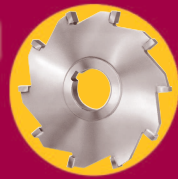


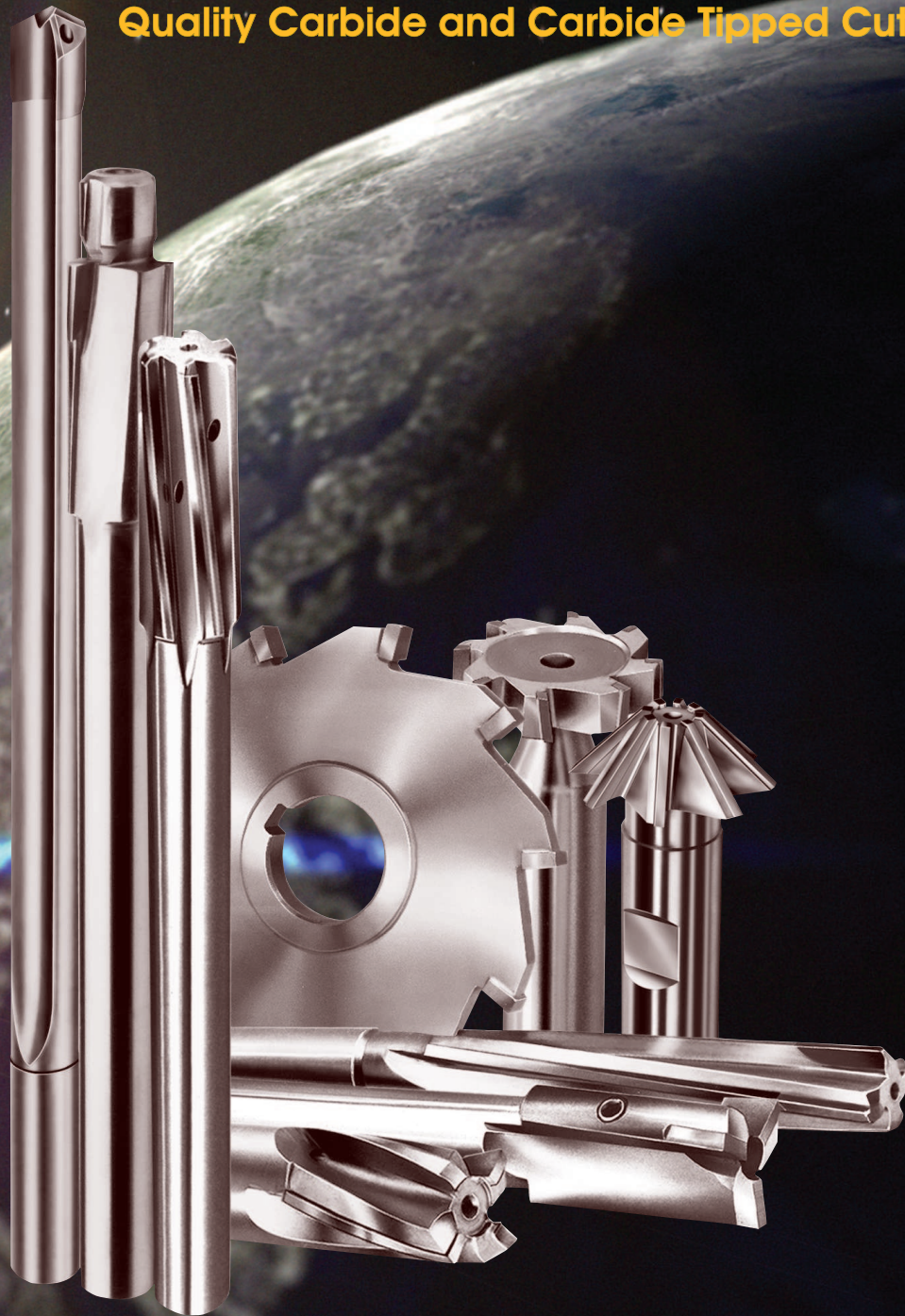
LEXINGTON

CUTTER, INC.



ISO 9001 Registered
Quality Carbide and Carbide Tipped Cutting Tools

2009



Proudly Made in the United States

LEXINGTON CUTTER TOOL INDEX

	Tool Type	Fractional Page	Metric Page	TOOL SELECTOR							CROSS REFERENCE						
				Non-Ferrous Soft	Non-Ferrous Hard	Cast Iron	Low Carbon Steel	Med. Strength Steels	High Strength Steels	High Strength Steels	Cleveland	Fullerton	Gay/lee	Moore	MYTD	Niagara	RTW (Greenfield)
MILLING CUTTERS - ARBOR TYPE				TOOL SELECTOR							CROSS REFERENCE						
Double Angle Cutter - 45° Included	3750	17								-	-	-	-	-	-	-	
Double Angle Cutter - 60° Included	3752	17								-	-	-	-	-	-	-	
Double Angle Cutter - 90° Included	3754	17								-	-	-	-	-	-	-	
Shell Mill Cutter - Cast Iron	3531	17								772	-	5859	-	4900	-	5690	
Shell Mill Cutter - Non-Ferrous	3530	17								773	-	5858	-	4920	-	5694	
Shell Mill Cutter - Steel	3532	17								771	-	5860	-	4910	-	5692	
Side Milling Cutter - Cast Iron	3541	16								-	-	5862	-	1590	-	5400	
Side Milling Cutter - Non-Ferrous	3540	16								-	-	5861	-	1630	-	5404	
Side Milling Cutter - Stainless Steel	3543	16								-	-	5849	-	-	-	-	
Side Milling Cutter - Steel	3542	16								-	-	5863	-	1550	-	5401	
Single Angle Cutter - 45° Left	3716	17								-	-	-	-	-	-	-	
Single Angle Cutter - 45° Right	3714	17								-	-	-	-	-	-	-	
Single Angle Cutter - 60° Left	3726	17								-	-	-	-	-	-	-	
Single Angle Cutter - 60° Right	3724	17								-	-	-	-	-	-	-	
Slitting Saw - Coarse Tooth - Cast Iron	3552	14								-	-	CCI 5847	-	4240	-	5406	
Slitting Saw - Coarse Tooth - Non-Ferrous	3550	14								-	-	CNF 5846	-	4690	-	5407	
Slitting Saw - Coarse Tooth - Stainless Steel	3558	14								-	-	GSS 5850	-	4260	-	-	
Slitting Saw - Coarse Tooth - Steel	3554	14								-	-	CST 5848	-	4220	-	5405	
Slitting Saw - Standard Tooth - Cast Iron	3553	15								1361	-	GPP	-	-	-	-	
Slitting Saw - Standard Tooth - Non-Ferrous	3551	15								1361	-	GPP	-	-	-	-	
Slitting Saw - Standard Tooth - Stainless Steel	3559	15								-	-	GSS	-	-	-	-	
Slitting Saw - Standard Tooth - Steel	3556	15								1360	-	STL	-	-	-	-	
MILLING CUTTERS - SHANK TYPE				TOOL SELECTOR							CROSS REFERENCE						
Chamfer Cutter - 45° Single Angle - Non-Ferrous & Cast Iron	3730	10								-	-	-	-	-	-	-	
Chamfer Cutter - 45° Single Angle - Steel	3731	10								-	-	-	-	-	-	-	
Chamfer Cutter - 60° Single Angle - Non-Ferrous & Cast Iron	3732	10								-	-	-	-	-	-	-	
Chamfer Cutter - 60° Single Angle - Steel	3733	10								-	-	-	-	-	-	-	
Chamfer Cutter - 60° Double Angle - Non-Ferrous & Cast Iron	3746	10								-	-	-	-	-	-	-	
Chamfer Cutter - 60° Double Angle - Steel	3747	10								-	-	-	-	-	-	-	
Chamfer Cutter - 90° Double Angle - Non-Ferrous & Cast Iron	3748	10								-	-	-	-	-	-	-	
Chamfer Cutter - 90° Double Angle - Steel	3749	10								-	-	-	-	-	-	-	
Dovetail Cutter - 45° Single Angle - Non-Ferrous & Cast Iron	3734	11								-	-	-	-	-	-	-	
Dovetail Cutter - 45° Single Angle - Steel	3735	11								-	-	-	-	-	-	-	
Dovetail Cutter - 60° Single Angle - Non-Ferrous & Cast Iron	3736	11								-	-	-	-	-	-	-	
Dovetail Cutter - 60° Single Angle - Steel	3737	11								-	-	-	-	-	-	-	
Face Mill - Cast Iron	3537	18								-	-	1450/1460	-	-	-	-	
Face Mill - Non-Ferrous	3536	18								-	-	1450/1460	-	-	-	-	
Face Mill - Steel	3538	18								-	-	1450/1460	-	-	-	-	
Keyseat Cutter - High Performance - Aluminum	3704	5								-	-	-	-	-	-	-	
Keyseat Cutter - Staggered Tooth - Non-Ferrous & Cast Iron	3701	7								-	-	-	-	-	-	-	
Keyseat Cutter - Staggered Tooth - Steel	3703	9								-	-	-	-	-	-	-	
Keyseat Cutter - Straight Tooth - Non-Ferrous & Cast Iron	3700	6								-	-	-	-	CB444	-	-	
Keyseat Cutter - Straight Tooth - Steel	3702	8								-	-	-	-	-	-	-	
Radius Cutter - Non-Ferrous & Cast Iron	3718	10								-	-	-	-	-	-	-	
Radius Cutter - Steel	3719	10								-	-	-	-	-	-	-	
T-Slot Cutter - Non-Ferrous & Cast Iron	3720	11								-	-	-	-	-	-	-	
T-Slot Cutter - Steel	3721	11								-	-	-	-	-	-	-	
END MILLS				TOOL SELECTOR							CROSS REFERENCE						
6° Left Spiral Flutes - Steel	3310	21								767	60LSS	-	5964	4738	-	LSEM	-
6° Right Spiral Flutes - Non-Ferrous & Cast Iron	3306	22								766	60RS-	-	5921	-	4700	RSEM	5682
6° Right Spiral Flutes - Non-Ferrous Soft - Upsharp	3307	22								-	-	-	-	-	-	-	-
6° Right Spiral Flutes - Steel	3308	21								-	60RSS	-	-	4736	-	-	-
15° Right Spiral Flutes - Cast Iron	3320	23								-	-	-	-	-	-	-	-
15° Right Spiral Flutes - Non-Ferrous & Cast Iron	3375	23								-	-	5692	4737	4840	HLS	5002	
15° Right Spiral Flutes - Steel	3350	21								-	60GSS	-	5960	4733	4820	HES	5001
25° Right Spiral Flutes - Non-Ferrous	3325	23								-	60FS	-	5958	4731	4860	HNS	5003
25° Right Spiral Flutes - Non-Ferrous Soft - Upsharp	3327	23								-	-	-	-	-	-	-	-
Bridgeport - Reduced 3/4" Shank - Non-Ferrous & Cast Iron	3323	20								-	-	-	-	-	-	-	-
Bridgeport - Reduced 3/4" Shank - Steel	3353	20								-	-	-	-	-	-	-	-
Center Cutting - 25° Right Spiral Flutes - Non-Ferrous & Cast Iron	3318	19								-	60CS	-	5966	-	-	-	-
Center Cutting - Straight Flutes (3) - Non-Ferrous & Cast Iron	3314	19								-	60SK	-	5935	-	4800	SKM	5689
Center Cutting - Straight Flutes (3) - Steel	3312	19								-	60SKS	-	5936	-	4780	-	5688
CNC 15° Right Spiral Finishing - Non-Ferrous & Cast Iron	3322	20								-	-	-	-	-	-	-	-
CNC 15° Right Spiral Finishing - Steel	3355	20								-	-	-	-	-	-	-	-
CNC 25° Right Spiral High Performance - Non-Ferrous Soft	3337	20								-	-	-	-	-	-	-	-
Corner Rounding - Non-Ferrous & Cast Iron	3740	19								-	-	-	-	-	-	-	-
Corner Rounding - Steel	3741	19								-	-	-	-	-	-	-	-
Straight Flutes (2) - Non-Ferrous & Cast Iron	3302	22								765	60TF	-	5923	4732	4700	TFEM	5680
Straight Flutes (2) - Steel	3300	21								-	60TFS	-	5927	-	-	-	-
Straight Flutes (4/6) - Non-Ferrous & Cast Iron	3304	22								765	60EM	-	5925	4734	4750	EM	5680
Straight Flutes (4) - Non-Ferrous Soft - Upsharp	3305	22								-	-	-	-	-	-	-	-
PORT CONTOUR CUTTERS				TOOL SELECTOR							CROSS REFERENCE						
Straight Shank	All	24-26	24							-	-	-	-	-	-	-	-
Taper Shank	All	26-27	24							-	-	-	-	-	-	-	-

SELECTING THE CORRECT LEXINGTON TOOL

LEXINGTON CUTTER'S carbide tipped tools are designed with the appropriate carbide grade and tool geometry for each material classification.

Follow the steps below to select the best tool types for maximum performance.

1. Determine classification of material being machined using table below.
2. Determine family of tool needed (i.e., drills, reamers, end mills, etc.).
3. Using the color coded index on the preceding pages, find the family of tool needed and the correct material classification column.
4. The index shows the tool types and page numbers for the recommended tools.
5. Turn to the page to find: sizes, tolerances, EDP numbers and prices.

CLASSIFICATION	MATERIAL	EXAMPLES
NON-FERROUS (SOFT)	ALUMINUM ALLOY - CAST ALUMINUM ALLOY - WROUGHT MAGNESIUM ALLOY LEAD ALLOY NON-METAL AND PLASTIC ZINC ALLOY - DIE CAST	308.0, 356.0, 360.0, 380.0, 390.0, 514.0 3003, 4032, 5052, 6061, 7075 AM60A, AZ21A, AZ91B-C, K1A Alloys 7, 8, 13, 15, 1Sb, 4Sb, 6Sb, 8Sb, 9Sb Bakelite, Nylon, Polystyrene, PVC AC41A, AG40A, AMS4803, ZDC NO. 7
NON-FERROUS (HARD)	ALUMINUM BRONZE BRASS ALLOY - LEADED AND FREE CUTTING BRASS ALLOY - YELLOW, RED, NAVAL COMMERCIAL BRONZE (LEADED) NICKEL SILVER COPPER ALLOY - TOUGH	614, 952-958 340, 342, 353, 360, 370, 485 268, 270, 464-467 314 745-770, 973-978 110, 170, 172, 175, 280, 425, 610, 655
CAST IRON	DUCTILE CAST IRON - AUSTENITIC FERRITIC FERRITIC - PEARLITIC PEARLITIC - MARTENSITIC MARTENSITIC GRAY CAST IRON MALLEABLE CAST IRON - FERRITIC OR PEARLITIC	D-2, D-2B, D-2C, D-2M, D-3, D-3A, D-4, D-5 60-40-18, 65-45-12, D4018, D4512 80-55-06, D5506 100-70-03, D7003 120-90-02, DQ&T 20, 25, 30, 35, 40, 45, 50, 55 32510, 35018, 45008, M3210, M4504
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - WROUGHT LOW AND MEDIUM CARBON STEEL - FREE MACHINING LOW CARBON STEEL - CAST LEADED LOW CARBON LEADED MEDIUM CARBON MEDIUM CARBON STEEL - CAST	1005-1029, 1030-1050 1108-1119, 1132-1151, 1211-1215 1010, 1020 10L18, 11L17, 12L13-12L15 10L45, 10L50, 11L37, 11L44 1030, 1040, 1050
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACH. MEDIUM AND HIGH CARBON ALLOY STEEL - LEADED STAINLESS STEEL - 300 SERIES (FREE MACH.)* STAINLESS STEEL - 400 SERIES STAINLESS STEEL - 400 SERIES (FREE MACH.)	4320, 4340, 4620, 5015, 8620, 9310 4140, 4142Se, 4145Te, 4150, 86L20 41L30, 41L40, 41L50 303, 303MA, 303Pb, 303 PLUS X, 303Se 409, 410, 420, 430, 436 416, 416Se, 420F, 430F, 440F
HIGH STRENGTH STEELS	ARMOR PLATE HIGH CARBON ALLOY STEEL HIGH STRENGTH STEEL - WROUGHT MARAGING STEEL NITRIDING STEEL TOOL STEEL	HY-80, HY-100, HY-180, MIL-S-12560 50100, 51100, 52100 300M, 4330V, 98BV40, HP 9-4-20 Grades 200, 250, 300, 350, HY 230 Nitalloy 125, 135, 135 Modified, 230 Series A2, D2, H13, M50, P20, S7, W1
HIGH TEMPERATURE ALLOYS	IRON BASE ALLOY NICKEL BASE ALLOY STAINLESS STEEL - 300 SERIES STAINLESS STEEL - PH SERIES TITANIUM ALLOY	A-286, Discaloy, Incoloy 800-802 Hastelloy C, Inconel 600, 625, 718, 825 302, 304, 309, 314, 316, 300, 347, 385 15-5PH, 16-6PH, 17-4PH, AM-350 Ti-6Al-4V, Ti-10V-2Fe-3Al, 98.9, 99.5

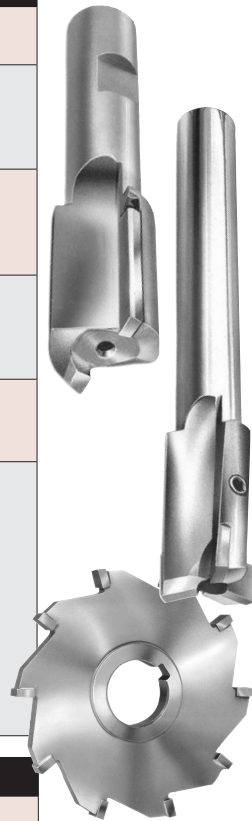
Lexington's tool selection is based on materials most common to condition. Special heat treatments or processing may change the material's machining characteristics. This guide is a suggested starting point for tool selection.

Phone 941-739-2726 • Fax 941-739-2827 • www.lexingtoncutter.com • LEXINGTON CUTTER, INC.

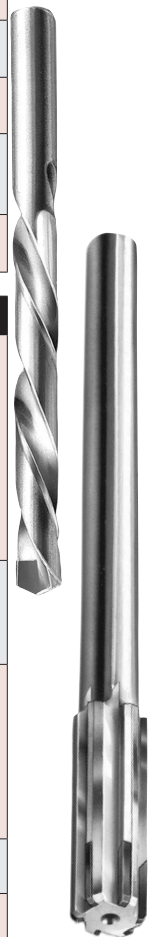
*When milling free machining 300 series stainless steel, use cast iron classification.

CARBIDE TIPPED TOOL PROBLEM SOLVING GUIDE

REAMING PROBLEMS	POSSIBLE CAUSES	POSSIBLE SOLUTIONS
1. Rough finish	Dull cutting edge Wrong feeds & speeds	Resharpener to original tool geometry. Increase speed — also try reduced feed.
2. Excessive cutting edge wear	Wrong feeds & speeds Rough cutting edge Insufficient coolant	Increase feed (should always be over .001" per tooth) — especially when machining ductile or free machining materials. Also try reduced speed. Lightly hone cutting edge with fine grit diamond hone. Increase coolant flow — review type of coolant.
3. Chipped cutting edge	Poor chip removal Recutting work hardened chips Vibration Incorrect carbide grade	Use tool with larger flute space — larger diameter or fewer flutes. Increase coolant flow. Increase rigidity of set-up, especially worn tool holders or arbors. Change to tougher carbide grade.
4. Chatter marks	Insufficient machine horsepower Vibration	Use tool with fewer flutes as correct speeds & feeds must be maintained. Consider climb milling. User larger diameter cutter. Resharpener tool with more clearance.
5. Glazed finish	Feed to light Dull cutting edge Insufficient clearance	Increase feed. Resharpener tool to original geometry. Resharpener tool with more clearance.
6. Poor tool life	Excessive cratering Milling abrasive material Milling hard material Insufficient chip room Milling surface scale Delayed resharpening Thermal cracked carbide	Increase speed or decrease feed. Change to harder grade of carbide. Decrease speed and increase feed. Increase coolant flow. Climb milling better than conventional milling. Reduce speed — rigidity very important. Use larger diameter tool. Conventional milling better than climb milling. Prompt resharpening to original geometry will increase total tool life. Maintain adequate coolant flow at all times. Climb milling is cooler than conventional milling.



REAMING PROBLEMS	POSSIBLE CAUSES	POSSIBLE SOLUTIONS
1. Chipped cutting edge	Excessive feed Excessive lip relief Variation Thermal cracked carbide	Reduce feed. Reduce lip relief to provide smaller chisel angle. Frequently a worn drill bushing — REPLACE. Maintain adequate coolant flow at all times.
2. Short tool life	Drill dwelling Only one lip cutting	Maintain adequate feed at all times. Regrind with equal lip heights and chisel in center.
3. Drill walks or drifts	Unequal lip heights Worn drilling bushing	Regrind with equal lip heights and chisel in center. Replace drill bushing.
4. Oversized holes	Unequal lip heights Excessive lip relief Worn drill bushing	Regrind with equal lip heights and chisel in center. Reduce lip relief to provide smaller chisel angle. Replace drill bushing.
5. Rough finish	Dull cutting Inadequate coolant	Regrind with fine grit diamond wheel. Review type of coolant and maintain adequate flow.



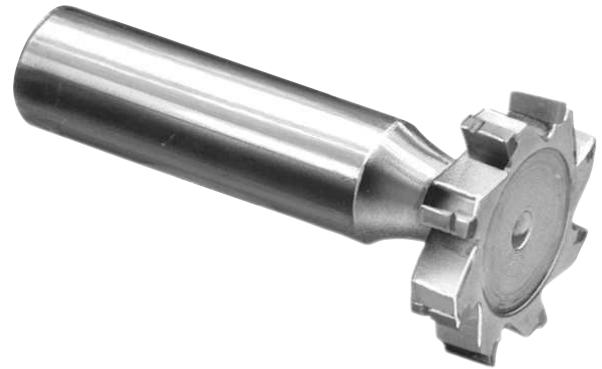
REAMING PROBLEMS	POSSIBLE CAUSES	POSSIBLE SOLUTIONS
1. Poor finish	Unequal chamfers Incorrect margins Excessive spindle runout Chatter Insufficient cutting action	Regrind reamer with equal chamfer height. Regrind reamer with correct margin for material being machined. Increase reamer back taper (to lose size faster). Increase speed and reduce feed rate. Use power feed unless material is hard. Use right or left spiral fluted reamer. Grind secondary lead angle immediately behind 45° chamfer. Specify reamer with positive radial rake to reduce cutting pressure — may produce slightly larger diameter holes.
2. Oversized holes or tapered holes or bell mouthed holes	Misalignment Incorrect feed and/or speed	Use bushing — .0002"/.0003" over reamer diameter. If hole location varies, use floating reamer holder. Increase reamer back taper (to lose size faster). Verify correct feeds & speeds.
3. Excessive tool wear	Insufficient stock removal Excessive reaming pressure Misalignment	Decrease previous operation drill size to allow more material for removal by reamer — leave 2% - 3% of tool diameter for cast iron and more stock for non-ferrous materials. Decrease feed rate. Reduce stock to be removed by increasing previous operation drill size — leave 2% - 3% of the tool diameter. See solution for "Misalignment" in #2 above.
4. Crooked holes	Drill walking or incorrect sharpening	Correct previous drilling operation — reamer will follow the drilled hole. Increase reamer attack angle (chamfer) to 120° - 180° included angle.
5. Tool breakage	Excessive reaming pressure Misalignment	See solution for "Excessive reaming pressure" in #3 above. See solution for "Misalignment" in #2 above.

CARBIDE TIPPED STRAIGHT TOOTH KEYSEAT CUTTERS FOR NON-FERROUS & CAST IRON

TYPE 3700 - STRAIGHT TOOTH

Carbide tips brazed to hardened alloy steel bodies.

Fast cutting to close tolerance with longer tool life. For milling slots in cast iron, non-ferrous metals, plastics and non-metals. Chip breakers are on all cutters 5/32" and greater width. Decimal size cutters DO NOT have chip breakers.



Tool diameter tolerance: +.020"/+.015".
Face width tolerance: +.0000"/-.0005".
Straight shank: 1/2" diameter, 2" long.

AMERICAN STANDARD NO.	TOOL DIAM.	NO. OF TEETH	WIDTH	NECK DIAM.	OVERALL LENGTH	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
									1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
204	1/2	6	1/16	.130	2 1/16	37000204	\$121.20	.0575 -.0787	\$163.15	\$145.05	\$139.00	\$136.05	\$133.00	\$130.50
304	1/2	6	3/32	.160	2 3/32	37000304	121.20	.0788 -.1088	163.15	145.05	139.00	136.05	133.00	130.50
404	1/2	6	1/8	.191	2 1/8	37000404	121.20	.1089 -.1400	163.15	145.05	139.00	136.05	133.00	130.50
305	5/8	6	3/32	.191	2 3/32	37000305	125.55	.0788 -.1088	167.70	149.60	143.50	140.55	137.50	135.00
405	5/8	6	1/8	.223	2 1/8	37000405	125.55	.1089 -.1400	167.70	149.60	143.50	140.55	137.50	135.00
505	5/8	6	5/32	.252	2 5/32	37000505	125.55	.1401 -.1713	167.70	149.60	143.50	140.55	137.50	135.00
605	5/8	6	3/16	.279	2 3/16	37000605	125.55	.1714 -.2025	167.70	149.60	143.50	140.55	137.50	135.00
406	3/4	6	1/8	.217	2 1/8	37000406	131.05	.1100 -.1400	173.50	155.40	149.25	146.40	143.30	140.80
506	3/4	6	5/32	.246	2 5/32	37000506	131.05	.1401 -.1713	173.50	155.40	149.25	146.40	143.30	140.80
606	3/4	6	3/16	.279	2 3/16	37000606	131.05	.1714 -.2025	173.50	155.40	149.25	146.40	143.30	140.80
-	3/4	6	7/32	.342	2 7/32	37002407	143.55	.2026 -.2339	173.50	155.40	149.25	146.40	143.30	140.80
806	3/4	6	1/4	.342	2 1/4	37000806	131.05	.2340 -.2650	173.50	155.40	149.25	146.40	143.30	140.80
507	7/8	6	5/32	.246	2 5/32	37000507	137.20	.1401 -.1713	179.95	161.85	155.75	152.85	149.75	147.30
607	7/8	6	3/16	.279	2 3/16	37000607	137.20	.1714 -.2025	179.95	161.85	155.75	152.85	149.75	147.30
707	7/8	6	7/32	.312	2 7/32	37000707	137.20	.2026 -.2339	179.95	161.85	155.75	152.85	149.75	147.30
807	7/8	6	1/4	.342	2 1/4	37000807	137.20	.2340 -.2650	179.95	161.85	155.75	152.85	149.75	147.30
608	1	8	3/16	.279	2 3/16	37000608	154.80	.1714 -.2025	198.35	180.25	174.15	171.20	168.15	165.65
708	1	8	7/32	.312	2 7/32	37000708	154.80	.2026 -.2339	198.35	180.25	174.15	171.20	168.15	165.65
808	1	8	1/4	.342	2 1/4	37000808	154.80	.2340 -.2650	198.35	180.25	174.15	171.20	168.15	165.65
-	1	8	9/32	.401	2 9/32	37003209	169.55	.2651 -.2968	198.35	180.25	174.15	171.20	168.15	165.65
1008	1	8	5/16	.401	2 5/16	37001008	154.80	.2969 -.3281	198.35	180.25	174.15	171.20	168.15	165.65
-	1	8	11/32	.467	2 11/32	37003211	169.55	.3282 -.3593	198.35	180.25	174.15	171.20	168.15	165.65
1208	1	8	3/8	.467	2 3/8	37001208	154.80	.3594 -.3900	198.35	180.25	174.15	171.20	168.15	165.65
609	1 1/8	8	3/16	.312	2 3/16	37000609	162.60	.1714 -.2025	206.50	188.40	182.35	179.40	176.35	173.85
709	1 1/8	8	7/32	.342	2 7/32	37000709	162.60	.2026 -.2339	206.50	188.40	182.35	179.40	176.35	173.85
809	1 1/8	8	1/4	.374	2 1/4	37000809	162.60	.2340 -.2650	206.50	188.40	182.35	179.40	176.35	173.85
-	1 1/8	8	9/32	.435	2 9/32	37003609	178.05	.2651 -.2968	206.50	188.40	182.35	179.40	176.35	173.85
1009	1 1/8	8	5/16	.435	2 5/16	37001009	162.60	.2969 -.3281	206.50	188.40	182.35	179.40	176.35	173.85
610	1 1/4	8	3/16	.312	2 3/16	37000610	170.75	.1714 -.2025	215.05	196.95	190.85	187.95	184.85	182.35
710	1 1/4	8	7/32	.342	2 7/32	37000710	170.75	.2026 -.2339	215.05	196.95	190.85	187.95	184.85	182.35
810	1 1/4	8	1/4	.374	2 1/4	37000810	170.75	.2340 -.2650	215.05	196.95	190.85	187.95	184.85	182.35
-	1 1/4	8	9/32	.435	2 9/32	37004009	187.00	.2651 -.2968	215.05	196.95	190.85	187.95	184.85	182.35
1010	1 1/4	8	5/16	.435	2 5/16	37001010	170.75	.2969 -.3281	215.05	196.95	190.85	187.95	184.85	182.35
-	1 1/4	8	11/32	.467	2 11/32	37004011	187.00	.3282 -.3593	215.05	196.95	190.85	187.95	184.85	182.35
1210	1 1/4	8	3/8	.467	2 3/8	37001210	170.75	.3594 -.3900	215.05	196.95	190.85	187.95	184.85	182.35
811	1 3/8	8	1/4	.401	2 1/4	37000811	179.35	.2340 -.2650	224.05	206.00	199.90	196.95	193.90	191.40
-	1 3/8	8	5/32	.467	2 9/32	37004409	196.40	.2651 -.2968	224.05	206.00	199.90	196.95	193.90	191.40
1011	1 3/8	8	3/16	.467	2 3/16	37001011	179.35	.2969 -.3281	224.05	206.00	199.90	196.95	193.90	191.40
-	1 3/8	8	11/32	.467	2 11/32	37004411	196.40	.3282 -.3593	224.05	206.00	199.90	196.95	193.90	191.40
1211	1 3/8	8	3/8	.467	2 3/8	37001211	179.35	.3594 -.3900	224.05	206.00	199.90	196.95	193.90	191.40
812	1 1/2	8	1/4	.435	2 1/4	37000812	188.30	.2340 -.2650	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	9/32	.467	2 9/32	37004809	206.25	.2651 -.2968	233.45	215.35	209.30	206.35	203.30	200.80
1012	1 1/2	8	5/16	.467	2 5/16	37001012	188.30	.2969 -.3281	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	11/32	.467	2 11/32	37004811	206.25	.3282 -.3593	233.45	215.35	209.30	206.35	203.30	200.80
1212	1 1/2	8	3/8	.467	2 3/8	37001212	188.30	.3594 -.3900	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	13/32	.467	2 13/32	37004813	206.25	.3901 -.4219	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	7/16	.467	2 7/16	37004814	206.25	.4220 -.4531	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	15/32	.467	2 15/32	37004815	206.25	.4532 -.4843	233.45	215.35	209.30	206.35	203.30	200.80
-	1 1/2	8	1/2	.467	2 1/2	37004816	206.25	.4844 -.5150	233.45	215.35	209.30	206.35	203.30	200.80

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CARBIDE TIPPED STAGGERED TOOTH KEYSEAT CUTTERS FOR NON-FERROUS & CAST IRON



TYPE 3701 - STAGGERED TOOTH

Carbide tips brazed to hardened alloy steel bodies.

Alternate 10° right and left axial rake. For milling slots in cast iron, non-ferrous metals, plastics and non-metals.

Tool diameter tolerance: +.020"/+.015".

Face width tolerance: +.0000"/-.0005".

Straight shank: 1/2" diameter, 2" long.

AMERICAN STANDARD NO.	TOOL DIAM.	NO. OF TEETH	WIDTH	NECK DIAM.	OVERALL LENGTH	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
									1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
204	1/2	6	1/16	.130	2 1/16	37010204	\$142.60	.0575 - .0787	\$185.55	\$167.50	\$161.40	\$158.45	\$155.35	\$152.90
304	1/2	6	3/32	.160	2 3/32	37010304	142.60	.0788 - .1088	185.55	167.50	161.40	158.45	155.35	152.90
404	1/2	6	1/8	.191	2 1/8	37010404	142.60	.1089 - .1400	185.55	167.50	161.40	158.45	155.35	152.90
305	5/8	6	3/32	.191	2 3/32	37010305	147.65	.0788 - .1088	190.90	172.80	166.70	163.80	160.70	158.25
405	5/8	6	1/8	.223	2 1/8	37010405	147.65	.1089 - .1400	190.90	172.80	166.70	163.80	160.70	158.25
505	5/8	6	5/32	.252	2 5/32	37010505	147.65	.1401 - .1713	190.90	172.80	166.70	163.80	160.70	158.25
605	5/8	6	3/16	.279	2 3/16	37010605	147.65	.1714 - .2025	190.90	172.80	166.70	163.80	160.70	158.25
406	3/4	6	1/8	.217	2 1/8	37010406	154.30	.1100 - .1400	197.85	179.75	173.65	170.70	167.65	165.15
506	3/4	6	5/32	.246	2 5/32	37010506	154.30	.1401 - .1713	197.85	179.75	173.65	170.70	167.65	165.15
606	3/4	6	3/16	.279	2 3/16	37010606	154.30	.1714 - .2025	197.85	179.75	173.65	170.70	167.65	165.15
-	3/4	6	7/32	.342	2 7/32	37012407	168.95	.2026 - .2339	197.85	179.75	173.65	170.70	167.65	165.15
806	3/4	6	1/4	.342	2 1/4	37010806	154.30	.2340 - .2650	197.85	179.75	173.65	170.70	167.65	165.15
507	7/8	6	5/32	.246	2 5/32	37010507	161.35	.1401 - .1713	205.20	187.10	181.00	178.10	175.00	172.55
607	7/8	6	3/16	.279	2 3/16	37010607	161.35	.1714 - .2025	205.20	187.10	181.00	178.10	175.00	172.55
707	7/8	6	7/32	.312	2 7/32	37010707	161.35	.2026 - .2339	205.20	187.10	181.00	178.10	175.00	172.55
807	7/8	6	1/4	.342	2 1/4	37010807	161.35	.2340 - .2650	205.20	187.10	181.00	178.10	175.00	172.55
608	1	8	3/16	.279	2 3/16	37010608	182.05	.1714 - .2025	226.95	208.85	202.75	199.80	196.75	194.25
708	1	8	7/32	.312	2 7/32	37010708	182.05	.2026 - .2339	226.95	208.85	202.75	199.80	196.75	194.25
808	1	8	1/4	.342	2 1/4	37010808	182.05	.2340 - .2650	226.95	208.85	202.75	199.80	196.75	194.25
-	1	8	9/32	.401	2 9/32	37013209	199.40	.2651 - .2968	226.95	208.85	202.75	199.80	196.75	194.25
1008	1	8	5/16	.401	2 5/16	37011008	182.05	.2969 - .3281	226.95	208.85	202.75	199.80	196.75	194.25
-	1	8	11/32	.467	2 11/32	37013211	199.40	.3282 - .3593	226.95	208.85	202.75	199.80	196.75	194.25
1208	1	8	3/8	.467	2 3/8	37011208	182.05	.3594 - .3900	226.95	208.85	202.75	199.80	196.75	194.25
609	1 1/8	8	3/16	.312	2 3/16	37010609	191.10	.1714 - .2025	236.40	218.30	212.20	209.25	206.20	203.75
709	1 1/8	8	7/32	.342	2 7/32	37010709	191.10	.2026 - .2339	236.40	218.30	212.20	209.25	206.20	203.75
809	1 1/8	8	1/4	.374	2 1/4	37010809	191.10	.2340 - .2650	236.40	218.30	212.20	209.25	206.20	203.75
-	1 1/8	8	9/32	.435	2 9/32	37013609	209.30	.2651 - .2968	236.40	218.30	212.20	209.25	206.20	203.75
1009	1 1/8	8	5/16	.435	2 5/16	37011009	191.10	.2969 - .3281	236.40	218.30	212.20	209.25	206.20	203.75
610	1 1/4	8	3/16	.312	2 3/16	37010610	200.75	.1714 - .2025	246.45	228.35	222.25	219.35	216.25	213.80
710	1 1/4	8	7/32	.342	2 7/32	37010710	200.75	.2026 - .2339	246.45	228.35	222.25	219.35	216.25	213.80
810	1 1/4	8	1/4	.374	2 1/4	37010810	200.75	.2340 - .2650	246.45	228.35	222.25	219.35	216.25	213.80
-	1 1/4	8	9/32	.435	2 9/32	37014009	219.85	.2651 - .2968	246.45	228.35	222.25	219.35	216.25	213.80
1010	1 1/4	8	5/16	.435	2 5/16	37011010	200.75	.2969 - .3281	246.45	228.35	222.25	219.35	216.25	213.80
-	1 1/4	8	11/32	.467	2 11/32	37014011	219.85	.3282 - .3593	246.45	228.35	222.25	219.35	216.25	213.80
1210	1 1/4	8	3/8	.467	2 3/8	37011210	200.75	.3594 - .3900	246.45	228.35	222.25	219.35	216.25	213.80
811	1 3/8	8	1/4	.401	2 1/4	37010811	210.85	.2340 - .2650	257.10	239.00	232.90	230.00	226.95	224.45
-	1 3/8	8	9/32	.467	2 9/32	37014409	230.95	.2651 - .2968	257.10	239.00	232.90	230.00	226.95	224.45
1011	1 3/8	8	5/16	.467	2 5/16	37011011	210.85	.2969 - .3281	257.10	239.00	232.90	230.00	226.95	224.45
-	1 3/8	8	11/32	.467	2 11/32	37014411	230.95	.3282 - .3593	257.10	239.00	232.90	230.00	226.95	224.45
1211	1 3/8	8	3/8	.467	2 3/8	37011211	210.85	.3594 - .3900	257.10	239.00	232.90	230.00	226.95	224.45
812	1 1/2	8	1/4	.435	2 1/4	37010812	221.45	.2340 - .2650	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	9/32	.467	2 9/32	37014809	242.55	.2651 - .2968	268.20	250.10	244.00	241.05	238.00	235.50
1012	1 1/2	8	5/16	.467	2 5/16	37011012	221.45	.2969 - .3281	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	11/32	.467	2 11/32	37014811	242.55	.3282 - .3593	268.20	250.10	244.00	241.05	238.00	235.50
1212	1 1/2	8	3/8	.467	2 3/8	37011212	221.45	.3594 - .3900	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	13/32	.467	2 13/32	37014813	242.55	.3901 - .4219	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	7/16	.467	2 7/16	37014814	242.55	.4220 - .4531	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	15/32	.467	2 15/32	37014815	242.55	.4532 - .4843	268.20	250.10	244.00	241.05	238.00	235.50
-	1 1/2	8	1/2	.467	2 1/2	37014816	242.55	.4844 - .5150	268.20	250.10	244.00	241.05	238.00	235.50

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*Quantities of 15 or more: price of fractional size in same size range.

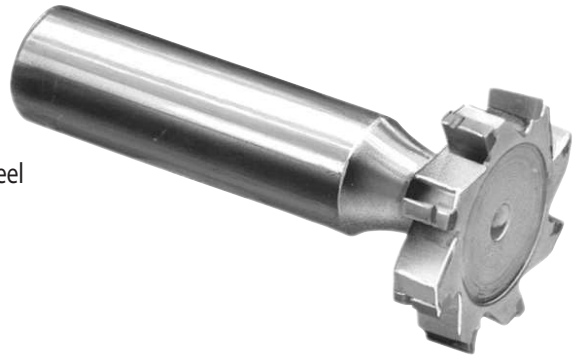
Made in U.S.A.

CARBIDE TIPPED STRAIGHT TOOTH KEYSEAT CUTTERS FOR STEEL

TYPE 3702 - STRAIGHT TOOTH

Carbide tips brazed to hardened alloy steel bodies.

Fast cutting to close tolerance with longer tool life. For milling slots in steel and steel alloys. Chip breakers are on all cutters 5/32" and greater width. Decimal size cutters DO NOT have chip breakers.

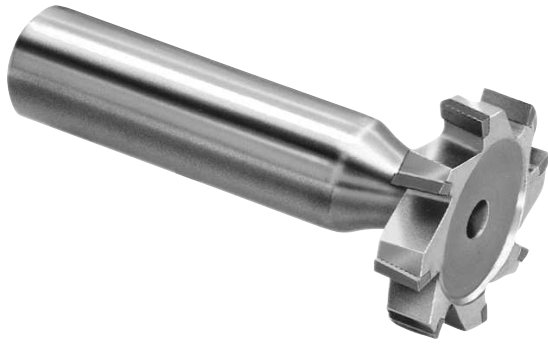


Tool diameter tolerance: +.020"/+.015".
Face width tolerance: +.0000"/-.0005".
Straight shank: 1/2" diameter, 2" long.

