



Drill-Reamers

Severance Drill-Reamers are designed to drill and ream in one pass. The maximum length of holes recommended for standard drill-reamers is twice their respective diameters. Drill-Reamers of special design can be made for holes of greater length. For best results, drilling should be completed before starting to ream.

Severance Drill-Reamers are well suited for use with jigs and require only one size jig bushing.

High Speed Steel

| Drill Reamer Size | Suggested Ream Length | Overall Length | Approx. Drill Length | Drill Dia. -.001 +.000 | Severance Tool Name | EDP Order Number |
|-------------------|-----------------------|----------------|----------------------|---------------------------|---------------------|------------------|
| 3/16" | 0.560 | 3-1/2" | 0.20 | .182 | DR-3/16 | 26480 |
| 1/4" | 0.750 | 4" | 0.30 | .242 | DR-1/4 | 26503 |
| 5/16" | 0.940 | 4-1/2" | 0.40 | .302 | DR-5/16 | 26519 |
| 3/8" | 1.130 | 5" | 0.40 | .368 | DR-3/8 | 26534 |
| 1/2" | 1.500 | 6" | 0.60 | .492 | DR-1/2 | 26548 |



Ball Seat Reamers

Six-Flute Chatterless™ Design

Sizes – Tolerances – Radius size (1/2 tool diameter) is held to a plus or minus .0005". Variations from this tolerance, and other sizes at a nominal extra charge.

Uses – Severance Chatterless™ Ball Seat and Cavity Reamers are being used with outstanding success on steering gear, ball pin sockets, fuel injector plungers, valve push rod caps, gear shift lever seats, molds, etc.

High Speed Steel

| Cutting Dia. | Ball Seat Radius | Overall Length | Shank Dia. | Shank Length | Severance Tool Name | EDP Order Number |
|--------------|------------------|----------------|------------|--------------|---------------------|------------------|
| 1/4" | .1247/.1253 | 1-7/16" | 3/16" | 3/4" | BS-1/4 | 26030 |
| 3/8" | .1872/.1877 | 1-11/16" | 1/4" | 7/8" | BS-3/8 | 26031 |
| 1/2" | .2497/.2503 | 1-15/16" | 3/8" | 1-1/8" | BS-1/2 | 26032 |
| 5/8" | .3122/.3127 | 2-3/16" | 3/8" | 1-1/8" | BS-5/8 | 26033 |
| 3/4" | .3747/.3753 | 2-1/2" | 1/2" | 1-5/16" | BS-3/4 | 26034 |
| 7/8" | .4372/.4377 | 2-5/8" | 1/2" | 1-5/16" | BS-7/8 | 26035 |
| 1" | .4997/.5003 | 2-5/8" | 1/2" | 1-5/16" | BS-1 | 26036 |
| 1-1/4" | .6247/.6253 | 3" | 3/4" | 1-5/8" | BS-1-1/4 | 26037 |
| 1-1/2" | .7497/.7503 | 3-1/4" | 3/4" | 1-5/8" | BS-1-1/2 | 26038 |

Special Ball Seat Reamer

Special ball seat reamer for use on valve seats for a automotive valve lifter application.



REF. # 55350



Micro Reamers[™]

Designed for smooth, chatter-free[™] action, Micro-Reamers[™] perform well in cast and malleable iron and in many nonferrous materials such as plastics, aluminum, etc. These tools feature solid carbide head with a steel body. The chatter-free tooth design and unique wiping flute geometry. A rigid setup, perfect alignment between the hole to be reamed, and the Micro-Reamer[™], and the guide bushing, will produce accurate, finely finished holes. The drilled hole, to be reamed, should be approximately .006 to .016 undersize in holes from 3/8 to 1 inch in diameter. Standard tool tolerance is +.0002/-.0000. Other sizes and tolerance specifications on request.

Carbide

| Cutting Dia. | Shank Dia. | Overall Length | Shank Length | Severance Tool Name | EDP Order Number |
|--------------|------------|----------------|--------------|---------------------|------------------|
| 1/8" | 7/64" | 2-3/4" | 1-3/4" | RW-.1250 | 26170 |
| 3/16" | 11/64" | 3-1/2" | 2-3/8" | RW-.1875 | 26171 |
| 3/8" | 5/16" | 5" | 3-1/4" | RW-.3750 | 26172 |
| 1/2" | 7/16" | 6" | 4" | RW-.5000 | 26173 |
| 9/16" | 7/16" | 6" | 4" | RW-.5625 | 26174 |



REF.#53260

Other style Reamers are available as a special. Here is an example of a large taper reamer.



Micro-Center Reamers[™]

These tools are used to clean center holes in parts after heat treat or other processes. Micro-Center Reamers[™] are particularly well suited in center lapping operations where speed is a factor and close tolerances must be maintained. They can be used in shifting centers to correct misalignment. Replace grinding wheels for: Dressing centers in hardened steel materials (will not chip out like center laps).

They will do an outstanding job on a wide variety of materials such as hardened tool steels; heat-treated forgings; and cast steels; Melanite and chilled iron, pitch and cut can be readily made to suit unusual conditions not responsive to the standard tool.

Carbide

| Cutting Dia. | Nose Dia. | Shank Dia. | Overall Length | Shank Length | C/L Angle | Severance Tool Name | EDP Order Number |
|--------------|-----------|------------|----------------|--------------|-----------|---------------------|------------------|
| 1/4" | .015 | 3/16" | 1-1/2" | 1-3/16" | 30° | MCR-4-W | 26130 |
| 3/8" | .020 | 1/4" | 1-3/4" | 1-3/4" | 30° | MCR-6-W | 26131 |
| 1/2" | .040 | 1/4" | 2-1/4" | 1-3/4" | 30° | MCR-8-W | 26132 |
| 5/8" | .050 | 3/8" | 2-3/8" | 1-1/2" | 30° | MCR-10-W | 26133 |
| 3/4" | .060 | 1/2" | 2-11/16" | 1-5/16" | 30° | MCR-12-W | 26134 |
| 1" | .090 | 1/2" | 2-13/16" | 1-5/16" | 30° | MCR-16-W | 26135 |

Note: All Micro-Center Reamers[™] are TiN Coated at no extra charge!