7.00
DMHS008U	8U	0.476	0.530	6.25	4	0.500	8.38
DMHS008V	8V	0.527	0.586	6.75	4	0.563	8.75
DMHS008W	8W	0.583	0.646	7.25	4	0.625	9.50
DMHS008X	8X	0.643	0.710	7.75	4	0.688	10.00

Our Die Maker Reamers can also be made as specials in duplex style, extra length, end cutting, special helix angles, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.



HELICAL CHUCKING REAMERS
 With Straight Shank
Schedule G1



Designed for general purpose machining, left hand spiral chucking reamers work best on through-hole or limited stock removal applications. The high helix design of our chucking reamers reduces chatter and vibration and provides for easier chip removal. Precision design provides for exceptional quality and accuracy in most materials. Ideal for use in lathes, drill presses, milling machines and machining and turning centers.

Flute Cut Shank Material
 High Spiral, Left Hand
 Right Hand
 Straight
 High Speed Steel

Part Number	Size	Flute Length	Number of Flutes	Shank Diameter	Overall Length
CRLS0006	.0469 - .0625	0.50	4	0.125	2.5
CRLS0007	.0626 - .0781	0.75	4	0.125	3.0
CRLS0009	.0782 - .0938	0.75	4	0.125	3.0
CRLS0010	.0939 - .1094	0.88	4	0.125	3.5
CRLS0012	.1095 - .1250	0.88	4	0.125	3.5
CRLS0014	.1251 - .1406	1.00	4	0.125	4.0
CRLS0015	.1407 - .1563	1.00	4	0.125	4.0
CRLS0017	.1564 - .1719	1.13	6	0.125	4.5
CRLS0018	.1720 - .1875	1.13	6	0.156	4.5
CRLS0020	.1876 - .2031	1.25	6	0.156	5.0
CRLS0021	.2032 - .2188	1.25	6	0.188	5.0
CRLS0023	.2189 - .2344	1.50	6	0.188	6.0
CRLS0025	.2345 - .2500	1.50	6	0.219	6.0
CRLS0026	.2501 - .2656	1.50	6	0.219	6.0
CRLS0028	.2657 - .2813	1.50	6	0.250	6.0
CRLS0029	.2814 - .2969	1.50	6	0.250	6.0
CRLS0031	.2970 - .3125	1.50	6	0.250	6.0
CRLS0032	.3126 - .3281	1.50	6	0.250	6.0
CRLS0034	.3282 - .3438	1.50	6	0.313	6.0
CRLS0035	.3439 - .3594	1.75	6	0.313	7.0
CRLS0037	.3595 - .3750	1.75	6	0.313	7.0
CRLS0039	.3751 - .3906	1.75	6	0.313	7.0
CRLS0040	.3907 - .4063	1.75	6	0.375	7.0
CRLS0042	.4064 - .4219	1.75	6	0.375	7.0
CRLS0043	.4220 - .4375	1.75	6	0.375	7.0
CRLS0045	.4376 - .4531	1.75	6	0.375	7.0
CRLS0046	.4532 - .4688	1.75	6	0.438	7.0
CRLS0048	.4689 - .4844	2.00	6	0.438	8.0
CRLS0050	.4845 - .5000	2.00	6	0.438	8.0
CRLS0053	.5001 - .5313	2.00	6	0.438	8.0

Part Number	Size	Flute Length	Number of Flutes	Shank Diameter	Overall Length
CRLS0056	.5314 - .5625	2.00	6	0.500	8.0
CRLS0059	.5626 - .5938	2.00	6	0.500	8.0
CRLS0062	.5939 - .6250	2.25	8	0.563	9.0
CRLS0065	.6251 - .6563	2.25	8	0.563	9.0
CRLS0068	.6564 - .6875	2.25	8	0.625	9.0
CRLS0071	.6876 - .7188	2.25	8	0.625	9.0
CRLS0075	.7189 - .7500	2.50	8	0.688	9.5
CRLS0078	.7501 - .7813	2.50	8	0.688	9.5
CRLS0081	.7814 - .8125	2.50	8	0.750	9.5
CRLS0084	.8126 - .8438	2.50	8	0.750	9.5
CRLS0087	.8439 - .8750	2.63	8	0.750	10.0
CRLS0090	.8751 - .9063	2.63	8	0.750	10.0
CRLS0093	.9064 - .9375	2.63	8	0.875	10.0
CRLS0096	.9376 - .9688	2.63	8	0.875	10.0
CRLS0100	.9689 - 1.0000	2.75	8	0.875	10.5
CRLS0106	1.0001 - 1.0625	2.75	10	0.875	10.5
CRLS0112	1.0626 - 1.1250	2.88	10	1.000	11.0
CRLS0118	1.1251 - 1.1875	2.88	10	1.000	11.0
CRLS0125	1.1876 - 1.2500	3.00	10	1.125	11.5
CRLS0131	1.2501 - 1.3125	3.00	10	1.125	11.5
CRLS0137	1.3126 - 1.3750	3.25	10	1.250	12.0
CRLS0143	1.3751 - 1.4375	3.25	10	1.250	12.0
CRLS0150	1.4376 - 1.5000	3.50	10	1.375	12.5
CRLS0156	1.5001 - 1.5625	3.50	10	1.375	12.5
CRLS0162	1.5626 - 1.6250	3.75	10	1.375	13.0
CRLS0168	1.6251 - 1.6875	3.75	12	1.375	13.0
CRLS0175	1.6876 - 1.7500	4.00	12	1.500	13.5
CRLS0181	1.7501 - 1.8125	4.00	12	1.500	13.5
CRLS0187	1.8126 - 1.8750	4.25	12	1.500	14.0
CRLS0193	1.8751 - 1.9375	4.25	12	1.500	14.0
CRLS0200	1.9376 - 2.0000	4.25	12	1.500	14.0

Chucking reamers are furnished as Left Hand Spiral, Right Hand Cut. Also available in Right Hand Spiral or Straight Flute.

Flute Diameters are held to a tolerance of +.0002"/-.0000" unless otherwise specified.