AMERICAN STANDARD NO.	TOOL DIAM.	NO. OF TEETH	WIDTH	NECK DIAM.	OVERALL LENGTH	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
									1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
204	1/2	6	1/16	.130	2 1/16	37020204	\$133.35	.0575 -.0787	\$175.90	\$157.80	\$151.70	\$148.80	\$145.70	\$143.20
304	1/2	6	3/32	.160	2 3/32	37020304	133.35	.0788 -.1088	175.90	157.80	151.70	148.80	145.70	143.20
404	1/2	6	1/8	.191	2 1/8	37020404	133.35	.1089 -.1400	175.90	157.80	151.70	148.80	145.70	143.20
305	5/8	6	3/32	.191	2 3/32	37020305	138.10	.0788 -.1088	180.85	162.75	156.65	153.70	150.65	148.15
405	5/8	6	1/8	.223	2 1/8	37020405	138.10	.1089 -.1400	180.85	162.75	156.65	153.70	150.65	148.15
505	5/8	6	5/32	.252	2 5/32	37020505	138.10	.1401 -.1713	180.85	162.75	156.65	153.70	150.65	148.15
605	5/8	6	3/16	.279	2 3/16	37020605	138.10	.1714 -.2025	180.85	162.75	156.65	153.70	150.65	148.15
406	3/4	6	1/8	.217	2 1/8	37020406	144.15	.1100 -.1400	187.20	169.10	163.00	160.10	157.00	154.55
506	3/4	6	5/32	.246	2 5/32	37020506	144.15	.1401 -.1713	187.20	169.10	163.00	160.10	157.00	154.55
606	3/4	6	3/16	.279	2 3/16	37020606	144.15	.1714 -.2025	187.20	169.10	163.00	160.10	157.00	154.55
-	3/4	6	7/32	.342	2 7/32	37022407	157.85	.2026 -.2339	187.20	169.10	163.00	160.10	157.00	154.55
806	3/4	6	1/4	.342	2 1/4	37020806	144.15	.2340 -.2650	187.20	169.10	163.00	160.10	157.00	154.55
507	7/8	6	5/32	.246	2 5/32	37020507	150.95	.1401 -.1713	194.30	176.20	170.10	167.20	164.10	161.65
607	7/8	6	3/16	.279	2 3/16	37020607	150.95	.1714 -.2025	194.30	176.20	170.10	167.20	164.10	161.65
707	7/8	6	7/32	.312	2 7/32	37020707	150.95	.2026 -.2339	194.30	176.20	170.10	167.20	164.10	161.65
807	7/8	6	1/4	.342	2 1/4	37020807	150.95	.2340 -.2650	194.30	176.20	170.10	167.20	164.10	161.65
608	1	8	3/16	.279	2 3/16	37020608	170.30	.1714 -.2025	214.55	196.45	190.35	187.45	184.35	181.90
708	1	8	7/32	.312	2 7/32	37020708	170.30	.2026 -.2339	214.55	196.45	190.35	187.45	184.35	181.90
808	1	8	1/4	.342	2 1/4	37020808	170.30	.2340 -.2650	214.55	196.45	190.35	187.45	184.35	181.90
-	1	8	9/32	.401	2 9/32	37023209	186.50	.2651 -.2968	214.55	196.45	190.35	187.45	184.35	181.90
1008	1	8	5/16	.401	2 5/16	37021008	170.30	.2969 -.3281	214.55	196.45	190.35	187.45	184.35	181.90
-	1	8	11/32	.467	2 11/32	37023211	186.50	.3282 -.3593	214.55	196.45	190.35	187.45	184.35	181.90
1208	1	8	3/8	.467	2 3/8	37021208	170.30	.3594 -.3900	214.55	196.45	190.35	187.45	184.35	181.90
609	1 1/8	8	3/16	.312	2 3/16	37020609	178.85	.1714 -.2025	223.55	205.50	199.35	196.45	193.40	190.90
709	1 1/8	8	7/32	.342	2 7/32	37020709	178.85	.2026 -.2339	223.55	205.50	199.35	196.45	193.40	190.90
809	1 1/8	8	1/4	.374	2 1/4	37020809	178.85	.2340 -.2650	223.55	205.50	199.35	196.45	193.40	190.90
-	1 1/8	8	9/32	.435	2 9/32	37023609	195.85	.2651 -.2968	223.55	205.50	199.35	196.45	193.40	190.90
1009	1 1/8	8	5/16	.435	2 5/16	37021009	178.85	.2969 -.3281	223.55	205.50	199.35	196.45	193.40	190.90
610	1 1/4	8	3/16	.312	2 3/16	37020610	187.80	.1714 -.2025	232.90	214.85	208.75	205.80	202.75	200.25
710	1 1/4	8	7/32	.342	2 7/32	37020710	187.80	.2026 -.2339	232.90	214.85	208.75	205.80	202.75	200.25
810	1 1/4	8	1/4	.374	2 1/4	37020810	187.80	.2340 -.2650	232.90	214.85	208.75	205.80	202.75	200.25
-	1 1/4	8	9/32	.435	2 9/32	37024009	205.70	.2651 -.2968	232.90	214.85	208.75	205.80	202.75	200.25
1010	1 1/4	8	5/16	.435	2 5/16	37021010	187.80	.2969 -.3281	232.90	214.85	208.75	205.80	202.75	200.25
-	1 1/4	8	11/32	.467	2 11/32	37024011	205.70	.3282 -.3593	232.90	214.85	208.75	205.80	202.75	200.25
1210	1 1/4	8	3/8	.467	2 3/8	37021210	187.80	.3594 -.3900	232.90	214.85	208.75	205.80	202.75	200.25
811	1 3/8	8	1/4	.401	2 1/4	37020811	197.25	.2340 -.2650	242.85	224.80	218.70	215.75	212.70	210.20
-	1 3/8	8	5/32	.467	2 5/32	37024409	216.05	.2651 -.2968	242.85	224.80	218.70	215.75	212.70	210.20
1011	1 3/8	8	5/16	.467	2 5/16	37021011	197.25	.2969 -.3281	242.85	224.80	218.70	215.75	212.70	210.20
-	1 3/8	8	11/32	.467	2 11/32	37024411	216.05	.3282 -.3593	242.85	224.80	218.70	215.75	212.70	210.20
1211	1 3/8	8	3/8	.467	2 3/8	37021211	197.25	.3594 -.3900	242.85	224.80	218.70	215.75	212.70	210.20
812	1 1/2	8	1/4	.435	2 1/4	37020812	207.10	.2340 -.2650	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	9/32	.467	2 9/32	37024809	226.85	.2651 -.2968	253.20	235.15	229.00	226.10	223.00	220.55
1012	1 1/2	8	5/16	.467	2 5/16	37021012	207.10	.2969 -.3281	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	11/32	.467	2 11/32	37024811	226.85	.3282 -.3593	253.20	235.15	229.00	226.10	223.00	220.55
1212	1 1/2	8	3/8	.467	2 3/8	37021212	207.10	.3594 -.3900	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	13/32	.467	2 13/32	37024813	226.85	.3901 -.4219	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	7/16	.467	2 7/16	37024814	226.85	.4220 -.4531	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	15/32	.467	2 15/32	37024815	226.85	.4532 -.4843	253.20	235.15	229.00	226.10	223.00	220.55
-	1 1/2	8	1/2	.467	2 1/2	37024816	226.85	.4844 -.5150	253.20	235.15	229.00	226.10	223.00	220.55

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CARBIDE TIPPED STAGGERED TOOTH KEYSEAT CUTTERS FOR STEEL



TYPE 3703 - STAGGERED TOOTH

Carbide tips brazed to hardened alloy steel bodies.

Alternate 10° right and left axial rake. For milling slots in steel and steel alloys.

Tool diameter tolerance: +.020"/+.015".

Face width tolerance: +.0000"/-.0005".

Straight shank: 1/2" diameter, 2" long.

AMERICAN STANDARD NO.	TOOL DIAM.	NO. OF TEETH	WIDTH	NECK DIAM.	OVERALL LENGTH	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
									1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
204	1/2	6	1/16	.130	2 1/16	37030204	\$156.85	.0575 - .0787	\$200.50	\$182.45	\$176.35	\$173.40	\$170.35	\$167.85
304	1/2	6	3/32	.160	2 3/32	37030304	156.85	.0788 - .1088	200.50	182.45	176.35	173.40	170.35	167.85
404	1/2	6	1/8	.191	2 1/8	37030404	156.85	.1089 - .1400	200.50	182.45	176.35	173.40	170.35	167.85
305	5/8	6	3/32	.191	2 3/32	37030305	162.45	.0788 - .1088	206.35	188.25	182.20	179.25	176.20	173.75
405	5/8	6	1/8	.223	2 1/8	37030405	162.45	.1089 - .1400	206.35	188.25	182.20	179.25	176.20	173.75
505	5/8	6	5/32	.252	2 5/32	37030505	162.45	.1401 - .1713	206.35	188.25	182.20	179.25	176.20	173.75
605	5/8	6	3/16	.279	2 3/16	37030605	162.45	.1714 - .2025	206.35	188.25	182.20	179.25	176.20	173.75
406	3/4	6	1/8	.217	2 1/8	37030406	169.70	.1100 - .1400	214.00	195.90	189.80	186.90	183.80	181.35
506	3/4	6	5/32	.246	2 5/32	37030506	169.70	.1401 - .1713	214.00	195.90	189.80	186.90	183.80	181.35
606	3/4	6	3/16	.279	2 3/16	37030606	169.70	.1714 - .2025	214.00	195.90	189.80	186.90	183.80	181.35
-	3/4	6	7/32	.342	2 7/32	37032407	185.85	.2026 - .2339	214.00	195.90	189.80	186.90	183.80	181.35
806	3/4	6	1/4	.342	2 1/4	37030806	169.70	.2340 - .2650	214.00	195.90	189.80	186.90	183.80	181.35
507	7/8	6	5/32	.246	2 5/32	37030507	177.50	.1401 - .1713	222.10	204.00	197.95	195.00	191.90	189.50
607	7/8	6	3/16	.279	2 3/16	37030607	177.50	.1714 - .2025	222.10	204.00	197.95	195.00	191.90	189.50
707	7/8	6	7/32	.312	2 7/32	37030707	177.50	.2026 - .2339	222.10	204.00	197.95	195.00	191.90	189.50
807	7/8	6	1/4	.342	2 1/4	37030807	177.50	.2340 - .2650	222.10	204.00	197.95	195.00	191.90	189.50
608	1	8	3/16	.279	2 3/16	37030608	200.30	.1714 - .2025	246.00	227.90	221.80	218.90	215.80	213.35
708	1	8	7/32	.312	2 7/32	37030708	200.30	.2026 - .2339	246.00	227.90	221.80	218.90	215.80	213.35
808	1	8	1/4	.342	2 1/4	37030808	200.30	.2340 - .2650	246.00	227.90	221.80	218.90	215.80	213.35
-	1	8	9/32	.401	2 9/32	37033209	219.35	.2651 - .2968	246.00	227.90	221.80	218.90	215.80	213.35
1008	1	8	5/16	.401	2 5/16	37031008	200.30	.2969 - .3281	246.00	227.90	221.80	218.90	215.80	213.35
-	1	8	11/32	.467	2 11/32	37033211	219.35	.3282 - .3593	246.00	227.90	221.80	218.90	215.80	213.35
1208	1	8	3/8	.467	2 3/8	37031208	200.30	.3594 - .3900	246.00	227.90	221.80	218.90	215.80	213.35
609	1 1/8	8	3/16	.312	2 3/16	37030609	210.20	.1714 - .2025	256.40	238.30	232.20	229.30	226.20	223.75
709	1 1/8	8	7/32	.342	2 7/32	37030709	210.20	.2026 - .2339	256.40	238.30	232.20	229.30	226.20	223.75
809	1 1/8	8	1/4	.374	2 1/4	37030809	210.20	.2340 - .2650	256.40	238.30	232.20	229.30	226.20	223.75
-	1 1/8	8	9/32	.435	2 9/32	37033609	230.25	.2651 - .2968	256.40	238.30	232.20	229.30	226.20	223.75
1009	1 1/8	8	5/16	.435	2 5/16	37031009	210.20	.2969 - .3281	256.40	238.30	232.20	229.30	226.20	223.75
610	1 1/4	8	3/16	.312	2 3/16	37030610	220.80	.1714 - .2025	267.45	249.35	243.30	240.35	237.35	234.85
710	1 1/4	8	7/32	.342	2 7/32	37030710	220.80	.2026 - .2339	267.45	249.35	243.30	240.35	237.35	234.85
810	1 1/4	8	1/4	.374	2 1/4	37030810	220.80	.2340 - .2650	267.45	249.35	243.30	240.35	237.35	234.85
-	1 1/4	8	9/32	.435	2 9/32	37034009	241.80	.2651 - .2968	267.45	249.35	243.30	240.35	237.35	234.85
1010	1 1/4	8	5/16	.435	2 5/16	37031010	220.80	.2969 - .3281	267.45	249.35	243.30	240.35	237.35	234.85
-	1 1/4	8	11/32	.467	2 11/32	37034011	241.80	.3282 - .3593	267.45	249.35	243.30	240.35	237.35	234.85
1210	1 1/4	8	3/8	.467	2 3/8	37031210	220.80	.3594 - .3900	267.45	249.35	243.30	240.35	237.35	234.85
811	1 3/8	8	1/4	.401	2 1/4	37030811	231.95	.2340 - .2650	279.25	261.15	255.05	252.10	249.05	246.55
-	1 3/8	8	9/32	.467	2 9/32	37034409	254.05	.2651 - .2968	279.25	261.15	255.05	252.10	249.05	246.55
1011	1 3/8	8	5/16	.467	2 5/16	37031011	231.95	.2969 - .3281	279.25	261.15	255.05	252.10	249.05	246.55
-	1 3/8	8	11/32	.467	2 11/32	37034411	254.05	.3282 - .3593	279.25	261.15	255.05	252.10	249.05	246.55
1211	1 3/8	8	3/8	.467	2 3/8	37031211	231.95	.3594 - .3900	279.25	261.15	255.05	252.10	249.05	246.55
812	1 1/2	8	1/4	.435	2 1/4	37030812	243.60	.2340 - .2650	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	9/32	.467	2 9/32	37034809	266.80	.2651 - .2968	291.40	273.30	267.20	264.30	261.20	258.70
1012	1 1/2	8	5/16	.467	2 5/16	37031012	243.60	.2969 - .3281	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	11/32	.467	2 11/32	37034811	266.80	.3282 - .3593	291.40	273.30	267.20	264.30	261.20	258.70
1212	1 1/2	8	3/8	.467	2 3/8	37031212	243.60	.3594 - .3900	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	13/32	.467	2 13/32	37034813	266.80	.3901 - .4219	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	7/16	.467	2 7/16	37034814	266.80	.4220 - .4531	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	15/32	.467	2 15/32	37034815	266.80	.4532 - .4843	291.40	273.30	267.20	264.30	261.20	258.70
-	1 1/2	8	1/2	.467	2 1/2	37034816	266.80	.4844 - .5150	291.40	273.30	267.20	264.30	261.20	258.70

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*Quantities of 15 or more: price of fractional size in same size range.

Made in U.S.A.

CARBIDE TIPPED CHAMFER MILLING CUTTERS

SINGLE ANGLE CUTTERS

TYPE 3730 - 45° - FOR NON-FERROUS & CAST IRON

TYPE 3731 - 45° - FOR STEEL

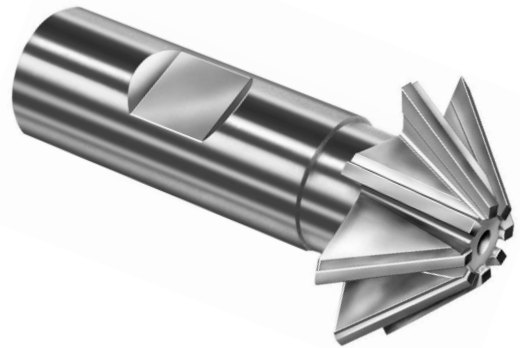
TYPE 3732 - 60° - FOR NON-FERROUS & CAST IRON

TYPE 3733 - 60° - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies. Right hand cut. Straight shank with Weldon flats.

Angle tolerance: +/- 1/4°.

Tool diameter tolerance: +.015"/-.000".



TOOL DIAMETER	SHANK DIAMETER	NO. OF TEETH	OVERALL LENGTH	45° ANGLE					60° ANGLE				
				CUTTER WIDTH	TYPE 3730 EDP NO.	PRICE EACH	TYPE 3731 EDP NO.	PRICE EACH	CUTTER WIDTH	TYPE 3732 EDP NO.	PRICE EACH	TYPE 3733 EDP NO.	PRICE EACH
1/2	3/8	4	2 1/8	1/8	373016	\$176.40	373116	\$193.95	7/32	373216	\$176.40	373316	\$193.95
3/4	3/8	6	2 1/8	3/16	373024	190.20	373124	209.20	5/16	373224	190.20	373324	209.20
1	1/2	6	2 1/2	5/16	373032	223.05	373132	245.35	7/16	373232	223.05	373332	245.35
1 1/2	3/4	8	2 3/4	1/2	373048	282.70	373148	311.05	3/8	373248	282.70	373348	311.05

DOUBLE ANGLE CUTTERS

TYPE 3746 - 60° - FOR NON-FERROUS & CAST IRON

TYPE 3747 - 60° - FOR STEEL

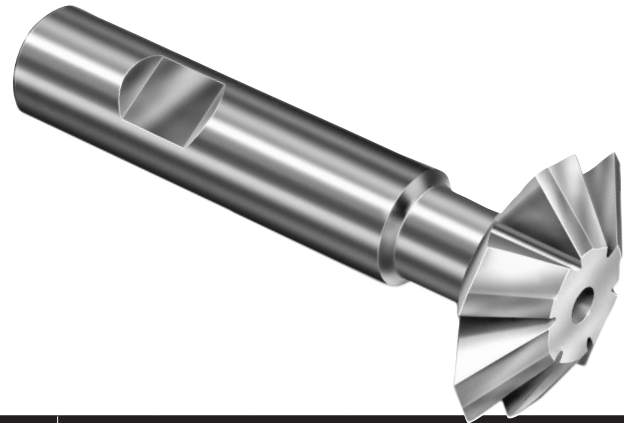
TYPE 3748 - 90° - FOR NON-FERROUS & CAST IRON

TYPE 3749 - 90° - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies. Right hand cut. Straight shank with Weldon flats.

Angle tolerance: +/- 1/4°.

Tool diameter tolerance: +.015"/-.000"; Corner radius: .010" - .020".



TOOL DIAMETER	SHANK DIAMETER	NO. OF TEETH	60° DOUBLE ANGLE					90° DOUBLE ANGLE						
			OVERALL LENGTH	CUTTER WIDTH	TYPE 3746 EDP NO.	PRICE EACH	TYPE 3747 EDP NO.	PRICE EACH	OVERALL LENGTH	CUTTER WIDTH	TYPE 3748 EDP NO.	PRICE EACH	TYPE 3749 EDP NO.	PRICE EACH
3/4	3/8	6	2 3/8	3/16	374624	\$157.20	374724	\$173.00	2 3/8	1/4	374824	\$157.20	374924	\$173.00
1	1/2	6	2 27/32	5/16	374632	185.75	374732	204.35	2 29/32	3/8	374832	185.75	374932	204.35
1 3/8	5/8	6	3 7/32	7/16	374644	215.20	374744	236.75	3 9/32	1/2	374844	215.20	374944	236.75
1 1/2	5/8	6	3 3/8	1/2	374648	225.95	374748	248.60	3 7/16	9/16	374848	225.95	374948	248.60
1 7/8	3/4	6	3 25/32	5/8	374660	343.15	374760	377.45	3 25/32	5/8	374860	343.15	374960	377.45
2 1/4	7/8	6	4 5/32	3/4	374672	464.45	374772	510.90	4 5/32	3/4	374872	464.45	374972	510.90

CARBIDE TIPPED RADIUS CUTTERS

TYPE 3718 - FOR NON-FERROUS & CAST IRON

TYPE 3719 - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies. Right hand cut. Convex radius. Straight shank with Weldon flats.

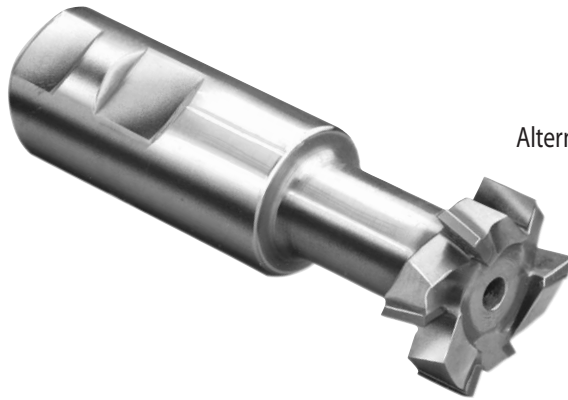


CUTTER RADIUS	TOOL DIAM.	SHANK DIAM.	NO. OF TEETH	CUTTER WIDTH	OVERALL LENGTH	TYPE 3718		TYPE 3719	
						EDP NO.	PRICE EACH	EDP NO.	PRICE EACH
1/32	3/4	1/2	6	1/16	3	371801	\$209.00	371901	\$229.90
1/16	3/4	1/2	6	1/8	3	371802	209.00	371902	229.90
3/32	7/8	1/2	6	3/16	3	371803	228.40	371903	251.15
1/8	1 1/4	3/4	6	1/4	3 1/2	371804	248.60	371904	273.50
5/32	1 5/16	3/4	6	5/16	3 1/2	371805	286.00	371905	314.65
3/16	1 3/8	3/4	6	3/8	3 1/2	371806	302.75	371906	333.00
1/4	1 1/2	3/4	6	1/2	4	371808	313.30	371908	344.75

Tool diameter tolerance: +.005"/-.000".

Tool radius tolerance thru 1/8" radius: +.001"/-.001"
over 1/8" radius: +.002"/-.002".

CARBIDE TIPPED T-SLOT CUTTERS



TYPE 3720 - FOR NON-FERROUS & CAST IRON

Carbide tips brazed to hardened alloy steel bodies.
Alternate 10° right and left axial rake. Straight shank with drive flats.
Used to machine cast iron and non-ferrous materials.

TYPE 3721 - FOR STEEL

Same as Type 3720 above, except carbide grade and geometry appropriate for cutting steel.

Tool diameter tolerance: +.000"/-.010".

BOLT DIAMETER	TOOL DIAMETER	SHANK DIAMETER	CUTTER WIDTH	NECK DIAMETER	UNDERCUT LENGTH	NO. OF TEETH	OVERALL LENGTH	TYPE 3720 EDP NO.	PRICE EACH	TYPE 3721 EDP NO.	PRICE EACH
1/4	9/16	1/2	15/64	17/64	35/64	6	2 19/32	372008	\$152.90	372108	\$165.10
5/16	21/32	1/2	17/64	21/64	39/64	6	2 11/16	372010	151.00	372110	163.10
3/8	25/32	3/4	21/64	13/32	55/64	6	3 1/4	372012	190.00	372112	205.25
1/2	31/32	3/4	25/64	17/32	63/64	6	3 7/16	372016	206.55	372116	223.10
5/8	1 1/4	1	31/64	21/32	1 9/64	6	3 15/16	372020	274.20	372120	296.15
3/4	1 15/32	1	5/8	25/32	1 1/2	6	4 7/16	372024	306.40	372124	330.90
1	1 27/32	1 1/4	53/64	1 1/32	1 43/64	8	4 13/16	372032	437.50	372132	472.45
1 1/4	2 7/32	1 1/4	1 3/32	1 7/32	1 31/32	8	5 3/8	372040	552.05	372140	596.25
1 1/2	2 27/32	1 1/4	1 11/32	1 17/32	2 1/8	8	5 29/32	372048	639.35	372148	690.55

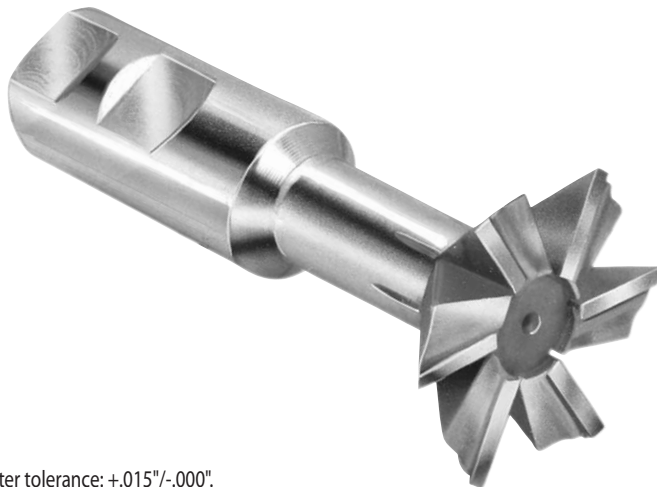
CARBIDE TIPPED DOVETAIL CUTTERS

TYPE 3734 - 45° SINGLE ANGLE FOR NON-FERROUS & CAST IRON TYPE 3735 - 45° SINGLE ANGLE FOR STEEL

Carbide tips brazed to hardened alloy steel bodies.
45° single angle with right hand cut.
Straight shank with drive flats.

TYPE 3736 - 60° SINGLE ANGLE FOR NON-FERROUS & CAST IRON TYPE 3737 - 60° SINGLE ANGLE FOR STEEL

Carbide tips brazed to hardened alloy steel bodies.
60° single angle with right hand cut.
Straight shank with drive flats.



Tool diameter tolerance: +.015"/-.000".
Corner radius: .015" - .020".

TOOL DIAMETER	SHANK DIAMETER	NECK DIAMETER	NO. OF TEETH	OVERALL LENGTH	45° SINGLE ANGLE					60° SINGLE ANGLE				
					CUTTER WIDTH	TYPE 3734 EDP NO.	PRICE EACH	TYPE 3735 EDP NO.	PRICE EACH	CUTTER WIDTH	TYPE 3736 EDP NO.	PRICE EACH	TYPE 3737 EDP NO.	PRICE EACH
1/2	3/8	3/16	3	2 1/8	5/32	373416	\$135.60	373516	\$146.50	7/32	373616	\$135.60	373716	\$146.50
3/4	3/8	1/4	3	2 1/4	1/4	373424	146.25	373524	157.95	1/4	373624	146.25	373724	157.95
1	1/2	3/8	4	2 1/2	5/16	373432	156.55	373532	169.05	3/8	373632	156.55	373732	169.05
1 1/4	5/8	1/2	4	2 3/4	3/8	373440	177.85	373540	192.15	1/2	373640	177.85	373740	192.15
1 1/2	3/4	1/2	4	3 1/4	1/2	373448	207.90	373548	224.55	5/8	373648	207.90	373748	224.55
2	1	3/4	6	4 1/4	5/8	373464	321.80	373564	347.55	3/4	373664	321.80	373764	347.55
2 1/2	1 1/4	1	6	4 3/8	3/4	373480	435.15	373580	469.95	7/8	373680	435.15	373780	469.95
3	1 1/4	1	6	4 1/2	1	373496	513.25	373596	554.30	1 1/8	373696	513.25	373796	554.30

FEEDS & SPEEDS CHART FOR KEYSEATS - CARBIDE TIPPED

Feeds & speeds are a starting recommendation for catalog standards only. Factors such as machine, fixture and tooling rigidity, horse-power available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all safety shields and glasses before performing these operations. (Series 3700, 3701, 3702, & 3703 Keyseat Cutters)

IPM is based on catalog standards only using the mid SFPM and a 0.002 IPT chip load as a starting point. For all other conditions use the following formulas to calculate RPM and IPM from the ranges listed in the material group and brinell harness section as a starting point.

$$\text{RPM} = \text{SFPM} * 3.82 / \text{Cutter Diameter}$$

$$\text{IPM} = \text{IPT} * \text{RPM} * \# \text{Teeth}$$



CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE IPT	KEYSEAT CUTTER DIAMETER									
					1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 3/8	1 1/2	
					IPM	IPM	IPM	IPM	IPM	IPM	IPM	IPM	IPM	
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30-150**	1200+	.002-.010	110	88	73	63	73	65	59	53	49	
	MAGNESIUM ALLOY	50-90**	1000+	.002-.010	92	73	61	52	61	54	49	44	41	
	LEAD ALLOY	10-20**	-	-	-	-	-	-	-	-	-	-	-	
	NON-METAL AND PLASTIC	-	1500+	.002-.006	138	110	92	79	92	81	73	67	61	
	ZINC ALLOY - DIE CAST	80-100	750-1000	.002-.006	80	64	53	46	53	48	43	39	36	
NON-FERROUS (HARD)	ALUMINUM BRONZE	40-175	200-600	.002-.006	37	29	24	21	24	22	20	18	16	
	BRASS ALLOY - LEADED AND FREE CUTTING	10-100Rb	400-550	.002-.006	44	35	29	25	29	26	23	21	19	
	NICKEL SILVER	10-100Rb	200-400	.002-.006	28	22	18	16	18	16	15	13	12	
	COPPER ALLOY - TOUGH	40-200**	200-500	.002-.006	32	26	21	18	21	19	17	16	14	
CAST IRON	DUCTILE CAST IRON - AUSTENITIC	120-275	75-150	.002-.004	10	8	7	6	7	6	6	5	5	
	DUCTILE CAST IRON - FERRITIC	140-270	200-400	.002-.007	28	22	18	16	18	16	15	13	12	
	DUCTILE CAST IRON - MARTENSITIC	270-440	150-350	.002-.007	23	18	15	13	15	14	12	11	10	
	GRAY - PEARLITIC	220-320	150-300	.002-.007	21	17	14	12	14	12	11	10	9	
	GRAY - FERRITIC	110-240	220-410	.002-.006	29	23	19	17	19	17	15	14	13	
	MALLEABLE CAST IRON - MARTENSITIC	200-320	130-300	.002-.004	20	16	13	11	13	12	11	10	9	
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100-250	200-500	.001-.005	32	26	21	18	21	19	17	16	14	
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100-375	200-400	.001-.005	28	22	18	16	18	16	15	13	12	
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100-275	200-400	.001-.005	28	22	18	16	18	16	15	13	12	
	LOW AND MEDIUM CARBON ALLOY STEEL	85-375	130-330	.001-.005	21	17	14	12	14	12	11	10	9	
	STAINLESS STEEL - 400 SERIES	135-325	135-375	.002-.005	24	19	16	14	16	14	13	12	11	
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135-275	250-500	.002-.005	34	28	23	20	23	20	18	17	15	
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175-400	75-200	.001-.004	13	28	23	20	23	20	18	17	15	
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140-300	50-150	.001-.004	9	7	6	5	6	5	5	4	4	
	STAINLESS STEEL - 300 SERIES	135-375	75-175	.001-.004	11	9	8	7	8	7	6	6	5	
	STAINLESS STEEL - PH SERIES	150-440	75-175	.001-.004	11	9	8	7	8	7	6	6	5	
	TITANIUM ALLOY	110-380	75-200	.002-.006	13	10	8	7	8	7	7	6	6	

FEEDS & SPEEDS CHART FOR MILLS & SAWS - CARBIDE TIPPED



Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all safety shields and glasses before performing these operations.

$$\text{RPM} = \text{SFPM} * 3.82 / \text{Cutter Diameter}$$

$$\text{IPM} = \text{IPT} * \text{RPM} * \# \text{Teeth}$$

CLASSIFICATION	MATERIAL	BRINELL	SURFACE FEET PER MINUTE (SFPM)	INCHES PER TOOTH (IPT)
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	1000 - 2000	.004-.008
	MAGNESIUM ALLOY	50 - 90*	750 - 1500	.004-.008
	LEAD ALLOY	10 - 20*	300 - 1000	.004-.008
	NON-METAL AND PLASTIC	-	1500 - 3000	.004-.008
	ZINC ALLOY - DIE CAST	80 - 100	750 - 1500	.005-.010
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	200 - 600	.003-.006
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	400 - 800	.004-.008
	NICKEL SILVER	10 - 100Rb	200 - 400	.003-.006
	COPPER ALLOY - TOUGH	40 - 200*	200 - 500	.004-.008
CAST IRON	DUCTILE CAST IRON - AUSTENITIC	120 - 275	75 - 150	.002-.004
	DUCTILE CAST IRON - FERRITIC	140 - 270	250 - 400	.003-.006
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	200 - 300	.003-.006
	GRAY - PEARLITIC	220 - 320	120 - 300	.002-.004
	GRAY - FERRITIC	110 - 240	250 - 425	.003-.006
	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	130 - 225	.002-.004
	MALLEABLE CAST IRON - FERRITIC & PEARLITIC	110 - 240	200 - 400	.003-.006
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	250 - 500	.003-.006
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	200 - 400	.002-.004
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	200 - 400	.002-.004
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	150 - 300	.002-.005
	STAINLESS STEEL - 400 SERIES	135 - 325	200 - 400	.003-.006
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	250 - 500	.003-.006
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	75 - 150	.002-.004
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	50 - 150	.002-.004
	STAINLESS STEEL - 300 SERIES	135 - 375	75 - 150	.002-.004
	STAINLESS STEEL - PH SERIES	150 - 440	75 - 150	.002-.004
	TITANIUM ALLOY	110 - 380	100 - 200	.002-.004

CARBIDE TIPPED SLITTING SAWS - COARSE TOOTH

TYPE 3550 - FOR NON-FERROUS

Carbide tips brazed to alloy steel bodies.

For machining aluminum, magnesium, zinc, brass, bronze, plastics and non-metals.

TYPE 3552 - FOR CAST IRON

Carbide tips brazed to alloy steel bodies.

For machining most materials, especially cast iron and malleable iron.

TYPE 3554 - FOR STEEL

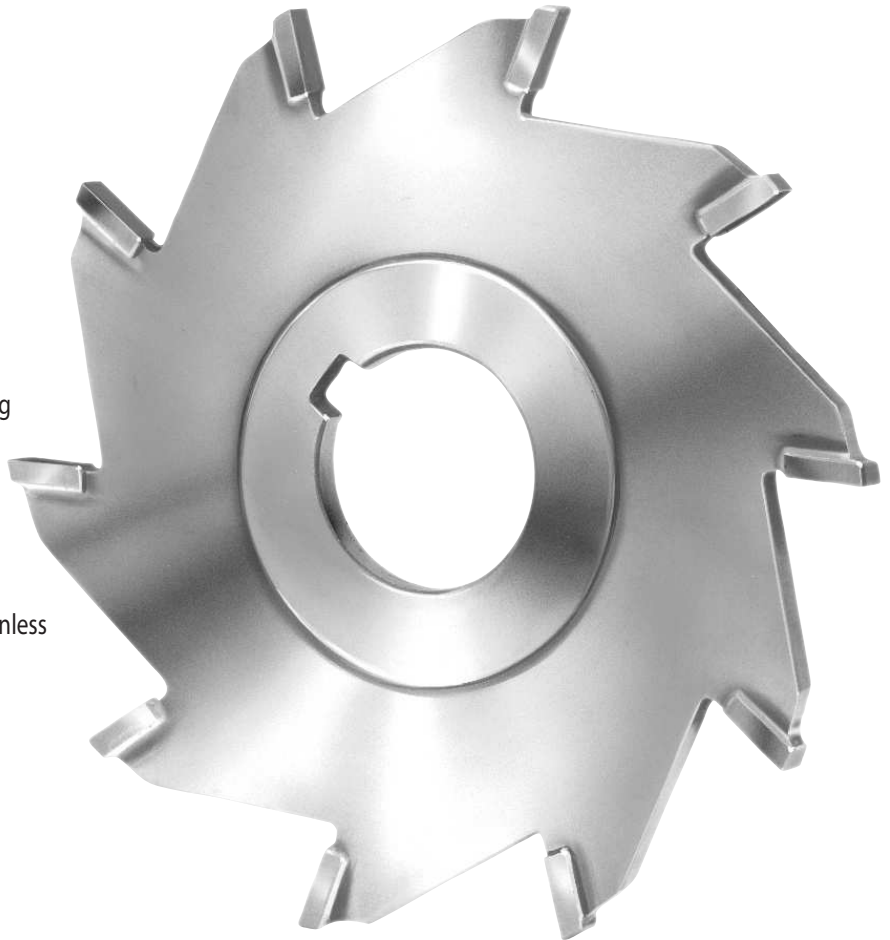
Carbide tips brazed to alloy steel bodies.

Steel cutting grade of carbide for machining most steels.

TYPE 3558 - FOR STAINLESS STEEL

Carbide tips brazed to alloy steel bodies.

High number of teeth for machining of stainless steel and related alloy steels. AISI type 200 thru 350 stainless steels.



ALL TYPES (page 14 & 15):
 Tool diameter tolerance: $+\frac{1}{16}"/-0.000"$.
 Face width tolerance: $+0.001"/-0.000"$.
 Arbor hole tolerance: $+0.001"/-0.000"$.
 Sharpened on all 3 cutting edges.

TOOL DIAM.	WIDTH		ARBOR HOLE	TYPE 3550 FOR NON-FERROUS			TYPE 3552 FOR CAST IRON			TYPE 3554 FOR STEEL			TYPE 3558 FOR STAINLESS STEEL		
	FRAC.	DECIMAL		NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH
3	$\frac{3}{32}$.0938	1	6	355032	\$161.55	6	355232	\$185.90	8	355432	\$184.25	8	355832	\$172.60
3	$\frac{1}{8}$.1250	1	6	355034	166.30	6	355234	196.85	8	355434	206.25	8	355834	179.15
3	$\frac{3}{16}$.1875	1	6	355036	172.95	6	355236	208.20	8	355436	208.20	8	355836	186.15
3	$\frac{1}{4}$.2500	1	6	355037	117.65	6	355237	170.70	8	355437	170.70	8	355837	204.90
3	$\frac{5}{16}$.3125	1	6	355031	123.45	6	355231	170.70	8	355431	170.70	8	355831	204.90
3	$\frac{3}{8}$.3750	1	6	355038	126.05	6	355238	173.45	8	355438	173.45	8	355838	208.20
4	$\frac{3}{32}$.0938	1	6	355042	198.30	8	355242	238.45	8	355442	238.45	10	355842	248.40
4	$\frac{1}{8}$.1250	1	6	355044	204.10	8	355244	241.45	8	355444	241.45	10	355844	251.60
4	$\frac{3}{16}$.1875	1	6	355046	207.20	8	355246	260.30	8	355446	260.30	10	355846	255.00
4	$\frac{1}{4}$.2500	1	6	355047	151.20	8	355247	221.05	8	355447	221.05	10	355847	265.35
4	$\frac{5}{16}$.3125	1	6	355041	155.45	8	355241	229.50	8	355441	229.50	10	355841	275.40
4	$\frac{3}{8}$.3750	1	6	355048	159.50	8	355248	237.90	8	355448	237.90	10	355848	285.45
4	$\frac{3}{8}$.3750	1 1/4	6	355049	159.50	8	355249	237.90	8	355449	237.90	10	355849	285.45
5	$\frac{3}{32}$.0938	1	8	355052	214.55	10	355252	320.00	10	355452	320.00	12	355852	337.80
5	$\frac{1}{8}$.1250	1	-	-	-	10	355254	344.15	10	355454	344.15	12	355854	344.75
5	$\frac{3}{16}$.1875	1	-	-	-	10	355256	387.45	10	355456	387.45	12	355856	358.55
6	$\frac{1}{8}$.1250	1 1/4	8	355063	292.20	12	355263	420.05	12	355463	420.05	14	355863	403.25
6	$\frac{3}{16}$.1875	1 1/4	8	355065	385.05	12	355265	433.85	12	355465	433.85	14	355865	413.60
6	$\frac{1}{4}$.2500	1 1/4	8	355067	398.80	12	355267	442.85	12	355467	442.85	14	355867	420.50
8	$\frac{1}{8}$.1250	1 1/4	10	355083	373.45	-	-	-	-	-	-	-	-	-
8	$\frac{3}{16}$.1875	1 1/4	-	-	-	16	355285	597.00	16	355485	597.00	-	-	-
8	$\frac{1}{4}$.2500	1 1/4	-	-	-	16	355287	619.90	16	355487	619.90	-	-	-

CARBIDE TIPPED SIDE MILLING CUTTERS

TYPE 3540 - FOR NON-FERROUS

Carbide tips brazed to alloy steel bodies.

High feed rates can be achieved due to the large flute capacity. For milling aluminum, magnesium, zinc, brass, bronze, plastics and non-metals.

