



## 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!**