Helical Chucking Reamers can also be made as specials in extra length, larger diameters, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

HELICAL CHUCKING REAMERS

With Morse Taper Shank

Schedule G2



Designed for general purpose machining, left hand spiral chucking reamers work best on through-hole or limited stock removal applications. The high helix design of our chucking reamers reduces chatter and vibration and provides for easier chip removal. Precision design provides for exceptional quality and accuracy in most materials. Ideal for use in lathes, drill presses, milling machines and machining and turning centers.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Morse Taper
Material High Speed Steel

Part Number	Size	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
CRLM1025	.2345 - .2500	1.500	6	1	6.0
CRLM1026	.2501 - .2656	1.500	6	1	6.0
CRLM1028	.2657 - .2813	1.500	6	1	6.0
CRLM1029	.2814 - .2969	1.500	6	1	6.0
CRLM1031	.2970 - .3125	1.500	6	1	6.0
CRLM1032	.3126 - .3281	1.500	6	1	6.0
CRLM1034	.3282 - .3438	1.500	6	1	6.0
CRLM1035	.3439 - .3594	1.750	6	1	7.0
CRLM1037	.3595 - .3750	1.750	6	1	7.0
CRLM1039	.3751 - .3906	1.750	6	1	7.0
CRLM1040	.3907 - .4063	1.750	6	1	7.0
CRLM1042	.4064 - .4219	1.750	6	1	7.0
CRLM1043	.4220 - .4375	1.750	6	1	7.0
CRLM1045	.4376 - .4531	1.750	6	1	7.0
CRLM1046	.4532 - .4688	1.750	6	1	7.0
CRLM1048	.4689 - .4844	2.000	6	1	8.0
CRLM1050	.4845 - .5000	2.000	6	1	8.0
CRLM1053	.5001 - .5313	2.000	6	1	8.0
CRLM1056	.5314 - .5625	2.000	6	1	8.0
CRLM1059	.5626 - .5938	2.000	6	1	8.0
CRHM2062	.5939 - .6250	2.250	8	2	9.0
CRHM2065	.6251 - .6563	2.250	8	2	9.0
CRHM2068	.6564 - .6875	2.250	8	2	9.0
CRHM2071	.6876 - .7188	2.250	8	2	9.0
CRHM2075	.7189 - .7500	2.500	8	2	9.5

Part Number	Size	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
CRLM2078	.7501 - .7813	2.500	8	2	9.5
CRLM2081	.7814 - .8125	2.500	8	2	9.5
CRLM2084	.8126 - .8438	2.500	8	2	9.5
CRLM2087	.8439 - .8750	2.625	8	2	10.0
CRLM2090	.8751 - .9063	2.625	8	2	10.0
CRLM3093	.9064 - .9375	2.625	8	3	10.0
CRLM3096	.9376 - .9688	2.625	8	3	10.0
CRLM3100	.9689 - 1.0000	2.750	8	3	10.5
CRLM3106	1.0001 - 1.0625	2.750	10	3	10.5
CRLM3112	1.0626 - 1.1250	2.875	10	3	11.0
CRLM3118	1.1251 - 1.1875	2.875	10	3	11.0
CRLM4125	1.1876 - 1.2500	3.000	10	4	11.5
CRLM4131	1.2501 - 1.3125	3.000	10	4	11.5
CRLM4137	1.3126 - 1.3750	3.250	10	4	12.0
CRLM4143	1.3751 - 1.4375	3.250	10	4	12.0
CRLM4150	1.4376 - 1.5000	3.500	10	4	12.5
CRLM4156	1.5001 - 1.5625	3.500	10	4	12.5
CRLM4162	1.5626 - 1.6250	3.750	10	4	13.0
CRLM4168	1.6251 - 1.6875	3.750	12	4	13.0
CRLM5175	1.6876 - 1.7500	4.000	12	5	13.5
CRLM5181	1.7501 - 1.8125	4.000	12	5	13.5
CRLM5187	1.8126 - 1.8750	4.250	12	5	14.0
CRLM5193	1.8751 - 1.9375	4.250	12	5	14.0
CRLM5200	1.9376 - 2.0000	4.250	12	5	14.0

Chucking reamers are furnished as Left Hand Spiral, Right Hand Cut. Also available in Right Hand Spiral or Straight Flute.

Flute Diameters are held to a tolerance of +.0002"/-.0000" unless otherwise specified.

Helical Chucking Reamers can also be made as specials in extra length, larger diameters, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

DUPLEX CHUCKING REAMERS

With Straight Shank

Schedule H1



One straight flute, all other flutes helical - for precision finishing and problem holes. Our unique duplex flute configuration eliminates chatter and rifling and provides an extremely fine finish - often eliminating the need for polishing or lapping. Excellent for use in a variety of materials including many types of steel, brass, aluminum and plastic.

Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Straight
Material High Speed Steel

Part Number	Size Range	Flute Length	Number of Flutes	Shank Diameter	Overall Length
CRDS0026	.2500 - .2656	1.50	6	0.219	6.0
CRDS0028	.2657 - .2813	1.50	6	0.250	6.0
CRDS0029	.2814 - .2969	1.50	6	0.250	6.0
CRDS0031	.2970 - .3125	1.50	6	0.250	6.0
CRDS0032	.3126 - .3281	1.50	6	0.250	6.0
CRDS0034	.3282 - .3438	1.50	6	0.313	6.0
CRDS0035	.3439 - .3594	1.75	6	0.313	7.0
CRDS0037	.3595 - .3750	1.75	6	0.313	7.0
CRDS0039	.3751 - .3906	1.75	6	0.313	7.0
CRDS0040	.3907 - .4063	1.75	6	0.375	7.0
CRDS0042	.4064 - .4219	1.75	6	0.375	7.0
CRDS0043	.4220 - .4375	1.75	6	0.375	7.0
CRDS0045	.4376 - .4531	1.75	6	0.375	7.0
CRDS0046	.4532 - .4688	1.75	6	0.438	7.0
CRDS0048	.4689 - .4844	2.00	6	0.438	8.0
CRDS0050	.4845 - .5000	2.00	6	0.438	8.0
CRDS0053	.5001 - .5313	2.00	6	0.438	8.0
CRDS0056	.5314 - .5625	2.00	6	0.438	8.0
CRDS0059	.5626 - .5938	2.00	6	0.500	8.0
CRDS0062	.5939 - .6250	2.25	8	0.500	9.0
CRDS0065	.6251 - .6563	2.25	8	0.563	9.0
CRDS0068	.6564 - .6875	2.25	8	0.563	9.0
CRDS0071	.6876 - .7188	2.25	8	0.625	9.0
CRDS0075	.7189 - .7500	2.50	8	0.688	9.5