TYPE 3541 - FOR CAST IRON

Carbide tips brazed to alloy steel bodies.

Increased number of teeth with large flute capacity permit higher metal removal at moderate speeds and feeds.

TYPE 3542 - FOR STEEL

Carbide tips brazed to alloy steel bodies.

Steel cutting grade of carbide permits the heavy chip loads for milling steel.

TYPE 3543 - FOR STAINLESS STEEL

Carbide tips brazed to alloy steel bodies.

High number of teeth for milling of stainless steel and related alloy steels. AISI type 200 thru 350 stainless steels.



ALL TYPES:
Tool diameter tolerance: $+\frac{1}{16}"/-.000"$.
Face width tolerance: $+.001"/-.000"$.
Arbor hole tolerance: $+.001"/-.000"$.
Sharpened on all 3 cutting edges.

TOOL DIAM.	WIDTH		TYPE 3540 FOR NON-FERROUS				TYPE 3541 FOR CAST IRON				TYPE 3542 FOR STEEL				TYPE 3543 FOR STAINLESS STEEL			
	FRACTION	DEC.	NO. OF TEETH	1"ARBOR EDP NO.	1 1/4"ARBOR EDP NO.	PRICE EACH	NO. OF TEETH	1"ARBOR EDP NO.	1 1/4"ARBOR EDP NO.	PRICE EACH	NO. OF TEETH	1"ARBOR EDP NO.	1 1/4"ARBOR EDP NO.	PRICE EACH	NO. OF TEETH	1"ARBOR EDP NO.	1 1/4"ARBOR EDP NO.	PRICE EACH
3	1/4	.2500	4	354030	-	\$128.80	6	354130	-	\$161.10	6	354230	-	\$159.05	8	354330	-	\$202.25
3	5/16	.3125	4	354031	-	135.25	6	354131	-	161.80	6	354231	-	161.20	8	354331	-	211.90
3	3/8	.3750	4	354032	-	140.15	6	354132	-	165.05	6	354232	-	163.20	8	354332	-	214.80
3	7/16	.4375	4	354033	-	145.90	6	354133	-	178.50	6	354233	-	182.05	-	-	-	-
3	1/2	.5000	4	354034	-	152.95	6	354134	-	185.80	6	354234	-	184.55	8	354334	-	240.05
4	1/4	.2500	4	354040	-	167.85	8	354140	-	208.15	8	354240	-	209.40	10	354340	-	252.80
4	5/16	.3125	4	354041	-	172.60	8	354141	-	215.10	8	354241	-	222.40	10	354341	-	265.60
4	3/8	.3750	4	354042	354043	177.15	8	354142	354143	226.05	8	354242	354243	222.40	10	354342	354343	271.55
4	7/16	.4375	4	354074	-	177.95	8	354174	-	230.60	8	354274	-	229.05	10	354374	-	294.85
4	1/2	.5000	4	354044	354045	177.95	8	354144	354145	238.20	8	354244	354245	237.00	10	354344	354345	297.10
4	9/16	.5625	4	354094	-	193.45	8	354194	-	244.80	8	354294	-	248.70	-	-	-	-
4	5/8	.6250	4	354046	354047	207.60	8	354146	354147	265.35	8	354246	354247	290.75	10	354346	354347	312.90
4	3/4	.7500	4	354048	354049	232.60	8	354148	354149	265.35	8	354248	354249	294.45	10	354348	354349	322.30
5	1/4	.2500	6	354050	-	234.50	10	354150	-	275.55	10	354250	-	275.80	-	-	-	-
5	5/16	.3125	-	-	-	-	10	354151	-	275.55	10	354251	-	275.80	-	-	-	-
5	3/8	.3750	-	-	-	-	10	-	354153	282.30	10	-	354253	289.55	-	-	-	-
5	7/16	.4375	6	-	354075	243.95	10	-	354175	283.65	10	-	354275	298.85	-	-	-	-
5	1/2	.5000	6	354054	354055	246.85	10	354154	354155	301.10	10	354254	354255	298.90	12	354354	354355	341.25
5	9/16	.5625	6	-	354095	254.75	10	-	354195	306.25	10	-	354295	312.10	-	-	-	-
5	5/8	.6250	6	-	354057	268.00	10	-	354157	326.00	10	-	354257	366.30	12	-	354357	372.80
5	3/4	.7500	6	354058	354059	285.80	10	354158	354159	369.15	10	354258	354259	405.40	12	354358	354359	418.05
5	1	1.0000	6	-	354015	286.25	10	-	354115	401.70	10	-	354215	427.55	-	-	-	-
6	3/8	.3750	6	354062	-	251.60	12	-	354163	346.80	12	-	354263	366.35	-	-	-	-
6	1/2	.5000	6	354064	354065	275.55	12	354164	354165	368.25	12	354264	354265	377.40	14	354364	354365	439.10
6	5/8	.6250	6	-	354067	302.00	12	-	354167	402.40	12	-	354267	410.50	14	-	354367	442.65
6	3/4	.7500	6	354068	354069	347.35	12	354168	354169	451.50	12	354268	354269	467.55	14	354368	354369	477.60
6	1	1.0000	6	-	354016	398.15	12	-	354116	456.35	12	-	354216	477.05	-	-	-	-
				1 1/4" ARBOR	1 1/2" ARBOR			1 1/4" ARBOR	1 1/2" ARBOR			1 1/4" ARBOR	1 1/2" ARBOR			1 1/4" ARBOR	1 1/2" ARBOR	
8	3/4	.7500	8	354088	354089	451.95	12	354188	354189	473.90	12	354288	354289	491.60	14	354388	-	512.05
8	1	1.0000	8	354080	354081	490.35	12	354180	354181	493.95	12	354280	354281	511.65	-	-	-	-

CARBIDE TIPPED ANGLE CUTTERS

SINGLE ANGLE CUTTERS

TYPE 3714 - 45° RIGHT
TYPE 3716 - 45° LEFT

TYPE 3724 - 60° RIGHT
TYPE 3726 - 60° LEFT

Carbide tips brazed to hardened alloy steel bodies. General purpose cutters for cutting non-ferrous materials and cast iron.

TOOL DIAMETER	WIDTH	ARBOR HOLE	NO. OF TEETH	RIGHT 45° TYPE 3714 EDP NO.	LEFT 45° TYPE 3716 EDP NO.	RIGHT 60° TYPE 3724 EDP NO.	LEFT 60° TYPE 3726 EDP NO.	ALL TYPES PRICE
3	1/2	1	8	371408	371608	372408	372608	\$346.15
4	1/2	1 1/4	10	371416	371616	372416	372616	428.40
4	3/4	1 1/4	10	371424	371624	372424	372624	464.70

DOUBLE ANGLE CUTTERS

TYPE 3750 - 45° DOUBLE
TYPE 3752 - 60° DOUBLE
TYPE 3754 - 90° DOUBLE

Carbide tips brazed to hardened alloy steel bodies. General purpose cutters for cutting non-ferrous materials and cast iron.

TOOL DIAMETER	WIDTH	ARBOR HOLE	NO. OF TEETH	45° TYPE 3750 EDP NO.	60° TYPE 3752 EDP NO.	90° TYPE 3754 EDP NO.	ALL TYPES PRICE
2 3/4	1/2	1	8	-	375207	375407	\$288.65
3	1/2	1	8	375008	375208	375408	360.00
4	1/2	1 1/4	10	375016	375216	375416	445.60
4	3/4	1 1/4	10	375024	375224	375424	483.35
4	1	1 1/4	10	-	375232	375432	565.75

CARBIDE TIPPED SHELL MILL CUTTERS

Carbide tips brazed to alloy steel bodies.

TYPE 3530 - FOR NON-FERROUS

Large, open right hand spiral flutes aid in chip removal.

TYPE 3531 - FOR CAST IRON

Open flutes for machining cast iron, soft cast iron and malleable iron.

TYPE 3532 - FOR STEEL

Large, open left hand spiral flutes absorb impact shock.

ALL TYPES ON THIS PAGE:

Tool diameter tolerance: +1/16"/-.000".

Arbor hole tolerance: +.001"/-.000".

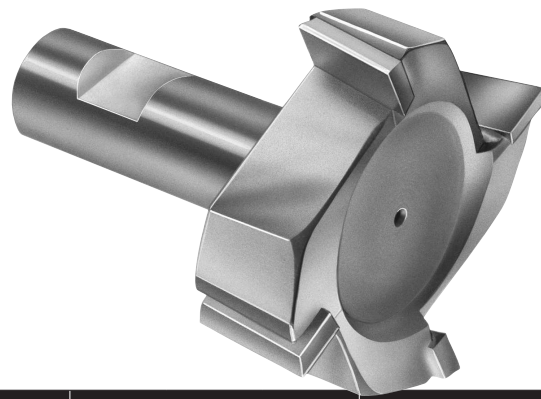
TOOL DIAMETER	ARBOR HOLE	CARBIDE LENGTH	OVERALL LENGTH	DRIVE SLOTS		TYPE 3530 FOR NON-FERROUS			TYPE 3531 FOR CAST IRON			TYPE 3532 FOR STEEL		
				WIDTH	DEPTH	NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH
1 1/4	1/2	1/2	1	1/4	5/32	4	353024	\$196.25	4	353124	\$196.25	4	353224	\$204.10
1 1/2	1/2	1/2	1 1/8	1/4	5/32	4	353026	204.30	4	353126	204.30	4	353226	212.50
1 3/4	3/4	1/2	1 1/4	5/16	3/16	4	353028	254.60	4	353128	254.60	4	353228	264.80
2	3/4	5/8	1 3/8	5/16	3/16	4	353032	262.30	4	353132	284.45	4	353232	295.85
2 1/4	1	5/8	1 1/2	3/8	7/32	6	353036	277.20	6	353136	308.00	6	353236	320.30
2 1/2	1	5/8	1 5/8	3/8	7/32	6	353040	291.90	6	353140	335.70	6	353240	335.70
2 3/4	1	5/8	1 5/8	3/8	7/32	6	353044	308.00	6	353144	352.15	6	353244	352.15
3	1 1/4	3/4	1 3/4	1/2	9/32	6	353048	337.65	6	353148	383.10	6	353248	383.10
3 1/2	1 1/4	3/4	1 7/8	1/2	9/32	6	353056	413.25	8	353156	450.55	6	353256	476.30
4	1 1/2	3/4	2 1/4	5/8	3/8	6	353064	519.30	8	353164	557.40	6	353264	591.50

CARBIDE TIPPED FACE MILLS

TYPE 3536 - FOR NON-FERROUS
TYPE 3537 - FOR CAST IRON
TYPE 3538 - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies.

Straight shank with Weldon flats. Tools are designed with appropriate carbide grade and geometry for material being machined.



TOOL DIAMETER	SHANK DIAMETER	TOOL WIDTH	CARBIDE LENGTH	DEPTH OF CARBIDE	OVERALL LENGTH	TYPE 3536 - NON-FERROUS			TYPE 3537 - CAST IRON			TYPE 3538 - STEEL		
						NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH	NO. OF TEETH	EDP NO.	PRICE EACH
1 1/2	3/4	3/4	1/2	1/4	2 7/8	4	353624	\$186.30	4	353724	\$186.30	4	353824	\$191.75
2	3/4	3/4	1/2	1/4	2 7/8	4	353632	227.75	4	353732	227.75	4	353832	233.05
2 1/2	3/4	3/4	1/2	1/4	2 7/8	6	353640	256.45	6	353740	256.45	6	353840	263.25
3 1/2	1 1/4	1 1/8	5/8	5/16	4	6	353656	442.55	6	353756	442.55	8	353856	457.75
3 1/2	1 1/2	1 1/8	5/8	5/16	4	6	353657	464.65	6	353757	464.65	8	353857	480.55
4	1 1/2	1 1/2	3/4	3/8	5	8	353664	497.30	8	353764	497.30	8	353864	497.75

CARBIDE TIPPED COUNTERSINKS

SINGLE FLUTE COUNTERSINKS

TYPE 3561 - 60°
TYPE 3581 - 82°
TYPE 3591 - 90°
TYPE 3584 - 100°

Carbide tips brazed to hardened alloy steel bodies.

The single flute design with a positive rake assures burr-free holes and chatterless operation. Not recommended for portable hand tool use — see three flute types.



THREE FLUTE COUNTERSINKS

TYPE 3563 - 60°
TYPE 3583 - 82°
TYPE 3590 - 90°
TYPE 3585 - 100°

Carbide tips brazed to hardened alloy steel bodies.

The three flute design tends to center the tool in portable tool use and results in longer tool life.



TOOL DIAM.	SHANK DIAM.	MINIMUM CUTTING DIAM.	60° ANGLE TYPE 3561 EDP NO.	82° ANGLE TYPE 3581 EDP NO.	90° ANGLE TYPE 3591 EDP NO.	100° ANGLE TYPE 3584 EDP NO.	ALL TYPES PRICE
1/4	3/16	1/16	356108	358108	359108	358408	\$55.95
3/8	1/4	5/64	356112	358112	359112	358412	55.95
1/2	3/8	3/32	356116	358116	359116	358416	66.40
3/4	1/2	1/8	356124	358124	359124	358424	83.00
1	1/2	1/8	356132	358132	359132	358432	108.40
1 1/4	1/2	5/32	356140	358140	359140	358440	138.00
1 1/2	1/2	3/16	356148	358148	359148	358448	154.70

TOOL DIAM.	SHANK DIAM.	MINIMUM CUTTING DIAM.	60° ANGLE TYPE 3563 EDP NO.	82° ANGLE TYPE 3583 EDP NO.	90° ANGLE TYPE 3590 EDP NO.	100° ANGLE TYPE 3585 EDP NO.	ALL TYPES PRICE
1/4	3/16	5/64	356308	358308	359008	358508	\$61.45
3/8	1/4	7/64	356312	358312	359012	358512	61.45
1/2	3/8	9/64	356316	358316	359016	358516	73.10
3/4	1/2	1/8	356320	358320	359020	358520	76.80
1	1/2	3/16	356324	358324	359024	358524	92.30
1 1/4	1/2	5/32	356328	358328	359028	358528	105.85
1 1/2	1/2	3/16	356332	358332	359032	358532	115.45
1 1/4	1/2	5/32	356340	358340	359040	358540	143.65
1 1/2	1/2	3/8	356348	358348	359048	358548	167.55

CARBIDE TIPPED CORNER ROUNDING END MILLS

TYPE 3740 - FOR NON-FERROUS & CAST IRON

TYPE 3741 - FOR STEEL

CIRCLE RADIUS	TOOL DIAM.	SHANK DIAM.	END DIAM.	CARBIDE LENGTH	OVERALL LENGTH	TYPE 3740		TYPE 3741	
						EDP NO.	PRICE EACH	EDP NO.	PRICE EACH
1/16	7/16	3/8	17/64	13/32	2 3/4	374002	\$132.40	374102	\$143.05
3/32	1/2	3/8	17/64	13/32	2 3/4	374003	132.40	374103	143.05
1/8	5/8	1/2	19/64	13/32	3	374004	137.00	374104	147.85
5/32	3/4	1/2	23/64	13/32	3	374005	145.25	374105	156.85
3/16	7/8	3/4	13/32	13/32	3 1/4	374006	153.70	374106	165.95
1/4	1	3/4	13/32	15/32	3 1/4	374008	175.25	374108	189.25
5/16	1 1/8	7/8	13/32	19/32	3 1/2	374010	180.00	374110	194.35
3/8	1 1/4	7/8	13/32	25/32	3 3/4	374012	186.95	374112	201.95
7/16	1 3/8	1	13/32	7/8	4	374014	208.20	374114	224.85
1/2	1 1/2	1	13/32	1	4	374016	231.70	374116	250.25
5/8	2	1 1/4	21/32	1 7/32	4 1/4	374020	285.15	374120	308.00

Carbide tips brazed to hardened alloy steel bodies. All sizes have three flutes and are used to mill round corners on square edges.



CARBIDE TIPPED CENTER CUTTING END MILLS

TYPE 3318 - 25° RIGHT SPIRAL FLUTES - FOR NON-FERROUS & CAST IRON

Flute long carbide tips brazed to hardened alloy steel bodies.



TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	CARBIDE TIP LENGTH	OVER ALL LEN.	TYPE 3318 - 25° RIGHT SPIRAL	
DECIMAL	FRAC.					EDP NO.	PRICE EACH
.5000	1/2	1/2	2	1	3	331816	\$152.05
.6250	5/8	5/8	2	1 1/4	3 3/8	331820	169.95
.7500	3/4	3/4	2	1 1/4	3 3/8	331824	180.10
.8750	7/8	7/8	2	1 1/2	3 3/4	331828	198.05
1.0000	1	1	2	1 1/2	4	331832	227.65
1.2500	1 1/4	1 1/4	2	1 3/4	4 1/4	331840	309.45
1.5000	1 1/2	1 1/2	2	2	4 3/4	331848	361.05

TYPE 3314 - THREE STRAIGHT FLUTES - FOR NON-FERROUS & CAST IRON

TYPE 3312 - THREE STRAIGHT FLUTES - FOR STEEL

Flute long carbide tips brazed to hardened alloy steel bodies.



ALL TYPES:

One flute is center cutting.

Straight shanks with drive flats.

Tool diameter tolerance: +.002"/-.000".

For plunge and side cut milling at moderate feeds and speeds.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	CARBIDE TIP LENGTH	OVERALL LENGTH	TYPE 3314 - FOR NON-FERR. & C.I.		TYPE 3312 - FOR STEEL	
DECIMAL	FRAC.					EDP NO.	PRICE EACH	EDP NO.	PRICE EACH
.3750	3/8	3/8	3	1/2	2 1/2	331412	\$90.95	331212	\$94.50
.4375	7/16	3/8	3	3/4	2 1/2	331414	93.00	331214	96.60
.5000	1/2	1/2	3	3/4	3	331416	95.40	331216	98.95
.5625	9/16	1/2	3	3/4	3	331418	99.05	331218	102.90
.6250	5/8	5/8	3	3/4	3 1/4	331420	115.95	331220	120.35
.7500	3/4	5/8	3	3/4	3 3/8	331424	121.35	331224	126.05
.8750	7/8	7/8	3	3/4	3 3/4	331428	141.60	331228	147.10
1.0000	1	7/8	3	3/4	3 3/4	331432	155.60	331232	161.55
1.1250	1 1/8	1	3	3/4	4	331436	166.70	331236	173.05
1.2500	1 1/4	1	3	3/4	4	331440	193.15	331240	200.65
1.5000	1 1/2	1 1/4	3	3/4	4	331448	229.60	331248	238.45

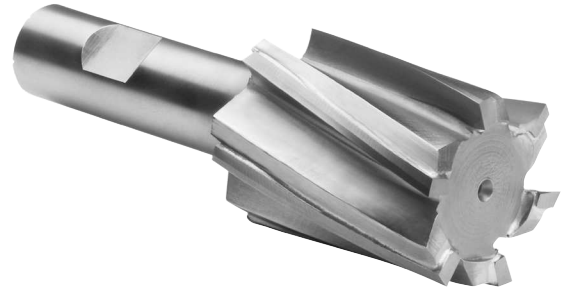
CARBIDE TIPPED BRIDGEPORT/REDUCED SHANK END MILLS

TYPE 3323 - 15° RIGHT SPIRAL FLUTES - FOR NON-FERROUS & CAST IRON

TYPE 3353 - 15° RIGHT SPIRAL FLUTES - FOR STEEL

Flute long carbide tips brazed to hardened alloy steel bodies.

The large capacity 15° spiral flutes permit easy chip flow.
 $\frac{3}{4}$ " shank designed for use on Bridgeport style machines.



TOOL DIAMETER		SHANK DIAM.	CARBIDE TIP LENGTH	OVER ALL LENGTH	NO. OF FLUTES	N-F/C.I. TYPE 3323 EDP NO.	STEEL TYPE 3353 EDP NO.	BOTH TYPES PRICE
DECIMAL	FRACTION							
.7500	$\frac{3}{4}$	$\frac{3}{4}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	4	332324	335324	\$120.20
.8750	$\frac{7}{8}$	$\frac{3}{4}$	1 $\frac{1}{2}$	3 $\frac{3}{4}$	4	332328	335328	137.65
1.0000	1	$\frac{3}{4}$	1 $\frac{1}{2}$	4	6	332332	335332	192.95
1.1250	1 $\frac{1}{8}$	$\frac{3}{4}$	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332336	335336	227.10
1.2500	1 $\frac{1}{4}$	$\frac{3}{4}$	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332340	335340	260.35
1.5000	1 $\frac{1}{2}$	$\frac{3}{4}$	2	4 $\frac{1}{2}$	6	332348	335348	299.55

CARBIDE TIPPED CNC FINISHING END MILLS

TYPE 3322 - 15° RIGHT SPIRAL FLUTES - FOR NON-FERROUS & CAST IRON

TYPE 3355 - 15° RIGHT SPIRAL FLUTES - FOR STEEL

Flute long carbide tips brazed to hardened alloy steel bodies.

CNC qualified edge provides for accurate and consistent resharping. Carbide grade and tool geometry appropriate for material being machined.



TOOL DIAMETER		SHANK DIAM.	CARBIDE TIP LENGTH	OVER ALL LENGTH	NO. OF FLUTES	N-F/C.I. TYPE 3322 EDP NO.	STEEL TYPE 3355 EDP NO.	BOTH TYPES PRICE
DECIMAL	FRACTION							
.5000	$\frac{1}{2}$	$\frac{1}{2}$	1	3	4	332216	335516	\$110.55
.6250	$\frac{5}{8}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	4	332220	335520	127.65
.7500	$\frac{3}{4}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	4	332224	335524	137.00
1.0000	1	1	1 $\frac{1}{2}$	4	6	332232	335532	220.00
1.1250	1 $\frac{1}{8}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332236	335536	258.90
1.2500	1 $\frac{1}{4}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332240	335540	296.80
1.5000	1 $\frac{1}{2}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	6	332248	335548	341.50
1.7500	1 $\frac{3}{4}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	8	332256	335556	429.55
2.0000	2	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	8	332264	335564	485.25

CARBIDE TIPPED CNC HIGH PERFORMANCE END MILLS

TYPE 3337 - 25° RIGHT SPIRAL FLUTES - FOR ALUMINUM & OTHER NON-FERROUS

Flute long carbide tips brazed to hardened alloy steel bodies.

High helix, high performance open flute design for high speed non-ferrous metal removal. CNC qualified edge provides for accurate and consistent resharping.

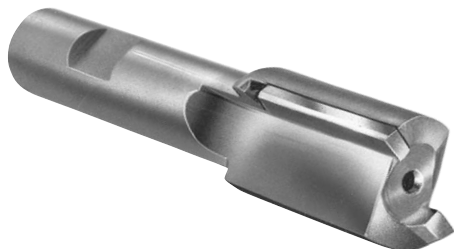


TOOL DIAMETER		SHANK DIAM.	CARBIDE TIP LENGTH	OVER ALL LENGTH	NO. OF FLUTES	NON-FERR. TYPE 3337 EDP NO.	PRICE EACH
DECIMAL	FRACTION						
.5000	$\frac{1}{2}$	$\frac{1}{2}$	1	3	2	333716	\$110.55
.6250	$\frac{5}{8}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	2	333720	127.65
.7500	$\frac{3}{4}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	2	333724	137.00
1.0000	1	1	1 $\frac{1}{2}$	4	2	333732	181.10
1.2500	1 $\frac{1}{4}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	3	333740	263.15
1.5000	1 $\frac{1}{2}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	3	333748	318.80
2.0000	2	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	3	333764	465.60

CARBIDE TIPPED END MILLS - FOR STEEL

TYPE 3300 - TWO STRAIGHT FLUTES

Flute long carbide tips brazed to hardened alloy steel bodies.
Large flute capacity for easier chip removal.



TYPE 3308 - 6° RIGHT SPIRAL FLUTES

Flute long carbide tips brazed to hardened alloy steel bodies.
Spiral flutes help remove chips, permitting faster speeds and higher feed rate. Produces better finish.



TYPE 3310 - 6° LEFT SPIRAL FLUTES

Flute long carbide tips brazed to hardened alloy steel bodies.
The left spiral flutes help absorb the impact shock on entering steel while maintaining constant pressure on the work piece. For milling all types of steel, including hardened steel and other tough steel alloys.



TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3300 - STRAIGHT FLUTES			TYPE 3308 OR TYPE 3310 - 6° SPIRAL FLUTES			
DEC.	FRACTIONAL				NO. OF FLTS.	EDP NO.	PRICE EACH	NO. OF FLTS.	TYPE 3308 RIGHT EDP NO.	TYPE 3310 LEFT EDP NO.	BOTH TYPES PRICE
.2500	1/4	3/8	1/2	2 1/2	2	330008	\$60.90	2	330808	331008	\$62.75
.3125	5/16	3/8	5/8	2 1/2	2	330010	63.50	2	330810	331010	67.60
.3750	3/8	3/8	5/8	2 1/2	2	330012	67.80	2	330812	331012	71.75
.4375	7/16	3/8	1	2 1/16	2	330014	67.80	2	330814	331014	71.75
.5000	1/2	1/2	1	3 1/4	2	330016	69.40	4	330816	331016	77.30
.5625	9/16	1/2	1	3 3/8	2	330018	76.85	4	330818	331018	83.00
.6250	5/8	1/2	1	3 3/8	2	330020	76.85	4	330820	331020	102.40
.7500	3/4	5/8	1	3 3/8	2	330024	83.15	4	330824	331024	110.05
.8750	7/8	5/8	1 1/4	4	2	330028	98.30	4	330828	331028	132.50
1.0000	1	7/8	1 1/4	4	2	330032	108.60	6	330832	331032	152.35
1.1250	1 1/8	1	1 1/4	4 1/4	2	330036	111.20	6	330836	331036	161.50
1.2500	1 1/4	1	1 1/4	4 1/4	2	330040	124.05	6	330840	331040	195.30
1.5000	1 1/2	1 1/4	1 1/2	4 1/2	2	330048	159.75	6	330848	331048	237.60
1.7500	1 3/4	1 1/4	1 1/2	4 1/2	2	330056	179.15	8	330856	331056	285.90
2.0000	2	1 1/4	1 1/2	4 1/2	2	330064	213.95	8	330864	331064	319.30

TYPE 3350 - 15° RIGHT SPIRAL FLUTES

Flute long carbide tips brazed to hardened alloy steel bodies.
For milling all types of steel. The large capacity of the 15° spiral flutes permits faster chip removal while allowing smoother finishes. The high spiral provides longer tool life.



ALL TYPES:

Radial edged tool diameter tolerance: +.002"/-.000".

Shank diameter tolerance: -.0001"/-.0005".

Straight shanks with drive flats.

All End Mills are radial edged; see page 23 for descriptions.

Also available in 3/4" shank diameter, see pg. 20.

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3350 - 15° RIGHT SPIRAL		
DECIMAL	FRACTIONAL				NO. OF FLTS.	EDP NO.	PRICE EACH
.5000	1/2	3/8	1	3	4	335016	\$96.90
.5000	1/2	1/2	1	3	4	335017	96.90
.5625	9/16	1/2	1	3	4	335018	104.15
.6250	5/8	1/2	1 1/4	3 1/4	4	335020	112.05
.6250	5/8	5/8	1 1/4	3 3/8	4	335021	112.05
.6875	11/16	1/2	1 1/4	3 1/4	4	335022	116.80
.6875	11/16	5/8	1 1/4	3 3/8	4	335023	116.80
.7500	3/4	1/2	1 1/4	3 1/4	4	335024	120.20
.7500	3/4	5/8	1 1/4	3 3/8	4	335025	120.20
.8125	13/16	5/8	1 1/2	3 5/8	4	335026	129.60
.8750	7/8	5/8	1 1/2	3 5/8	4	335028	137.65
.8750	7/8	7/8	1 1/2	3 3/4	4	335029	137.65

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3350 - 15° RIGHT SPIRAL		
DECIMAL	FRACTIONAL				NO. OF FLTS.	EDP NO.	PRICE EACH
.9375	15/16	5/8	1 1/2	3 3/4	4	335030	\$203.85
.9375	15/16	7/8	1 1/2	3 3/4	4	335031	203.85
1.0000	1	7/8	1 1/2	3 3/4	6	335032	192.95
1.0000	1	1	1 1/2	4	6	335033	192.95
1.1250	1 1/8	1	1 3/4	4 1/4	6	335036	227.15
1.2500	1 1/4	1	1 3/4	4 1/4	6	335040	260.40
1.3750	1 3/8	1	1 3/4	4 1/4	6	335044	304.15
1.5000	1 1/2	1 1/4	2	4 1/2	6	335048	299.60
1.6250	1 5/8	1 1/4	2	4 1/2	8	335052	399.40
1.7500	1 3/4	1 1/4	2	4 1/2	8	335056	425.95
1.8750	1 7/8	1 1/4	2	4 1/2	8	335060	455.55
2.0000	2	1 1/4	2	4 1/2	8	335064	481.20

CARBIDE TIPPED END MILLS - FOR NON-FERROUS & CAST IRON

TYPE 3302 - TWO STRAIGHT FLUTES - RADIAL EDGED

Flute long carbide tips brazed to hardened alloy steel bodies.
Large flute capacity for easier chip removal.



TYPE 3304 - FOUR/SIX STRAIGHT FLUTES - RADIAL EDGED

Flute long carbide tips brazed to hardened alloy steel bodies.
Best when machine horsepower allows a higher capacity end mill.



TYPE 3305 - FOUR STRAIGHT FLUTES - UPSHARP

Flute long carbide tips brazed to hardened alloy steel bodies.
Reduced horsepower requirements in a high capacity end mill.



TYPE 3306 - 6° RIGHT SPIRAL FLUTES - RADIAL EDGED

Flute long carbide tips brazed to hardened alloy steel bodies.
Spiral flutes help remove chips, permitting faster speeds and heavier feeds. Produces better finish.

TYPE 3307 - 6° RIGHT SPIRAL FLUTES - UPSHARP

Flute long carbide tips brazed to hardened alloy steel bodies.
Spiral flutes help remove chips which permits heavier feeds and faster speeds. Ideal for zinc and aluminum.

ALL TYPES:

Radial edged tool diameter tolerance: +.002"/-.000".

Upsharp tool diameter tolerance: +.005"/-.000".

Shank diameter tolerance: -.0001"/-.0005".

Straight shanks with drive flats.

For radial edged and upsharp descriptions, see page 23.

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3302 - STR. FLTS.			TYPE 3304 - FOUR/SIX STR. FLTS.			TYPE 3305 - FOUR STR. FLTS.			TYPE 3306 - 6° RIGHT SPIRAL			TYPE 3307 - 6° RIGHT SPIRAL		
DECIMAL	FRACTION				NO. OF FLTS.	EDP NO.	PRICE EACH	NO. OF FLTS.	EDP NO.	PRICE EACH	NO. OF FLTS.	EDP NO.	PRICE EACH	NO. OF FLTS.	EDP NO.	PRICE EACH	NO. OF FLTS.	EDP NO.	PRICE EACH
.2500	1/4	3/8	1/2	2 1/2	2	330208	\$53.05	4	330408	\$53.50	4	330508	\$53.45	2	330608	\$55.20	2	330708	\$57.50
.3125	5/16	3/8	5/8	2 1/2	2	330210	55.05	4	330410	57.10	-	-	-	2	330610	57.25	-	-	-
.3750	3/8	3/8	5/8	2 1/2	2	330212	58.95	4	330412	60.25	-	-	-	2	330612	61.25	-	-	-
.4375	7/16	3/8	1	2 1/16	2	330214	58.95	4	330414	60.25	4	330514	57.95	2	330614	61.25	2	330714	63.70
.5000	1/2	1/2	1	3 1/4	2	330216	60.45	4	330416	61.65	4	330516	61.50	2	330616	62.85	2	330716	65.30
.5625	9/16	1/2	1	3 3/4	2	330218	66.90	4	330418	69.30	4	330518	69.05	2	330618	69.55	2	330718	72.20
.6250	5/8	1/2	1	3 3/8	2	330220	66.90	4	330420	72.50	4	330520	72.35	4	330620	72.30	4	330720	75.10
.6875	11/16	5/8	1	3 3/8	2	330222	72.35	4	330422	79.90	4	330522	79.70	-	-	-	-	-	-
.7500	3/4	5/8	1	3 5/8	2	330224	72.35	4	330424	71.90	4	330524	79.70	4	330624	79.60	4	330724	82.65
.8125	13/16	5/8	1	3 5/8	2	330226	87.50	4	330426	84.95	4	330526	91.30	-	-	-	-	-	-
.8750	7/8	5/8	1 1/4	4	2	330228	88.05	4	330428	84.95	4	330528	94.20	4	330628	106.40	4	330728	110.65
.9375	15/16	7/8	1 1/4	4	2	330230	94.20	4	330430	94.25	4	330530	100.40	-	-	-	-	-	-
1.0000	1	7/8	1 1/4	4	2	330232	94.60	4	330432	98.20	4	330532	108.85	4	330632	122.95	4	330732	127.75
1.1250	1 1/8	1	1 1/4	4 1/4	2	330236	97.00	4	330436	111.35	4	330536	123.35	4	330636	139.40	-	-	-
1.2500	1 1/4	1	1 1/4	4 1/4	2	330240	116.95	4	330440	125.20	4	330540	138.70	4	330640	156.70	4	330740	162.70
1.5000	1 1/2	1 1/4	1 1/2	4 1/2	2	330248	144.90	4	330448	161.35	4	330548	171.80	4	330648	194.10	4	330748	194.20
1.7500	1 3/4	1 1/4	1 1/2	4 1/2	2	330256	171.80	6	330456	208.05	-	-	-	6	330656	250.45	-	-	-
2.0000	2	1 1/4	1 1/2	4 1/2	2	330264	191.60	6	330464	239.65	-	-	-	6	330664	288.40	6	330764	288.45

CARBIDE TIPPED END MILLS - FOR NON-FERROUS & CAST IRON

TYPE 3320 - 15° RIGHT SPIRAL FLUTES - RADIAL EDGED

Flute long carbide tips brazed to hardened alloy steel bodies.

For milling primarily cast iron and malleable iron. However, they can be used on other materials *except steel*. The large capacity of the 15° spiral flutes permits faster chip removal while allowing smoother finishes. Also the high spiral provides longer tool life. More flutes than Type 3375 for use where less feed rate per flute is required but table feed is maintained for same productivity.

Also available in 3/4" shank diameter, see pg. 20.



TYPE 3375 - 15° RIGHT SPIRAL FLUTES - RADIAL EDGED

Same as Type 3320, except less flutes.

TYPE 3325 - 25° RIGHT SPIRAL FLUTES - RADIAL EDGED

Flute long carbide tips brazed to hardened alloy steel bodies.

For milling all types of non-ferrous metals and non-metals. The large capacity of the 25° spiral flutes permits faster chip removal while allowing smoother finishes. Also the high spiral provides longer tool life.



TYPE 3327 - 25° RIGHT SPIRAL FLUTES - UPSHARP

Flute long carbide tips brazed to hardened alloy steel bodies.

For high speed milling of aluminum, plastics, and other soft non-ferrous materials.

UPSHARP END MILLS:

These tools are manufactured with sharp cutting edges on the periphery and permit maximum metal removal with less horsepower.

RADIAL EDGED END MILLS:

These tools are manufactured with a precise .002" to .003" radial edge on the periphery, thus eliminating the need to hand hone the feathered edge. This small margin results in a stronger cutting edge and minimizes edge chipping for longer tool life.

ALL TYPES:

Radial edged tool diameter tolerance: +.002"/-.000".

Upsharp tool diameter tolerance: +.005"/-.000".

Shank diameter tolerance: -.0001"/-.0005".

Straight shanks with drive flats.

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3320 - 15° RIGHT SPIRAL			TYPE 3375 - 15° RIGHT SPIRAL			TYPE 3327 OR TYPE 3325 - 25° RIGHT SPIRAL			
DECIMAL	FRACTION				NO. OF FLUTES	EDP NO.	PRICE EACH	NO. OF FLUTES	EDP NO.	PRICE EACH	NO. OF FLUTES	TYPE 3327 EDP NO.	TYPE 3325 EDP NO.	PRICE EACH
.5000	1/2	3/8	1	3	-	-	-	2	337516	\$91.00	2	-	332516	\$96.90
.5000	1/2	1/2	1	3	4	332017	\$96.90	2	337517	91.00	2	-	332517	96.90
.5625	9/16	1/2	1	3	-	-	-	2	337518	97.85	2	-	332518	104.15
.6250	5/8	1/2	1 1/4	3 1/4	-	-	-	2	337520	105.25	2	-	332520	112.05
.6250	5/8	5/8	1 1/4	3 3/8	4	332021	112.05	2	337521	105.25	2	332721	332521	112.05
.6875	11/16	1/2	1 1/4	3 1/4	-	-	-	2	337522	109.70	2	-	332522	116.80
.6875	11/16	5/8	1 1/4	3 3/8	4	332023	116.80	2	337523	109.70	2	-	332523	116.80
.7500	3/4	1/2	1 1/4	3 1/4	-	-	-	2	337524	112.85	2	332724	332524	120.20
.7500	3/4	5/8	1 1/4	3 3/8	4	332025	120.20	2	337525	112.85	2	332725	332525	120.20
.8125	13/16	5/8	1 1/2	3 5/8	4	332026	129.60	2	337526	121.70	2	332726	332526	129.60
.8750	7/8	5/8	1 1/2	3 5/8	-	-	-	2	337528	129.30	2	-	332528	137.65
.8750	7/8	7/8	1 1/2	3 3/4	4	332029	137.65	2	337529	129.30	2	-	332529	137.65
.9375	15/16	5/8	1 1/2	3 3/4	-	-	-	3	337530	191.40	2	-	332530	155.70
.9375	15/16	7/8	1 1/2	3 3/4	-	-	-	3	337531	191.40	2	-	332531	155.70
1.0000	1	7/8	1 1/2	3 3/4	-	-	-	3	337532	181.20	2	332732	332532	158.90
1.0000	1	1	1 1/2	4	6	332033	192.95	3	337533	181.20	2	332733	332533	158.90
1.1250	1 1/8	1	1 3/4	4 1/4	6	332036	227.15	3	337536	213.35	2	-	332536	173.95
1.2500	1 1/4	1	1 3/4	4 1/4	6	332040	260.40	4	337540	244.55	3	332740	332540	230.80
1.3750	1 3/8	1	1 3/4	4 1/4	6	332044	304.15	4	337544	285.60	3	332744	332544	250.25
1.5000	1 1/2	1 1/4	2	4 1/2	6	332048	299.60	4	337548	281.40	3	332748	332548	279.50
1.6250	1 5/8	1 1/4	2	4 1/2	-	-	-	4	337552	344.10	3	-	332552	330.75
1.7500	1 3/4	1 1/4	2	4 1/2	8	332056	376.80	4	337556	367.00	3	-	332556	354.90
1.8750	1 7/8	1 1/4	2	4 1/2	-	-	-	4	337560	392.45	3	-	332560	382.05
2.0000	2	1 1/4	2	4 1/2	8	332064	425.70	4	337564	414.60	3	332764	332564	408.45

CARBIDE TIPPED PORT CONTOUR CUTTERS

ISO 6149-1 METRIC PORTS - WITHOUT I.D. GROOVE

TYPE 3786 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3787 - STRAIGHT SHANK - FOR STEEL

Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.