Part Number	Size Range	Flute Length	Number of Flutes	Shank Diameter	Overall Length
CRDS0078	.7501 - .7813	2.50	8	0.688	9.5
CRDS0081	.7814 - .8125	2.50	8	0.750	9.5
CRDS0084	.8126 - .8438	2.50	8	0.750	9.5
CRDS0087	.8439 - .8750	2.63	8	0.750	10.0
CRDS0090	.8751 - .9063	2.63	8	0.750	10.0
CRDS0093	.9064 - .9375	2.63	8	0.875	10.0
CRDS0096	.9376 - .9688	2.63	8	0.875	10.0
CRDS0100	.9689 - 1.0000	2.75	8	0.875	10.5
CRDS0106	1.0001 - 1.0625	2.75	10	0.875	10.5
CRDS0112	1.0626 - 1.1250	2.88	10	1.000	11.0
CRDS0118	1.1251 - 1.1875	2.88	10	1.000	11.0
CRDS0125	1.1876 - 1.2500	3.00	10	1.125	11.5
CRDS0131	1.2501 - 1.3125	3.00	10	1.125	11.5
CRDS0137	1.3126 - 1.3750	3.25	10	1.250	12.0
CRDS0143	1.3751 - 1.4375	3.25	10	1.250	12.0
CRDS0150	1.4376 - 1.5000	3.50	10	1.375	12.5
CRDS0156	1.5001 - 1.5625	3.50	10	1.375	12.5
CRDS0162	1.5626 - 1.6250	3.75	10	1.375	13.0
CRDS0168	1.6251 - 1.6875	3.75	12	1.375	13.0
CRDS0175	1.6876 - 1.7500	4.00	12	1.500	13.5
CRDS0181	1.7501 - 1.8125	4.00	12	1.500	13.5
CRDS0187	1.8126 - 1.8750	4.25	12	1.500	14.0
CRDS0193	1.8751 - 1.9375	4.25	12	1.500	14.0
CRDS0200	1.9376 - 2.0000	4.25	12	1.500	14.0

Chucking reamers are furnished as Left Hand Spiral, Right Hand Cut. Also available in Right Hand Spiral or Straight Flute.

Flute Diameters are held to a tolerance of +.0002"/-.0000" unless otherwise specified.

Duplex Chucking Reamers can also be made as specials in extra length, special helix angles, end cutting, with larger diameters or in premium high speed steel or carbide.

All surface treatments available upon request.

DUPLEX CHUCKING REAMERS

With Morse Taper Shank

Schedule H2



One straight flute, all other flutes helical - for precision finishing and problem holes. Our unique duplex flute configuration eliminates chatter and rifling and provides an extremely fine finish - often eliminating the need for polishing or lapping. Excellent for use in a variety of materials including many types of steel, brass, aluminum and plastic.

Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Morse Taper
Material High Speed Steel

Part Number	Size	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
CRDM1026	.2500 - .2656	1.50	6	1	6.0
CRDM1028	.2657 - .2813	1.50	6	1	6.0
CRDM1029	.2814 - .2969	1.50	6	1	6.0
CRDM1031	.2970 - .3125	1.50	6	1	6.0
CRDM1032	.3126 - .3281	1.50	6	1	6.0
CRDM1034	.3282 - .3438	1.50	6	1	6.0
CRDM1035	.3439 - .3594	1.75	6	1	7.0
CRDM1037	.3595 - .3750	1.75	6	1	7.0
CRDM1039	.3751 - .3906	1.75	6	1	7.0
CRDM1040	.3907 - .4063	1.75	6	1	7.0
CRDM1042	.4064 - .4219	1.75	6	1	7.0
CRDM1043	.4220 - .4375	1.75	6	1	7.0
CRDM1045	.4376 - .4531	1.75	6	1	7.0
CRDM1046	.4532 - .4688	1.75	6	1	7.0
CRDM1048	.4689 - .4844	2.00	6	1	8.0
CRDM1050	.4845 - .5000	2.00	6	1	8.0
CRDM1053	.5001 - .5313	2.00	6	1	8.0
CRDM1056	.5314 - .5625	2.00	6	1	8.0
CRDM1059	.5626 - .5938	2.00	6	1	8.0
CRDM2062	.5939 - .6250	2.25	8	2	9.0
CRDM2065	.6251 - .6563	2.25	8	2	9.0
CRDM2068	.6564 - .6875	2.25	8	2	9.0
CRDM2071	.6876 - .7188	2.25	8	2	9.0
CRDM2075	.7189 - .7500	2.50	8	2	9.5
CRDM2078	.7501 - .7813	2.50	8	2	9.5
CRDM2081	.7814 - .8125	2.50	8	2	9.5
CRDM2084	.8126 - .8438	2.50	8	2	9.5
CRDM2087	.8439 - .8750	2.63	8	2	10.0
CRDM2090	.8751 - .9063	2.63	8	2	10.0
CRDM3093	.9064 - .9375	2.63	8	3	10.0
CRDM3096	.9376 - .9688	2.63	8	3	10.0
CRDM3100	.9689 - 1.0000	2.75	8	3	10.5
CRDM3106	1.0001 - 1.0625	2.75	10	3	10.5
CRDM3112	1.0626 - 1.1250	2.88	10	3	11.0
CRDM3118	1.1251 - 1.1875	2.88	10	3	11.0
CRDM4125	1.1876 - 1.2500	3.00	10	4	11.5
CRDM4131	1.2501 - 1.3125	3.00	10	4	11.5
CRDM4137	1.3126 - 1.3750	3.25	10	4	12.0
CRDM4143	1.3751 - 1.4375	3.25	10	4	12.0
CRDM4150	1.4376 - 1.5000	3.50	10	4	12.5
CRDM4156	1.5001 - 1.5625	3.50	10	4	12.5
CRDM4162	1.5626 - 1.6250	3.75	10	4	13.0
CRDM4168	1.6251 - 1.6875	3.75	12	4	13.0
CRDM5175	1.6876 - 1.7500	4.00	12	5	13.5
CRDM5181	1.7501 - 1.8125	4.00	12	5	13.5
CRDM5187	1.8126 - 1.8750	4.25	12	5	14.0
CRDM5193	1.8751 - 1.9375	4.25	12	5	14.0
CRDM5200	1.9376 - 2.0000	4.25	12	5	14.0