THREAD SIZE	DIMENSIONS									N-F/CI TYPE 3786 EDP NO.	STEEL TYPE 3787 EDP NO.	BOTH TYPES PRICE
	DIAMETER			TAPER SHANK NO.	SEALING SEAT ANGLE	LENGTH						
	REAMER	SPOTFACE	SHANK			SHANK	REAMER	HEAD	OVERALL			
M 8X1	.2770	.6690	.5000	3	12°	2	.4530	1 1/8	3 1/8	3786080	3787080	\$376.95
M 10X1	.3560	.7870	.5000	3	12°	2	.4530	1 1/4	3 1/4	3786100	3787100	376.95
M 12X1.5	.4150	.9060	.5000	3	15°	2	.5510	1 1/4	3 1/4	3786120	3787120	394.80
M 14X1.5	.4930	.9840	.5000	3	15°	2	.5510	1 1/4	3 1/4	3786140	3787140	394.80
M 16X1.5	.5720	1.1020	.5000	3	15°	2	.6100	1 1/4	3 1/4	3786160	3787160	434.70
M 18X1.5	.6510	1.1810	.7500	3	15°	2	.6690	1 3/8	3 3/8	3786180	3787180	434.70
M 20X1.5	.7300	1.2600	.7500	3	15°	2	.6890	1 3/8	3 3/8	3786200	3787200	451.50
M 22X1.5	.8080	1.3390	.7500	3	15°	2	.7090	1 3/8	3 5/8	3786220	3787220	468.30
M 27X2	.9850	1.5750	.7500	3	15°	2 1/4	.8660	1 7/8	4 1/8	3786270	3787270	506.10
M 33X2	1.2210	1.9290	.7500	3	15°	2 1/4	.8660	1 7/8	4 1/8	3786330	3787330	554.40
M 42X2	1.5760	2.3620	1.0000	3	15°	2 1/4	.8860	1 7/8	4 1/8	3786420	3787420	605.85
M 48X2	1.8120	2.5890	1.0000	4	15°	2 1/4	.9840	2	4 1/4	3786480	3787480	640.50
M 60X2	2.2840	2.9920	1.0000	4	15°	2 1/4	1.0830	2	4 1/4	3786600	3787600	661.50

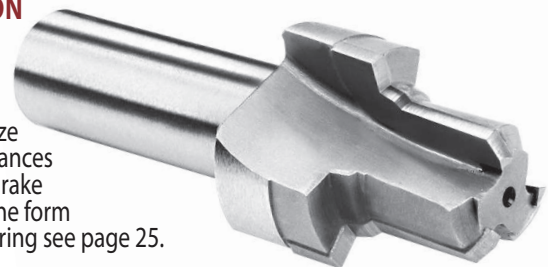
S.A.E. PORTS - MS16142 - J514F - J1926

TYPE 3780 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3781 - STRAIGHT SHANK - FOR STEEL

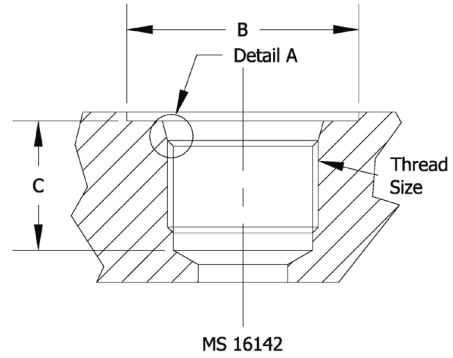
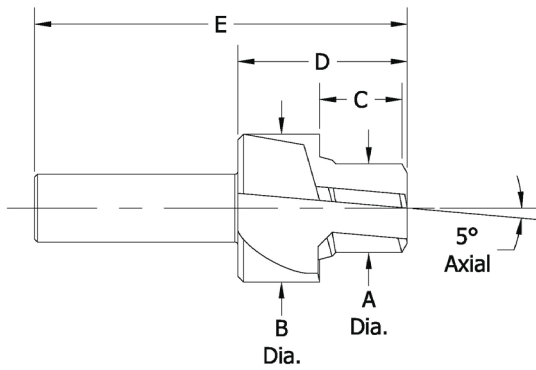
Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.



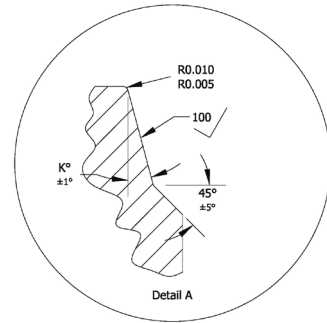
TUBE			DIMENSIONS							N-F/CI TYPE 3780 EDP NO.	STEEL TYPE 3781 EDP NO.	BOTH TYPES PRICE	
NO.	SIZE	THREAD SIZE	DIAMETER			SEALING SEAT ANGLE	LENGTH						
			REAMER	SPOTFACE	SHANK		SHANK	REAMER	HEAD				OVERALL
2	1/8	5/16-24	.2720	.6820	.5000	12°	2	.4730	1 1/8	3 1/8	378002	378102	\$333.90
3	3/16	3/8-24	.3350	.7600	.5000	12°	2	.4730	1 1/4	3 1/4	378003	378103	333.90
4	1/4	7/16-20	.3890	.8380	.5000	12°	2	.5520	1 1/4	3 1/4	378004	378104	333.90
5	5/16	1/2-20	.4520	.9160	.5000	12°	2	.5520	1 1/4	3 1/4	378005	378105	344.40
6	3/8	9/16-18	.5090	.9790	.5000	12°	2	.6140	1 1/4	3 1/4	378006	378106	344.40
8	1/2	3/4-16	.6890	1.1980	.7500	15°	2	.6930	1 3/8	3 3/8	378008	378108	376.95
10	5/8	7/8-14	.8060	1.3540	.7500	15°	2	.7860	1 5/8	3 5/8	378010	378110	426.30
12	3/4	1 1/16-12	.9810	1.6350	.7500	15°	2 1/4	.9110	1 7/8	4 1/8	378012	378112	459.90
14	7/8	1 3/16-12	1.1060	1.7750	.7500	15°	2 1/4	.9110	1 7/8	4 1/8	378014	378114	467.25
16	1	1 5/16-12	1.2310	1.9200	.7500	15°	2 1/4	.9110	1 7/8	4 1/8	378016	378116	502.95
20	1 1/4	1 5/8-12	1.5440	2.2800	1.0000	15°	2 1/4	.9110	2	4 1/4	378020	378120	538.65
24	1 1/2	1 7/8-12	1.7940	2.5700	1.0000	15°	2 1/4	.9110	2	4 1/4	378024	378124	681.45
32	2	2 1/2-12	2.4190	3.4900	1.0000	15°	2 1/4	.9110	2 1/4	4 1/2	378032	378132	865.20

CARBIDE TIPPED PORT CONTOUR CUTTERS



FILL IN BLANKS BELOW FOR ORDERING SPECIALS:

- A - REAMER DIAMETER _____
- B - SPOTFACE DIAMETER _____
- C - REAMER LENGTH _____
- D - HEAD LENGTH _____
- E - OVERALL LENGTH _____
- F - SEALING SEAT ANGLE _____



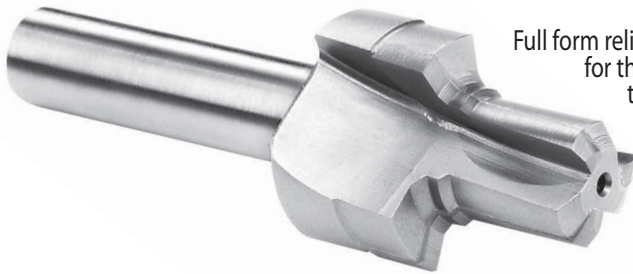
MS 33649 - INTEGRAL REAMER PILOT

TYPE 3792 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3793 - STRAIGHT SHANK - FOR STEEL

Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports.



TUBE			DIMENSIONS							N-F/CI TYPE 3792 EDP NO.	STEEL TYPE 3793 EDP NO.	BOTH TYPES PRICE
NO.	SIZE	THREAD SIZE	DIAMETER			LENGTH						
			REAMER	SPOTFACE	SHANK	SHANK	REAMER	HEAD	OVERALL			
1	1/16	1/4-28	.2150	.6500	.5000	2	.4070	1	3	379201	379301	\$409.50
2	1/8	5/16-24	.2750	.7420	.5000	2	.5820	1 1/8	3 3/8	379202	379302	409.50
3	3/16	3/8-24	.3390	.8050	.5000	2	.5880	1 1/4	3 1/4	379203	379303	388.50
4	1/4	7/16-20	.3930	.8880	.5000	2	.6610	1 1/4	3 1/4	379204	379304	399.00
5	5/16	1/2-20	.4550	.9500	.5000	2	.6610	1 1/4	3 1/4	379205	379305	409.50
6	3/8	9/16-18	.5120	1.0120	.5000	2	.7140	1 1/2	3 1/2	379206	379306	430.50
7	7/16	5/8-18	.5750	1.1050	.5000	2	.7300	1 1/2	3 1/2	379207	379307	441.00
8	1/2	3/4-16	.6930	1.2400	.7500	2	.8390	1 5/8	3 5/8	379208	379308	451.50
9	9/16	13/16-16	.7560	1.3020	.7500	2	.8550	1 5/8	3 5/8	379209	379309	462.00
10	5/8	7/8-14	.8100	1.4150	.7500	2 1/4	.9350	1 7/8	4 1/8	379210	379310	472.50
11	1 1/16	1-12	.9250	1.6020	.7500	2 1/4	1.0690	2 1/8	4 3/8	379211	379311	514.50
12	3/4	1 1/16-12	.9870	1.6650	.7500	2 1/4	1.0690	2 1/8	4 3/8	379212	379312	546.00
14	7/8	1 3/16-12	1.1120	1.7900	.7500	2 1/4	1.0690	2 1/8	4 3/8	379214	379314	577.50
16	1	1 1/4-12	1.2370	1.9650	.7500	2 1/4	1.0690	2 1/8	4 3/8	379216	379316	609.00
18	1 1/8	1 1/2-12	1.4250	2.0900	.7500	2 1/4	1.1210	2 1/4	4 1/2	379218	379318	656.25
20	1 1/4	1 5/8-12	1.5500	2.3100	1.0000	2 1/4	1.1210	2 1/4	4 1/2	379220	379320	703.50
24	1 1/2	1 7/8-12	1.8000	2.6000	1.0000	2 1/4	1.1320	2 1/4	4 1/2	379224	379324	819.00
28	1 3/4	2 1/4-12	2.1750	3.0500	1.0000	2 1/4	1.2480	2 1/4	4 1/2	379228	379328	1232.50
32	2	2 1/2-12	2.4250	3.5200	1.0000	2 1/2	1.3730	2 1/2	5	379232	379332	1401.90

CARBIDE TIPPED PORT CONTOUR CUTTERS

A.N.D. 10050 INTEGRAL REAMER PILOT

TYPE 3794 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3795 - STRAIGHT SHANK - FOR STEEL



Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.

TUBE			DIMENSIONS							N-F/CI TYPE 3794 EDP NO.	STEEL TYPE 3795 EDP NO.	BOTH TYPES PRICE
NO.	SIZE	THREAD SIZE	DIAMETER			LENGTH						
			REAMER	SPOTFACE	SHANK	SHANK	REAMER	HEAD	OVERALL			
1	1/16	1/4-28	.2110	.6500	.5000	2	.4500	1	3	379401	379501	\$408.30
2	1/8	5/16-24	.2710	.7420	.5000	2	.6090	1 1/8	3 1/8	379402	379502	408.30
3	3/16	3/8-24	.3330	.8050	.5000	2	.6090	1 1/4	3 1/4	379403	379503	426.30
4	1/4	7/16-20	.3860	.8880	.5000	2	.6870	1 1/4	3 1/4	379404	379504	426.30
5	5/16	1/2-20	.4490	.9500	.5000	2	.6870	1 1/4	3 1/4	379405	379505	444.15
6	3/8	9/16-18	.5060	1.0120	.5000	2	.7340	1 1/2	3 1/2	379406	379506	451.85
8	1/2	3/4-16	.6870	1.2400	.7500	2	.8590	1 5/8	3 5/8	379408	379508	480.20
10	5/8	7/8-14	.8020	1.4150	.7500	2 1/4	.9530	1 7/8	4 1/8	379410	379510	516.05
12	3/4	1 1/16-12	.9760	1.6650	.7500	2 1/4	1.0930	2 1/8	4 3/8	379412	379512	570.00
16	1	1 5/16-12	1.2260	1.9650	.7500	2 1/4	1.0930	2 1/2	4 3/8	379416	379516	767.75
20	1 1/4	1 3/8-12	1.5380	2.3100	1.0000	2 1/4	1.1400	2 1/4	4 1/2	379420	379520	975.80
24	1 1/2	1 7/8-12	1.7880	2.6000	1.0000	2 1/4	1.1400	2 1/4	4 1/2	379424	379524	1122.10
28	1 3/4	2 1/4-12	2.1630	3.0500	1.0000	2 1/4	1.2650	2 1/4	4 1/2	379428	379528	1232.50
32	2	2 1/2-12	2.4140	3.5200	1.0000	2 1/2	1.3900	2 1/2	5	379432	379532	1402.00

METRIC PORT REAMER PILOT SERIES

TYPE 3790 - TAPER SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3791 - TAPER SHANK - FOR STEEL



Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.

THREAD SIZE	DIMENSIONS							N-F/CI TYPE 3790 EDP NO.	STEEL TYPE 3791 EDP NO.	BOTH TYPES PRICE
	DIAMETER		TAPER SHANK NO.	SEALING SEAT ANGLE	LENGTH					
	REAMER	SPOTFACE			REAMER	HEAD	OVERALL			
M 8X1	.2770	.6690	2	12°	.5510	1 3/4	4 7/8	3790080	3791080	\$377.45
M 10X1	.3560	.7870	2	12°	.5510	1 3/4	4 7/8	3790100	3791100	393.55
M 12X1.5	.4150	.8660	2	15°	.6610	1 3/4	4 7/8	3790120	3791120	408.30
M 14X1.5	.4930	.9840	2	15°	.7200	1 3/4	4 7/8	3790140	3791140	423.70
M 16X1.5	.5720	1.0630	2	15°	.7200	1 3/4	4 7/8	3790160	3791160	448.70
M 18X1.5	.6510	1.1420	3	15°	.8110	1 7/8	5 3/4	3790180	3791180	463.40
M 20X1.5	.7300	1.2600	3	15°	.6890	2	5 7/8	3790200	3791200	480.20
M 22X1.5	.8080	1.3390	3	15°	.9370	2	5 7/8	3790220	3791220	502.60
M 27X2	.9850	1.5750	3	15°	1.0940	2 1/8	6	3790270	3791270	540.55
M 33X2	1.2210	1.8110	3	15°	1.0940	2 1/8	6	3790330	3791330	622.65
M 42X2	1.5760	2.2050	3	15°	1.0940	2 1/8	6	3790420	3791420	671.50
M 48X2	1.8120	2.5980	4	15°	1.0940	2 1/8	7	3790480	3791480	729.25
M 60X2	2.2840	2.9920	4	15°	1.0940	2 1/8	7	3790600	3791600	857.70

CARBIDE TIPPED PORT CONTOUR CUTTERS

S.A.E. PORTS - MS16142 - J514F - J1926

TYPE 3782 - TAPER SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3783 - TAPER SHANK - FOR STEEL



Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.

TUBE		DIMENSIONS								N-F/CI TYPE 3784 EDP NO.	STEEL TYPE 3785 EDP NO.	BOTH TYPES PRICE
NO.	SIZE	THREAD SIZE	DIAMETER		TAPER SHANK NO.	SEALING SEAT ANGLE	LENGTH					
			REAMER	SPOTFACE			REAMER	HEAD	OVERALL			
2	1/8	5/16-24	.2720	.6820	2	12°	.4730	1 5/8	4 3/4	378202	378302	\$333.90
3	3/16	3/8-24	.3350	.7600	2	12°	.4730	1 5/8	4 3/4	378203	378303	333.90
4	1/4	7/16-20	.3890	.8380	2	12°	.5520	1 5/8	4 3/4	378204	378304	333.90
5	5/16	1/2-20	.4520	.9160	2	12°	.5520	1 5/8	4 3/4	378205	378305	344.40
6	3/8	9/16-18	.5090	.9790	2	12°	.6140	1 5/8	4 3/4	378206	378306	344.40
8	1/2	3/4-16	.6890	1.1980	3	15°	.6930	1 3/4	5 5/8	378208	378308	376.95
10	5/8	7/8-14	.8060	1.3540	3	15°	.7860	1 7/8	5 3/4	378210	378310	426.30
12	3/4	1 1/16-12	.9810	1.6350	3	15°	.9110	2	5 7/8	378212	378312	459.90
14	7/8	1 3/16-12	1.1060	1.7750	3	15°	.9110	2	5 7/8	378214	378314	467.25
16	1	1 5/16-12	1.2310	1.9200	3	15°	.9110	2	5 7/8	378216	378316	502.95
20	1 1/4	1 5/8-12	1.5440	2.2800	4	15°	.9110	2 1/4	7 1/8	378220	378320	538.65
24	1 1/2	1 7/8-12	1.7940	2.5700	4	15°	.9110	2 1/4	7 1/8	378224	378324	681.45
32	2	2 1/2-12	2.4190	3.4900	4	15°	.9110	2 1/4	7 1/8	378232	378332	865.20

S.A.E. PORTS - MS16142 - J514F - J1926

TYPE 3784 - TAPER SHANK - EXTRA LENGTH REAMER - FOR NON-FERROUS & CAST IRON

TYPE 3785 - TAPER SHANK - EXTRA LENGTH REAMER - FOR STEEL



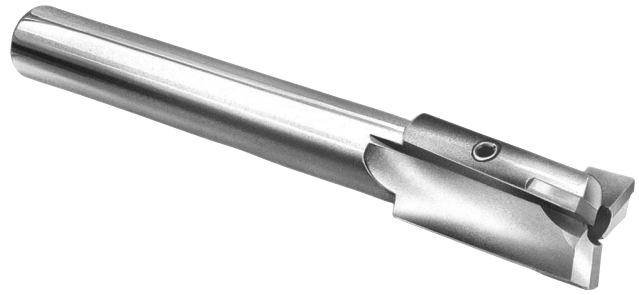
Carbide tips brazed to one piece heat treated steel bodies.

Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 25.

TUBE		DIMENSIONS								N-F/CI TYPE 3784 EDP NO.	STEEL TYPE 3785 EDP NO.	BOTH TYPES PRICE
NO.	SIZE	THREAD SIZE	DIAMETER		TAPER SHANK NO.	SEALING SEAT ANGLE	LENGTH					
			REAMER	SPOTFACE			REAMER	HEAD	OVERALL			
2	1/8	5/16-24	.2720	.6820	2	12°	.5800	1 3/4	4 7/8	378402	378502	\$351.75
3	3/16	3/8-24	.3350	.7600	2	12°	.5800	1 3/4	4 7/8	378403	378503	351.75
4	1/4	7/16-20	.3890	.8380	2	12°	.6900	1 3/4	4 7/8	378404	378504	351.75
5	5/16	1/2-20	.4520	.9160	2	12°	.6900	1 3/4	4 7/8	378405	378505	360.15
6	3/8	9/16-18	.5090	.9790	2	12°	.7500	1 3/4	4 7/8	378406	378506	360.15
8	1/2	3/4-16	.6890	1.1980	3	15°	.8400	2	5 7/8	378408	378508	395.85
10	5/8	7/8-14	.8060	1.3540	3	15°	.9700	2	5 7/8	378410	378510	448.35
12	3/4	1 1/16-12	.9810	1.6350	3	15°	1.1250	2 1/4	6 1/8	378412	378512	480.90
14	7/8	1 3/16-12	1.1060	1.7750	3	15°	1.1250	2 1/4	6 1/8	378414	378514	492.45
16	1	1 5/16-12	1.2310	1.9200	3	15°	1.1250	2 1/4	6 1/8	378416	378516	528.15
20	1 1/4	1 5/8-12	1.5440	2.2800	4	15°	1.1250	2 1/2	7 3/8	378420	378520	567.00
24	1 1/2	1 7/8-12	1.7940	2.5700	4	15°	1.1250	2 1/2	7 3/8	378424	378524	811.50
32	2	2 1/2-12	2.4190	3.4900	4	15°	1.1250	2 1/2	7 3/8	378432	378532	1019.40

FEEDS & SPEEDS CHART FOR COUNTERBORES

Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all safety shields and glasses before performing these operations.



$$\text{RPM} = \text{SFPM} * 3.82 / \text{Cutter Diameter}$$

CLASSIFICATION	MATERIAL	COUNTERBORING		FEED RATE (INCHES PER REVOLUTION) FINISHED HOLE DIAMETER IN INCHES					
		BRINELL	SFPM	¼	½	¾	1	1 ½	2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30-150*	750-900	.006	.006	.007	.007	.009	.010
	MAGNESIUM ALLOY	50-90*	875-1000	.006	.006	.007	.007	.009	.010
	LEAD	10-20*	875-1000	.006	.006	.007	.007	.009	.010
	NON-METAL AND PLASTIC	-	700-1200	.006	.006	.007	.007	.009	.010
	ZINC ALLOY - DIE CAST	80-100	700-850	.005	.005	.006	.006	.007	.009
NON-FERROUS (HARD)	ALUMINUM BRONZE	40-175	700-850	.006	.006	.007	.007	.009	.010
	BRASS ALLOY - LEADED AND FREE CUTTING	10-100Rb	850-1000	.006	.006	.007	.007	.009	.010
	CHROMIUM - NICKEL	10-100Rb	75-85	.003	.003	.003	.003	.004	.005
	COPPER ALLOY - TOUGH	40-200*	275-350	.005	.005	.006	.006	.007	.009
CAST IRON	DUCTILE CAST IRON - AUSTENITIC	120-275	85-110	.002	.002	.002	.002	.003	.004
	DUCTILE CAST IRON - FERRITIC	140-270	200-250	.006	.006	.007	.007	.009	.010
	DUCTILE CAST IRON - MARTENSITIC	270-400	75-95	.002	.002	.002	.002	.003	.004
	GRAY - PEARLITIC	220-320	125-200	.004	.004	.004	.005	.006	.007
	GRAY - FERRITIC	110-240	200-250	.004	.004	.004	.005	.006	.007
	MALLEABLE CAST IRON - MARTENSITIC	200-320	60-85	.004	.004	.004	.005	.006	.007
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100-250	200-250	.006	.006	.007	.007	.009	.010
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100-375	150-200	.006	.006	.007	.007	.009	.010
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100-275	145-185	.004	.004	.004	.005	.006	.007
	LOW AND MEDIUM CARBON ALLOY STEEL	85-375	130-165	.004	.004	.004	.005	.006	.007
	STAINLESS STEEL - 400 SERIES	135-325	150-200	.003	.003	.003	.003	.004	.005
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135-275	155-205	.003	.003	.003	.003	.004	.005
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175-400	90-135	.002	.002	.002	.002	.003	.003
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140-300	40-65	.002	.002	.002	.002	.003	.003
	STAINLESS STEEL - 300 SERIES	135-375	150-300	.003	.003	.003	.003	.004	.005
	STAINLESS STEEL - PH SERIES	150-440	115-175	.003	.003	.003	.003	.004	.005
	TITANIUM ALLOY	110-380	125-175	.002	.002	.002	.002	.003	.003

CARBIDE TIPPED CAPSCREW COUNTERBORES

TYPE 3513 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON

TYPE 3515 - STRAIGHT SHANK - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies. Right spiral smooth flutes. Integral pilot type.

Tools are designed with appropriate carbide grade and tool geometry for material being machined. The pilot is manufactured in nominal screw body diameters as well as 1/64" and 1/32" over size diameters.

Decimal sizes available upon request.



TOOL DIAMETER		PILOT DIAMETER	PILOT LENGTH	SHANK DIAMETER	OVERALL LENGTH	TYPE 3513 - NON-FERR/CI		PRICE EACH	TYPE 3515 - STEEL		PRICE EACH
DECIMAL	SCREW SIZE					NO. OF FLUTES	EDP NO.		NO. OF FLUTES	EDP NO.	
.3820	1/4	.2500	.3125	5/16	5 5/8	3	35132500	\$85.20	3	35152500	\$93.70
.3980	1/4	.2650	.3125	5/16	5 5/8	3	35132650	94.70	3	35152650	104.20
.4140	1/4	.2810	.3125	5/16	5 5/8	3	35132810	94.70	3	35152810	104.20
.4750	5/16	.3125	.3750	3/8	6 1/8	3	35133125	95.35	3	35153125	104.90
.4910	5/16	.3280	.3750	3/8	6 1/8	3	35133280	95.35	3	35153280	104.90
.5070	5/16	.3430	.3750	3/8	6 1/8	3	35133430	95.35	3	35153430	104.90
.5720	3/8	.3750	.5000	1/2	6 1/2	3	35133750	107.50	3	35153750	118.25
.5880	3/8	.3900	.5000	1/2	6 1/2	3	35133900	107.50	3	35153900	118.25
.6040	3/8	.4060	.5000	1/2	6 1/2	3	35134060	107.50	3	35154060	118.25
.6630	7/16	.4375	.5000	1/2	7	3	35134375	103.90	3	35154375	114.25
.6790	7/16	.4530	.5000	1/2	7	3	35134530	103.90	3	35154530	114.25
.6950	7/16	.4680	.5000	1/2	7	3	35134680	103.90	3	35154680	114.25
.7570	1/2	.5000	.5000	1/2	7 1/2	3	35135000	117.75	3	35155000	129.55
.7730	1/2	.5150	.5000	1/2	7 1/2	3	35135150	117.75	3	35155150	129.55
.7890	1/2	.5310	.5000	1/2	7 1/2	3	35135310	117.75	3	35155310	129.55
.8510	9/16	.5625	.5625	5/8	7 5/8	3	35135625	113.80	3	35155625	125.25
.8670	9/16	.5780	.5625	5/8	7 5/8	3	35135780	113.80	3	35155780	125.25
.8830	9/16	.5930	.5625	5/8	7 5/8	3	35135930	113.80	3	35155930	125.25
.9450	5/8	.6250	.6250	5/8	7 5/8	3	35136250	129.80	3	35156250	142.75
.9610	5/8	.6400	.6250	5/8	7 5/8	3	35136400	129.80	3	35156400	142.75
.9770	5/8	.6560	.6250	5/8	7 5/8	3	35136560	129.80	3	35156560	142.75
1.1330	3/4	.7500	.7500	3/4	7 3/4	3	35137500	127.90	3	35157500	140.70
1.1490	3/4	.7650	.7500	3/4	7 3/4	3	35137650	127.90	3	35157650	140.70
1.1650	3/4	.7810	.7500	3/4	7 3/4	3	35137810	127.90	3	35157810	140.70
1.3220	7/8	.8750	.8750	7/8	8 1/8	4	35138750	142.25	4	35158750	156.50
1.3380	7/8	.8910	.8750	7/8	8 1/8	4	35138910	142.25	4	35158910	156.50
1.3540	7/8	.9060	.8750	7/8	8 1/8	4	35139060	142.25	4	35159060	156.50
1.5100	1	1.0000	1.0000	1	8 1/2	4	35130000	162.80	4	35150000	179.10
1.5260	1	1.0150	1.0000	1	8 1/2	4	35130156	162.80	4	35150156	179.10
1.5420	1	1.0310	1.0000	1	8 1/2	4	35130313	162.80	4	35150313	179.10

TYPE 3513 - STRAIGHT SHANK - FOR NON-FERROUS & CAST IRON - METRIC

TYPE 3515 - STRAIGHT SHANK - FOR STEEL - METRIC

Same as above except metric sizes.

TOOL DIAMETER		PILOT DIAMETER	PILOT LENGTH	SHANK DIAMETER	OVERALL LENGTH	TYPE 3513 - NON-FERR/CI		PRICE EACH	TYPE 3515 - STEEL		PRICE EACH
SCREW SIZE mm	DECIMAL					NO. OF FLUTES	EDP NO.		NO. OF FLUTES	EDP NO.	
5	.3543	5.5	3/32	5/16	5 5/8	3	3513055	\$94.45	3	3515055	\$103.90
6	.4134	6.5	5/16	5/16	5 5/8	3	3513065	99.65	3	3515065	109.60
8	.5315	8.5	3/8	1/2	6 1/2	3	3513085	118.40	3	3515085	130.20
10	.6496	10.5	1/2	1/2	7	3	3513105	128.75	3	3515105	141.65
12	.7283	12.5	1/2	1/2	7 1/2	3	3513125	120.80	3	3515125	132.90
14	.8465	14.5	5/16	5/8	7 5/8	3	3513145	140.90	3	3515145	155.00
16	.9646	16.5	3/8	5/8	7 5/8	3	3513165	147.20	3	3515165	162.00
20	1.0039	20.5	3/4	7/8	8	3	3513205	136.55	3	3515205	150.20

CARBIDE TIPPED COUNTERBORES FOR NON-FERROUS & CAST IRON

TYPE 3512 - STRAIGHT SHANK - FOUR FLUTES

TYPE 3514 - STRAIGHT SHANK - THREE/FOUR FLUTES

Carbide tips brazed to hardened alloy steel bodies. Right spiral smooth flutes. Interchangeable pilot type.

Tools are designed with appropriate carbide grade and tool geometry for machining non-ferrous, cast iron and non-metals.



Tool diameter tolerance: +.001"/-.000".
Shank diameter tolerance: +.0000"/-.0005".

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	SHANK DIAM.	OVER ALL LEN.	TYPE 3512		TYPE 3514		BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION					NO. OF FLTS.	EDP NO.	NO. OF FLTS.	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	.114	3/32	15/64	3 13/16	-	-	3	351408	\$72.85	.2381 - .2530	\$113.90	\$93.40	\$86.55	\$83.15	\$79.70	\$76.90
.2812	9/32	.114	3/32	17/64	3 13/16	-	-	3	351409	89.05	.2531 - .2840	130.10	109.55	102.70	99.35	95.90	93.05
.3125	5/16	.114	3/32	19/64	3 13/16	-	-	3	351410	80.90	.2841 - .3150	121.95	101.45	94.60	91.20	87.75	84.95
.3438	11/32	.114	3/32	5/16	3 13/16	-	-	3	351411	102.30	.3151 - .3470	143.35	122.85	116.00	112.60	109.15	106.35
.3750	3/8	.182	5/32	5/16	4 1/16	-	-	3	351412	85.80	.3471 - .3780	123.60	104.70	98.40	95.25	92.10	89.50
.4062	13/32	.182	5/32	3/8	4 1/16	-	-	3	351413	96.75	.3781 - .4090	134.60	115.70	109.35	106.25	103.05	100.45
.4375	7/16	.182	5/32	3/8	4 1/16	-	-	3	351414	88.00	.4091 - .4410	125.85	106.90	100.60	97.50	94.30	91.70
.4688	15/32	.228	3/16	7/16	4 5/16	-	-	3	351415	107.45	.4411 - .4720	145.30	126.35	120.05	116.95	113.75	111.15
.5000	1/2	.228	3/16	7/16	4 5/16	4	351216	3	351416	97.65	.4721 - .5030	135.50	116.55	110.25	107.15	103.95	101.35
.5312	17/32	.228	3/16	1/2	4 5/16	4	351217	3	351417	110.55	.5031 - .5340	148.40	129.50	123.15	120.05	116.85	114.25
.5625	9/16	.228	3/16	1/2	4 5/16	4	351218	3	351418	100.55	.5341 - .5660	138.40	119.45	113.15	110.05	106.85	104.25
.5938	19/32	.228	3/16	1/2	5 1/8	4	351219	3	351419	111.65	.5661 - .5970	149.50	130.60	124.30	121.15	118.00	115.40
.6250	5/8	.228	3/16	1/2	5 1/8	4	351220	3	351420	101.50	.5971 - .6280	139.35	120.45	114.10	111.00	107.80	105.20
.6562	21/32	.228	3/16	1/2	5 1/8	4	351221	3	351421	118.20	.6281 - .6590	156.05	137.10	130.80	127.70	124.50	121.90
.6875	11/16	.228	3/16	1/2	5 1/8	4	351222	3	351422	107.50	.6591 - .6910	145.35	126.45	120.15	117.00	113.80	111.25
.7188	23/32	.290	1/4	1/2	5 3/8	4	351223	3	351423	121.00	.6911 - .7220	158.85	139.95	133.65	130.50	127.35	124.75
.7500	3/4	.290	1/4	1/2	5 3/8	4	351224	3	351424	109.95	.7221 - .7530	147.80	128.90	122.60	119.45	116.25	113.65
.7812	25/32	.290	1/4	5/8	5 3/8	4	351225	3	351425	123.55	.7531 - .7840	161.40	142.45	136.15	133.05	129.85	127.25
.8125	13/16	.290	1/4	5/8	5 3/8	4	351226	3	351426	112.25	.7841 - .8160	150.10	131.20	124.90	121.75	118.55	115.95
.8438	27/32	.290	1/4	3/4	5 3/8	4	351227	3	351427	130.90	.8161 - .8470	168.75	149.80	143.50	140.40	137.20	134.60
.8750	7/8	.290	1/4	3/4	5 3/8	4	351228	3	351428	119.00	.8471 - .8780	156.85	137.95	131.65	128.50	125.30	122.75
.9062	29/32	.290	1/4	3/4	6 1/8	4	351229	3	351429	133.55	.8781 - .9090	171.40	152.50	146.15	143.05	139.85	137.25
.9375	15/16	.290	1/4	3/4	6 1/8	4	351230	3	351430	121.45	.9091 - .9410	159.30	140.40	134.10	130.95	127.75	125.20
.9688	31/32	.353	5/16	3/4	6 3/8	4	351231	3	351431	137.40	.9411 - .9720	175.25	156.35	150.05	146.90	143.75	141.15
1.0000	1	.353	5/16	3/4	6 3/8	4	351232	3	351432	124.95	.9721 - 1.0030	162.80	143.85	137.55	134.45	131.25	128.65
1.0625	1 1/16	.353	5/16	3/4	6 3/8	4	351234	3	351434	126.30	1.0031 - 1.0660	164.15	145.20	138.90	135.80	132.60	130.00
1.1250	1 1/8	.353	5/16	1	6 3/8	4	351236	3	351436	129.50	1.0661 - 1.1280	167.30	148.40	142.10	139.00	135.80	133.20
1.1875	1 3/16	.353	5/16	1	6 3/8	4	351238	3	351438	135.25	1.1281 - 1.1905	173.10	154.20	147.90	144.75	141.55	139.00
1.2500	1 1/4	.426	3/8	1	6 3/8	-	-	4	351440	150.60	1.1906 - 1.2530	191.65	171.15	164.30	160.90	157.45	154.65
1.3125	1 5/16	.426	3/8	1	6 3/8	-	-	4	351442	162.60	1.2531 - 1.3155	203.65	183.15	176.30	172.90	169.45	166.65
1.3750	1 3/8	.426	3/8	1	6 3/8	-	-	4	351444	171.00	1.3156 - 1.3780	212.05	191.50	184.65	181.30	177.80	175.00
1.4375	1 7/16	.426	3/8	1 1/4	7 7/8	-	-	4	351446	187.40	1.3781 - 1.4405	232.05	209.75	202.30	198.60	194.85	191.80
1.5000	1 1/2	.426	3/8	1 1/4	7 7/8	-	-	4	351448	208.85	1.4406 - 1.5030	253.50	231.20	223.75	220.05	216.30	213.25
1.5625	1 5/8	.489	7/16	1 1/4	8 1/8	-	-	4	351450	215.00	1.5031 - 1.5660	259.60	237.30	229.85	226.20	222.40	219.35
1.6250	1 5/8	.489	7/16	1 1/4	8 1/8	-	-	4	351452	219.55	1.5661 - 1.6280	264.15	241.85	234.40	230.75	226.95	223.90
1.6875	1 11/16	.489	7/16	1 1/4	8 1/8	-	-	4	351454	262.60	1.6281 - 1.6910	310.80	286.70	278.70	274.70	270.65	267.35
1.7500	1 3/4	.489	7/16	1 1/4	8 1/8	-	-	4	351456	262.60	1.6911 - 1.7530	310.80	286.70	278.70	274.70	270.65	267.35
1.8125	1 13/16	.489	7/16	1 1/2	8 1/8	-	-	4	351458	310.90	1.7531 - 1.8160	359.10	335.00	326.95	323.00	318.95	315.65
1.8750	1 7/8	.489	7/16	1 1/2	8 1/8	-	-	4	351460	310.90	1.8161 - 1.8780	359.10	335.00	326.95	323.00	318.95	315.65
1.9375	1 15/16	.489	7/16	1 1/2	8 1/8	-	-	4	351462	339.80	1.8781 - 1.9410	388.00	363.90	355.90	351.90	347.85	344.55
2.0000	2	.551	1/2	1 1/2	8 3/8	-	-	4	351464	339.80	1.9411 - 2.0030	388.00	363.90	355.90	351.90	347.85	344.55

CARBIDE TIPPED AIRCRAFT/REDUCED SHANK COUNTERBORES

TYPE 3522 - STRAIGHT SHANK - THREE FLUTES

Carbide tips brazed to alloy steel bodies. Polished flutes.

For counterboring and spotfacing composites, non-metals, and non-ferrous materials used in airframe manufacturing.



Tool diameter tolerance: $+0.001''/-0.000''$.
Shank diameter tolerance: $+0.0000''/-0.0005''$.
Corner radius: $1/64''$.

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	NO. OF FLUTES	SMALL SHANK DIAM.	OVER ALL LENGTH	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.									1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	.125	3/32	3	1/4	2 3/8	352208	\$55.10	.2381 - .2530	\$93.65	\$74.40	\$67.95	\$64.80	\$61.55	\$58.90
.2812	9/32	.125	3/32	3	1/4	2 3/8	352209	55.20	.2531 - .2840	93.75	74.45	68.05	64.85	61.60	58.95
.3125	5/16	.125	3/32	3	1/4	2 3/8	352210	56.55	.2841 - .3150	95.10	75.85	69.40	66.25	62.95	60.35
.3438	11/32	.125	3/32	3	1/4	2 3/8	352211	57.70	.3151 - .3470	96.25	76.95	70.55	67.35	64.10	61.45
.3750	3/8	.125	3/32	3	1/4	2 3/8	352212	57.85	.3471 - .3780	96.40	77.10	70.70	67.50	64.25	61.60
.4062	13/32	.156	1/8	3	1/4	2 3/4	352213	65.75	.3781 - .4090	104.35	85.05	78.60	75.45	72.20	69.55
.4375	7/16	.156	1/8	3	1/4	2 3/4	352214	70.90	.4091 - .4410	109.45	90.20	83.75	80.60	77.35	74.70
.4688	15/32	.156	1/8	3	1/4	2 3/4	352215	72.10	.4411 - .4720	110.70	91.40	84.95	81.80	78.55	75.90
.5000	1/2	.156	1/8	3	1/4	2 3/4	352216	72.95	.4721 - .5030	111.50	92.25	85.80	82.65	79.40	76.75
.5312	17/32	.156	1/8	3	1/4	2 3/4	352217	73.35	.5031 - .5340	111.90	92.60	86.20	83.00	79.75	77.10
.5625	9/16	.156	1/8	3	1/4	2 3/4	352218	73.65	.5341 - .5660	112.20	92.90	86.50	83.30	80.05	77.40
.5938	19/32	.156	1/8	3	1/4	2 3/4	352219	74.10	.5661 - .5970	112.65	93.35	86.95	83.75	80.50	77.85
.6250	5/8	.156	1/8	3	1/4	2 3/4	352220	74.90	.5971 - .6280	113.50	94.20	87.75	84.60	81.35	78.70
.6562	21/32	.219	3/16	3	1/4	2 3/4	352221	83.25	.6281 - .6590	121.80	102.50	96.10	92.90	89.65	87.00
.6875	11/16	.219	3/16	3	1/4	2 3/4	352222	87.40	.6591 - .6910	125.95	106.65	100.25	97.05	93.80	91.15
.7188	23/32	.219	3/16	3	1/4	2 3/4	352223	90.35	.6911 - .7220	128.90	109.60	103.20	100.00	96.75	94.10
.7500	3/4	.219	3/16	3	1/4	2 3/4	352224	91.50	.7221 - .7530	130.05	110.75	104.35	101.15	97.90	95.25
.7812	25/32	.219	3/16	3	1/4	2 3/4	352225	91.85	.7531 - .7840	130.40	111.15	104.70	101.55	98.30	95.65
.8125	13/16	.219	3/16	3	1/4	2 3/4	352226	92.70	.7841 - .8160	131.25	111.95	105.55	102.35	99.10	96.45
.8438	27/32	.219	3/16	3	1/4	2 3/4	352227	93.30	.8161 - .8470	131.85	112.55	106.15	102.95	99.70	97.05
.8750	7/8	.219	3/16	3	1/4	2 3/4	352228	94.20	.8471 - .8780	132.75	113.50	107.05	103.85	100.60	98.00
.9062	29/32	.219	3/16	3	1/4	2 3/4	352229	94.90	.8781 - .9090	133.45	114.15	107.75	104.55	101.30	98.65
.9375	15/16	.219	3/16	3	1/4	2 3/4	352230	95.80	.9091 - .9410	134.35	115.05	108.65	105.45	102.20	99.55
.9688	31/32	.219	3/16	3	1/4	2 3/4	352231	96.40	.9411 - .9720	134.95	115.65	109.25	106.05	102.80	100.15
1.0000	1	.219	3/16	3	1/4	2 3/4	352232	96.70	.9721 - 1.0030	135.25	115.95	109.55	106.35	103.10	100.45
1.0625	1 1/16	.219	3/16	3	3/8	2 3/4	352234	123.40	1.0031 - 1.0660	161.95	142.65	136.25	133.05	129.80	127.15
1.1250	1 1/8	.219	3/16	3	3/8	2 3/4	352236	131.70	1.0661 - 1.1280	170.25	150.95	144.55	141.35	138.10	135.50
1.1875	1 3/16	.219	3/16	3	3/8	2 3/4	352238	133.35	1.1281 - 1.1905	171.90	152.65	146.20	143.05	139.80	137.15
1.2500	1 1/4	.281	1/4	3	3/8	2 3/4	352240	135.85	1.1906 - 1.2530	174.40	155.15	148.70	145.55	142.30	139.65
1.3125	1 5/16	.281	1/4	3	3/8	2 3/4	352242	138.35	1.2531 - 1.3155	176.90	157.65	151.20	148.00	144.75	142.15
1.3750	1 3/8	.281	1/4	3	3/8	2 3/4	352244	140.00	1.3156 - 1.3780	178.55	159.30	152.85	149.70	146.45	143.80
1.4375	1 7/16	.281	1/4	3	3/8	2 3/4	352246	141.65	1.3781 - 1.4405	180.25	160.95	154.55	151.35	148.10	145.45
1.5000	1 1/2	.281	1/4	3	3/8	2 3/4	352248	149.10	1.4406 - 1.5030	189.10	169.10	162.45	159.15	155.80	153.05
1.5625	1 9/16	.343	5/16	3	1/2	3 1/16	352250	165.90	1.5031 - 1.5660	205.90	185.90	179.20	175.95	172.55	169.80
1.6250	1 5/8	.343	5/16	3	1/2	3 1/16	352252	168.10	1.5661 - 1.6280	208.05	188.10	181.40	178.10	174.75	172.00
1.6875	1 11/16	.343	5/16	3	1/2	3 1/16	352254	170.30	1.6281 - 1.6910	210.25	190.30	183.60	180.30	176.95	174.20
1.7500	1 3/4	.343	5/16	3	1/2	3 1/16	352256	172.85	1.6911 - 1.7530	212.85	192.85	186.20	182.90	179.55	176.80
1.8125	1 13/16	.343	5/16	3	1/2	3 1/16	352258	174.90	1.7531 - 1.8160	214.60	194.60	187.90	184.65	181.25	178.50
1.8750	1 7/8	.343	5/16	3	1/2	3 1/16	352260	176.25	1.8161 - 1.8780	216.25	196.25	189.55	186.30	182.90	180.15
1.9375	1 15/16	.343	5/16	3	1/2	3 1/16	352262	194.45	1.8781 - 1.9410	234.40	214.40	207.75	204.45	201.10	198.35
2.0000	2	.343	5/16	3	1/2	3 1/16	352264	242.00	1.9411 - 2.0030	282.00	262.00	255.35	252.05	248.70	245.95

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CARBIDE TIPPED PIN DRIVE COUNTERBORES

TYPE 3573 - FOR NON-FERROUS & CAST IRON

Carbide tips brazed to hardened alloy steel bodies.

Tools are designed with appropriate carbide grade and tool geometry for machining non-ferrous, cast iron and non-metals.

TYPE 3574 - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies.

Tools are designed with appropriate carbide grade and tool geometry for machining steel and steel alloys.

Both types have 10° right spiral smooth flutes and accept short or long threaded shank pilots. For short shank pilots, see page 37. For long threaded shank pilots, contact us for price and availability. Pin drive shanks can also be used in straight shank holders or collets.



Tool diameter tolerance: +.001"/-.000".
Body length: 1 3/8".

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	PIN DRIVE NO.	SHANK DIAM.	NO. OF FLTS.	OVER ALL LENGTH	N-F/C.I. TYPE 3573 EDP NO.	STEEL TYPE 3574 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL											1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.5000	1/2	.2188	.1875	1	3/16	3	2 7/8	357316	357416	\$144.70	.4721 - .5030	\$214.30	\$179.55	\$167.90	\$162.15	\$156.35	\$151.50
.5625	9/16	.2188	.1875	1	3/16	3	2 7/8	357318	357418	144.70	.5341 - .5660	214.30	179.55	167.90	162.15	156.35	151.50
.6250	5/8	.2188	.1875	1	3/16	3	2 7/8	357320	357420	144.70	.5971 - .6280	214.30	179.55	167.90	162.15	156.35	151.50
.6875	11/16	.2969	.2500	1	3/16	3	2 7/8	357322	357422	135.95	.6591 - .6910	205.55	170.80	159.15	153.45	147.60	142.80
.7500	3/4	.2969	.2500	1	3/16	3	2 7/8	357324	357424	135.95	.7221 - .7530	205.55	170.80	159.15	153.45	147.60	142.80
.8125	13/16	.2969	.2500	1	3/16	4	2 7/8	357326	357426	135.95	.7841 - .8160	205.55	170.80	159.15	153.45	147.60	142.80
.8750	7/8	.2969	.2500	1	3/16	4	2 7/8	357328	357428	135.95	.8471 - .8780	205.55	170.80	159.15	153.45	147.60	142.80
.9375	15/16	.2969	.2500	1	3/16	4	2 7/8	357330	357430	139.05	.9091 - .9410	208.65	173.90	162.25	156.50	150.70	145.85
1.0000	1	.2969	.2500	1	3/16	4	2 7/8	357332	357432	141.60	.9721 - 1.0030	211.20	176.45	164.80	159.05	153.25	148.40
1.0625	1 1/16	.2969	.2500	1	3/16	4	2 7/8	357334	357434	156.50	1.0031 - 1.0660	226.15	191.35	179.70	174.00	168.15	163.35
1.0625	1 1/16	.3594	.3125	2	7/8	4	3	357335	357435	165.35	1.0031 - 1.0660	234.95	200.20	188.55	182.80	177.00	172.15
1.1250	1 1/8	.2969	.2500	1	3/16	4	2 7/8	357336	357436	156.50	1.0661 - 1.1280	226.15	191.35	179.70	174.00	168.15	163.35
1.1250	1 1/8	.3594	.3125	2	7/8	4	3	357337	357437	165.35	1.0661 - 1.1280	234.95	200.20	188.55	182.80	177.00	172.15
1.1875	1 3/16	.3594	.3125	2	7/8	4	3	357338	357438	171.45	1.1281 - 1.1905	241.05	206.30	194.65	188.90	183.10	178.25
1.2500	1 1/4	.3594	.3125	2	7/8	4	3	357340	357440	171.45	1.1906 - 1.2530	241.05	206.30	194.65	188.90	183.10	178.25
1.3125	1 3/16	.3594	.3125	2	7/8	4	3	357342	357442	174.15	1.2531 - 1.3155	243.80	209.05	197.40	191.65	185.80	181.00
1.3750	1 3/8	.3594	.3125	2	7/8	4	3	357344	357444	174.15	1.3156 - 1.3780	243.80	209.05	197.40	191.65	185.80	181.00
1.4375	1 7/16	.3594	.3125	2	7/8	4	3	357346	357446	182.90	1.3781 - 1.4405	252.50	217.75	206.10	200.40	194.55	189.75
1.5000	1 1/2	.3594	.3125	2	7/8	4	3	357348	357448	191.90	1.4406 - 1.5030	261.55	226.75	215.10	209.40	203.55	198.75
1.5625	1 5/8	.3594	.3125	2	7/8	4	3	357350	357450	206.40	1.5031 - 1.5660	276.00	241.25	229.60	223.85	218.05	213.20
1.6250	1 3/4	.3594	.3125	2	7/8	4	3	357352	357452	215.40	1.5661 - 1.6280	285.00	250.25	238.60	232.85	227.05	222.20
1.6875	1 11/16	.3594	.3125	2	7/8	4	3	357354	357454	224.20	1.6281 - 1.6910	293.85	259.10	247.45	241.70	235.85	231.05
1.7500	1 3/4	.3594	.3125	2	7/8	4	3	357356	357456	236.15	1.6911 - 1.7530	305.75	271.00	259.35	253.60	247.80	242.95
1.7500	1 3/4	.4844	.4375	3	1 1/4	6	3 1/16	357357	357457	268.80	1.6911 - 1.7530	338.45	303.65	292.00	286.30	280.45	275.65
1.8750	1 7/8	.4844	.4375	3	1 1/4	6	3 1/16	357360	357460	268.80	1.8161 - 1.8780	338.45	303.65	292.00	286.30	280.45	275.65
2.0000	2	.4844	.4375	3	1 1/4	6	3 1/16	357364	357464	304.20	1.9411 - 2.0030	373.85	339.05	327.40	321.70	315.85	311.05
2.1250	2 1/8	.4844	.4375	3	1 1/4	6	3 1/16	357368	357468	312.70	2.0661 - 2.1280	382.30	347.55	335.90	330.15	324.30	319.50
2.2500	2 1/4	.4844	.4375	3	1 1/4	6	3 1/16	357372	357472	324.60	2.1906 - 2.2530	394.20	359.45	347.80	342.05	336.25	331.40
2.3750	2 3/8	.4844	.4375	3	1 1/4	6	3 1/16	357376	357476	351.00	2.3156 - 2.3780	420.60	385.85	374.20	368.45	362.65	357.80
2.5000	2 1/2	.5625	.5000	3	1 1/4	6	3 1/16	357380	357480	377.45	2.4406 - 2.5030	447.10	412.30	400.65	394.95	389.10	384.30
2.7500	2 3/4	.5625	.5000	3	1 1/4	6	3 1/16	357388	357488	418.95	2.6911 - 2.7530	488.60	453.80	442.15	436.45	430.60	425.80
3.0000	3	.5625	.5000	3	1 1/4	6	3 1/16	357396	357496	442.70	2.9411 - 3.0030	512.35	477.55	465.90	460.20	454.35	449.55

CARBIDE TIPPED STUB TAPER SHANK COUNTERBORES

TYPE 3575 - FOR NON-FERROUS & CAST IRON

Carbide tips brazed to hardened alloy steel bodies.

Tools are designed with appropriate carbide grade and tool geometry for machining non-ferrous, cast iron and non-metals.

TYPE 3576 - FOR STEEL

Carbide tips brazed to hardened alloy steel bodies.

Tools are designed with appropriate carbide grade and tool geometry for machining steel and steel alloys.

Both types have 10° right spiral smooth flutes and accept only short shank pilots (see page 37).



Tool diameter tolerance: +.001"/-.000".

Stub taper dimensions conform to ASME/ANSI B5.10 specifications.

Body length = 1 1/4" thru 1.9410" tool diameter.

= 1 1/2" above 1.9410" tool diameter.

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	STUB TAPER NO.	NO. OF FLTS.	OVER ALL LENGTH	N-F/C.I. TYPE 3575 EDP NO.	STEEL TYPE 3576 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL										1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.5000	1/2	.2188	.1875	1	3	2 1/16	357516	357616	175.90	.4721 - .5030	\$242.80	\$209.40	\$198.20	\$192.65	\$187.10	\$182.45
.5625	9/16	.2188	.1875	1	3	2 1/16	357518	357618	175.90	.5341 - .5660	242.80	209.40	198.20	192.65	187.10	182.45
.6250	5/8	.2188	.1875	1	3	2 1/16	357520	357620	175.90	.5971 - .6280	242.80	209.40	198.20	192.65	187.10	182.45
.6875	11/16	.2188	.1875	1	3	2 1/16	357522	357622	175.90	.6591 - .6910	242.80	209.40	198.20	192.65	187.10	182.45
.7500	3/4	.2969	.2500	2	4	2 7/8	357524	357624	164.85	.7221 - .7530	231.80	198.35	187.15	181.65	176.05	171.40
.8125	13/16	.2969	.2500	2	4	2 7/8	357526	357626	164.85	.7841 - .8160	231.80	198.35	187.15	181.65	176.05	171.40
.8750	7/8	.2969	.2500	2	4	2 7/8	357528	357628	164.85	.8471 - .8780	231.80	198.35	187.15	181.65	176.05	171.40
.9375	15/16	.2969	.2500	2	4	2 7/8	357530	357630	159.00	.9091 - .9410	225.95	192.50	181.30	175.80	170.20	165.55
1.0000	1	.3594	.3125	2	4	2 7/8	357532	357632	159.00	.9721 - 1.0030	225.95	192.50	181.30	175.80	170.20	165.55
1.0625	1 1/16	.3594	.3125	2	4	2 7/8	357534	357634	159.00	1.0031 - 1.0660	225.95	192.50	181.30	175.80	170.20	165.55
1.1250	1 1/8	.3594	.3125	2	4	2 7/8	357536	357636	159.00	1.0661 - 1.1280	225.95	192.50	181.30	175.80	170.20	165.55
1.1875	1 3/16	.3594	.3125	2	4	2 7/8	357538	357638	164.85	1.1281 - 1.1905	231.80	198.35	187.15	181.65	176.05	171.40
1.2500	1 1/4	.3594	.3125	2	4	2 7/8	357540	357640	164.85	1.1906 - 1.2530	231.80	198.35	187.15	181.65	176.05	171.40
1.3125	1 5/16	.3594	.3125	2	4	2 7/8	357542	357642	167.45	1.2531 - 1.3155	234.40	201.00	189.80	184.30	178.65	174.05
1.3750	1 3/8	.3594	.3125	2	4	2 7/8	357544	357644	184.55	1.3156 - 1.3780	251.45	218.05	206.85	201.35	195.75	191.10
1.4375	1 7/16	.3594	.3125	2	4	2 7/8	357546	357646	201.50	1.3781 - 1.4405	268.45	235.05	223.85	218.30	212.70	208.10
1.5000	1 1/2	.3594	.3125	2	4	2 7/8	357548	357648	218.50	1.4406 - 1.5030	285.45	252.00	240.80	235.30	229.70	225.05
1.5625	1 5/8	.4844	.4375	3	6	3 3/16	357550	357650	232.65	1.5031 - 1.5660	299.60	266.20	254.95	249.45	243.85	239.20
1.6250	1 5/8	.4844	.4375	3	6	3 3/16	357552	357652	261.00	1.5661 - 1.6280	327.95	294.55	283.30	277.80	272.20	267.55
1.6875	1 11/16	.4844	.4375	3	6	3 3/16	357554	357654	283.70	1.6281 - 1.6910	350.60	317.20	306.00	300.45	294.90	290.25
1.7500	1 3/4	.4844	.4375	3	6	3 3/16	357556	357656	306.35	1.6911 - 1.7530	373.30	339.85	328.65	323.15	317.55	312.90
1.8125	1 13/16	.4844	.4375	3	6	3 3/16	357558	357658	323.50	1.7531 - 1.8160	390.45	357.00	345.80	340.30	334.70	330.05
1.8750	1 7/8	.4844	.4375	3	6	3 3/16	357560	357660	340.40	1.8161 - 1.8780	407.30	373.90	362.70	357.20	351.55	346.95
1.9375	1 15/16	.4844	.4375	3	6	3 3/16	357562	357662	357.55	1.8781 - 1.9410	424.45	391.05	379.85	374.30	368.70	364.10
2.0000	2	.5625	.5000	4	6	3 3/4	357564	357664	374.40	1.9411 - 2.0030	441.35	407.95	396.70	391.20	385.60	380.95
2.1250	2 1/8	.5625	.5000	4	6	3 3/4	357568	357668	385.80	2.0661 - 2.1280	452.75	419.30	408.10	402.60	397.00	392.35
2.2500	2 1/4	.5625	.5000	4	6	3 3/4	357572	357672	396.90	2.1906 - 2.2530	463.85	430.40	419.20	413.70	408.10	403.45
2.3750	2 3/8	.5625	.5000	4	6	3 3/4	357576	357676	411.35	2.3156 - 2.3780	478.25	444.85	433.65	428.15	422.55	417.90
2.5000	2 1/2	.5625	.5000	4	6	3 3/4	357580	357680	425.70	2.4406 - 2.5030	492.60	459.20	448.00	442.50	436.90	432.25
2.7500	2 3/4	.5625	.5000	4	6	3 3/4	357588	357688	448.25	2.6911 - 2.7530	515.20	481.75	470.55	465.05	459.45	454.80
3.0000	3	.5625	.5000	4	6	3 3/4	357596	357696	470.85	2.9411 - 3.0030	537.75	504.35	493.15	487.65	482.05	477.40

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*Quantities of 15 or more: price of fractional size in same size range.

Made in U.S.A.

SOLID CARBIDE HEAD REAMERS

TYPE 3801 - STRAIGHT STEEL SHANK - STRAIGHT FLUTES - FOR NON-FERROUS
TYPE 3800 - STRAIGHT STEEL SHANK - STRAIGHT FLUTES - FOR CAST IRON & STEEL

Solid carbide head brazed to hardened alloy steel shank on tool diameters .1911" and larger.
 Solid carbide head and shank on diameters .1910" and below.
 Tool geometry appropriate for material being machined.

We recommend our Carbide Tipped Reamers Type 3480 (page 68) or Type 3459 (page 84) for better performance when reaming cast steels and tough steel alloys. The carbide grade and tool geometry are appropriate for these materials.



Tool diameter tolerance thru .2500": +.0002"/-.0000" .
 over .2500": +.0003"/-.0000".

Shank diameter tolerance: +.0000"/-.0010".

For closer tool diameter tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLUTES	LENGTH		NON-FERR. TYPE 3801 EDP NO.	C.I./STEEL TYPE 3800 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLUTE	OAL					1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
-	.*	.0800	4	3/4	3	-	380099	-	.0811 - .0890	\$68.85	\$50.85	\$44.85	\$41.95	\$38.90	\$36.45
.0938	3/32*	.0880	4	3/4	3	-	380006	\$32.95	.0891 - .0970	68.85	50.85	44.85	41.95	38.90	36.45
.1094	7/64*	.0943	4	7/8	3 1/2	-	380007	32.95	.0971 - .1120	68.85	50.85	44.85	41.95	38.90	36.45
.1250	1/8*	.1099	4	7/8	3 1/2	380108	380008	32.95	.1121 - .1280	68.85	50.85	44.85	41.95	38.90	36.45
.1406	9/64*	.1255	4	7/8	3 1/2	380109	380009	37.65	.1281 - .1435	73.55	55.55	49.55	46.65	43.60	41.15
.1562	5/32*	.1411	4	1	4	380110	380010	38.75	.1436 - .1590	74.70	56.65	50.65	47.80	44.70	42.25
.1719	11/64*	.1567	4	1	4	380111	380011	43.65	.1591 - .1750	79.60	61.60	55.55	52.70	49.60	47.20
.1875	3/16*	.1724	4	1 1/8	4 1/2	380112	380012	44.60	.1751 - .1910	80.55	62.55	56.50	53.65	50.55	48.15
.2031	13/64	.1880	6	1 1/4	5	380113	380013	47.55	-	-	-	-	-	-	-
.2188	7/32	.1880	6	1 1/4	5	380114	380014	47.55	.1911 - .2210	83.50	65.50	59.45	56.60	53.50	51.10
.2344	15/64	.2193	6	1 1/2	6	380115	380015	50.55	-	-	-	-	-	-	-
.2500	1/4	.2193	6	1 1/2	6	380116	380016	50.55	.2211 - .2530	86.50	68.50	62.50	59.60	56.50	54.10
.2656	17/64	.2505	6	1 1/2	6	380117	380017	54.40	-	-	-	-	-	-	-
.2812	9/32	.2505	6	1 1/2	6	380118	380018	54.40	.2531 - .2840	90.35	72.30	66.30	63.45	60.35	57.90
.2969	19/64	.2817	6	1 5/8	6	380119	380019	56.60	-	-	-	-	-	-	-
.3125	5/16	.2817	6	1 5/8	6	380120	380020	56.60	.2841 - .3150	92.55	74.55	68.50	65.65	62.55	60.10
.3281	21/64	.3130	6	1 5/8	6	380121	380021	60.50	-	-	-	-	-	-	-
.3438	11/32	.3130	6	1 5/8	6	380122	380022	60.50	.3151 - .3470	96.45	78.40	72.40	69.55	66.45	64.00
.3594	23/64	.3443	6	1 3/4	7	380123	380023	65.10	-	-	-	-	-	-	-
.3750	3/8	.3443	6	1 3/4	7	380124	380024	65.10	.3471 - .3780	101.05	83.05	77.05	74.15	71.05	68.65
.3906	25/64	.3755	6	1 3/4	7	380125	380025	74.40	-	-	-	-	-	-	-
.4062	13/32	.3755	6	1 3/4	7	380126	380026	74.40	.3781 - .4090	110.30	92.30	86.30	83.40	80.35	77.90
.4219	27/64	.4067	6	1 3/4	7	380127	380027	79.00	-	-	-	-	-	-	-
.4375	7/16	.4067	6	1 3/4	7	380128	380028	79.00	.4091 - .4410	114.95	96.95	90.90	88.05	84.95	82.55
.4531	29/64	.4380	6	1 3/4	8	380129	380029	83.80	-	-	-	-	-	-	-
.4688	15/32	.4380	6	1 3/4	8	380130	380030	83.80	.4411 - .4720	119.75	101.70	95.70	92.85	89.75	87.30
.4844	31/64	.4693	6	1 3/4	8	380131	380031	89.95	-	-	-	-	-	-	-
.5000	1/2	.4693	6	1 3/4	8	380132	380032	89.95	.4721 - .5030	125.90	107.90	101.85	99.00	95.90	93.50
.5156	33/64	.5005	6	1 7/8	9	380133	380033	116.00	-	-	-	-	-	-	-
.5312	17/32	.5005	6	1 7/8	9	380134	380034	116.00	.5031 - .5340	151.90	133.90	127.90	125.00	121.95	119.50
.5469	35/64	.5005	6	1 7/8	9	380135	380035	136.95	-	-	-	-	-	-	-
.5625	9/16	.5005	6	1 7/8	9	380136	380036	136.95	.5341 - .5660	172.85	154.85	148.85	145.95	142.90	140.45
.5781	37/64	.5630	6	1 7/8	9	380137	380037	155.40	-	-	-	-	-	-	-
.5938	19/32	.5630	6	1 7/8	9	380138	380038	155.40	.5661 - .5970	191.30	173.30	167.30	164.40	161.35	158.90
.6094	39/64	.5630	6	1 7/8	9	380139	380039	157.15	-	-	-	-	-	-	-
.6250	5/8	.5630	6	1 7/8	9	380140	380040	157.15	.5971 - .6280	193.10	175.10	169.05	166.20	163.10	160.65

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SOLID CARBIDE HEAD SPIRAL REAMERS

TYPE 3811 - STRAIGHT STEEL SHANK - RIGHT SPIRAL FLUTES - FOR NON-FERROUS
TYPE 3810 - STRAIGHT STEEL SHANK - RIGHT SPIRAL FLUTES - FOR CAST IRON & STEEL

Solid carbide head brazed to hardened alloy steel shank on tool diameters of .1911" and larger. Tool geometry appropriate for material being machined.

Ground with spiral flutes for reaming blind holes with interruptions such as keyways, slots or intersecting holes.



TYPE 3821 - STRAIGHT STEEL SHANK - LEFT SPIRAL FLUTES - FOR NON-FERROUS
TYPE 3820 - STRAIGHT STEEL SHANK - LEFT SPIRAL FLUTES - FOR CAST IRON & STEEL

Same as Types 3810 & 3811, except left spiral flutes. Used in through holes only.



ALL TYPES ON THIS PAGE:

Tool diameter tolerance thru .2500": +.0002"/-.0000".
 over .2500": +.0003"/-.0000".

Shank diameter tolerance: +.0000"/-.0010".

For closer tool diameter tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		RIGHT SPIRAL		LEFT SPIRAL		ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRAC.			FLT	OAL	NON-FERR. TYPE 3811 EDP NO.	C.I./STEEL TYPE 3810 EDP NO.	NON-FERR. TYPE 3821 EDP NO.	C.I./STEEL TYPE 3820 EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.1250	1/8*	.1099	4	7/8	3 1/2	381108	381008	382108	382008	\$40.15	.1121 - .1280	\$76.05	\$58.05	\$52.05	\$49.15	\$46.10	\$43.65
.1406	9/64*	.1255	4	7/8	3 1/2	381109	381009	382109	382009	45.85	.1281 - .1435	81.80	63.80	57.75	54.90	51.80	49.40
.1562	5/32*	.1411	4	1	4	381110	381010	382110	382010	47.25	.1436 - .1590	83.20	65.20	59.15	56.30	53.20	50.80
.1719	11/64*	.1567	4	1	4	381111	381011	382111	382011	53.30	.1591 - .1750	89.25	71.20	65.20	62.35	59.25	56.80
.1875	3/16*	.1724	4	1 1/8	4 1/2	381112	381012	382112	382012	54.40	.1751 - .1910	90.35	72.30	66.30	63.45	60.35	57.90
.2031	13/64	.1880	6	1 1/4	5	381113	381013	382113	382013	57.90	-	-	-	-	-	-	-
.2188	7/32	.1880	6	1 1/4	5	381114	381014	382114	382014	57.90	.1911 - .2210	93.85	75.85	69.80	66.95	63.85	61.45
.2344	15/64	.2193	6	1 1/2	6	381115	381015	382115	382015	61.65	-	-	-	-	-	-	-
.2500	1/4	.2193	6	1 1/2	6	381116	381016	382116	382016	61.65	.2211 - .2530	97.60	79.60	73.55	70.70	67.60	65.20
.2656	17/64	.2505	6	1 1/2	6	381117	381017	382117	382017	66.30	-	-	-	-	-	-	-
.2812	9/32	.2505	6	1 1/2	6	381118	381018	382118	382018	66.30	.2531 - .2840	102.25	84.25	78.20	75.35	72.25	69.80
.2969	19/64	.2817	6	1 5/8	6	381119	381019	382119	382019	69.00	-	-	-	-	-	-	-
.3125	5/16	.2817	6	1 5/8	6	381120	381020	382120	382020	69.00	.2841 - .3150	104.95	86.95	80.90	78.05	74.95	72.55
.3281	21/64	.3130	6	1 5/8	6	381121	381021	382121	382021	73.70	-	-	-	-	-	-	-
.3438	11/32	.3130	6	1 5/8	6	381122	381022	382122	382022	73.70	.3151 - .3470	109.65	91.65	85.65	82.75	79.65	77.25
.3594	23/64	.3443	6	1 3/4	7	381123	381023	382123	382023	79.40	-	-	-	-	-	-	-
.3750	3/8	.3443	6	1 3/4	7	381124	381024	382124	382024	79.40	.3471 - .3780	115.30	97.30	91.30	88.40	85.35	82.90
.3906	25/64	.3755	6	1 3/4	7	381125	381025	382125	382025	90.70	-	-	-	-	-	-	-
.4062	13/32	.3755	6	1 3/4	7	381126	381026	382126	382026	90.70	.3781 - .4090	126.65	108.65	102.60	99.75	96.65	94.25
.4219	27/64	.4067	6	1 3/4	7	381127	381027	382127	382027	96.30	-	-	-	-	-	-	-
.4375	7/16	.4067	6	1 3/4	7	381128	381028	382128	382028	96.30	.4091 - .4410	132.25	114.20	108.20	105.35	102.25	99.80
.4531	29/64	.4380	6	1 3/4	8	381129	381029	382129	382029	102.15	-	-	-	-	-	-	-
.4688	15/32	.4380	6	1 3/4	8	381130	381030	382130	382030	102.15	.4411 - .4720	138.10	120.10	114.05	111.20	108.10	105.70
.4844	31/64	.4693	6	1 3/4	8	381131	381031	382131	382031	109.60	-	-	-	-	-	-	-
.5000	1/2	.4693	6	1 3/4	8	381132	381032	382132	382032	109.60	.4721 - .5030	145.55	127.50	121.50	118.65	115.55	113.10
.5156	33/64	.5005	6	1 7/8	9	381133	381033	382133	382033	141.35	-	-	-	-	-	-	-
.5312	17/32	.5005	6	1 7/8	9	381134	381034	382134	382034	141.35	.5031 - .5340	177.30	159.25	153.25	150.40	147.30	144.85
.5469	35/64	.5005	6	1 7/8	9	381135	381035	382135	382035	166.90	-	-	-	-	-	-	-
.5625	9/16	.5005	6	1 7/8	9	381136	381036	382136	382036	166.90	.5341 - .5660	202.85	184.85	178.85	175.95	172.85	170.45
.5781	37/64	.5630	6	1 7/8	9	381137	381037	382137	382037	189.40	-	-	-	-	-	-	-
.5938	19/32	.5630	6	1 7/8	9	381138	381038	382138	382038	189.40	.5661 - .5970	225.35	207.35	201.30	198.45	195.35	192.95
.6094	39/64	.5630	6	1 7/8	9	381139	381039	382139	382039	191.60	-	-	-	-	-	-	-
.6250	5/8	.5630	6	1 7/8	9	381140	381040	382140	382040	191.60	.5971 - .6280	227.55	209.55	203.50	200.65	197.55	195.15

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*Solid carbide head and shank (.0811" - .1910" tool diameters). **Quantities of 15 or more: price of fractional size in same size range.

Made in U.S.A.

SOLID CARBIDE CHUCKING REAMERS

TYPE 3801 - LONG LENGTH - STRAIGHT SHANK - STRAIGHT FLUTES - FOR NON-FERROUS
TYPE 3800 - LONG LENGTH - STRAIGHT SHANK - STRAIGHT FLUTES - FOR CAST IRON & STEEL

Extended length series solid carbide chucking reamers. Tool geometry appropriate for material being machined.



Tool diameter tolerance +.0002"/-.0000".
 Shank diameter tolerance: +.0000"/-.0010".
 For closer tool diameter tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLUTES	LENGTH		NON-FERR. TYPE 3801 EDP NO.	C.I./STEEL TYPE 3800 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLUTE	OAL					1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
-	-	.0800	4	3/4	3	-	380099	-	.0811 - .0890	\$68.85	\$50.85	\$44.85	\$41.95	\$38.90	\$36.45
.0938	3/32	.0880	4	3/4	3	-	380006	\$32.95	.0891 - .0970	68.85	50.85	44.85	41.95	38.90	36.45
.1094	7/64	.0943	4	7/8	3 1/2	-	380007	32.95	.0971 - .1120	68.85	50.85	44.85	41.95	38.90	36.45
.1250	1/8	.1099	4	7/8	3 1/2	380108	380008	32.95	.1121 - .1280	68.85	50.85	44.85	41.95	38.90	36.45
.1406	9/64	.1255	4	7/8	3 1/2	380109	380009	37.65	.1281 - .1435	73.55	55.55	49.55	46.65	43.60	41.15
.1562	5/32	.1411	4	1	4	380110	380010	38.75	.1436 - .1590	74.70	56.65	50.65	47.80	44.70	42.25
.1719	11/64	.1567	4	1	4	380111	380011	43.65	.1591 - .1750	79.60	61.60	55.55	52.70	49.60	47.20
.1875	3/16	.1724	4	1 1/8	4 1/2	380112	380012	44.60	.1751 - .1910	80.55	62.55	56.50	53.65	50.55	48.15

*Quantities of 15 or more: price of fractional size in same size range.

TYPE 3803 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR NON-FERROUS
TYPE 3802 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR CAST IRON & STEEL

Short series solid carbide head and shank. Tool geometry appropriate for material being machined.
 For stocked general purpose reamers in decimal sizes and .0005" increments (Type 3804), see pages 44-48.



Tool diameter tolerance thru .2500": +.0002"/-.0000".
 over .2500": +.0003"/.0000".
 Shank diameter tolerance: +.0000"/-.0010".
 For closer tool diameter tolerance pricing, see page 50.

DECIMAL SIZE RANGE	MAX. SHANK DIAMETER	NO. OF FLUTES	LENGTH		NON-FERR. TYPE 3803 EDP NO.	C.I./STEEL TYPE 3802 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
			FLUTE	OAL			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.0591 - .0660	.0580	4	3/8	1 1/2	-	380204	\$71.65	\$44.60	\$35.55	\$31.30	\$26.70	\$23.00	\$17.70
.0661 - .0740	.0650	4	1/2	1 3/4	-	380245	71.90	44.85	35.80	31.55	26.90	23.25	17.95
.0741 - .0810	.0730	4	1/2	1 3/4	-	380205	71.95	44.90	35.85	31.60	26.95	23.30	18.00
.0811 - .0890	.0800	4	1/2	2	-	380255	72.45	45.40	36.40	32.10	27.50	23.80	18.50
.0891 - .0970	.0880	4	1/2	2	-	380206	72.85	45.80	36.75	32.50	27.85	24.20	18.90
.0971 - .1120	.0943	4	5/8	2 1/4	380307	380207	73.15	46.10	37.05	32.80	28.15	24.50	19.20
.1121 - .1280	.1099	4	5/8	2 1/4	380308	380208	74.40	47.35	38.30	34.05	29.40	25.70	20.45
.1281 - .1435	.1255	4	3/4	2 1/2	380309	380209	74.95	47.90	38.90	34.60	30.00	26.30	21.00
.1436 - .1590	.1411	4	3/4	2 1/2	380310	380210	76.20	49.15	40.15	35.85	31.25	27.55	22.25
.1591 - .1750	.1567	4	7/8	2 3/4	380311	380211	79.10	52.05	43.00	38.75	34.10	30.45	25.15
.1751 - .1910	.1724	4	7/8	2 3/4	380312	380212	81.00	53.95	44.90	40.65	36.00	32.35	27.05
.1911 - .2210	.1880	6	1	3	380314	380214	84.40	57.35	48.30	44.05	39.40	35.70	30.45
.2211 - .2530	.2193	6	1	3	380316	380216	90.10	63.05	54.00	49.75	45.15	41.45	36.15
.2531 - .2840	.2505	6	1 1/8	3 1/4	380318	380218	96.80	69.75	60.70	56.45	51.80	48.15	42.85
.2841 - .3150	.2817	6	1 1/8	3 1/4	380320	380220	104.15	77.10	68.05	63.80	59.15	55.50	50.20
.3151 - .3470	.3130	6	1 1/4	3 1/2	380322	380222	115.10	88.05	79.00	74.75	70.10	66.45	61.15
.3471 - .3780	.3443	6	1 1/4	3 1/2	380324	380224	116.55	89.50	80.50	76.20	71.60	67.90	62.60
.3781 - .4090	.3755	6	1 3/8	3 3/4	380326	380226	126.20	99.15	90.10	85.85	81.20	77.55	72.25
.4091 - .4410	.4067	6	1 3/8	3 3/4	380328	380228	127.25	100.20	91.15	86.90	82.25	78.55	73.30
.4411 - .4720	.4380	6	1 1/2	4	380330	380230	135.00	107.95	98.95	94.65	90.05	86.35	81.05
.4721 - .5150	.4693	6	1 1/2	4	380332	380232	142.50	115.45	106.45	102.15	97.55	93.85	88.55

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SOLID CARBIDE SPIRAL CHUCKING REAMERS

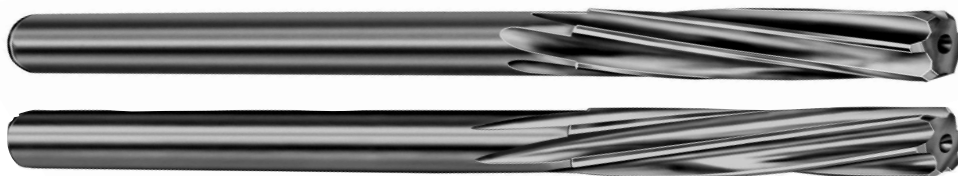
TYPE 3811 - LONG LENGTH - RIGHT SPIRAL FLUTES - FOR NON-FERROUS

TYPE 3810 - LONG LENGTH - RIGHT SPIRAL FLUTES - FOR CAST IRON & STEEL

TYPE 3821 - LONG LENGTH - LEFT SPIRAL FLUTES - FOR NON-FERROUS

TYPE 3820 - LONG LENGTH - LEFT SPIRAL FLUTES - FOR CAST IRON & STEEL

Extended length series. Ground with spiral flutes for reaming holes with interruptions such as keyways, slots or intersecting holes. Left spiral flutes should not be used on blind holes.



Tool diameter tolerance: +.0002"/-.0000".

Shank diameter tolerance: +.0000"/-.0010".

For closer tool diameter tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		RIGHT SPIRAL		LEFT SPIRAL		ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRAC.			FLT.	OAL	NON-FERR. TYPE 3811 EDP NO.	C.I./STEEL TYPE 3810 EDP NO.	NON-FERR. TYPE 3821 EDP NO.	C.I./STEEL TYPE 3820 EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1250	1/8	.1099	4	7/8	3 1/2	381108	381008	382108	382008	\$40.15	.1121 - .1280	\$76.05	\$58.05	\$52.05	\$49.15	\$46.10	\$43.65
.1406	9/64	.1255	4	7/8	3 1/2	381109	381009	382109	382009	45.85	.1281 - .1435	81.80	63.80	57.75	54.90	51.80	49.40
.1562	5/32	.1411	4	1	4	381110	381010	382110	382010	47.25	.1436 - .1590	83.20	65.20	59.15	56.30	53.20	50.80
.1719	11/64	.1567	4	1	4	381111	381011	382111	382011	53.30	.1591 - .1750	89.25	71.20	65.20	62.35	59.25	56.80
.1875	3/16	.1724	4	1 1/8	4 1/2	381112	381012	382112	382012	54.40	.1751 - .1910	90.35	72.30	66.30	63.45	60.35	57.90

*Quantities of 15 or more: price of fractional size in same size range.

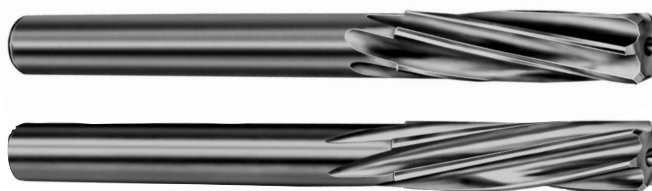
TYPE 3813 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - FOR NON-FERROUS

TYPE 3812 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - FOR CAST IRON & STEEL

TYPE 3823 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - FOR NON-FERROUS

TYPE 3822 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - FOR CAST IRON & STEEL

Short length solid carbide head and shank. Ground with spiral flutes for reaming holes with interruptions such as keyways, slots or intersecting holes. Left spiral flutes should not be used on blind holes.



Tool diameter tolerance thru .2500": +.0002"/-.0000".

over .2500": +.0003"/.0000".

Shank diameter tolerance: +.0000"/-.0010".

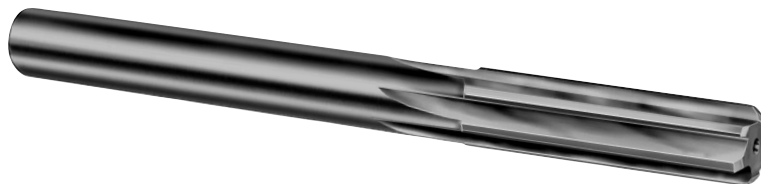
For closer tool diameter tolerance pricing, see page 50.

DECIMAL SIZE RANGE	MAX. SHANK DIAM.	NO. OF FLTS.	FLT. LEN.	OVER ALL LEN.	RIGHT SPIRAL		LEFT SPIRAL		PRICE EACH - FINISHED TO DECIMAL SIZE						
					NON-FERR. TYPE 3813 EDP NO.	C.I./STEEL TYPE 3812 EDP NO.	NON-FERR. TYPE 3823 EDP NO.	C.I./STEEL TYPE 3822 EDP NO.	1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.0971 - .1120	.0943	4	5/8	2 1/4	381307	381207	382307	382207	\$75.05	\$48.00	\$38.95	\$34.70	\$30.05	\$26.40	\$21.10
.1121 - .1280	.1099	4	5/8	2 1/4	381308	381208	382308	382208	76.45	49.40	40.35	36.10	31.45	27.80	22.50
.1281 - .1435	.1255	4	3/4	2 1/2	381309	381209	382309	382209	77.10	50.05	41.00	36.75	32.10	28.45	23.15
.1436 - .1590	.1411	4	3/4	2 1/2	381310	381210	382310	382210	78.50	51.45	42.40	38.15	33.50	29.85	24.55
.1591 - .1750	.1567	4	7/8	2 3/4	381311	381211	382311	382211	81.65	54.60	45.55	41.30	36.70	33.00	27.70
.1751 - .1910	.1724	4	7/8	2 3/4	381312	381212	382312	382212	83.70	56.65	47.65	43.35	38.75	35.05	29.75
.1911 - .2210	.1880	6	1	3	381314	381214	382314	382214	87.40	60.35	51.30	47.05	42.40	38.75	33.45
.2211 - .2530	.2193	6	1	3	381316	381216	382316	382216	93.80	66.75	57.70	53.45	48.80	45.15	39.85
.2531 - .2840	.2505	6	1 1/8	3 1/4	381318	381218	382318	382218	101.15	74.10	65.05	60.80	56.15	52.50	47.20
.2841 - .3150	.2817	6	1 1/8	3 1/4	381320	381220	382320	382220	109.15	82.10	73.05	68.80	64.15	60.50	55.20
.3151 - .3470	.3130	6	1 1/4	3 1/2	381322	381222	382322	382222	121.20	94.15	85.10	80.85	76.20	72.55	67.25
.3471 - .3780	.3443	6	1 1/4	3 1/2	381324	381224	382324	382224	122.80	95.75	86.75	82.45	77.85	74.15	68.85
.3781 - .4090	.3755	6	1 3/8	3 3/4	381326	381226	382326	382226	126.20	99.15	90.10	85.85	81.20	77.55	72.25
.4091 - .4410	.4067	6	1 3/8	3 3/4	381328	381228	382328	382228	127.25	100.20	91.15	86.90	82.25	78.55	73.30
.4411 - .4720	.4380	6	1 1/2	4	381330	381230	382330	382230	135.00	107.95	98.95	94.65	90.05	86.35	81.05
.4721 - .5150	.4693	6	1 1/2	4	381332	381232	382332	382232	142.50	115.45	106.45	102.15	97.55	93.85	88.55

SOLID CARBIDE DECIMAL SIZE CHUCKING REAMERS

**TYPE 3804 - SOLID CARBIDE - STRAIGHT FLUTES - SHORT LENGTH
STANDARD DECIMAL DIAMETER REAMERS (.0005" INCREMENTS)
THIS PAGE .2680" THRU .3875"**

Short length solid carbide head and shank. Tool geometry appropriate for material being machined. For fractional, wire and letter sizes, see page 44.