Chucking reamers are furnished as Left Hand Spiral, Right Hand Cut. Also available in Right Hand Spiral or Straight Flute.

Flute Diameters are held to a tolerance of +.0002"/-.0000" unless otherwise specified.

Duplex Chucking Reamers can also be made as specials in extra length, special helix angles, end cutting, with larger diameters or in premium high speed steel or carbide.

All surface treatments available upon request.

COMBINATION CHUCKING REAMERS

With Straight Shank

Schedule J1



Combination Chucking Reamers - partially straight flute, partially helical flute - are ideal for straightening out wandering holes. This tool can also be used to rough and finish holes in one pass or as piloted reamers.

Flute Partially Straight,
Partially Helical
Cut Right Hand
Shank Straight
Material High Speed Steel

Part Number	Size	Flute Length	Number of Flutes	Shank Diameter	Overall Length	Part Number	Size	Flute Length	Number of Flutes	Shank Diameter	Overall Length
CRCS0026	.2500 - .2656	1.50	6	0.219	6.0	CRCS0078	.7501 - .7813	2.50	8	0.688	9.5
CRCS0028	.2657 - .2813	1.50	6	0.250	6.0	CRCS0081	.7814 - .8125	2.50	8	0.750	9.5
CRCS0029	.2814 - .2969	1.50	6	0.250	6.0	CRCS0084	.8126 - .8438	2.50	8	0.750	9.5
CRCS0031	.2970 - .3125	1.50	6	0.250	6.0	CRCS0087	.8439 - .8750	2.63	8	0.750	10.0
CRCS0032	.3126 - .3281	1.50	6	0.250	6.0	CRCS0090	.8751 - .9063	2.63	8	0.750	10.0
CRCS0034	.3282 - .3438	1.50	6	0.313	6.0	CRCS0093	.9064 - .9375	2.63	8	0.875	10.0
CRCS0035	.3439 - .3594	1.75	6	0.313	7.0	CRCS0096	.9376 - .9688	2.63	8	0.875	10.0
CRCS0037	.3595 - .3750	1.75	6	0.313	7.0	CRCS0100	.9689 - 1.0000	2.75	8	0.875	10.5
CRCS0039	.3751 - .3906	1.75	6	0.313	7.0	CRCS0106	1.0001 - 1.0625	2.75	10	0.875	10.5
CRCS0040	.3907 - .4063	1.75	6	0.375	7.0	CRCS0112	1.0626 - 1.1250	2.88	10	1.000	11.0
CRCS0042	.4064 - .4219	1.75	6	0.375	7.0	CRCS0118	1.1251 - 1.1875	2.88	10	1.000	11.0
CRCS0043	.4220 - .4375	1.75	6	0.375	7.0	CRCS0125	1.1876 - 1.2500	3.00	10	1.125	11.5
CRCS0045	.4376 - .4531	1.75	6	0.375	7.0	CRCS0131	1.2501 - 1.3125	3.00	10	1.125	11.5
CRCS0046	.4532 - .4688	1.75	6	0.438	7.0	CRCS0137	1.3126 - 1.3750	3.25	10	1.250	12.0
CRCS0048	.4689 - .4844	2.00	6	0.438	8.0	CRCS0143	1.3751 - 1.4375	3.25	10	1.250	12.0
CRCS0050	.4845 - .5000	2.00	6	0.438	8.0	CRCS0150	1.4376 - 1.5000	3.50	10	1.375	12.5
CRCS0053	.5001 - .5313	2.00	6	0.438	8.0	CRCS0156	1.5001 - 1.5625	3.50	10	1.375	12.5
CRCS0056	.5314 - .5625	2.00	6	0.438	8.0	CRCS0162	1.5626 - 1.6250	3.75	10	1.375	13.0
CRCS0059	.5626 - .5938	2.00	6	0.500	8.0	CRCS0168	1.6251 - 1.6875	3.75	12	1.375	13.0
CRCS0062	.5939 - .6250	2.25	8	0.500	9.0	CRCS0175	1.6876 - 1.7500	4.00	12	1.500	13.5
CRCS0065	.6251 - .6563	2.25	8	0.563	9.0	CRCS0181	1.7501 - 1.8125	4.00	12	1.500	13.5
CRCS0068	.6564 - .6875	2.25	8	0.563	9.0	CRCS0187	1.8126 - 1.8750	4.25	12	1.500	14.0
CRCS0071	.6876 - .7188	2.25	8	0.625	9.0	CRCS0193	1.8751 - 1.9375	4.25	12	1.500	14.0
CRCS0075	.7189 - .7500	2.50	8	0.688	9.5	CRCS0200	1.9376 - 2.0000	4.25	12	1.500	14.0

Combination Chucking Reamers are furnished with diameters held to a tolerance of +.0002" / -.0000" unless otherwise requested.

Combination Chucking Reamers can also be made as specials in extra length, special helix angles, end cutting, in large diameters or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for sharpening.

COMBINATION CHUCKING REAMERS

With Morse Taper Shank

Schedule J2



Combination Chucking Reamers - partially straight flute, partially helical flute - are ideal for straightening out wandering holes. This tool can be used to rough and finish holes in one pass or as piloted reamers.

Flute *Partially Straight,
Partially Helical*
Cut *Right Hand*
Shank *Morse Taper*
Material *High Speed Steel*

Part Number	Size	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
CRCM0026	.2500 - .2656	1.50	6	1	6.0
CRCM0028	.2657 - .2813	1.50	6	1	6.0
CRCM0029	.2814 - .2969	1.50	6	1	6.0
CRCM0031	.2970 - .3125	1.50	6	1	6.0
CRCM0032	.3126 - .3281	1.50	6	1	6.0
CRCM0034	.3282 - .3438	1.50	6	1	6.0
CRCM0035	.3439 - .3594	1.75	6	1	7.0
CRCM0037	.3595 - .3750	1.75	6	1	7.0
CRCM0039	.3751 - .3906	1.75	6	1	7.0
CRCM0040	.3907 - .4063	1.75	6	1	7.0
CRCM0042	.4064 - .4219	1.75	6	1	7.0
CRCM0043	.4220 - .4375	1.75	6	1	7.0
CRCM0045	.4376 - .4531	1.75	6	1	7.0
CRCM0046	.4532 - .4688	1.75	6	1	7.0
CRCM0048	.4689 - .4844	2.00	6	1	8.0
CRCM0050	.4845 - .5000	2.00	6	1	8.0
CRCM0053	.5001 - .5313	2.00	6	1	8.0
CRCM0056	.5314 - .5625	2.00	6	1	8.0
CRCM0059	.5626 - .5938	2.00	6	1	8.0
CRCM0062	.5939 - .6250	2.25	8	2	9.0
CRCM0065	.6251 - .6563	2.25	8	2	9.0
CRCM0068	.6564 - .6875	2.25	8	2	9.0
CRCM0071	.6876 - .7188	2.25	8	2	9.0
CRCM0075	.7189 - .7500	2.50	8	2	9.5

Part Number	Size	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
CRCM0078	.7501 - .7813	2.50	8	2	9.5
CRCM0081	.7814 - .8125	2.50	8	2	9.5
CRCM0084	.8126 - .8438	2.50	8	2	9.5
CRCM0087	.8439 - .8750	2.63	8	2	10.0
CRCM0090	.8751 - .9063	2.63	8	2	10.0
CRCM0093	.9064 - .9375	2.63	8	3	10.0
CRCM0096	.9376 - .9688	2.63	8	3	10.0
CRCM0100	.9689 - 1.0000	2.75	8	3	10.5
CRCM0106	1.0001 - 1.0625	2.75	10	3	10.5
CRCM0112	1.0626 - 1.1250	2.88	10	3	11.0
CRCM0118	1.1251 - 1.1875	2.88	10	4	11.0
CRCM0125	1.1876 - 1.2500	3.00	10	4	11.5
CRCM0131	1.2501 - 1.3125	3.00	10	4	11.5
CRCM0137	1.3126 - 1.3750	3.25	10	4	12.0
CRCM0143	1.3751 - 1.4375	3.25	10	4	12.0
CRCM0150	1.4376 - 1.5000	3.50	10	4	12.5
CRCM0156	1.5001 - 1.5625	3.50	10	4	12.5
CRCM0162	1.5626 - 1.6250	3.75	10	4	13.0
CRCM0168	1.6251 - 1.6875	3.75	12	4	13.0
CRCM0175	1.6876 - 1.7500	4.00	12	5	13.5
CRCM0181	1.7501 - 1.8125	4.00	12	5	13.5
CRCM0187	1.8126 - 1.8750	4.25	12	5	14.0
CRCM0193	1.8751 - 1.9375	4.25	12	5	14.0
CRCM0200	1.9376 - 2.0000	4.25	12	5	14.0

Combination Chucking Reamers are furnished with diameters held to a tolerance of $+.0002" / -.0000"$ unless otherwise requested.

Combination Chucking Reamers can also be made as specials in extra length, special helix angles, end cutting, in larger diameters or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharping.

EXTRA LENGTH STUB SCREW MACHINE REAMERS

Left Hand Spiral with Right Hand Cut	SELR
Right Hand Spiral with Right Hand Cut	SERR
Straight Flute with Right Hand Cut	SESR
Left Hand Spiral with Left Hand Cut	SELL
Right Hand Spiral with Left Hand Cut	SERL
Straight Flute with Left Hand Cut	SESL

Schedule K1



These abbreviated versions of the chucking reamer are ideal for applications where the holes are shallow. Originally designed for use in screw machines, these tools can be used in a wide variety of machining applications. Pinholes in the shank allow for use in floating holders. Gammons Stub Screw Machine Reamers are available in a wide variety of diameters, cuts and flute spirals. They are also available in 3 or 4 flute styles or as semi-finished blanks.



Order specific style using the four letter part number code listed above followed by the number of flutes.

Part Number	Blank	Diameter Range	Overall Length	Flute Length	Shank Length	Shank Diameter	Hole Diameter	Span	Number of Flutes
*****03A	3/A	.0871 - .0960	2.5	1.13	1.25	0.188	0.086	0.625	4
*****02A	2/A	.0961 - .1110	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00A	A	.1111 - .1280	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00B	B	.1281 - .1410	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00C	C	.1411 - .1580	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00D	D	.1581 - .1730	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00E	E	.1731 - .1910	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00F	F	.1911 - .2190	2.5	1.13	1.25	0.188	0.086	0.625	4
*****00G	G	.2191 - .2530	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00H	H	.2531 - .2820	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00I	I	.2821 - .3130	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00J	J	.3131 - .3440	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00K	K	.3441 - .3780	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00L	L	.3781 - .4090	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00M	M	.4091 - .4410	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00N	N	.4411 - .4720	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00O	O	.4721 - .5020	4.0	2.00	2.00	0.375	0.188	0.875	4 or 6
*****00P	P	.5021 - .5670	4.0	2.00	2.00	0.625	0.188	0.875	4 or 6
*****00Q	Q	.5671 - .6280	4.0	2.00	2.00	0.625	0.188	0.875	4 or 8
*****00R	R	.6281 - .6920	4.0	2.00	2.00	0.625	0.188	0.875	4 or 8
*****00S	S	.6921 - .7520	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00T	T	.7521 - .8130	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00U	U	.8131 - .8750	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00V	V	.8751 - .9530	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00W	W	.9531 - .9850	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00X	X	.9851 - 1.047	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00Y	Y	1.048 - 1.110	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****00Z	Z	1.111 - 1.235	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****02Z	2/Z	1.236 - 1.360	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****03Z	3/Z	1.361 - 1.485	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8
*****04Z	4/Z	1.486 - 1.610	4.5	2.00	2.50	0.750	0.250	0.875	4 or 8

Flute diameters are held to a tolerance of $\pm .0002$ " / $-.0000$ " unless otherwise requested.