Tool diameter tolerance thru .2500": +.0002"/-.0000"
over .2500": +.0003"/.0000"

Shank diameter tolerance: +.0000"/-.0010"

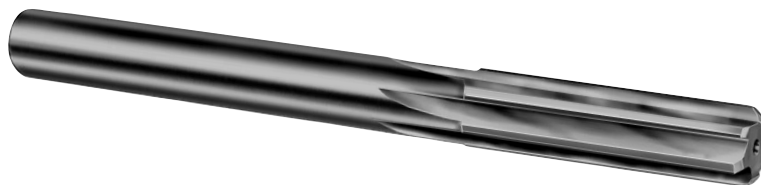
For closer tool diameter tolerance pricing, see page 50.

DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH
.2680	38042680	\$57.20	.2920	38042920	\$66.90	.3160	38043160	\$69.70	.3400	38043400	\$84.95	.3640	38043640	\$87.15
.2685	38042685	57.20	.2925	38042925	66.90	.3165	38043165	74.25	.3405	38043405	84.95	.3645	38043645	87.15
.2690	38042690	57.20	.2930	38042930	66.90	.3170	38043170	74.25	.3410	38043410	84.95	.3650	38043650	87.15
.2695	38042695	57.20	.2935	38042935	66.90	.3175	38043175	74.25	.3415	38043415	84.95	.3655	38043655	87.15
.2700	38042700	57.20	.2940	38042940	66.90	.3180	38043180	74.25	.3420	38043420	84.95	.3660	38043660	87.15
.2705	38042705	57.20	.2945	38042945	66.90	.3185	38043185	74.25	.3425	3804087	84.75	.3665	38043665	87.15
.2710	38042710	57.20	.2950	38042950	63.65	.3190	38043190	74.25	.3430	38043430	84.95	.3670	38043670	87.15
.2715	38042715	57.20	.2955	38042955	66.90	.3195	38043195	74.25	.3435	38043435	84.95	.3675	38043675	87.15
.2720	38042720	54.25	.2960	38042960	66.90	.3200	38043200	74.25	.3440	38043440	85.10	.3680	38043680	82.90
.2725	38042725	57.20	.2965	38042965	66.90	.3205	38043205	74.25	.3445	38043445	85.10	.3685	38043685	87.90
.2730	38042730	57.20	.2970	38042970	69.70	.3210	38043210	74.25	.3450	38043450	85.10	.3690	38043690	88.20
.2735	38042735	57.20	.2975	38042975	69.70	.3215	38043215	74.25	.3455	38043455	85.10	.3695	38043695	87.90
.2740	38042740	57.20	.2980	38042980	69.70	.3220	38043220	74.25	.3460	38043460	85.10	.3700	38043700	87.90
.2745	38042745	57.20	.2985	38042985	69.70	.3225	38043225	74.25	.3465	3804088	85.10	.3705	38043705	87.90
.2750	38042750	57.20	.2990	38042990	69.70	.3230	38043230	70.55	.3470	38043470	85.10	.3710	38043710	87.90
.2755	38042755	57.20	.2995	38042995	69.70	.3235	38043235	74.25	.3475	38043475	85.10	.3715	38043715	87.90
.2760	38042760	57.20	.3000	38043000	69.70	.3240	38043240	84.95	.3480	38043480	81.05	.3720	38043720	87.90
.2765	38042765	57.20	.3005	38043005	69.70	.3245	38043245	84.95	.3485	38043485	85.10	.3725	38043725	87.90
.2770	38042770	54.25	.3010	38043010	69.70	.3250	38043250	84.95	.3490	38043490	85.10	.3730	38043730	87.90
.2775	38042775	57.20	.3015	38043015	69.70	.3255	38043255	84.95	.3495	38043495	85.10	.3735	38043735	87.90
.2780	38042780	61.90	.3020	38043020	66.35	.3260	38043260	84.95	.3500	38043500	85.10	.3740	3804095	83.35
.2785	38042785	61.90	.3025	38043025	69.70	.3265	38043265	84.95	.3505	38043505	85.10	.3745	38043745	87.90
.2790	38042790	61.90	.3030	38043030	69.70	.3270	38043270	84.95	.3510	38043510	85.10	.3750	380424	76.30
.2795	3804071	61.80	.3035	38043035	69.70	.3275	38043275	84.95	.3515	38043515	85.10	.3755	38043755	104.20
.2800	38042800	61.90	.3040	38043040	69.70	.3280	38043280	84.95	.3520	38043520	85.10	.3760	38043760	104.35
.2805	38042805	61.90	.3045	38043045	69.70	.3285	38043285	84.95	.3525	38043525	85.10	.3765	38043765	104.20
.2810	38042810	58.80	.3050	38043050	69.70	.3290	38043290	84.95	.3530	38043530	85.10	.3770	38043770	99.00
.2815	38042815	61.90	.3055	38043055	69.70	.3295	38043295	84.95	.3535	38043535	85.10	.3775	38043775	104.20
.2820	38042820	66.90	.3060	38043060	69.70	.3300	38043300	84.95	.3540	38043540	85.10	.3780	3804096	104.00
.2825	38042825	66.90	.3065	38043065	69.70	.3305	38043305	84.95	.3545	38043545	85.10	.3785	38043785	104.20
.2830	38042830	66.90	.3070	38043070	69.70	.3310	38043310	82.05	.3550	38043550	85.55	.3790	38043790	104.20
.2835	3804072	66.80	.3075	38043075	69.70	.3315	38043315	84.95	.3555	38043555	85.55	.3795	38043795	104.20
.2840	38042840	66.90	.3080	38043080	69.70	.3320	38043320	80.70	.3560	38043560	85.55	.3800	38043800	104.20
.2845	38042845	66.90	.3085	38043085	69.70	.3325	38043325	84.95	.3565	38043565	85.55	.3805	38043805	104.20
.2850	38042850	66.90	.3090	38043090	69.70	.3330	38043330	84.95	.3570	38043570	85.55	.3810	38043810	104.20
.2855	38042855	66.90	.3095	38043095	69.70	.3335	38043335	84.95	.3575	38043575	85.55	.3815	38043815	104.20
.2860	38042860	66.90	.3100	38043100	69.70	.3340	38043340	84.95	.3580	38043580	81.45	.3820	38043820	104.20
.2865	38042865	66.90	.3105	38043105	69.70	.3345	38043345	84.95	.3585	38043585	85.55	.3825	38043825	104.20
.2870	38042870	66.90	.3110	3804079	69.70	.3350	38043350	84.95	.3590	38043590	86.15	.3830	38043830	104.20
.2875	38042875	66.90	.3115	38043115	69.70	.3355	38043355	84.95	.3595	38043595	87.15	.3835	38043835	104.20
.2880	38042880	66.90	.3120	38043120	69.70	.3360	38043360	84.95	.3600	38043600	87.15	.3840	38043840	104.20
.2885	38042885	66.90	.3125	380420	60.65	.3365	38043365	84.95	.3605	38043605	87.15	.3845	38043845	104.20
.2890	38042890	66.90	.3130	38043130	69.70	.3370	38043370	84.95	.3610	38043610	87.15	.3850	38043850	104.20
.2895	38042895	66.90	.3135	38043135	69.70	.3375	38043375	84.95	.3615	38043615	87.15	.3855	38043855	104.20
.2900	38042900	63.65	.3140	38043140	69.70	.3380	38043380	84.95	.3620	38043620	87.15	.3860	38043860	99.20
.2905	38042905	66.90	.3145	38043145	69.70	.3385	38043385	84.95	.3625	38043625	87.15	.3865	38043865	109.60
.2910	38042910	66.90	.3150	3804080	60.65	.3390	38043390	80.70	.3630	38043630	87.15	.3870	38043870	109.60
.2915	38042915	66.90	.3155	38043155	69.70	.3395	38043395	84.95	.3635	38043635	87.15	.3875	38043875	109.60

SOLID CARBIDE DECIMAL SIZE CHUCKING REAMERS

**TYPE 3804 - SOLID CARBIDE - STRAIGHT FLUTES - SHORT LENGTH
STANDARD DECIMAL DIAMETER REAMERS (.0005" INCREMENTS)
THIS PAGE .3880" THRU .5150"**

Short length solid carbide head and shank. Tool geometry appropriate for material being machined.
For fractional, wire and letter sizes, see page 44.



Tool diameter tolerance thru .2500": +.0002"/-.0000"
over .2500": +.0003"/.0000"

Shank diameter tolerance: +.0000"/-.0010"

For closer tool diameter tolerance pricing, see page 50.

DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH	DECIMAL SIZE	EDP NO.	PRICE EACH
.3880	38043880	\$109.60	.4135	38044135	\$112.55	.4390	38044390	\$123.25	.4645	38044645	\$123.25	.4910	38044910	\$134.05
.3885	38043885	109.60	.4140	38044140	112.55	.4395	38044395	123.25	.4650	38044650	123.25	.4915	38044915	134.05
.3890	38043890	109.60	.4145	38044145	112.55	.4400	38044400	123.25	.4655	38044655	123.25	.4920	38044920	134.05
.3895	38043895	109.60	.4150	38044150	112.55	.4405	38044405	123.25	.4660	38044660	123.25	.4925	38044925	134.05
.3900	38043900	109.60	.4155	38044155	112.55	.4410	38044410	123.25	.4665	38044665	123.25	.4930	38044930	134.05
.3905	38043905	109.60	.4160	38044160	112.55	.4415	38044415	123.25	.4670	38044670	123.25	.4935	38044935	134.05
.3910	38043910	109.60	.4165	38044165	112.55	.4420	38044420	123.25	.4675	38044675	123.25	.4940	38044940	134.05
.3915	38043915	109.60	.4170	38044170	112.55	.4425	38044425	123.25	.4680	38044680	123.25	.4945	38044945	134.05
.3920	38043920	109.60	.4175	38044175	112.55	.4430	38044430	123.25	.4685	38041119	123.25	.4950	38044950	134.05
.3925	38043925	109.60	.4180	38044180	112.55	.4435	38044435	123.25	.4690	38044690	123.25	.4955	38044955	134.05
.3930	38043930	109.60	.4185	38044185	112.55	.4440	38044440	123.25	.4695	38044695	123.25	.4960	38044960	134.05
.3935	38043935	109.60	.4190	38044190	112.55	.4445	38044445	123.25	.4700	38044700	123.25	.4965	38044965	134.05
.3940	38043940	109.60	.4195	38044195	112.55	.4450	38044450	123.25	.4705	38044705	123.25	.4970	38044970	134.05
.3945	38043945	109.60	.4200	38044200	112.55	.4455	38044455	123.25	.4710	38044710	123.25	.4975	38044975	134.05
.3950	38043950	109.60	.4205	38044205	112.55	.4460	38044460	123.25	.4715	38044715	123.25	.4980	38044980	134.05
.3955	38043955	109.60	.4210	38044210	112.55	.4465	38044465	123.25	.4720	38044720	123.25	.4985	38044985	134.05
.3960	38043960	109.60	.4215	38044215	112.55	.4470	38044470	123.25	.4725	38044725	134.05	.4990	38044990	134.05
.3965	38043965	109.60	.4220	38044220	112.55	.4475	38044475	123.25	.4730	38044730	134.05	.4995	38044995	126.85
.3970	38043970	104.35	.4225	38044225	112.55	.4480	38044480	123.25	.4735	38044735	134.05	.5000	380432	126.85
.3975	38043975	109.60	.4230	38044230	112.55	.4485	38044485	123.25	.4740	38044740	134.05	.5005	38045005	159.20
.3980	38043980	109.60	.4235	38044235	112.55	.4490	38044490	123.25	.4745	38044745	134.05	.5010	38045010	159.20
.3985	38043985	109.60	.4240	38044240	112.55	.4495	38044495	123.25	.4750	38044750	134.05	.5015	38045015	159.20
.3990	38043990	109.60	.4245	38044245	112.55	.4500	38044500	123.25	.4755	38044755	134.05	.5020	38045020	159.20
.3995	38043995	109.60	.4250	38044250	112.55	.4505	38044505	123.25	.4760	38044760	134.05	.5025	38045025	159.20
.4000	38044000	109.60	.4255	38044255	112.55	.4510	38044510	123.25	.4765	38044765	134.05	.5030	38045030	159.20
.4005	38044005	109.60	.4260	38044260	112.55	.4515	38044515	123.25	.4770	38044770	134.05	.5035	38045035	159.20
.4010	38044010	109.60	.4265	38044265	112.55	.4520	38044520	123.25	.4775	38044775	134.05	.5040	38045040	159.20
.4015	38044015	109.60	.4270	38044270	112.55	.4525	38044525	123.25	.4780	38044780	134.05	.5045	38045045	159.20
.4020	38044020	109.60	.4275	38044275	112.55	.4530	38044530	123.25	.4785	38044785	134.05	.5050	38045050	159.20
.4025	38044025	109.60	.4280	38044280	112.55	.4535	38044535	123.25	.4790	38044790	134.05	.5055	38045055	159.20
.4030	38044030	109.60	.4285	38044285	112.55	.4540	38044540	123.25	.4795	38044795	134.05	.5060	38045060	159.20
.4035	38044035	109.60	.4290	38044290	112.55	.4545	38044545	123.25	.4800	38044800	134.05	.5065	38045065	159.20
.4040	38044040	104.35	.4295	38044295	112.55	.4550	38044550	123.25	.4805	38044805	134.05	.5070	38045070	159.20
.4045	38044045	109.60	.4300	38044300	112.55	.4555	38044555	123.25	.4810	38044810	134.05	.5075	38045075	159.20
.4050	38044050	109.60	.4305	38044305	112.55	.4560	38044560	123.25	.4815	38044815	134.05	.5080	38045080	159.20
.4055	3804103	109.60	.4310	38044310	112.55	.4565	38044565	123.25	.4820	38044820	134.05	.5085	38045085	159.20
.4060	38044060	109.60	.4315	38044315	112.55	.4570	38044570	123.25	.4835	38044835	134.05	.5090	38045090	159.20
.4065	38044065	109.60	.4320	38044320	112.55	.4575	38044575	123.25	.4840	38044840	134.05	.5095	38045095	159.20
.4070	38044070	109.60	.4325	38044325	112.55	.4580	38044580	123.25	.4845	38044845	134.05	.5100	38045100	159.20
.4075	38044075	109.60	.4330	38044330	112.55	.4585	38044585	123.25	.4850	38044850	134.05	.5105	38045105	159.20
.4080	38044080	109.60	.4335	38044335	112.55	.4590	38044590	123.25	.4855	38044855	134.05	.5110	38045110	159.20
.4085	38044085	109.60	.4340	38044340	112.55	.4595	38044595	123.25	.4860	38044860	134.05	.5115	38045115	159.20
.4090	38044090	109.60	.4345	38044345	112.55	.4600	38044600	123.25	.4865	38044865	134.05	.5120	38045120	159.20
.4095	38044095	109.60	.4350	38044350	112.55	.4605	38044605	123.25	.4870	38044870	134.05	.5125	38045125	159.20
.4100	38044100	109.60	.4355	38044355	112.55	.4610	38044610	123.25	.4875	38044875	134.05	.5130	38045130	159.20
.4105	38044105	109.60	.4360	38044360	112.55	.4615	38044615	123.25	.4880	38044880	134.05	.5135	38045135	159.20
.4110	38044110	109.60	.4365	38044365	112.55	.4620	38044620	123.25	.4885	38044885	134.05	.5140	38045140	159.20
.4115	38044115	109.60	.4370	3804111	112.55	.4625	38044625	123.25	.4890	38044890	134.05	.5145	38045145	159.20
.4120	38044120	109.60	.4375	380428	107.10	.4630	38044630	123.25	.4895	38044895	134.05	.5150	38045150	159.20
.4125	38044125	109.60	.4380	38044380	123.25	.4635	38044635	123.25	.4900	38044900	134.05	-	-	-
.4130	38044130	104.35	.4385	38044385	123.25	.4640	38044640	123.25	.4905	38044905	134.05	-	-	-

FEEDS & SPEEDS CHARTS FOR REAMERS - CARBIDE TIPPED

Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all safety shields and glasses before performing these operations.



$$RPM = SFPM * 3.82 / \text{Cutter Diameter}$$

CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE (INCHES PER REVOLUTION)					HOLE DIAMETER IN INCHES			
			GENERAL PURPOSE (G.P.)	1/8	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	150 - 250	.004	.006	.008	.011	.012	.013	.016	.019	.020
	MAGNESIUM ALLOY	50 - 90*	130 - 190	.005	.010	.012	.015	.016	.017	.020	.022	.025
	LEAD ALLOY	10 - 20*	150 - 250	.002	.006	.008	.012	.014	.015	.018	.021	.022
	NON-METAL AND PLASTIC	-	90 - 250	.004	.005	.007	.008	.009	.012	.014	.016	.018
	ZINC ALLOY - DIE CAST	80 - 100	140 - 210	.005	.007	.008	.010	.011	.012	.015	.018	.020
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	50 - 90	.004	.006	.010	.012	.014	.016	.018	.020	.022
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	100 - 250	.005	.008	.011	.015	.017	.018	.020	.022	.025
	NICKEL SILVER	10 - 100Rb	50 - 90	.004	.006	.008	.010	.011	.012	.014	.015	.016
CAST IRON	COPPER ALLOY - TOUGH	40 - 200*	50 - 90	.005	.006	.008	.010	.011	.012	.014	.016	.017
	DUCTILE CAST IRON - AUSTENITIC	120 - 275	45 - 70	.004	.006	.007	.008	.010	.013	.015	.018	.020
	DUCTILE CAST IRON - FERRITIC	140 - 270	50 - 90	.004	.005	.008	.010	.012	.014	.017	.020	.023
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	35 - 60	.004	.006	.007	.008	.009	.010	.012	.014	.016
	GRAY - PEARLITIC	220 - 320	45 - 70	.004	.006	.008	.009	.010	.012	.014	.018	.020
	GRAY - FERRITIC	120 - 220	65 - 135	.005	.008	.010	.011	.013	.016	.020	.022	.025
LOW CARBON STEELS	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	45 - 70	.004	.006	.008	.010	.012	.013	.015	.018	.025
	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	70 - 100	.005	.008	.010	.012	.014	.015	.020	.025	.030
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	30 - 85	.004	.008	.009	.011	.013	.015	.018	.020	.022
	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	65 - 100	.005	.008	.010	.015	.017	.018	.022	.025	.027
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	40 - 85	.005	.010	.012	.015	.018	.020	.025	.027	.030
	STAINLESS STEEL - 400 SERIES	135 - 325	40 - 90	.003	.005	.006	.007	.008	.008	.010	.011	.012
HIGH STRENGTH STEELS	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	65 - 100	.004	.006	.007	.008	.009	.009	.010	.011	.012
	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	35 - 70	.004	.006	.007	.008	.009	.010	.011	.012	.013
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	15 - 85	.003	.005	.005	.005	.006	.007	.008	.010	.012
	STAINLESS STEEL - 300 SERIES	135 - 375	40 - 75	.003	.004	.005	.006	.006	.007	.008	.009	.010
	STAINLESS STEEL - PH SERIES	150 - 440	35 - 70	.003	.004	.004	.005	.006	.007	.008	.009	.010
	TITANIUM ALLOY	110 - 380	30 - 45	.004	.006	.008	.010	.011	.011	.012	.013	.014

CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE (INCHES PER REVOLUTION)					HOLE DIAMETER IN INCHES			
			COOLANT FED (C.F.)	1/8	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	200 - 300	-	.008	.010	.013	.015	.017	.021	.022	.024
	MAGNESIUM ALLOY	50 - 90*	150 - 250	-	.012	.015	.018	.019	.020	.024	.026	.028
	LEAD ALLOY	10 - 20*	200 - 300	-	.008	.010	.016	.017	.018	.022	.024	.026
	NON-METAL AND PLASTIC	-	125 - 300	-	.006	.008	.009	.010	.014	.016	.018	.020
	ZINC ALLOY - DIE CAST	80 - 100	170 - 240	-	.009	.011	.013	.014	.016	.020	.022	.025
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	70 - 105	-	.008	.013	.015	.016	.018	.021	.024	.028
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	125 - 300	-	.010	.014	.020	.022	.024	.026	.028	.032
	NICKEL SILVER	10 - 100Rb	70 - 190	-	.007	.010	.012	.013	.014	.017	.018	.018
CAST IRON	COPPER ALLOY - TOUGH	40 - 200*	70 - 105	-	.008	.010	.013	.014	.016	.018	.019	.020
	DUCTILE CAST IRON - AUSTENITIC	120 - 275	65 - 100	-	.008	.009	.011	.014	.016	.018	.020	.025
	DUCTILE CAST IRON - FERRITIC	140 - 270	70 - 105	-	.007	.010	.012	.015	.017	.022	.024	.027
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	50 - 85	-	.008	.009	.010	.011	.013	.014	.017	.019
	GRAY - PEARLITIC	220 - 320	55 - 100	-	.008	.010	.012	.014	.015	.018	.020	.026
	GRAY - FERRITIC	120 - 220	95 - 190	-	.010	.013	.014	.017	.020	.024	.028	.030
LOW CARBON STEELS	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	65 - 100	-	.008	.010	.012	.014	.015	.020	.023	.030
	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	100 - 150	-	.012	.014	.016	.018	.020	.025	.030	.035
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	40 - 110	-	.009	.011	.013	.015	.017	.022	.024	.026
	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	90 - 135	-	.010	.012	.018	.020	.022	.025	.027	.030
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	65 - 100	-	.012	.015	.018	.022	.024	.028	.030	.033
	STAINLESS STEEL - 400 SERIES	135 - 325	50 - 100	-	.007	.007	.008	.009	.009	.012	.014	.015
HIGH STRENGTH STEELS	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	90 - 135	-	.008	.009	.010	.011	.012	.013	.013	.014
	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	50 - 100	-	.007	.008	.009	.011	.012	.014	.015	.016
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	20 - 115	-	.006	.007	.007	.008	.008	.010	.012	.015
	STAINLESS STEEL - 300 SERIES	135 - 375	60 - 90	-	.006	.007	.008	.008	.009	.010	.011	.012
	STAINLESS STEEL - PH SERIES	150 - 440	50 - 90	-	.006	.006	.007	.008	.009	.010	.012	.014
	TITANIUM ALLOY	110 - 380	40 - 60	-	.008	.010	.013	.014	.014	.016	.016	.018

CARBIDE TIPPED JOBBERS DRILL LENGTH REAMERS

TYPE 3401 - STRAIGHT SHANK - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies.
Straight polished flutes.

Designed and manufactured for maximum tool life. Used for all general types of reaming, including low carbon steel, cast iron, non-ferrous metals and non-metals. These shorter length reamers provide increased rigidity and should be used in applications requiring jobbers length drills.



TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1562	5/32	.151	4	1	1/2	3 1/8	340105	\$64.30	.1560 - .1769	\$102.65	\$83.40	\$77.00	\$73.95	\$70.65	\$68.05
.1719	1/16	.151	4	1	1/2	3 1/4	34011719	64.30	-	-	-	-	-	-	-
.1875	3/16	1/16	4	1 1/8	1/2	3 1/2	340106	62.20	.1770 - .2040	99.50	80.80	74.55	71.55	68.35	65.85
.2031	13/64	1/16	4	1 1/8	1/2	3 5/8	34012031	62.55	-	-	-	-	-	-	-
.2188	7/32	13/64	4	1 1/4	1/2	3 3/4	340107	62.20	.2041 - .2210	99.50	80.80	74.55	71.55	68.35	65.85
.2344	15/64	7/32	4	1 1/2	1/2	3 7/8	34012344	62.55	.2211 - .2380	99.90	81.20	74.95	71.95	68.75	66.25
.2500	1/4	15/64	4	1 1/2	1/2	4	340108	62.20	.2381 - .2530	99.50	80.80	74.55	71.55	68.35	65.85
.2656	17/64	15/64	4	1 1/2	1/2	4 1/8	34012656	63.40	-	-	-	-	-	-	-
.2812	9/32	15/64	4	1 1/2	1/2	4 1/4	340109	63.00	.2531 - .2840	100.35	81.65	75.40	72.40	69.20	66.70
.2969	19/64	9/32	4	1 1/2	1/2	4 3/8	34012969	63.40	-	-	-	-	-	-	-
.3125	5/16	9/32	4	1 1/2	1/2	4 1/2	340110	63.00	.2841 - .3150	100.35	81.65	75.40	72.40	69.20	66.70
.3281	21/64	9/32	4	1 1/2	5/8	4 5/8	34013281	65.30	-	-	-	-	-	-	-
.3438	11/32	9/32	4	1 1/2	5/8	4 3/4	340111	64.55	.3151 - .3470	101.85	83.15	76.90	73.95	70.75	68.20
.3594	23/64	5/16	4	1 3/4	5/8	4 7/8	34013594	65.30	-	-	-	-	-	-	-
.3750	3/8	5/16	4	1 3/4	5/8	5	340112	59.20	.3471 - .3780	93.45	76.30	70.55	67.85	64.90	62.60
.3906	25/64	5/16	4	1 3/4	5/8	5 1/8	34013906	67.75	-	-	-	-	-	-	-
.4062	13/32	5/16	4	1 3/4	5/8	5 1/4	340113	66.60	.3781 - .4090	103.90	85.25	78.95	76.00	72.80	70.25
.4219	27/64	3/8	4	1 3/4	5/8	5 3/8	34014219	67.75	-	-	-	-	-	-	-
.4375	7/16	3/8	4	1 3/4	5/8	5 1/2	340114	69.50	.4091 - .4410	106.80	88.15	81.85	78.90	75.70	73.15
.4531	29/64	3/8	4	1 3/4	5/8	5 5/8	34014531	72.25	-	-	-	-	-	-	-
.4688	15/32	3/8	4	1 3/4	5/8	5 3/4	340115	72.65	.4411 - .4720	109.95	91.25	85.00	82.00	78.80	76.30
.4844	31/64	7/16	6	2	5/8	5 7/8	34014844	77.00	-	-	-	-	-	-	-
.5000	1/2	7/16	6	2	5/8	6	340116	81.55	.4721 - .5030	122.65	102.05	95.15	91.90	88.35	85.60
.5156	33/64	7/16	6	2	5/8	6 5/8	34015156	86.70	-	-	-	-	-	-	-
.5312	17/32	7/16	6	2	5/8	6 5/8	340117	86.70	.5031 - .5340	127.75	107.20	100.30	97.00	93.50	90.70
.5469	35/64	7/16	6	2	5/8	6 5/8	34015469	86.70	-	-	-	-	-	-	-
.5625	9/16	7/16	6	2	5/8	6 5/8	340118	86.70	.5341 - .5660	127.75	107.20	100.30	97.00	93.50	90.70
.5781	37/64	7/16	6	2	5/8	6 5/8	34015781	89.10	-	-	-	-	-	-	-
.5938	19/32	7/16	6	2	5/8	7 1/8	340119	89.10	.5661 - .5970	130.20	109.60	102.75	99.45	95.95	93.15
.6094	39/64	9/16	6	2 1/4	5/8	7 1/8	34016094	89.10	-	-	-	-	-	-	-
.6250	5/8	9/16	6	2 1/4	5/8	7 1/8	340120	89.10	.5971 - .6280	130.20	109.60	102.75	99.45	95.95	93.15
.6406	41/64	9/16	6	2 1/4	5/8	7 1/8	34016406	90.20	-	-	-	-	-	-	-
.6562	21/32	9/16	6	2 1/4	5/8	7 1/8	340121	90.20	.6281 - .6590	131.30	110.70	103.80	100.55	97.00	94.25
.6719	43/64	9/16	6	2 1/4	5/8	7 5/8	34016719	90.20	-	-	-	-	-	-	-
.6875	11/16	9/16	6	2 1/4	5/8	7 5/8	340122	90.20	.6591 - .6910	131.30	110.70	103.80	100.55	97.00	94.25
.7031	45/64	9/16	6	2 1/4	5/8	7 5/8	34017031	93.30	-	-	-	-	-	-	-
.7188	23/32	9/16	6	2 1/4	5/8	7 5/8	340123	93.30	.6911 - .7220	134.40	113.80	106.95	103.65	100.15	97.35
.7344	47/64	5/8	6	2 1/2	3/4	7 5/8	34017344	93.30	-	-	-	-	-	-	-
.7500	3/4	5/8	6	2 1/2	3/4	8	340124	93.30	.7221 - .7530	134.40	113.80	106.95	103.65	100.15	97.35

*Quantities of 15 or more: price of fractional size in same size range.

REAMER TOLERANCES & CLOSER TOLERANCE PRICING

TOOL TYPE	TOOL DIAMETER TOLERANCES		CLOSER TOLERANCE PRICING			TOOL TYPE	SHANK DIAMETER TOLERANCES (BASED ON TOOL DIAMETER)	
			.0001"	.0002"	.0003"			
3480, NAS 897 EXCLUDING COOLANT	.0000" THRU .5000"	+ .0002"/-.0000"	\$4.20	-	-	NAS 897 & COOLANT	UP TO 23/32"	+ .0000"/-.0010"
	.5001" THRU .7500"	+ .0003"/-.0000"	4.20	\$1.40	-		OVER 23/32"	+ .0000"/-.0015"
	.7501" AND UP	+ .0004"/-.0000"	7.00	4.20	\$1.40			
ALL OTHER REAMERS	.0000" THRU 1.5000"	+ .0003"/-.0000"	4.20	1.40	-	ALL OTHER REAMERS	ALL SIZES	
	1.5001" AND UP	+ .0004"/-.0000"	7.00	4.20	1.40		-.0005"/-.0015"	

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CARBIDE TIPPED OVER & UNDER SIZE REAMERS

TYPE 3479 - JOBBERS DRILL LENGTH STRAIGHT SHANK & FLUTES

These precision ground carbide tipped reamers are very convenient for finishing accurate holes in most materials.

Same specifications as Type 3401 (pg. 50).

Tool diameter tolerance: +.0002"/-.0000".

TOOL DIAMETER	SHANK DIAM.	NO. OF FLUTES	LENGTH			TYPE 3479 EDP NO.	PRICE EACH
			FLT	CARB	OAL		
.1865	1/64	4	1 1/8	1/2	3 1/2	347918	\$62.55
.1885	1/64	4	1 1/8	1/2	3 1/2	347919	62.55
.2490	15/64	4	1 1/2	1/2	4	347924	62.55
.2510	15/64	4	1 1/2	1/2	4	347925	62.55
.3115	9/32	4	1 1/2	1/2	4 1/2	347931	63.40
.3135	9/32	4	1 1/2	1/2	4 1/2	347932	63.40
.3740	5/16	4	1 3/4	5/8	5	347937	65.30
.3760	5/16	4	1 3/4	5/8	5	347938	65.30
.4365	3/8	4	1 3/4	5/8	5 1/2	347943	72.25
.4385	3/8	4	1 3/4	5/8	5 1/2	347944	72.25
.4990	7/16	6	2	5/8	6	347949	77.00
.5010	7/16	6	2	5/8	6	347950	77.00

TYPE 3478 - REGULAR LENGTH STRAIGHT SHANK & FLUTES

These precision ground carbide tipped reamers are very convenient for finishing accurate holes in most materials.

Same specifications as Type 3400 (pg. 52).

Tool diameter tolerance: +.0002"/-.0000".

TOOL DIAMETER	SHANK DIAM.	NO. OF FLUTES	LENGTH			TYPE 3478 EDP NO.	PRICE EACH
			FLT	CARB	OAL		
.1865	1/64	4	1 1/8	1/2	4 1/2	347818	\$50.30
.1885	1/64	4	1 1/8	1/2	4 1/2	347819	50.30
.2490	15/64	4	1 1/2	1/2	6	347824	50.30
.2510	15/64	4	1 1/2	1/2	6	347825	50.30
.3115	9/32	4	1 1/2	1/2	6	347831	51.35
.3135	9/32	4	1 1/2	1/2	6	347832	51.35
.3740	5/16	4	1 3/4	5/8	7	347837	53.25
.3760	5/16	4	1 3/4	5/8	7	347838	53.25
.4365	3/8	4	1 3/4	5/8	7	347843	59.60
.4385	3/8	4	1 3/4	5/8	7	347844	59.60
.4990	7/16	6	2	5/8	8	347849	65.30
.5010	7/16	6	2	5/8	8	347850	65.30
.6240	9/16	6	2 1/4	5/8	9	347862	78.30
.6260	9/16	6	2 1/4	5/8	9	347863	78.30
.7490	5/8	6	2 1/2	3/4	9 1/2	347874	82.50
.7510	5/8	6	2 1/2	3/4	9 1/2	347875	82.50
.8740	3/4	6	2 5/8	3/4	10	347886	87.60
.8760	3/4	6	2 5/8	3/4	10	347887	87.60
.9990	7/8	8	2 3/4	3/4	10 1/2	347898	104.10
1.0010	7/8	8	2 3/4	3/4	10 1/2	347899	99.75

CARBIDE TIPPED DOWEL PIN SIZE REAMERS

TYPE 3477 - JOBBERS DRILL LENGTH STRAIGHT SHANK & FLUTES

These precision ground carbide tipped reamers accurately finish holes in most materials resulting in properly fitting dowel pins.

Should be used in pairs of .0005" and .0020" under the fractional size.

Note special undersize tolerance.

Same specifications as Type 3401 (pg. 50).

Tool diameter tolerance: +.0000"/-.0002".

TOOL DIAMETER	SHANK DIAM.	NO. OF FLUTES	LENGTH			TYPE 3477 EDP NO.	PRICE EACH
			FLT	CARB	OAL		
.1855	1/64	4	1 1/8	1/2	3 1/2	347717	\$62.55
.1870	1/64	4	1 1/8	1/2	3 1/2	347718	62.55
.2480	15/64	4	1 1/2	1/2	4	347723	62.55
.2495	15/64	4	1 1/2	1/2	4	347724	62.55
.3105	9/32	4	1 1/2	1/2	4 1/2	347730	63.40
.3120	9/32	4	1 1/2	1/2	4 1/2	347731	63.40
.3730	5/16	4	1 3/4	5/8	5	347736	65.30
.3745	5/16	4	1 3/4	5/8	5	347737	65.30
.4355	3/8	4	1 3/4	5/8	5 1/2	347742	72.25
.4370	3/8	4	1 3/4	5/8	5 1/2	347743	72.25
.4980	7/16	6	2	5/8	6	347748	77.00
.4995	7/16	6	2	5/8	6	347749	77.00

TYPE 3476 - REGULAR LENGTH STRAIGHT SHANK & FLUTES

These precision ground carbide tipped reamers accurately finish holes in most materials resulting in properly fitting dowel pins.

Should be used in pairs of .0005" and .0020" under the fractional size.

Note special undersize tolerance.

Same specifications as Type 3400 (pg. 52).

Tool diameter tolerance: +.0000"/-.0002".

TOOL DIAMETER	SHANK DIAM.	NO. OF FLUTES	LENGTH			TYPE 3476 EDP NO.	PRICE EACH
			FLT	CARB	OAL		
.1855	1/64	4	1 1/8	1/2	4 1/2	347617	\$50.30
.1870	1/64	4	1 1/8	1/2	4 1/2	347618	50.30
.2480	15/64	4	1 1/2	1/2	6	347623	50.30
.2495	15/64	4	1 1/2	1/2	6	347624	50.30
.3105	9/32	4	1 1/2	1/2	6	347630	51.35
.3120	9/32	4	1 1/2	1/2	6	347631	51.35
.3730	5/16	4	1 3/4	5/8	7	347636	53.25
.3745	5/16	4	1 3/4	5/8	7	347637	53.25
.4355	3/8	4	1 3/4	5/8	7	347642	59.60
.4370	3/8	4	1 3/4	5/8	7	347643	59.60
.4980	7/16	6	2	5/8	8	347648	65.30
.4995	7/16	6	2	5/8	8	347649	65.30
CASED SET OF ABOVE 12 REAMERS						347600	627.15

CARBIDE TIPPED REGULAR LENGTH CHUCKING REAMERS

TYPE 3400 - STRAIGHT SHANK - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

Designed and manufactured for maximum tool life. Used for all general types of reaming, including low carbon steels, cast iron, non-ferrous metals and non-metals.



For metric sizes, see page 54.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1562	5/32	.151	4	1	1/2	4	340005	\$43.50	.1560 - .1769	\$82.30	\$62.65	\$56.30	\$53.15	\$49.85	\$47.30
.1719	11/64	.151	4	1	1/2	4	34001719	43.50	-	-	-	-	-	-	-
.1875	3/16	11/64	4	1 1/8	1/2	4 1/2	340006	40.00	.1770 - .2040	77.30	58.60	52.35	49.35	46.15	43.65
.1875	3/16	11/64	4	1 1/4	1/2	5	340086	42.35	.1770 - .2040	79.65	60.95	54.80	51.75	48.55	46.00
.2031	13/64	11/64	4	1 1/8	1/2	4 1/2	34002031	42.35	-	-	-	-	-	-	-
.2188	7/32	13/64	4	1 1/4	1/2	5	340007	40.00	.2041 - .2210	77.30	58.60	52.35	49.35	46.15	43.65
.2344	15/64	7/32	4	1 1/2	1/2	6	34002344	42.35	.2211 - .2380	79.65	60.95	54.80	51.75	48.55	46.00
.2500	1/4	15/64	4	1 1/2	1/2	6	340008	40.00	.2381 - .2530	77.30	58.60	52.35	49.35	46.15	43.65
.2656	17/64	15/64	4	1 1/2	1/2	6	34002656	43.25	-	-	-	-	-	-	-
.2812	9/32	15/64	4	1 1/2	1/2	6	340009	40.80	.2531 - .2840	78.15	59.45	53.20	50.20	47.00	44.50
.2969	19/64	9/32	4	1 1/2	1/2	6	34002969	43.25	-	-	-	-	-	-	-
.3125	5/16	9/32	4	1 1/2	1/2	6	340010	40.80	.2841 - .3150	78.15	59.45	53.20	50.20	47.00	44.50
.3281	21/64	9/32	4	1 1/2	5/8	6	34003281	44.85	-	-	-	-	-	-	-
.3438	11/32	9/32	4	1 1/2	5/8	6	340011	42.25	.3151 - .3470	79.60	60.90	54.65	51.65	48.45	45.95
.3594	23/64	5/16	4	1 3/4	5/8	7	34003594	44.85	-	-	-	-	-	-	-
.3750	3/8	5/16	4	1 3/4	5/8	7	340012	38.80	.3471 - .3780	73.00	55.85	50.10	47.40	44.45	42.15
.3906	25/64	5/16	4	1 3/4	5/8	7	34003906	47.10	-	-	-	-	-	-	-
.4062	13/32	5/16	4	1 3/4	5/8	7	340013	44.35	.3781 - .4090	81.65	62.95	56.70	53.70	50.50	48.00
.4219	27/64	3/8	4	1 3/4	5/8	7	34004219	50.15	-	-	-	-	-	-	-
.4375	7/16	3/8	4	1 3/4	5/8	7	340014	47.30	.4091 - .4410	84.60	65.90	59.65	56.70	53.50	50.95
.4531	29/64	3/8	4	1 3/4	5/8	7	34004531	50.90	-	-	-	-	-	-	-
.4688	15/32	3/8	4	1 3/4	5/8	7	340015	48.00	.4411 - .4720	85.30	66.60	60.35	57.40	54.15	51.65
.4844	31/64	7/16	6	2	5/8	8	34004844	55.00	-	-	-	-	-	-	-
.5000	1/2	7/16	6	2	5/8	8	340016	57.10	.4721 - .5030	98.20	77.60	70.75	67.45	63.90	61.15
.5156	33/64	7/16	6	2	5/8	8	34005156	62.15	-	-	-	-	-	-	-
.5312	17/32	7/16	6	2	5/8	8	340017	62.15	.5031 - .5340	103.25	82.65	75.85	72.50	68.95	66.20
.5469	35/64	7/16	6	2	5/8	8	34005469	62.15	-	-	-	-	-	-	-
.5625	9/16	7/16	6	2	5/8	8	340018	62.15	.5341 - .5660	103.25	82.65	75.85	72.50	68.95	66.20
.5781	37/64	7/16	6	2	5/8	8	34005781	64.70	-	-	-	-	-	-	-
.5938	19/32	7/16	6	2	5/8	8	340019	64.70	.5661 - .5970	105.75	85.20	78.30	75.00	71.50	68.70
.6094	39/64	9/16	6	2 1/4	5/8	9	34006094	64.70	-	-	-	-	-	-	-
.6250	5/8	9/16	6	2 1/4	5/8	9	340020	64.70	.5971 - .6280	105.75	85.20	78.30	75.00	71.50	68.70
.6406	41/64	9/16	6	2 1/4	5/8	9	34006406	65.75	-	-	-	-	-	-	-
.6562	21/32	9/16	6	2 1/4	5/8	9	340021	65.75	.6281 - .6590	106.85	86.25	79.40	76.10	72.60	69.80
.6719	43/64	9/16	6	2 1/4	5/8	9	34006719	65.75	-	-	-	-	-	-	-
.6875	11/16	9/16	6	2 1/4	5/8	9	340022	65.75	.6591 - .6910	106.85	86.25	79.40	76.10	72.60	69.80
.7031	45/64	9/16	6	2 1/4	5/8	9	34007031	68.90	-	-	-	-	-	-	-
.7188	23/32	9/16	6	2 1/4	5/8	9	340023	68.90	.6911 - .7220	109.95	89.40	82.50	79.20	75.70	72.90
.7344	47/64	5/8	6	2 1/2	3/4	9 1/2	34007344	68.90	-	-	-	-	-	-	-
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	340024	68.90	.7221 - .7530	109.95	89.40	82.50	79.20	75.70	72.90

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.7656	49/64	5/8	6	2 1/2	3/4	9 1/2	34007656	\$71.15	-	-	-	-	-	-	-
.7812	25/32	5/8	6	2 1/2	3/4	9 1/2	340025	71.15	.7531 - .7840	\$112.20	\$91.65	\$84.75	\$81.50	\$77.95	\$75.20
.7969	51/64	5/8	6	2 1/2	3/4	9 1/2	34007969	71.15	-	-	-	-	-	-	-
.8125	13/16	5/8	6	2 1/2	3/4	9 1/2	340026	71.15	.7841 - .8160	112.20	91.65	84.75	81.50	77.95	75.20
.8281	53/64	5/8	6	2 1/2	3/4	9 1/2	34008281	74.00	-	-	-	-	-	-	-
.8438	27/32	5/8	6	2 1/2	3/4	9 1/2	340027	74.00	.8161 - .8470	115.10	94.50	87.60	84.35	80.80	78.05
.8594	55/64	3/4	6	2 5/8	3/4	10	34008594	74.00	-	-	-	-	-	-	-
.8750	7/8	3/4	6	2 5/8	3/4	10	340028	74.00	.8471 - .8780	115.10	94.50	87.60	84.35	80.80	78.05
.8906	57/64	3/4	6	2 5/8	3/4	10	34008906	86.20	-	-	-	-	-	-	-
.9062	29/32	3/4	6	2 5/8	3/4	10	340029	86.20	.8781 - .9090	127.25	106.70	99.80	96.50	93.00	90.20
.9219	59/64	3/4	8	2 5/8	3/4	10	34009219	86.20	-	-	-	-	-	-	-
.9375	15/16	3/4	8	2 5/8	3/4	10	340030	86.20	.9091 - .9410	127.25	106.70	99.80	96.50	93.00	90.20
.9531	61/64	3/4	8	2 5/8	3/4	10	34009531	90.40	-	-	-	-	-	-	-
.9688	31/32	3/4	8	2 5/8	3/4	10	340031	90.40	.9411 - .9720	131.45	110.90	104.00	100.70	97.20	94.40
.9844	63/64	7/8	8	2 3/4	3/4	10 1/2	34009844	90.40	-	-	-	-	-	-	-
1.0000	1	7/8	8	2 3/4	3/4	10 1/2	340032	90.40	.9721 - 1.0030	131.45	110.90	104.00	100.70	97.20	94.40
1.0625	1 1/16	7/8	8	2 3/4	3/4	10 1/2	340034	93.45	1.0031 - 1.0660	132.80	113.10	106.50	103.35	100.00	97.30
1.1250	1 1/8	7/8	8	2 7/8	7/8	11	340036	101.05	1.0661 - 1.1280	140.40	120.65	114.05	110.95	107.55	104.90
1.1875	1 3/16	1	8	2 7/8	7/8	11	340038	106.20	1.1281 - 1.1905	145.55	125.80	119.20	116.10	112.70	110.05
1.2500	1 1/4	1	8	3	7/8	11 1/2	340040	112.30	1.1906 - 1.2530	151.65	131.95	125.35	122.20	118.80	116.15
1.3125	1 5/16	1	8	3	7/8	11 1/2	340042	118.10	1.2531 - 1.3155	157.45	137.75	131.15	128.00	124.60	121.95
1.3750	1 3/8	1	8	3 1/4	7/8	12	340044	125.35	1.3156 - 1.3780	164.70	145.00	138.40	135.25	131.85	129.20
1.4375	1 7/16	1 1/4	8	3 1/4	7/8	12	340046	139.65	1.3781 - 1.4405	179.05	159.30	152.70	149.55	146.20	143.55
1.5000	1 1/2	1 1/4	8	3 1/2	7/8	12 1/2	340048	147.65	1.4406 - 1.5030	187.00	167.30	160.70	157.55	154.15	151.50
1.5625	1 9/16	1 1/4	8	3 1/2	7/8	12 1/2	340050	219.30	1.5031 - 1.5660	258.65	238.90	232.30	229.20	225.80	223.15
1.6250	1 5/8	1 1/4	8	3 3/4	7/8	13	340052	226.75	1.5661 - 1.6280	266.15	246.40	239.80	236.65	233.30	230.65
1.6875	1 11/16	1 1/4	8	3 3/4	7/8	13	340054	255.10	1.6281 - 1.6910	294.45	274.75	268.15	265.00	261.60	258.95
1.7500	1 3/4	1 1/4	10	4	7/8	13 1/2	340056	255.10	1.6911 - 1.7530	294.45	274.75	268.15	265.00	261.60	258.95
1.8125	1 13/16	1 1/2	10	4	7/8	13 1/2	340058	255.10	1.7531 - 1.8160	294.45	274.75	268.15	265.00	261.60	258.95
1.8750	1 7/8	1 1/2	10	4 1/4	7/8	14	340060	267.25	1.8161 - 1.8780	306.60	286.90	280.30	277.15	273.80	271.10
1.9375	1 15/16	1 1/2	10	4 1/4	7/8	14	340062	267.25	1.8781 - 1.9410	306.60	286.90	280.30	277.15	273.80	271.10
2.0000	2	1 1/2	12	4 1/4	7/8	14	340064	267.25	1.9411 - 2.0030	306.60	286.90	280.30	277.15	273.80	271.10

*Quantities of 15 or more: price of fractional size in same size range.

WIRE & LETTER SIZES

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH
WIRE LETTER	DECIMAL			FLT	CARB	OAL		
22	.1570	.151	4	1	1/2	4	34001570	\$56.30
21	.1590	.151	4	1	1/2	4	34001590	56.30
20	.1610	.151	4	1	1/2	4	34001610	56.30
19	.1660	.151	4	1	1/2	4	34001660	56.30
18	.1695	.151	4	1	1/2	4	34001695	56.30
17	.1730	.151	4	1	1/2	4	34001730	56.30
16	.1770	11/64	4	1 1/8	1/2	4 1/2	34001770	52.35
15	.1800	11/64	4	1 1/8	1/2	4 1/2	34001800	52.35
14	.1820	11/64	4	1 1/8	1/2	4 1/2	34001820	52.35
13	.1850	11/64	4	1 1/8	1/2	4 1/2	3400047	52.35
12	.1890	11/64	4	1 1/8	1/2	4 1/2	3400048	52.35
11	.1910	11/64	4	1 1/8	1/2	4 1/2	34001910	52.35
10	.1935	11/64	4	1 1/8	1/2	4 1/2	34001935	52.35
9	.1960	11/64	4	1 1/8	1/2	4 1/2	34001960	52.35
8	.1990	11/64	4	1 1/8	1/2	4 1/2	34001990	52.35
7	.2010	11/64	4	1 1/8	1/2	4 1/2	34002010	52.35
6	.2040	11/64	4	1 1/8	1/2	4 1/2	34002040	52.35
5	.2055	13/64	4	1 1/4	1/2	5	34002055	52.35
4	.2090	13/64	4	1 1/4	1/2	5	34002090	52.35
3	.2130	13/64	4	1 1/4	1/2	5	34002130	52.35
2	.2210	13/64	4	1 1/4	1/2	5	34002210	52.35
1	.2280	7/32	4	1 1/2	1/2	6	34002280	54.80
A	.2340	7/32	4	1 1/2	1/2	6	34002340	54.80
B	.2380	7/32	4	1 1/2	1/2	6	34002380	54.80

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH
WIRE LETTER	DECIMAL			FLT	CARB	OAL		
C	.2420	15/64	4	1 1/2	1/2	6	34002420	\$52.35
D	.2460	15/64	4	1 1/2	1/2	6	34002460	52.35
E	.2500	15/64	4	1 1/2	1/2	6	3400008	40.00
F	.2570	15/64	4	1 1/2	1/2	6	34002570	53.20
G	.2610	15/64	4	1 1/2	1/2	6	34002610	53.20
H	.2660	15/64	4	1 1/2	1/2	6	34002660	53.20
I	.2720	15/64	4	1 1/2	1/2	6	34002720	53.20
J	.2770	15/64	4	1 1/2	1/2	6	34002770	53.20
K	.2810	15/64	4	1 1/2	1/2	6	34002810	53.20
L	.2900	9/32	4	1 1/2	1/2	6	34002900	53.20
M	.2950	9/32	4	1 1/2	1/2	6	34002950	53.20
N	.3020	9/32	4	1 1/2	1/2	6	34003020	53.20
O	.3160	9/32	4	1 1/2	1/2	6	34003160	54.65
P	.3230	9/32	4	1 1/2	1/2	6	34003230	54.65
Q	.3320	9/32	4	1 1/2	1/2	6	34003320	54.65
R	.3390	9/32	4	1 1/2	1/2	6	34003390	54.65
S	.3480	5/16	4	1 3/4	5/8	7	34003480	50.10
T	.3580	5/16	4	1 3/4	5/8	7	34003580	50.10
U	.3680	5/16	4	1 3/4	5/8	7	34003680	50.10
V	.3770	5/16	4	1 3/4	5/8	7	34003770	50.10
W	.3860	5/16	4	1 3/4	5/8	7	34003860	56.70
X	.3970	5/16	4	1 3/4	5/8	7	34003970	56.70
Y	.4040	5/16	4	1 3/4	5/8	7	34004040	56.70
Z	.4130	3/8	4	1 3/4	5/8	7	34004130	59.65

CARBIDE TIPPED REGULAR LENGTH CHUCKING REAMERS

TYPE 3400 - STRAIGHT SHANK - STRAIGHT FLUTES

Detailed description and fractional sizes on pages 52 & 53. Tolerances on page 50. Tool diameter in millimeters with all other dimensions in inches.



TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
4.0	.1575	.151	4	1	1/2	4	3400040	\$56.30	3.962 - 4.493	\$85.05	\$65.95	\$59.50	\$56.35	\$53.15	\$50.50	\$46.80
4.5	.1772	1/64	4	1 1/8	1/2	4 1/2	3400045	52.35	4.494 - 5.182	80.40	61.80	55.55	52.50	49.35	46.75	43.20
5.0	.1969	1/64	4	1 1/8	1/2	4 1/2	3400050	52.35	-	-	-	-	-	-	-	-
5.5	.2165	13/64	4	1 1/4	1/2	5	3400055	52.35	5.183 - 5.613	80.40	61.80	55.55	52.50	49.35	46.75	43.20
6.0	.2362	7/32	4	1 1/2	1/2	6	3400060	54.80	5.614 - 6.045	82.80	64.15	57.90	54.85	51.75	49.15	45.55
-	-	15/64	4	1 1/2	1/2	6	3400063	-	6.046 - 6.426	80.40	61.80	55.55	52.50	49.35	46.75	43.20
6.5	.2559	15/64	4	1 1/2	1/2	6	3400065	53.20	6.427 - 7.214	81.25	62.65	56.40	53.35	50.20	47.60	44.05
7.0	.2756	15/64	4	1 1/2	1/2	6	3400070	53.20	-	-	-	-	-	-	-	-
7.5	.2953	9/32	4	1 1/2	1/2	6	3400075	53.20	7.215 - 8.001	81.25	62.65	56.40	53.35	50.20	47.60	44.05
8.0	.3150	9/32	4	1 1/2	1/2	6	3400080	53.20	-	-	-	-	-	-	-	-
8.5	.3346	9/32	4	1 1/2	5/8	6	3400085	54.65	8.002 - 8.814	82.70	64.10	57.85	54.80	51.65	49.05	45.45
9.0	.3543	5/16	4	1 3/4	5/8	7	3400090	50.10	8.815 - 9.601	75.90	58.80	53.05	50.25	47.40	45.00	41.70
9.5	.3740	5/16	4	1 3/4	5/8	7	347837	53.25	-	-	-	-	-	-	-	-
10.0	.3937	5/16	4	1 3/4	5/8	7	3400100	56.70	9.602 - 10.389	84.75	66.15	59.90	56.85	53.70	51.10	47.55
10.5	.4134	3/8	4	1 3/4	5/8	7	3400105	59.65	10.390 - 11.201	87.75	69.15	62.85	59.80	56.70	54.10	50.50
11.0	.4331	3/8	4	1 3/4	5/8	7	3400110	59.65	-	-	-	-	-	-	-	-
11.5	.4528	3/8	4	1 3/4	5/8	7	3400115	60.35	11.202 - 11.989	88.45	69.80	63.55	60.50	57.40	54.80	51.20
12.0	.4724	7/16	6	2	5/8	8	3400120	70.75	11.990 - 12.776	101.65	81.15	74.25	70.90	67.45	64.60	60.65
12.5	.4921	7/16	6	2	5/8	8	3400125	70.75	-	-	-	-	-	-	-	-
13.0	.5118	7/16	6	2	5/8	8	3400130	75.85	12.777 - 13.564	106.70	86.20	79.30	75.95	72.50	69.65	65.70
13.5	.5315	7/16	6	2	5/8	8	3400135	75.85	-	-	-	-	-	-	-	-
14.0	.5512	7/16	6	2	5/8	8	3400140	75.85	13.565 - 14.376	106.70	86.20	79.30	75.95	72.50	69.65	65.70
14.5	.5709	7/16	6	2	5/8	8	3400145	78.30	14.377 - 15.164	109.20	88.70	81.80	78.45	75.00	72.15	68.20
15.0	.5906	7/16	6	2	5/8	8	3400150	78.30	-	-	-	-	-	-	-	-
15.5	.6102	9/16	6	2 1/4	5/8	9	3400155	78.30	15.165 - 15.951	109.20	88.70	81.80	78.45	75.00	72.15	68.20
16.0	.6299	9/16	6	2 1/4	5/8	9	3400160	79.40	15.952 - 16.739	110.30	89.80	82.90	79.55	76.10	73.25	69.30
16.5	.6496	9/16	6	2 1/4	5/8	9	3400165	79.40	-	-	-	-	-	-	-	-
17.0	.6693	9/16	6	2 1/4	5/8	9	3400170	79.40	16.740 - 17.551	110.30	89.80	82.90	79.55	76.10	73.25	69.30
17.5	.6890	9/16	6	2 1/4	5/8	9	3400175	79.40	-	-	-	-	-	-	-	-
18.0	.7087	9/16	6	2 1/4	5/8	9	3400180	82.50	17.552 - 18.339	113.40	92.90	86.00	82.65	79.20	76.35	72.40
18.5	.7283	5/8	6	2 1/2	3/4	9 1/2	3400185	82.50	18.340 - 19.126	113.40	92.90	86.00	82.65	79.20	76.35	72.40
19.0	.7480	5/8	6	2 1/2	3/4	9 1/2	3400190	82.50	-	-	-	-	-	-	-	-
19.5	.7677	5/8	6	2 1/2	3/4	9 1/2	3400195	84.75	19.127 - 19.914	115.65	95.15	88.30	84.90	81.50	78.60	74.70
20.0	.7874	5/8	6	2 1/2	3/4	9 1/2	3400200	84.75	19.915 - 20.726	115.65	95.15	88.30	84.90	81.50	78.60	74.70
20.5	.8071	5/8	6	2 1/2	3/4	9 1/2	3400205	84.75	-	-	-	-	-	-	-	-
21.0	.8268	5/8	6	2 1/2	3/4	9 1/2	3400210	87.60	20.727 - 21.514	118.50	98.05	91.15	87.80	84.35	81.50	77.55
21.5	.8465	5/8	6	2 1/2	3/4	9 1/2	3400215	87.60	-	-	-	-	-	-	-	-
22.0	.8661	3/4	6	2 5/8	3/4	10	3400220	87.60	21.515 - 22.301	118.50	98.05	91.15	87.80	84.35	81.50	77.55
22.5	.8858	3/4	6	2 5/8	3/4	10	3400225	99.80	22.302 - 23.089	130.70	110.20	103.30	99.95	96.50	93.65	89.70
23.0	.9055	3/4	6	2 5/8	3/4	10	3400230	99.80	-	-	-	-	-	-	-	-
23.5	.9252	3/4	8	2 5/8	3/4	10	3400235	99.80	23.090 - 23.901	130.70	110.20	103.30	99.95	96.50	93.65	89.70
24.0	.9449	3/4	8	2 5/8	3/4	10	3400240	104.00	23.902 - 24.689	134.90	114.40	107.50	104.15	100.70	97.85	93.90
24.5	.9646	3/4	8	2 5/8	3/4	10	3400245	104.00	-	-	-	-	-	-	-	-
25.0	.9843	7/8	8	2 3/4	3/4	10 1/2	3400250	104.00	24.690 - 25.476	134.90	114.40	107.50	104.15	100.70	97.85	93.90
25.5	1.0039	7/8	8	2 3/4	3/4	10 1/2	3400255	106.50	25.477 - 27.076	136.15	116.50	109.90	106.65	103.35	100.60	96.85
26.0	1.0236	7/8	8	2 3/4	3/4	10 1/2	3400260	106.50	-	-	-	-	-	-	-	-
27.0	1.0630	7/8	8	2 3/4	3/4	10 1/2	3400270	106.50	-	-	-	-	-	-	-	-
28.0	1.1024	7/8	8	2 7/8	7/8	11	3400280	114.05	27.077 - 28.651	143.70	124.05	117.45	114.25	110.95	108.20	104.40
29.0	1.1417	1	8	2 7/8	7/8	11	3400290	119.20	28.652 - 30.239	148.85	129.20	122.60	119.40	116.10	113.35	109.55
30.0	1.1811	1	8	2 7/8	7/8	11	3400300	119.20	-	-	-	-	-	-	-	-
31.0	1.2205	1	8	3	7/8	11 1/2	3400310	125.35	30.240 - 31.826	154.95	135.30	128.70	125.50	122.20	119.45	115.70
32.0	1.2598	1	8	3	7/8	11 1/2	3400320	131.15	31.827 - 33.414	160.75	141.10	134.50	131.30	128.00	125.25	121.45
33.0	1.2992	1	8	3	7/8	11 1/2	3400330	131.15	-	-	-	-	-	-	-	-
34.0	1.3386	1	8	3 1/4	7/8	12	3400340	138.40	33.415 - 35.001	168.00	148.35	141.75	138.55	135.25	132.50	128.70
35.0	1.3780	1	8	3 1/4	7/8	12	3400350	138.40	-	-	-	-	-	-	-	-
36.0	1.4173	1 1/4	8	3 1/4	7/8	12	3400360	152.70	35.002 - 36.589	182.35	162.70	156.10	152.85	149.55	146.85	143.05
37.0	1.4567	1 1/4	8	3 1/2	7/8	12 1/2	3400370	160.70	36.590 - 38.176	190.30	170.65	164.05	160.85	157.55	154.80	151.00

CARBIDE TIPPED SEMI-FINISHED REAMERS

Semi-finished reamers are furnished with a tool diameter above the largest diameter indicated in the size range column below.

Before semi-finished reamers can be used, the tool diameter must be finished ground and relieved. The reamer end must be faced and chamfered.

Semi-finished reamers are used by regrind shops or distributors and users with regrind facilities.

For detailed description of each specific type, see page indicated in table below.

Call for pricing on Types 3420 & 3467 semi-finished reamers.



SEMI-FINISHED TOOL DIAMETER RANGE	TYPE 3400 PAGE 52		TYPE 3402 PAGE 60		TYPE 3410 PAGE 72		TYPE 3430 PAGE 80	TYPE 3440 PAGE 80	BOTH TYPES PRICE	TYPE 3450 PAGE 62		TYPE 3465 PAGE 76	
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	EDP NO.	EDP NO.		EDP NO.	PRICE EACH	EDP NO.	PRICE EACH
.1770 - .2040	340006SF	\$34.05	-	-	341006SF	\$44.45	343006SF	344006SF	\$44.30	345006SF	\$40.70	-	-
.2041 - .2210	340007SF	34.05	-	-	341007SF	44.45	343007SF	344007SF	44.30	345007SF	40.70	-	-
.2211 - .2380	34002344SF	36.00	-	-	34102344SF	44.45	34302344SF	34402344SF	44.30	34502344SF	40.70	-	-
.2381 - .2530	340008SF	34.05	340208SF	\$39.20	341008SF	44.45	343008SF	344008SF	44.30	345008SF	40.70	-	-
.2531 - .2840	340009SF	34.65	340209SF	39.85	341009SF	44.60	343009SF	344009SF	44.30	345009SF	41.55	-	-
.2841 - .3150	340010SF	34.65	340210SF	39.85	341010SF	44.60	343010SF	344010SF	51.50	345010SF	41.55	346510SF	\$62.70
.3151 - .3470	340011SF	35.95	340211SF	41.35	341011SF	49.00	343011SF	344011SF	52.00	345011SF	43.05	346511SF	62.70
.3471 - .3780	340012SF	32.95	340212SF	37.95	341012SF	49.55	343012SF	344012SF	56.35	345012SF	43.05	346512SF	58.80
.3781 - .4090	340013SF	37.70	340213SF	43.35	341013SF	51.75	343013SF	344013SF	57.15	345013SF	45.15	346513SF	62.40
.4091 - .4410	340014SF	40.20	340214SF	46.15	341014SF	53.80	343014SF	344014SF	67.75	345014SF	48.85	346514SF	62.40
.4411 - .4720	340015SF	40.80	340215SF	47.45	341015SF	57.10	343015SF	344015SF	67.75	345015SF	52.85	346515SF	66.10
.4721 - .5030	340016SF	48.55	340216SF	55.85	341016SF	65.00	343016SF	344016SF	74.05	345016SF	56.60	346516SF	66.10
.5031 - .5340	340017SF	52.85	340217SF	60.30	341017SF	65.00	343017SF	344017SF	74.05	345017SF	58.15	346517SF	67.75
.5341 - .5660	340018SF	52.85	340218SF	60.30	341018SF	65.00	343018SF	344018SF	78.10	345018SF	58.15	346518SF	67.75
.5661 - .5970	340019SF	54.95	340219SF	63.15	341019SF	66.95	343019SF	344019SF	78.10	345019SF	60.40	346519SF	70.70
.5971 - .6280	340020SF	54.95	340220SF	63.15	341020SF	66.95	343020SF	344020SF	80.20	345020SF	60.40	346520SF	70.70
.6281 - .6590	340021SF	55.95	340221SF	64.35	341021SF	71.25	343021SF	344021SF	80.20	345021SF	61.50	346521SF	77.30
.6591 - .6910	340022SF	55.95	340222SF	64.35	341022SF	73.40	343022SF	344022SF	83.90	345022SF	61.50	346522SF	77.30
.6911 - .7220	340023SF	58.55	340223SF	67.30	341023SF	75.50	343023SF	344023SF	83.90	345023SF	64.35	346523SF	80.25
.7221 - .7530	340024SF	58.55	340224SF	67.30	341024SF	75.50	343024SF	344024SF	86.05	345024SF	64.35	346524SF	80.25
.7531 - .7840	340025SF	60.50	340225SF	69.40	341025SF	80.10	343025SF	344025SF	86.05	345025SF	66.55	346525SF	86.50
.7841 - .8160	340026SF	60.50	340226SF	69.40	341026SF	80.10	343026SF	344026SF	93.45	345026SF	66.55	346526SF	86.50
.8161 - .8470	340027SF	62.90	340227SF	72.30	341027SF	84.50	343027SF	344027SF	93.45	345027SF	69.20	346527SF	89.90
.8471 - .8780	340028SF	62.90	340228SF	72.30	341028SF	84.50	343028SF	344028SF	98.45	345028SF	69.20	346528SF	89.90
.8781 - .9090	340029SF	73.35	340229SF	84.85	341029SF	98.40	343029SF	344029SF	98.45	345029SF	80.55	346529SF	95.60
.9091 - .9410	340030SF	73.35	340230SF	84.85	341030SF	98.40	343030SF	344030SF	108.35	345030SF	80.55	346530SF	95.60
.9411 - .9720	340031SF	76.85	340231SF	88.35	341031SF	103.15	343031SF	344031SF	108.35	345031SF	84.40	346531SF	99.35
.9721 - 1.0030	340032SF	76.85	340232SF	88.35	341032SF	103.15	343032SF	344032SF	113.75	345032SF	84.40	346532SF	99.35
1.0031 - 1.0660	340034SF	79.45	340234SF	121.45	341034SF	110.80	343034SF	344034SF	113.75	345034SF	87.35	346534SF	108.95
1.0661 - 1.1280	340036SF	85.90	340236SF	129.30	341036SF	114.15	343036SF	344036SF	133.05	345036SF	94.50	346536SF	108.95
1.1281 - 1.1905	340038SF	90.25	340238SF	137.00	341038SF	119.95	343038SF	344038SF	138.80	345038SF	98.85	346538SF	118.85
1.1906 - 1.2530	340040SF	95.40	340240SF	152.25	341040SF	126.95	343040SF	344040SF	162.60	345040SF	115.45	346540SF	118.85
1.2531 - 1.3155	340042SF	100.40	340242SF	164.15	341042SF	140.50	343042SF	344042SF	162.60	345042SF	115.45	346542SF	131.80
1.3156 - 1.3780	340044SF	106.50	340244SF	170.80	341044SF	153.90	343044SF	344044SF	164.85	345044SF	117.15	346544SF	137.95
1.3781 - 1.4405	340046SF	118.75	340246SF	174.35	341046SF	163.05	343046SF	344046SF	192.25	345046SF	129.35	346546SF	163.00
1.4406 - 1.5030	340048SF	125.50	340248SF	183.05	341048SF	172.30	343048SF	344048SF	230.85	345048SF	155.35	346548SF	167.80

CARBIDE TIPPED CHUCKING REAMERS

TYPE 3402 - TAPER SHANK - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

Designed and manufactured for maximum tool life. Used for all general types of reaming including low carbon steels, cast iron, non-ferrous metals and non-metals.



For metric sizes, see page 61.

For reamer tolerances and closer tolerance pricing, see page 50.

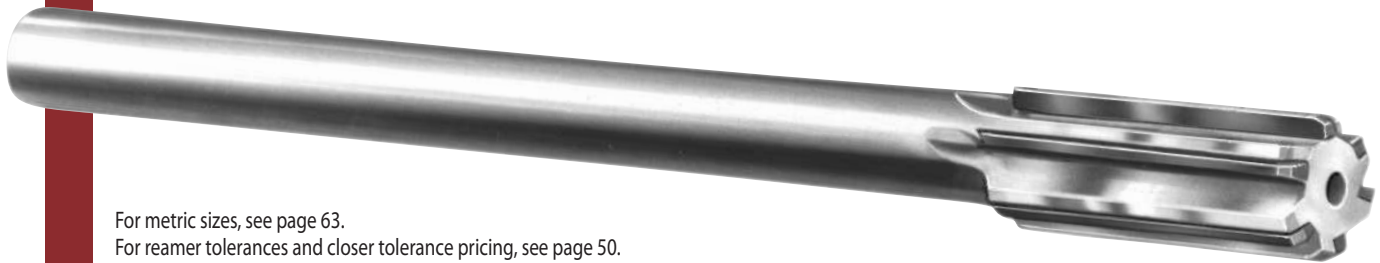
TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	1	4	1 1/2	1/2	6	340208	\$46.10	.2381 - .2530	\$83.40	\$64.70	\$58.45	\$55.45	\$52.25	\$49.75
.2812	9/32	1	4	1 1/2	1/2	6	340209	46.90	.2531 - .2840	84.25	65.55	59.30	56.30	53.10	50.60
.3125	5/16	1	4	1 1/2	1/2	6	340210	46.90	.2841 - .3150	84.25	65.55	59.30	56.30	53.10	50.60
.3438	11/32	1	4	1 1/2	5/8	6	340211	48.70	.3151 - .3470	86.00	67.30	61.05	58.05	54.85	52.35
.3750	3/8	1	4	1 3/4	5/8	7	340212	44.65	.3471 - .3780	78.90	61.75	56.00	53.25	50.35	48.00
.4062	13/32	1	4	1 3/4	5/8	7	340213	51.05	.3781 - .4090	88.35	69.65	63.40	60.45	57.20	54.70
.4375	7/16	1	4	1 3/4	5/8	7	340214	54.35	.4091 - .4410	91.65	72.95	66.70	63.70	60.50	58.00
.4688	15/32	1	4	1 3/4	5/8	7	340215	55.80	.4411 - .4720	93.10	74.40	68.15	65.15	61.95	59.45
.5000	1/2	1	6	2	5/8	8	340216	65.70	.4721 - .5030	106.75	86.20	79.30	76.00	72.50	69.70
.5312	17/32	1	6	2	5/8	8	340217	70.90	.5031 - .5340	111.95	91.40	84.50	81.25	77.70	74.95
.5625	9/16	1	6	2	5/8	8	340218	70.90	.5341 - .5660	111.95	91.40	84.50	81.25	77.70	74.95
.5938	19/32	1	6	2	5/8	8	340219	74.35	.5661 - .5970	115.40	94.85	87.95	84.65	81.15	78.35
.6250	5/8	2	6	2 1/4	5/8	9	340220	74.35	.5971 - .6280	115.40	94.85	87.95	84.65	81.15	78.35
.6562	21/32	2	6	2 1/4	5/8	9	340221	75.70	.6281 - .6590	116.75	96.20	89.30	86.00	82.50	79.70
.6875	11/16	2	6	2 1/4	5/8	9	340222	75.70	.6591 - .6910	116.75	96.20	89.30	86.00	82.50	79.70
.7188	23/32	2	6	2 1/4	5/8	9	340223	79.15	.6911 - .7220	120.20	99.60	92.75	89.45	85.95	83.15
.7500	3/4	2	6	2 1/2	3/4	9 1/2	340224	79.15	.7221 - .7530	120.20	99.60	92.75	89.45	85.95	83.15
.7812	25/32	2	6	2 1/2	3/4	9 1/2	340225	81.55	.7531 - .7840	122.65	102.05	95.15	91.90	88.35	85.60
.8125	13/16	2	6	2 1/2	3/4	9 1/2	340226	81.55	.7841 - .8160	122.65	102.05	95.15	91.90	88.35	85.60
.8438	27/32	2	6	2 1/2	3/4	9 1/2	340227	85.10	.8161 - .8470	126.15	105.60	98.70	95.40	91.90	89.10
.8750	7/8	2	6	2 5/8	3/4	10	340228	85.10	.8471 - .8780	126.15	105.60	98.70	95.40	91.90	89.10
.9062	29/32	2	6	2 5/8	3/4	10	340229	99.80	.8781 - .9090	140.85	120.30	113.40	110.10	106.60	103.80
.9375	15/16	3	8	2 5/8	3/4	10	340230	99.80	.9091 - .9410	140.85	120.30	113.40	110.10	106.60	103.80
.9688	31/32	3	8	2 5/8	3/4	10	340231	104.00	.9411 - .9720	145.05	124.50	117.60	114.30	110.80	108.00
1.0000	1	3	8	2 3/4	3/4	10 1/2	340232	104.00	.9721 - 1.0030	145.05	124.50	117.60	114.30	110.80	108.00
1.0625	1 1/16	3	8	2 3/4	3/4	10 1/2	340234	142.90	1.0031 - 1.0660	182.25	162.55	155.95	152.80	149.40	146.75
1.1250	1 1/8	3	8	2 7/8	7/8	11	340236	152.15	1.0661 - 1.1280	191.50	171.80	165.20	162.05	158.65	156.00
1.1875	1 3/16	3	8	2 7/8	7/8	11	340238	161.15	1.1281 - 1.1905	200.55	180.80	174.20	171.05	167.70	165.00
1.2500	1 1/4	4	8	3	7/8	11 1/2	340240	179.10	1.1906 - 1.2530	218.50	198.75	192.15	189.00	185.65	183.00
1.3125	1 5/16	4	8	3	7/8	11 1/2	340242	193.10	1.2531 - 1.3155	232.50	212.75	206.15	203.00	199.65	197.00
1.3750	1 3/8	4	8	3 1/4	7/8	12	340244	200.95	1.3156 - 1.3780	240.30	220.55	213.95	210.85	207.45	204.80
1.4375	1 7/16	4	8	3 1/4	7/8	12	340246	205.10	1.3781 - 1.4405	244.50	224.75	218.15	215.00	211.65	209.00
1.5000	1 1/2	4	8	3 1/2	7/8	12 1/2	340248	215.35	1.4406 - 1.5030	254.70	235.00	228.40	225.25	221.85	219.20
1.5625	1 9/16	4	8	3 1/2	7/8	12 1/2	340250	232.40	1.5031 - 1.5660	271.75	252.05	245.45	242.30	238.90	236.25
1.6250	1 5/8	4	8	3 3/4	7/8	13	340252	240.45	1.5661 - 1.6280	279.80	260.10	253.50	250.35	246.95	244.30
1.6875	1 11/16	4	8	3 3/4	7/8	13	340254	270.40	1.6281 - 1.6910	309.75	290.05	283.45	280.30	276.90	274.25
1.7500	1 3/4	4	10	4	7/8	13 1/2	340256	270.40	1.6911 - 1.7530	309.75	290.05	283.45	280.30	276.90	274.25
1.8125	1 13/16	4	10	4	7/8	13 1/2	340258	270.40	1.7531 - 1.8160	309.75	290.05	283.45	280.30	276.90	274.25
1.8750	1 7/8	4	10	4 1/4	7/8	14	340260	283.30	1.8161 - 1.8780	322.65	302.90	296.30	293.20	289.80	287.15
1.9375	1 15/16	4	10	4 1/4	7/8	14	340262	283.30	1.8781 - 1.9410	322.65	302.90	296.30	293.20	289.80	287.15
2.0000	2	4	12	4 1/4	7/8	14	340264	283.30	1.9411 - 2.0030	322.65	302.90	296.30	293.20	289.80	287.15

CARBIDE TIPPED CHUCKING REAMERS

TYPE 3450 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies.
Straight polished flutes.

Designed and manufactured for maximum tool life. Used for all general types of reaming including low carbon steels, cast iron, non-ferrous metals and non-metals. Designed with flute long carbide for deep hole reaming. Smaller sizes available in solid carbide. See pages 42 through 46.



For metric sizes, see page 63.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH		EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLUTE	OVERALL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	1 1/64	4	1 1/2	6	345006	\$47.80	.1770 - .2040	\$86.15	\$66.95	\$60.60	\$57.45	\$54.15	\$51.60
.2188	7/32	13/64	4	1 1/2	6	345007	47.80	.2041 - .2210	86.15	66.95	60.60	57.45	54.15	51.60
.2344	15/64	7/32	4	1 1/2	6	34502344	47.80	.2211 - .2380	86.15	66.95	60.60	57.45	54.15	51.60
.2500	1/4	15/64	4	1 1/2	6	345008	47.80	.2381 - .2530	86.15	66.95	60.60	57.45	54.15	51.60
.2812	9/32	15/64	4	1 1/2	6	345009	48.85	.2531 - .2840	87.20	67.95	61.55	58.50	55.20	52.60
.3125	5/16	9/32	4	1 1/2	6	345010	48.85	.2841 - .3150	87.20	67.95	61.55	58.50	55.20	52.60
.3438	11/32	9/32	4	1 1/2	6	345011	50.65	.3151 - .3470	89.00	69.80	63.35	60.30	57.00	54.40
.3750	3/8	5/16	4	1 3/4	7	345012	50.65	.3471 - .3780	89.00	69.80	63.35	60.30	57.00	54.40
.4062	13/32	5/16	4	1 3/4	7	345013	53.15	.3781 - .4090	91.50	72.30	65.85	62.80	59.50	56.90
.4375	7/16	3/8	4	1 3/4	7	345014	57.45	.4091 - .4410	95.80	76.60	70.15	67.10	63.80	61.25
.4688	15/32	3/8	4	1 3/4	7	345015	62.10	.4411 - .4720	100.45	81.20	74.80	71.75	68.45	65.85
.5000	1/2	7/16	6	2	8	345016	66.55	.4721 - .5030	107.60	87.00	80.15	76.85	73.35	70.55
.5312	17/32	7/16	6	2	8	345017	68.40	.5031 - .5340	109.45	88.85	82.05	78.70	75.20	72.40
.5625	9/16	7/16	6	2	8	345018	68.40	.5341 - .5660	109.45	88.85	82.05	78.70	75.20	72.40
.5938	19/32	7/16	6	2	8	345019	71.05	.5661 - .5970	112.15	91.55	84.65	81.40	77.85	75.10
.6250	5/8	9/16	6	2	9	345020	71.05	.5971 - .6280	112.15	91.55	84.65	81.40	77.85	75.10
.6562	21/32	9/16	6	2	9	345021	72.30	.6281 - .6590	113.40	92.80	85.95	82.65	79.15	76.35
.6875	11/16	9/16	6	2	9	345022	72.30	.6591 - .6910	113.40	92.80	85.95	82.65	79.15	76.35
.7188	23/32	9/16	6	2	9	345023	75.70	.6911 - .7220	116.75	96.20	89.30	86.00	82.50	79.70
.7500	3/4	5/8	6	2	9 1/2	345024	75.70	.7221 - .7530	116.75	96.20	89.30	86.00	82.50	79.70
.7812	25/32	5/8	6	2	9 1/2	345025	78.30	.7531 - .7840	119.35	98.80	91.90	88.60	85.10	82.30
.8125	13/16	5/8	6	2	9 1/2	345026	78.30	.7841 - .8160	119.35	98.80	91.90	88.60	85.10	82.30
.8438	27/32	5/8	6	2	9 1/2	345027	81.40	.8161 - .8470	122.45	101.90	95.00	91.75	88.20	85.45
.8750	7/8	3/4	6	2 1/4	10	345028	81.40	.8471 - .8780	122.45	101.90	95.00	91.75	88.20	85.45
.9062	29/32	3/4	6	2 1/4	10	345029	94.75	.8781 - .9090	135.85	115.25	108.35	105.10	101.55	98.80
.9375	15/16	3/4	8	2 1/4	10	345030	94.75	.9091 - .9410	135.85	115.25	108.35	105.10	101.55	98.80
.9688	31/32	3/4	8	2 1/4	10	345031	99.30	.9411 - .9720	140.35	119.80	112.90	109.60	106.10	103.30
1.0000	1	7/8	8	2 1/4	10 1/2	345032	99.30	.9721 - 1.0030	140.35	119.80	112.90	109.60	106.10	103.30
1.0625	1 1/16	7/8	8	2 1/4	10 1/2	345034	102.70	1.0031 - 1.0660	142.10	122.35	115.75	112.60	109.25	106.60
1.1250	1 1/8	7/8	8	2 1/4	11	345036	111.15	1.0661 - 1.1280	150.55	130.80	124.20	121.05	117.70	115.05
1.1875	1 3/16	1	8	2 1/4	11	345038	116.30	1.1281 - 1.1905	155.70	135.95	129.35	126.20	122.85	120.20
1.2500	1 1/4	1	8	2 1/2	11 1/2	345040	135.80	1.1906 - 1.2530	175.15	155.45	148.85	145.70	142.30	139.65
1.3125	1 5/16	1	8	2 1/2	11 1/2	345042	135.80	1.2531 - 1.3155	175.15	155.45	148.85	145.70	142.30	139.65
1.3750	1 3/8	1	8	2 1/2	12	345044	137.80	1.3156 - 1.3780	177.20	157.45	150.85	147.70	144.35	141.70
1.4375	1 7/16	1 1/4	8	2 1/2	12	345046	152.25	1.3781 - 1.4405	191.60	171.85	165.25	162.15	158.75	156.10
1.5000	1 1/2	1 1/4	8	2 1/2	12 1/2	345048	182.75	1.4406 - 1.5030	222.10	202.40	195.80	192.65	189.25	186.60
1.5625	1 9/16	1 1/4	8	2 1/2	12 1/2	345050	241.20	1.5031 - 1.5660	280.55	260.80	254.20	251.10	247.70	245.05
1.6250	1 5/8	1 1/4	8	2 3/4	13	345052	249.45	1.5661 - 1.6280	288.85	269.10	262.50	259.35	256.00	253.35
1.6875	1 11/16	1 1/4	8	2 3/4	13	345054	273.95	1.6281 - 1.6910	313.30	293.60	287.00	283.85	280.45	277.80
1.7500	1 3/4	1 1/4	10	3	13 1/2	345056	273.95	1.6911 - 1.7530	313.30	293.60	287.00	283.85	280.45	277.80
1.8125	1 13/16	1 1/2	10	3	13 1/2	345058	280.30	1.7531 - 1.8160	319.65	299.95	293.35	290.20	286.80	284.15
1.8750	1 7/8	1 1/2	10	3 1/4	14	345060	293.90	1.8161 - 1.8780	333.25	313.55	306.95	303.80	300.45	297.75
1.9375	1 15/16	1 1/2	10	3 1/4	14	345062	311.60	1.8781 - 1.9410	351.00	331.25	324.65	321.50	318.15	315.50
2.0000	2	1 1/2	12	3 1/4	14	345064	311.60	1.9411 - 2.0030	351.00	331.25	324.65	321.50	318.15	315.50

LEXINGTON CUTTER, INC. • sales@lexingtoncutter.com • Phone 800-882-2627 • Fax 800-882-3637

CARBIDE TIPPED CHUCKING REAMERS FOR STEEL

TYPE 3480 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies.
Straight polished flutes.