Also furnished as specials with end teeth, steps or pilots.

Available in premium high speed steel or carbide. All surface treatments are available upon request.

All sizes larger than *****00F may be special ordered in four flute style.

STANDARD LENGTH STUB SCREW MACHINE REAMERS

Left Hand Spiral with Right Hand Cut	SSLR
Right Hand Spiral with Right Hand Cut	SSRR
Straight Flute with Right Hand Cut	SSSR
Left Hand Spiral with Left Hand Cut	SSLL
Right Hand Spiral with Left Hand Cut	SSRL
Straight Flute with Left Hand Cut	SSSL



Schedule K2

These abbreviated versions of the chucking reamer are ideal for applications where the holes are shallow. Originally designed for use in screw machines, these tools can be used in a wide variety of machining applications. Pinholes in the shank allow for use in floating holders. Gammons Stub Screw Machine Reamers are available in a wide variety of diameters, cuts and flute spirals. They are also available in 3 or 4 flute styles or as semi-finished blanks.



Order specific style using the four letter part number code listed above followed by the number of flutes.

Part Number	Blank	Diameter Range	Overall Length	Flute Length	Shank Length	Shank Diameter	Hole Diameter	Number of Flutes
****300	3/0	.0301 - .0599	1.75	0.50	1.00	0.125	0.063	4
****200	2/0	.0600 - .0660	1.75	0.50	1.00	0.125	0.063	4
****000	0	.0661 - .0740	1.75	0.50	1.00	0.125	0.063	4
****001	1	.0741 - .0840	1.75	0.50	1.00	0.125	0.063	4
****002	2	.0841 - .0960	1.75	0.50	1.00	0.125	0.063	4
****003	3	.0961 - .1260	2.00	0.75	1.00	0.125	0.063	4
****004	4	.1261 - .1580	2.25	1.00	1.00	0.250	0.094	4
****005	5	.1581 - .1880	2.25	1.00	1.00	0.250	0.094	4
****006	6	.1881 - .2190	2.25	1.00	1.00	0.250	0.094	3, 4 or 6
****007	7	.2191 - .2510	2.25	1.00	1.00	0.250	0.094	3, 4 or 6
****008	8	.2511 - .2820	2.25	1.00	1.00	0.375	0.125	3, 4 or 6
****009	9	.2821 - .3130	2.25	1.00	1.00	0.375	0.125	3, 4 or 6
****010	10	.3131 - .3440	2.50	1.25	1.00	0.375	0.125	3, 4 or 6
****011	11	.3441 - .3760	2.50	1.25	1.00	0.375	0.125	3, 4 or 6
****012	12	.3761 - .4070	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****013	13	.4071 - .4390	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****014	14	.4391 - .4700	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****015	15	.4701 - .5050	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****016	16	.5051 - .5670	3.00	1.50	1.25	0.625	0.250	3, 4 or 6
****017	17	.5671 - .6280	3.00	1.50	1.25	0.625	0.250	3, 4 or 6
****018	18	.6281 - .6920	3.00	1.50	1.25	0.625	0.250	3, 4 or 8
****019	19	.6921 - .7550	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****020	20	.7551 - .8170	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****021	21	.8171 - .8800	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****022	22	.8801 - .9420	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****023	23	.9421 - 1.010	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****024	24	1.011 - 1.047	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****025	25	1.048 - 1.110	3.00	1.50	1.25	0.750	0.313	4 or 8
****026	26	1.111 - 1.235	3.00	1.50	1.25	0.750	0.313	4 or 8
****027	27	1.236 - 1.360	3.00	1.50	1.25	0.750	0.313	4 or 8
****028	28	1.361 - 1.550	3.00	1.50	1.25	0.750	0.313	4 or 8

Flute diameters are held to a tolerance of +.0002"/-.0000" unless otherwise requested.
 Also furnished as specials with end teeth, steps or pilots.
 Available in premium high speed steel or carbide. All surface treatments are available upon request.

All sizes between ****006 and ****024 may be special ordered in three and four flute style.
 All sizes between ****025 and ****028 may be special ordered in four flute style.

HELICAL MORSE TAPER REAMER

with Squared Shank

Schedule O1



Helical Morse Taper Reamers are used to finish Morse Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill press, milling machines or machining centers.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
MTHQ0000	0	0.250	0.367	2.25	4	0.313	3.75
MTHQ0001	1	0.367	0.517	3.00	4	0.438	5.00
MTHQ0002	2	0.570	0.744	3.50	4	0.625	6.00
MTHQ0003	3	0.775	0.988	4.25	6	0.875	7.25
MTHQ0004	4	1.017	1.289	5.25	6	1.125	8.50
MTHQ0005	5	1.472	1.801	6.25	6	1.500	9.75
MTHQ0006	6	2.112	2.555	8.50	8	2.000	12.25

Helical Morse Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL MORSE TAPER REAMERS

With Morse Taper Shank

Schedule O2



Helical Morse Taper Reamers are used to finish Morse Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill press, milling machines or machining centers.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Morse Taper
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Morse Taper Shank	Overall Length
MTHM0000	0	0.250	0.367	2.25	4	0	5.34
MTHM1001	1	0.367	0.517	3.00	4	1	6.31
MTHM2002	2	0.570	0.744	3.50	4	2	7.38
MTHM3003	3	0.775	0.988	4.25	6	3	8.88
MTHM4004	4	1.017	1.289	5.25	6	4	10.88
MTHM5005	5	1.472	1.801	6.25	8	5	13.13
MTHM5006	6	2.112	2.555	8.50	8	5	17.75

Helical Morse Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

DUPLEX MORSE TAPER REAMER

With Squared Shank

Schedule Q1



Duplex Morse Taper Reamers are used to finish Morse Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill press, milling machines or machining centers.

Gammons Duplex Morse Taper Reamers are ideally suited for precision finishing. The flute configuration of one straight or slow spiral flute surrounded by high helix flutes eliminates chatter and rifling, thereby providing an extremely fine finish.

Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes *	Shank Diameter	Overall Length
MTDQ0000	0	0.250	0.367	2.25	4	0.313	3.75
MTDQ0001	1	0.367	0.517	3.00	6	0.438	5.00
MTDQ0002	2	0.570	0.744	3.50	6	0.625	6.00
MTDQ0003	3	0.775	0.988	4.25	8	0.875	7.25
MTDQ0004	4	1.017	1.289	5.25	8	1.125	8.50
MTDQ0005	5	1.472	1.801	6.25	10	1.500	9.75
MTDQ0006	6	2.112	2.555	8.50	12	2.000	12.25

* Including the straight flute

Duplex Morse Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

DUPLEX MORSE TAPER REAMER

With Morse Taper Shank

Schedule Q2



Duplex Morse Taper Reamers are used to finish Morse Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill press, milling machines or machining centers.

Gammons Duplex Morse Taper Reamers are ideally suited for precision finishing. The flute configuration of one straight or slow spiral flute surrounded by high helix flutes eliminates chatter and rifling, thereby providing an extremely fine finish.

Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Morse Taper
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes*	Morse Taper Shank	Overall Length
MTDM0000	0	0.250	0.367	2.25	4	0	5.34
MTDM1001	1	0.367	0.517	3.00	6	1	6.31
MTDM2002	2	0.570	0.744	3.50	6	2	7.38
MTDM3003	3	0.775	0.988	4.25	8	3	8.88
MTDM4004	4	1.017	1.289	5.25	8	4	10.88
MTDM5005	5	1.472	1.801	6.25	10	5	13.13
MTDM5006	6	2.112	2.555	8.50	12	5	17.75

* Including the straight flute

Duplex Morse Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL BROWN & SHARPE TAPER REAMERS

With Squared Shank

Schedule S1



Brown & Sharpe Taper Reamers, also referred to as Aircraft Taper Reamers, are used to finish Brown & Sharpe Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill presses, milling machines or machining centers.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
BSHQ0000	0	0.160	0.275	2.75	3	0.250	4.63
BSHQ0001	1	0.197	0.318	2.88	4	0.281	4.75
BSHQ0002	2	0.247	0.378	3.13	4	0.344	5.13
BSHQ0003	3	0.310	0.451	3.38	4	0.406	5.50
BSHQ0004	4	0.347	0.502	3.69	6	0.438	5.88
BSHQ0005	5	0.447	0.615	4.00	6	0.563	6.38
BSHQ0006	6	0.497	0.681	4.38	6	0.625	6.88
BSHQ0007	7	0.597	0.801	4.88	6	0.750	7.50
BSHQ0008	8	0.747	0.977	5.50	8	0.813	8.13
BSHQ0009	9	0.897	1.153	6.13	8	1.000	8.88
BSHQ0010	10	1.042	1.338	6.88	8	1.125	9.75
BSHQ0011	11	1.247	1.566	7.63	8	1.375	10.63
BSHQ0012	12	1.497	1.841	8.25	8	1.250	11.50

Brown & Sharpe Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

DUPLEX BROWN & SHARPE TAPER REAMERS

With Squared Shank

Schedule S2



Brown & Sharpe Taper Reamers, also referred to as Aircraft Taper Reamers, are used to finish Brown & Sharpe Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as a drill presses, milling machines or machining centers.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

The duplex flute configuration of one straight or slow spiral flute surrounded by high helix flutes eliminates chatter and rifling, thereby providing an extremely fine finish.

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
BSDQ0000	0	0.160	0.275	2.75	3	0.250	4.63
BSDQ0001	1	0.197	0.318	2.88	4	0.281	4.75
BSDQ0002	2	0.247	0.378	3.13	4	0.344	5.13
BSDQ0003	3	0.310	0.451	3.38	4	0.406	5.50
BSDQ0004	4	0.347	0.502	3.69	6	0.438	5.88
BSDQ0005	5	0.447	0.615	4.00	6	0.563	6.38
BSDQ0006	6	0.497	0.681	4.38	6	0.625	6.88
BSDQ0007	7	0.597	0.801	4.88	6	0.750	7.50
BSDQ0008	8	0.747	0.977	5.50	8	0.813	8.13
BSDQ0009	9	0.897	1.153	6.13	8	1.000	8.88
BSDQ0010	10	1.042	1.338	6.88	8	1.125	9.75
BSDQ0011	11	1.247	1.566	7.63	8	1.375	10.63
BSDQ0012	12	1.497	1.841	8.25	8	1.250	11.50

Brown & Sharpe Taper Reamers can also be made as specials in extra length, special helix angles, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL JARNO TAPER REAMERS

With Squared Shanks

Schedule U



Helical Jarno Taper Reamers are used to finish Jarno Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as drill presses or milling machines.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
JTHQ0001	1	0.100	0.144	0.88	3	0.125	1.75
JTHQ0002	2	0.200	0.269	1.38	6	0.234	2.63
JTHQ0003	3	0.300	0.400	2.00	6	0.375	3.50
JTHQ0004	4	0.400	0.531	2.63	6	0.438	4.38
JTHQ0005	5	0.500	0.659	3.19	6	0.563	5.13
JTHQ0006	6	0.600	0.787	3.75	6	0.688	5.88
JTHQ0007	7	0.700	0.916	4.31	6	0.813	6.63
JTHQ0008	8	0.800	1.044	4.88	8	0.938	7.38
JTHQ0009	9	0.900	1.169	5.38	8	1.063	8.13
JTHQ0010	10	1.000	1.297	5.94	8	1.125	8.88
JTHQ0011	11	1.100	1.422	6.44	8	1.188	9.50
JTHQ0012	12	1.200	1.550	7.00	8	1.313	10.13
JTHQ0013	13	1.300	1.675	7.50	8	1.438	10.75
JTHQ0014	14	1.400	1.800	8.00	8	1.500	11.38
JTHQ0015	15	1.500	1.928	8.56	10	1.625	12.00
JTHQ0016	16	1.600	2.053	9.06	10	1.750	12.63
JTHQ0017	17	1.700	2.181	9.63	12	1.750	13.38
JTHQ0018	18	1.800	2.306	10.13	12	1.875	14.00
JTHQ0019	19	1.900	2.431	10.63	12	2.000	14.63
JTHQ0020	20	2.000	2.556	11.13	12	2.000	15.25

Also furnished as Specials with special helix angle, extra length, end cutting, with chip breakers or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

HELICAL AUTOMOTIVE TAPER REAMERS

With Squared Shank

1 1/2" Taper per foot (.1250" per inch)

Schedule V



The high helix design of our Automotive Taper Reamers allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring. Helical Automotive Taper Reamers are ideal for use in steering arm, tie rod end and ball joint applications.

Flute *High Spiral, Left Hand*
 Cut *Right Hand*
 Shank *Squared*
 Material *High Speed Steel*

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
ATHQA250	1/4	0.250	0.563	2.5	4	0.438	4.0
ATHQA375	*3/8	0.375	0.750	3.0	4	0.625	5.0
ATHQB375	*3/8	0.375	0.750	3.0	4	0.500	5.0
ATHQB500	*1/2	0.500	0.938	3.5	6	0.500	6.0
ATHQA500	*1/2	0.500	0.938	3.5	6	0.875	6.0
ATHQA625	*5/8	0.625	1.188	4.5	6	0.750	7.5
ATHQB625	*5/8	0.625	1.188	4.5	6	1.000	7.5
ATHQA750	3/4	0.750	1.438	5.5	8	1.000	8.5

* Specify shank size

Also furnished as Specials in duplex style, roughing reamers, or with special helix angles, extra length, end cutting, chip breakers or premium high speed steel and carbide.

All surface treatments available upon request.

Return to Gammons for resharpening.

DUPLEX MORSE TAPER WELDING EQUIPMENT REAMERS

Solid Type

Schedule W1



Duplex Morse Taper Welding Reamers are ideally suited for precision finishing in welding guns, cap-type electrodes, and other forms of welding equipment.

The duplex flute configuration of one straight or slow spiral flute surrounded by high helix flutes eliminates chatter and rifling, thereby providing an extremely fine finish.

Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
MWDMS000	0	0.284	0.362	1.5	6	0.313	3.00
MWDMS001	1	0.436	0.511	1.5	6	0.438	3.00
MWDMS002	2	0.586	0.661	1.5	8	0.563	3.00
MWDMS003	3	0.812	0.887	1.5	8	0.750	3.00

Duplex Morse Taper Welding Equipment Reamers can also be made as specials in different angles, extra length, special helix angles, end cutting or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for resharpener.

**DUPLEX MORSE TAPER WELDING
EQUIPMENT REAMERS**
Hole Through Type

Schedule W2



Duplex Morse Taper Welding Reamers are ideally suited for precision finishing in welding guns, cap-type electrodes, and other forms of welding equipment.

The duplex flute configuration of one straight or slow spiral flute surrounded by high helix flutes eliminates chatter and rifling, thereby providing an extremely fine finish.



Flute High Spiral, Left Hand
w/ One Straight Flute
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
MWDMH000	0	0.284	0.324	0.75	6	N/A	1.13
MWDMH001	1	0.436	0.486	1.00	6	N/A	1.50
MWDMH002	2	0.586	0.636	1.00	6	N/A	1.50
MWDMH003	3	0.812	0.887	1.50	8	N/A	2.00

Duplex Morse Taper Welding Equipment Reamers can also be made as specials in different angles, extra length, special helix angles, end cutting or in premium high speed steel or carbide.

All surface treatments available upon request.

Return to Gammons for sharpening.

HELICAL RWMA WELDING EQUIPMENT REAMERS

.050" Taper Per Inch - .600' Taper Per Foot

Schedule Y



The high helix design of our RWMA Welding Equipment Reamers allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring.

Helical RWMA Welding Equipment Welding Reamers are ideally suited for precision finishing in welding guns, cap-type electrodes, and other forms of welding equipment.

Flute High Spiral, Left Hand
Cut Right Hand
Shank Squared
Material High Speed Steel

Part Number	Size	Small End Diameter	Large End Diameter	Flute Length	Number of Flutes	Shank Diameter	Overall Length
RWHQ03RW	3 RW	0.348	0.392	1.00	4	0.375	2.25
RWHQ04RW	4 RW	0.436	0.499	1.38	4	0.500	3.00
RWHQ05RW	5 RW	0.576	0.626	1.38	4	0.500	3.00
RWHQ06RW	6 RW	0.704	0.754	1.38	6	0.500	3.00
RWHQ07RW	7 RW	0.817	0.880	1.38	6	0.750	3.00
RWHQ04CP	4 CAP	0.348	0.392	1.00	4	0.375	2.25
RWHQ05CP	5 CAP	0.394	0.438	1.00	4	0.375	2.25
RWHQ06CP	6 CAP	0.473	0.517	1.00	4	0.375	2.25
RWHQ07CP	7 CAP	0.576	0.626	1.38	4	0.500	3.00

3 RW through 7RW have water tube holes.
 RWMA tapers are interchangeable with AWS tapers.

Also furnished as Specials with special helix angles, extra length, end cutting, chip breakers or premium high speed steel and carbide.

All surface treatments available upon request.

Return to Gammons for resharpenering.