Designed and manufactured for reaming accurate holes in steel, tough steel alloys and cast steels. Steel grade carbide is used in a full flute design with special steel cutting geometry that results in excellent performance and maximum tool life. Fast cutting to close tolerance.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLUTES	LENGTH		EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLUTE	OVERALL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	.1805	4	1 1/8	4 1/2	348006	\$57.40	.1770 - .2040	\$95.75	\$76.50	\$70.10	\$67.05	\$63.75	\$61.15
.2031	13/64	.1805	4	1 1/8	4 1/2	34802031	57.40	-	-	-	-	-	-	-
.2188	7/32	.2075	4	1 1/4	5	348007	57.40	.2041 - .2210	95.75	76.50	70.10	67.05	63.75	61.15
.2344	15/64	.2265	4	1 1/2	6	34802344	57.40	.2211 - .2380	95.75	76.50	70.10	67.05	63.75	61.15
.2500	1/4	.2405	4	1 1/2	6	348008	57.40	.2381 - .2530	95.75	76.50	70.10	67.05	63.75	61.15
.2656	17/64	.2485	4	1 1/2	6	34802656	58.65	-	-	-	-	-	-	-
.2812	9/32	.2485	4	1 1/2	6	348009	58.65	.2531 - .2840	97.00	77.75	71.35	68.30	65.00	62.40
.2969	19/64	.2792	4	1 1/2	6	34802969	58.65	-	-	-	-	-	-	-
.3125	5/16	.2792	4	1 1/2	6	348010	58.65	.2841 - .3150	97.00	77.75	71.35	68.30	65.00	62.40
.3281	21/64	.2792	4	1 1/2	6	34803281	60.75	-	-	-	-	-	-	-
.3438	11/32	.2792	4	1 1/2	6	348011	60.75	.3151 - .3470	99.10	79.90	73.45	70.40	67.10	64.50
.3594	23/64	.3105	4	1 3/4	7	34803594	60.75	-	-	-	-	-	-	-
.3750	3/8	.3105	4	1 3/4	7	348012	60.75	.3471 - .3780	99.10	79.90	73.45	70.40	67.10	64.50
.3906	25/64	.3105	4	1 3/4	7	34803906	63.75	-	-	-	-	-	-	-
.4062	13/32	.3105	4	1 3/4	7	348013	63.75	.3781 - .4090	102.10	82.85	76.45	73.40	70.10	67.50
.4219	27/64	.3730	6	1 3/4	7	34804219	73.85	-	-	-	-	-	-	-
.4375	7/16	.3730	6	1 3/4	7	348014	73.85	.4091 - .4410	112.20	93.00	86.55	83.50	80.20	77.60
.4531	29/64	.3730	6	1 3/4	7	34804531	74.55	-	-	-	-	-	-	-
.4688	15/32	.3730	6	1 3/4	7	348015	74.55	.4411 - .4720	112.90	93.70	87.25	84.20	80.90	78.30
.4844	31/64	.4355	6	2	8	34804844	79.90	-	-	-	-	-	-	-
.5000	1/2	.4355	6	2	8	348016	79.90	.4721 - .5030	120.95	100.40	93.50	90.20	86.70	83.90
.5156	33/64	.4355	6	2	8	34805156	82.15	-	-	-	-	-	-	-
.5312	17/32	.4355	6	2	8	348017	82.15	.5031 - .5340	123.25	102.65	95.75	92.50	88.95	86.20
.5469	35/64	.4355	6	2	8	34805469	82.15	-	-	-	-	-	-	-
.5625	9/16	.4355	6	2	8	348018	82.15	.5341 - .5660	123.25	102.65	95.75	92.50	88.95	86.20
.5781	37/64	.4355	6	2	8	34805781	85.25	-	-	-	-	-	-	-
.5938	19/32	.4355	6	2	8	348019	85.25	.5661 - .5970	126.35	105.75	98.85	95.60	92.05	89.30
.6094	39/64	.5615	6	2 1/4	9	34806094	85.25	-	-	-	-	-	-	-
.6250	5/8	.5615	6	2 1/4	9	348020	85.25	.5971 - .6280	126.35	105.75	98.85	95.60	92.05	89.30
.6406	41/64	.5615	6	2 1/4	9	34806406	86.85	-	-	-	-	-	-	-
.6562	21/32	.5615	6	2 1/4	9	348021	86.85	.6281 - .6590	127.95	107.35	100.45	97.20	93.65	90.90
.6719	43/64	.5615	6	2 1/4	9	34806719	86.85	-	-	-	-	-	-	-

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLUTES	LENGTH		EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLUTE	OVERALL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.6875	11/16	.5615	6	2 1/4	9	348022	\$86.85	.6591 - .6910	\$127.95	\$107.35	\$100.45	\$97.20	93.65	\$90.90
.7031	45/64	.5615	6	2 1/4	9	34807031	90.80	-	-	-	-	-	-	-
.7188	23/32	.5615	6	2 1/4	9	348023	90.80	.6911 - .7220	131.90	111.30	104.40	101.15	97.60	94.85
.7344	47/64	.6245	6	2 1/2	9 1/2	34807344	90.80	-	-	-	-	-	-	-
.7500	3/4	.6245	6	2 1/2	9 1/2	348024	90.80	.7221 - .7530	131.90	111.30	104.40	101.15	97.60	94.85
.7656	49/64	.6245	6	2 1/2	9 1/2	34807656	93.90	-	-	-	-	-	-	-
.7812	25/32	.6245	6	2 1/2	9 1/2	348025	93.90	.7531 - .7840	135.00	114.40	107.50	104.25	100.70	97.95
.7969	51/64	.6245	6	2 1/2	9 1/2	34807969	93.90	-	-	-	-	-	-	-
.8125	13/16	.6245	6	2 1/2	9 1/2	348026	93.90	.7841 - .8160	135.00	114.40	107.50	104.25	100.70	97.95
.8281	53/64	.6245	6	2 1/2	9 1/2	34808281	97.70	-	-	-	-	-	-	-
.8438	27/32	.6245	6	2 1/2	9 1/2	348027	97.70	.8161 - .8470	138.75	118.20	111.30	108.00	104.50	101.70
.8594	55/64	.7495	6	2 5/8	10	34808594	97.70	-	-	-	-	-	-	-
.8750	7/8	.7495	6	2 5/8	10	348028	97.70	.8471 - .8780	138.75	118.20	111.30	108.00	104.50	101.70
.8906	57/64	.7495	6	2 5/8	10	34808906	113.75	-	-	-	-	-	-	-
.9062	29/32	.7495	6	2 5/8	10	348029	113.75	.8781 - .9090	154.80	134.25	127.35	124.05	120.55	117.75
.9219	59/64	.7495	8	2 5/8	10	34809219	113.75	-	-	-	-	-	-	-
.9375	15/16	.7495	8	2 5/8	10	348030	113.75	.9091 - .9410	154.80	134.25	127.35	124.05	120.55	117.75
.9531	61/64	.7495	8	2 5/8	10	34809531	119.20	-	-	-	-	-	-	-
.9688	31/32	.7495	8	2 5/8	10	348031	119.20	.9411 - .9720	160.25	139.70	132.80	129.55	126.00	123.25
.9844	63/64	.8745	8	2 3/4	10 1/2	34809844	119.20	-	-	-	-	-	-	-
1.0000	1	.8745	8	2 3/4	10 1/2	348032	119.20	.9721 - 1.0030	160.25	139.70	132.80	129.55	126.00	123.25
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	348034	123.25	1.0031 - 1.0660	162.60	142.90	136.30	133.15	129.75	127.10
1.1250	1 1/8	.8745	8	2 7/8	11	348036	133.45	1.0661 - 1.1280	172.85	153.10	146.50	143.35	140.00	137.35
1.1875	1 3/16	.9995	8	2 7/8	11	348038	146.20	1.1281 - 1.1905	185.55	165.85	159.25	156.10	152.70	150.05
1.2500	1 1/4	.9995	8	3	11 1/2	348040	162.95	1.1906 - 1.2530	202.30	182.55	175.95	172.85	169.45	166.80
1.3125	1 5/16	.9995	8	3	11 1/2	348042	162.95	1.2531 - 1.3155	202.30	182.55	175.95	172.85	169.45	166.80
1.3750	1 3/8	.9995	8	3 1/4	12	348044	165.35	1.3156 - 1.3780	204.70	185.00	178.40	175.25	171.85	169.20
1.4375	1 7/16	.9995	8	3 1/4	12	348046	182.65	1.3781 - 1.4405	222.00	202.30	195.70	192.55	189.20	186.50
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	348048	219.35	1.4406 - 1.5030	258.75	239.00	232.40	229.25	225.90	223.25

*Quantities of 15 or more: price of fractional size in same size range.

CARBIDE TIPPED OVER & UNDER SIZE REAMERS FOR STEEL

TYPE 3488 - STRAIGHT SHANK STRAIGHT FLUTE LONG CARBIDE

These precision ground carbide tipped reamers are very convenient for finishing accurate holes in most steels.

Tool diameter tolerance: +.0002"/-.0000".

TOOL DIAMETER	MAX SHANK DIAM.	NO. OF FLUTES	LENGTH		TYPE 3488 EDP NO.	PRICE EACH
			FLUTE	OVERALL		
.1865	.1805	4	1 1/8	4 1/2	348818	\$71.75
.1885	.1805	4	1 1/8	4 1/2	348819	71.75
.2490	.2405	4	1 1/2	6	348824	71.75
.2510	.2405	4	1 1/2	6	348825	71.75
.3115	.2792	4	1 1/2	6	348831	73.00
.3135	.2792	4	1 1/2	6	348832	73.00
.3740	.3105	4	1 3/4	7	348837	75.10
.3760	.3105	4	1 3/4	7	348838	75.10
.4365	.3730	6	1 3/4	7	348843	88.20
.4385	.3730	6	1 3/4	7	348844	88.20
.4990	.4355	6	2	8	348849	95.25
.5010	.4355	6	2	8	348850	95.25
CASED SET OF ABOVE 12 REAMERS					348800	902.65

CARBIDE TIPPED DOWEL PIN SIZE REAMERS FOR STEEL

TYPE 3486 - STRAIGHT SHANK STRAIGHT FLUTE LONG CARBIDE

These precision ground carbide tipped reamers accurately finish dowel pin holes in most steels. Should be used in pairs .0005" and .0020" under the fractional size. Note special undersize tolerance.

Tool diameter tolerance: +.0000"/-.0002".

TOOL DIAMETER	MAX SHANK DIAM.	NO. OF FLUTES	LENGTH		TYPE 3486 EDP NO.	PRICE EACH
			FLUTE	OVERALL		
.1855	.1805	4	1 1/8	4 1/2	348617	\$71.75
.1870	.1805	4	1 1/8	4 1/2	348618	71.75
.2480	.2405	4	1 1/2	6	348623	71.75
.2495	.2405	4	1 1/2	6	348624	71.75
.3105	.2792	4	1 1/2	6	348630	73.00
.3120	.2792	4	1 1/2	6	348631	73.00
.3730	.3105	4	1 3/4	7	348636	75.10
.3745	.3105	4	1 3/4	7	348637	75.10
.4355	.3730	6	1 3/4	7	348642	88.20
.4370	.3730	6	1 3/4	7	348643	88.20
.4980	.4355	6	2	8	348648	95.25
.4995	.4355	6	2	8	348649	95.25
CASED SET OF ABOVE 12 REAMERS					348600	902.65

CARBIDE TIPPED CHUCKING REAMERS

TYPE 3452 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies.
Straight polished flutes.

Designed and manufactured for maximum tool life. Used for all general reaming. Designed with flute long carbide for deep hole reaming.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH		EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLUTE	OVERALL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	1	4	1 1/2	6	345208	\$55.05	.2381 - .2530	\$93.35	\$74.15	\$67.75	\$64.70	\$61.40	\$58.80
.2812	9/32	1	4	1 1/2	6	345209	55.80	.2531 - .2840	94.15	74.95	68.50	65.45	62.15	59.60
.3125	5/16	1	4	1 1/2	6	345210	55.80	.2841 - .3150	94.15	74.95	68.50	65.45	62.15	59.60
.3438	11/32	1	4	1 1/2	6	345211	57.10	.3151 - .3470	95.40	76.20	69.80	66.70	63.45	60.85
.3750	3/8	1	4	1 3/4	7	345212	57.70	.3471 - .3780	96.05	76.85	70.40	67.35	64.05	61.45
.4062	13/32	1	4	1 3/4	7	345213	60.75	.3781 - .4090	99.10	79.90	73.45	70.40	67.10	64.50
.4375	7/16	1	4	1 3/4	7	345214	64.75	.4091 - .4410	103.10	83.90	77.45	74.40	71.10	68.50
.4688	15/32	1	4	1 3/4	7	345215	66.10	.4411 - .4720	104.45	85.20	78.80	75.75	72.45	69.85
.5000	1/2	1	6	2	8	345216	71.25	.4721 - .5030	112.30	91.75	84.85	81.55	78.05	75.25
.5312	17/32	1	6	2	8	345217	78.05	.5031 - .5340	119.10	98.55	91.65	88.35	84.85	82.05
.5625	9/16	1	6	2	8	345218	78.05	.5341 - .5660	119.10	98.55	91.65	88.35	84.85	82.05
.5938	19/32	1	6	2	8	345219	81.65	.5661 - .5970	122.70	102.15	95.25	92.00	88.45	85.70
.6250	5/8	2	6	2	9	345220	81.65	.5971 - .6280	122.70	102.15	95.25	92.00	88.45	85.70
.6562	21/32	2	6	2	9	345221	83.15	.6281 - .6590	124.25	103.65	96.75	93.50	89.95	87.20
.6875	11/16	2	6	2	9	345222	83.15	.6591 - .6910	124.25	103.65	96.75	93.50	89.95	87.20
.7188	23/32	2	6	2	9	345223	84.35	.6911 - .7220	125.40	104.85	97.95	94.65	91.15	88.35
.7500	3/4	2	6	2	9 1/2	345224	87.00	.7221 - .7530	128.10	107.50	100.65	97.35	93.85	91.05
.7812	25/32	2	6	2	9 1/2	345225	87.70	.7531 - .7840	128.75	108.20	101.30	98.05	94.50	91.75
.8125	13/16	2	6	2	9 1/2	345226	89.70	.7841 - .8160	130.80	110.20	103.30	100.05	96.50	93.75
.8438	27/32	2	6	2	9 1/2	345227	93.65	.8161 - .8470	134.75	114.15	107.25	104.00	100.45	97.70
.8750	7/8	2	6	2 1/4	10	345228	93.65	.8471 - .8780	134.75	114.15	107.25	104.00	100.45	97.70
.9062	29/32	2	6	2 1/4	10	345229	105.50	.8781 - .9090	146.60	126.00	119.10	115.85	112.30	109.55
.9375	15/16	3	8	2 1/4	10	345230	109.70	.9091 - .9410	150.80	130.20	123.30	120.05	116.50	113.75
.9688	31/32	3	8	2 1/4	10	345231	114.25	.9411 - .9720	155.30	134.75	127.85	124.55	121.05	118.25
1.0000	1	3	8	2 1/4	10 1/2	345232	114.25	.9721 - 1.0030	155.30	134.75	127.85	124.55	121.05	118.25
1.0625	1 1/16	3	8	2 1/4	10 1/2	345234	156.55	1.0031 - 1.0660	195.95	176.20	169.60	166.45	163.10	160.45
1.1250	1 1/8	3	8	2 1/4	11	345236	168.65	1.0661 - 1.1280	208.00	188.30	181.70	178.55	175.15	172.50
1.1875	1 3/16	3	8	2 1/4	11	345238	181.20	1.1281 - 1.1905	220.55	200.85	194.25	191.10	187.75	185.05
1.2500	1 1/4	4	8	2 1/2	11 1/2	345240	192.55	1.1906 - 1.2530	231.90	212.20	205.60	202.45	199.10	196.40
1.3125	1 5/16	4	8	2 1/2	11 1/2	345242	217.45	1.2531 - 1.3155	256.80	237.05	230.45	227.35	223.95	221.30
1.3750	1 3/8	4	8	2 1/2	12	345244	248.40	1.3156 - 1.3780	287.80	268.05	261.45	258.30	254.95	252.30
1.4375	1 7/16	4	8	2 1/2	12	345246	259.30	1.3781 - 1.4405	298.65	278.95	272.35	269.20	265.80	263.15
1.5000	1 1/2	4	8	2 1/2	12 1/2	345248	270.15	1.4406 - 1.5030	309.50	289.80	283.20	280.05	276.70	274.00

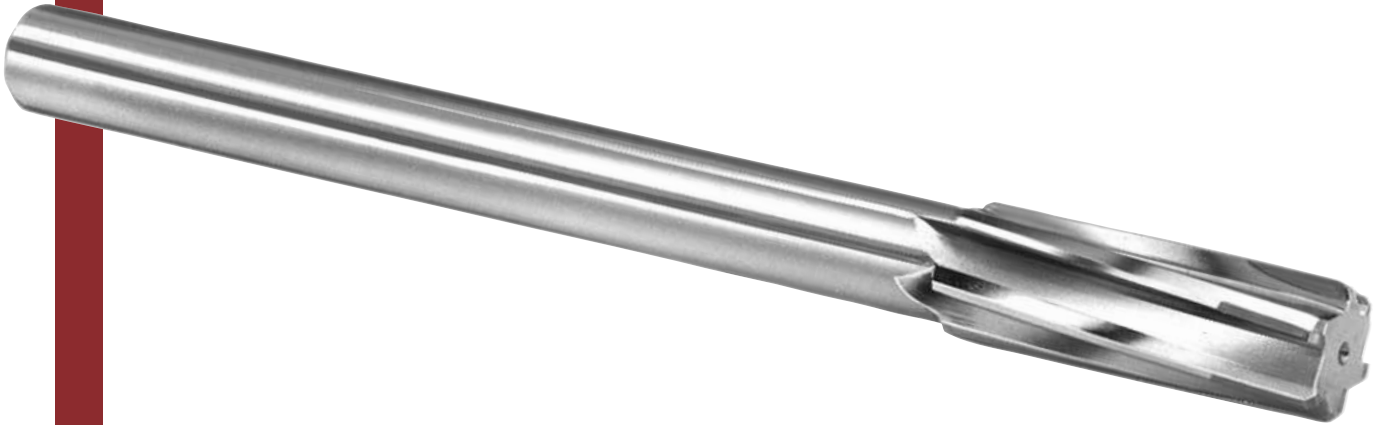
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CARBIDE TIPPED RIGHT SPIRAL CHUCKING REAMERS

TYPE 3410 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Right spiral polished flutes.

Designed and manufactured for maximum tool life. Right spiral flutes have greater chip clearing ability for use with ductile materials, highly abrasive materials or blind holes. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.



For metric sizes, see page 74.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	11/64	4	1 1/8	1/2	4 1/2	341006	\$52.25	.1770 - .2040	\$88.20	\$70.20	\$64.15	\$61.30	\$58.20	\$55.80
.2188	7/32	13/64	4	1 1/4	1/2	5	341007	52.25	.2041 - .2210	88.20	70.20	64.15	61.30	58.20	55.80
.2344	15/64	7/32	4	1 1/2	1/2	6	34102344	52.25	.2211 - .2380	88.20	70.20	64.15	61.30	58.20	55.80
.2500	1/4	15/64	4	1 1/2	1/2	6	341008	52.25	.2381 - .2530	88.20	70.20	64.15	61.30	58.20	55.80
.2812	9/32	15/64	4	1 1/2	1/2	6	341009	52.40	.2531 - .2840	88.35	70.35	64.30	61.45	58.35	55.95
.3125	5/16	9/32	4	1 1/2	1/2	6	341010	52.40	.2841 - .3150	88.35	70.35	64.30	61.45	58.35	55.95
.3438	11/32	9/32	4	1 1/2	5/8	6	341011	57.70	.3151 - .3470	93.65	75.65	69.60	66.75	63.65	61.25
.3750	3/8	5/16	4	1 3/4	5/8	7	341012	58.20	.3471 - .3780	94.15	76.15	70.10	67.25	64.15	61.75
.4062	13/32	5/16	4	1 3/4	5/8	7	341013	60.85	.3781 - .4090	96.80	78.80	72.75	69.90	66.80	64.40
.4375	7/16	3/8	4	1 3/4	5/8	7	341014	63.30	.4091 - .4410	99.20	81.20	75.20	72.30	69.25	66.80
.4688	15/32	3/8	4	1 3/4	5/8	7	341015	67.20	.4411 - .4720	103.10	85.10	79.10	76.20	73.15	70.70
.5000	1/2	7/16	6	2	5/8	8	341016	76.50	.4721 - .5030	114.85	95.65	89.20	86.15	82.85	80.30
.5312	17/32	7/16	6	2	5/8	8	341017	76.50	.5031 - .5340	114.85	95.65	89.20	86.15	82.85	80.30
.5625	9/16	7/16	6	2	5/8	8	341018	76.50	.5341 - .5660	114.85	95.65	89.20	86.15	82.85	80.30
.5938	19/32	7/16	6	2	5/8	8	341019	78.80	.5661 - .5970	117.15	97.90	91.50	88.45	85.15	82.55
.6250	5/8	9/16	6	2 1/4	5/8	9	341020	78.80	.5971 - .6280	117.15	97.90	91.50	88.45	85.15	82.55
.6562	21/32	9/16	6	2 1/4	5/8	9	341021	83.80	.6281 - .6590	122.15	102.95	96.50	93.45	90.15	87.55
.6875	11/16	9/16	6	2 1/4	5/8	9	341022	86.30	.6591 - .6910	124.65	105.45	99.00	95.95	92.65	90.10
.7188	23/32	9/16	6	2 1/4	5/8	9	341023	88.85	.6911 - .7220	127.15	107.95	101.55	98.45	95.20	92.60
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	341024	88.85	.7221 - .7530	127.15	107.95	101.55	98.45	95.20	92.60
.7812	25/32	5/8	6	2 1/2	3/4	9 1/2	341025	94.25	.7531 - .7840	132.55	113.35	106.95	103.90	100.60	98.00
.8125	13/16	5/8	6	2 1/2	3/4	9 1/2	341026	94.25	.7841 - .8160	132.55	113.35	106.95	103.90	100.60	98.00
.8438	27/32	5/8	6	2 1/2	3/4	9 1/2	341027	99.40	.8161 - .8470	137.75	118.55	112.10	109.05	105.75	103.15
.8750	7/8	3/4	6	2 5/8	3/4	10	341028	99.40	.8471 - .8780	137.75	118.55	112.10	109.05	105.75	103.15
.9062	29/32	3/4	6	2 5/8	3/4	10	341029	115.80	.8781 - .9090	154.15	134.95	128.50	125.45	122.15	119.55
.9375	15/16	3/4	8	2 5/8	3/4	10	341030	115.80	.9091 - .9410	154.15	134.95	128.50	125.45	122.15	119.55
.9688	31/32	3/4	8	2 5/8	3/4	10	341031	121.45	.9411 - .9720	159.80	140.55	134.15	131.10	127.80	125.20
1.0000	1	7/8	8	2 3/4	3/4	10 1/2	341032	121.45	.9721 - 1.0030	159.80	140.55	134.15	131.10	127.80	125.20
1.0625	1 1/16	7/8	8	2 3/4	3/4	10 1/2	341034	130.30	1.0031 - 1.0660	168.65	149.45	143.00	139.95	136.65	134.05
1.1250	1 1/8	7/8	8	2 7/8	7/8	11	341036	134.30	1.0661 - 1.1280	172.65	153.45	147.00	143.95	140.65	138.05
1.1875	1 3/16	1	8	2 7/8	7/8	11	341038	141.10	1.1281 - 1.1905	179.45	160.25	153.80	150.75	147.45	144.90
1.2500	1 1/4	1	8	3	7/8	11 1/2	341040	149.35	1.1906 - 1.2530	187.70	168.50	162.05	159.00	155.70	153.10
1.3125	1 5/16	1	8	3	7/8	11 1/2	341042	165.25	1.2531 - 1.3155	203.60	184.40	177.95	174.90	171.60	169.05
1.3750	1 3/8	1	8	3 1/4	7/8	12	341044	181.10	1.3156 - 1.3780	219.45	200.25	193.80	190.75	187.45	184.85
1.4375	1 7/16	1 1/4	8	3 1/4	7/8	12	341046	191.85	1.3781 - 1.4405	230.20	210.95	204.55	201.50	198.20	195.60
1.5000	1 1/2	1 1/4	8	3 1/2	7/8	12 1/2	341048	202.65	1.4406 - 1.5030	241.00	221.80	215.35	212.30	209.00	206.45

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CARBIDE TIPPED LEFT SPIRAL CHUCKING REAMERS

TYPE 3420 - STRAIGHT SHANK - LEFT SPIRAL FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Left spiral polished flutes.

Designed and manufactured for maximum tool life. Left spiral flutes should only be used on through holes for heat treated steels, hard cast iron and other hard materials. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.



For metric sizes, see page 74.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	11/64	4	1 1/8	1/2	4 1/2	342006	\$59.10	.1770 - .2040	\$97.45	\$78.25	\$71.80	\$68.75	\$65.45	\$62.90
.2188	7/32	13/64	4	1 1/4	1/2	5	342007	59.10	.2041 - .2210	97.45	78.25	71.80	68.75	65.45	62.90
.2344	15/64	7/32	4	1 1/2	1/2	6	34202344	59.10	.2211 - .2380	97.45	78.25	71.80	68.75	65.45	62.90
.2500	1/4	15/64	4	1 1/2	1/2	6	342008	59.10	.2381 - .2530	97.45	78.25	71.80	68.75	65.45	62.90
.2812	9/32	15/64	4	1 1/2	1/2	6	342009	59.25	.2531 - .2840	97.60	78.40	71.95	68.90	65.60	63.05
.3125	5/16	9/32	4	1 1/2	1/2	6	342010	59.25	.2841 - .3150	97.60	78.40	71.95	68.90	65.60	63.05
.3438	11/32	9/32	4	1 1/2	5/8	6	342011	65.25	.3151 - .3470	103.55	84.35	77.95	74.85	71.60	69.00
.3750	3/8	5/16	4	1 3/4	5/8	7	342012	65.85	.3471 - .3780	104.20	85.00	78.55	75.50	72.20	69.60
.4062	13/32	5/16	4	1 3/4	5/8	7	342013	68.85	.3781 - .4090	107.15	87.95	81.55	78.50	75.20	72.60
.4375	7/16	3/8	4	1 3/4	5/8	7	342014	71.60	.4091 - .4410	109.90	90.70	84.30	81.20	77.95	75.35
.4688	15/32	3/8	4	1 3/4	5/8	7	342015	75.95	.4411 - .4720	114.30	95.10	88.65	85.60	82.30	79.75
.5000	1/2	7/16	6	2	5/8	8	342016	78.80	.4721 - .5030	118.15	98.45	91.85	88.70	85.35	82.65
.5312	17/32	7/16	6	2	5/8	8	342017	81.20	.5031 - .5340	120.60	100.85	94.25	91.15	87.75	85.10
.5625	9/16	7/16	6	2	5/8	8	342018	81.20	.5341 - .5660	120.60	100.85	94.25	91.15	87.75	85.10
.5938	19/32	7/16	6	2	5/8	8	342019	83.65	.5661 - .5970	123.00	103.30	96.70	93.55	90.15	87.50
.6250	5/8	9/16	6	2 1/4	5/8	9	342020	83.65	.5971 - .6280	123.00	103.30	96.70	93.55	90.15	87.50
.6562	21/32	9/16	6	2 1/4	5/8	9	342021	86.05	.6281 - .6590	125.40	105.70	99.10	95.95	92.60	89.90
.6875	11/16	9/16	6	2 1/4	5/8	9	342022	91.60	.6591 - .6910	130.95	111.25	104.65	101.50	98.15	95.45
.7188	23/32	9/16	6	2 1/4	5/8	9	342023	92.90	.6911 - .7220	132.25	112.55	105.95	102.80	99.40	96.75
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	342024	94.35	.7221 - .7530	133.70	114.00	107.40	104.25	100.85	98.20
.7812	25/32	5/8	6	2 1/2	3/4	9 1/2	342025	96.75	.7531 - .7840	136.15	116.40	109.80	106.65	103.30	100.60
.8125	13/16	5/8	6	2 1/2	3/4	9 1/2	342026	96.75	.7841 - .8160	136.15	116.40	109.80	106.65	103.30	100.60
.8438	27/32	5/8	6	2 1/2	3/4	9 1/2	342027	102.05	.8161 - .8470	141.45	121.70	115.10	112.00	108.60	105.95
.8750	7/8	3/4	6	2 5/8	3/4	10	342028	102.05	.8471 - .8780	141.45	121.70	115.10	112.00	108.60	105.95
.9062	29/32	3/4	6	2 5/8	3/4	10	342029	118.90	.8781 - .9090	158.25	138.55	131.95	128.80	125.40	122.75
.9375	15/16	3/4	8	2 5/8	3/4	10	342030	118.90	.9091 - .9410	158.25	138.55	131.95	128.80	125.40	122.75
.9688	31/32	3/4	8	2 5/8	3/4	10	342031	124.70	.9411 - .9720	164.05	144.35	137.75	134.60	131.20	128.55
1.0000	1	7/8	8	2 3/4	3/4	10 1/2	342032	124.70	.9721 - 1.0030	164.05	144.35	137.75	134.60	131.20	128.55
1.0625	1 1/16	7/8	8	2 3/4	3/4	10 1/2	342034	133.80	1.0031 - 1.0660	173.15	153.45	146.85	143.70	140.30	137.65
1.1250	1 1/8	7/8	8	2 3/4	7/8	11	342036	137.90	1.0661 - 1.1280	177.25	157.55	150.95	147.80	144.40	141.75
1.1875	1 3/16	1	8	2 7/8	7/8	11	342038	144.90	1.1281 - 1.1905	184.25	164.55	157.95	154.80	151.40	148.75
1.2500	1 1/4	1	8	3	7/8	11 1/2	342040	153.35	1.1906 - 1.2530	192.70	173.00	166.40	163.25	159.85	157.20
1.3125	1 5/16	1	8	3	7/8	11 1/2	342042	169.70	1.2531 - 1.3155	209.05	189.35	182.75	179.60	176.20	173.55
1.3750	1 3/8	1	8	3 1/4	7/8	12	342044	185.95	1.3156 - 1.3780	225.30	205.60	199.00	195.85	192.50	189.80
1.4375	1 7/16	1 1/4	8	3 1/4	7/8	12	342046	197.00	1.3781 - 1.4405	236.35	216.65	210.00	206.90	203.50	200.85
1.5000	1 1/2	1 1/4	8	3 1/2	7/8	12 1/2	342048	208.10	1.4406 - 1.5030	247.45	227.75	221.15	218.00	214.60	211.95

CARBIDE TIPPED SPIRAL CHUCKING REAMERS

TYPE 3412 - TAPER SHANK - RIGHT SPIRAL FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Right spiral polished flutes.

Designed and manufactured for maximum tool life. Right spiral flutes have greater chip clearing ability for use with ductile materials, highly abrasive materials or blind holes.

Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.



TYPE 3422 - TAPER SHANK - LEFT SPIRAL FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Left spiral polished flutes.

Designed and manufactured for maximum tool life. Left spiral flutes should only be used on through holes for heat treated steels, hard cast iron and other hard materials. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH			RT. SPIRAL TYPE 3412 EDP NO.	LEFT SPIRAL TYPE 3422 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT	CARB	OAL					1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	1	4	1 1/2	1/2	6	341208	342208	\$59.00	.2381 - .2530	\$94.95	\$76.95	\$70.95	\$68.05	\$64.95	\$62.55
.2812	9/32	1	4	1 1/2	1/2	6	341209	342209	59.00	.2531 - .2840	94.95	76.95	70.95	68.05	64.95	62.55
.3125	5/16	1	4	1 1/2	1/2	6	341210	342210	60.35	.2841 - .3150	96.30	78.30	72.25	69.40	66.30	63.85
.3438	11/32	1	4	1 1/2	5/8	6	341211	342211	61.35	.3151 - .3470	97.30	79.30	73.30	70.40	67.35	64.90
.3750	3/8	1	4	1 3/4	5/8	7	341212	342212	62.35	.3471 - .3780	98.25	80.25	74.25	71.35	68.30	65.85
.4062	13/32	1	4	1 3/4	5/8	7	341213	342213	65.35	.3781 - .4090	101.30	83.30	77.25	74.40	71.30	68.85
.4375	7/16	1	4	1 3/4	5/8	7	341214	342214	68.15	.4091 - .4410	104.10	86.05	80.05	77.20	74.10	71.65
.4688	15/32	1	4	1 3/4	5/8	7	341215	342215	70.80	.4411 - .4720	106.70	88.70	82.70	79.80	76.75	74.30
.5000	1/2	1	6	2	5/8	8	341216	342216	81.55	.4721 - .5030	119.85	100.65	94.25	91.20	87.90	85.30
.5312	17/32	1	6	2	5/8	8	341217	342217	83.75	.5031 - .5340	122.05	102.85	96.45	93.35	90.10	87.50
.5625	9/16	1	6	2	5/8	8	341218	342218	83.75	.5341 - .5660	122.05	102.85	96.45	93.35	90.10	87.50
.5938	19/32	1	6	2	5/8	8	341219	342219	87.00	.5661 - .5970	125.35	106.15	99.70	96.65	93.35	90.80
.6250	5/8	2	6	2 1/4	5/8	9	341220	342220	87.00	.5971 - .6280	125.35	106.15	99.70	96.65	93.35	90.80
.6875	11/16	2	6	2 1/4	5/8	9	341222	342222	95.50	.6591 - .6910	133.85	114.60	108.20	105.15	101.85	99.25
.7500	3/4	2	6	2 1/2	3/4	9 1/2	341224	342224	101.00	.7221 - .7530	139.30	120.10	113.70	110.60	107.35	104.75
.8125	13/16	2	6	2 1/2	3/4	9 1/2	341226	342226	105.20	.7841 - .8160	143.55	124.35	117.90	114.85	111.55	109.00
.8750	7/8	2	6	2 5/8	3/4	10	341228	342228	109.15	.8471 - .8780	147.45	128.25	121.85	118.80	115.50	112.90
.9375	15/16	3	8	2 5/8	3/4	10	341230	342230	126.95	.9091 - .9410	165.25	146.05	139.65	136.55	133.30	130.70
1.0000	1	3	8	2 3/4	3/4	10 1/2	341232	342232	131.30	.9721 - 1.0030	169.65	150.45	144.00	140.95	137.65	135.10

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*Quantities of 15 or more: price of fractional size in same size range.

CARBIDE TIPPED EXPANSION CHUCKING REAMERS

METRIC

TYPE 3467 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE



Detailed description and fractional sizes on page 78. Tolerances on page 50. Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAMETER		MORSE TAPER	NO. OF FLTS.	LENGTH		EDP NO.	PRICE EACH	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH			FLUTE	OVERALL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
7.5	.2953	1	4	1	6	3467075	\$ 95.80	7.215 - 8.001	\$124.65	\$105.55	\$99.10	\$95.95	\$92.75	\$90.10	\$86.40
8.0	.3150	1	4	1	6	3467080	95.80	-	-	-	-	-	-	-	-
8.5	.3346	1	4	1	6	3467085	95.80	8.002 - 8.814	124.65	105.55	99.10	95.95	92.75	90.10	86.40
9.0	.3543	1	4	1	7	3467090	89.80	8.815 - 9.601	116.85	98.95	92.90	89.95	86.95	84.45	81.00
9.5	.3740	1	4	1	7	3467095	89.80	-	-	-	-	-	-	-	-
10.0	.3937	1	4	1	7	3467100	92.15	9.602 - 10.389	119.20	101.30	95.25	92.30	89.30	86.80	83.35
10.5	.4134	1	4	1	7	3467105	92.15	10.390 - 11.201	119.20	101.30	95.25	92.30	89.30	86.80	83.35
11.0	.4331	1	4	1	7	3467110	92.15	-	-	-	-	-	-	-	-
11.5	.4528	1	4	1	7	3467115	96.15	11.202 - 11.989	123.20	105.25	99.20	96.30	93.25	90.75	87.30
12.0	.4724	1	6	1	8	3467120	96.15	11.990 - 12.776	123.20	105.25	99.20	96.30	93.25	90.75	87.30
12.5	.4921	1	6	1	8	3467125	96.15	-	-	-	-	-	-	-	-
13.0	.5118	1	6	1	8	3467130	98.70	12.777 - 13.564	125.75	107.80	101.80	98.85	95.85	93.35	89.90
13.5	.5315	1	6	1	8	3467135	98.70	-	-	-	-	-	-	-	-
14.0	.5512	1	6	1 1/8	8	3467140	98.70	13.565 - 14.376	125.75	107.80	101.80	98.85	95.85	93.35	89.90
14.5	.5709	1	6	1 1/8	8	3467145	102.25	14.377 - 15.164	129.30	111.35	105.35	102.40	99.35	96.85	93.40
15.0	.5906	1	6	1 1/8	8	3467150	102.25	-	-	-	-	-	-	-	-
15.5	.6102	2	6	1 1/4	9	3467155	102.25	15.165 - 15.951	129.30	111.35	105.35	102.40	99.35	96.85	93.40
16.0	.6299	2	6	1 1/4	9	3467160	113.55	15.952 - 16.739	140.60	122.65	116.65	113.70	110.70	108.20	104.75
16.5	.6496	2	6	1 1/4	9	3467165	113.55	-	-	-	-	-	-	-	-
17.0	.6693	2	6	1 1/4	9	3467170	113.55	16.740 - 17.551	140.60	122.65	116.65	113.70	110.70	108.20	104.75
17.5	.6890	2	6	1 1/4	9	3467175	113.55	-	-	-	-	-	-	-	-
18.0	.7087	2	6	1 1/4	9	3467180	113.85	17.552 - 18.339	140.90	122.95	116.95	114.00	111.00	108.50	105.05
18.5	.7283	2	6	1 3/8	9 1/2	3467185	113.85	18.340 - 19.126	140.90	122.95	116.95	114.00	111.00	108.50	105.05
19.0	.7480	2	6	1 3/8	9 1/2	3467190	113.85	-	-	-	-	-	-	-	-
19.5	.7677	2	6	1 3/8	9 1/2	3467195	121.35	19.127 - 19.914	148.40	130.45	124.45	121.50	118.50	116.00	112.55
20.0	.7874	2	6	1 3/8	9 1/2	3467200	121.35	19.915 - 20.726	148.40	130.45	124.45	121.50	118.50	116.00	112.55
20.5	.8071	2	6	1 3/8	9 1/2	3467205	121.35	-	-	-	-	-	-	-	-
21.0	.8268	2	6	1 3/8	9 1/2	3467210	125.90	20.727 - 21.514	152.95	135.00	129.00	126.05	123.05	120.55	117.10
21.5	.8465	2	6	1 3/8	9 1/2	3467215	125.90	-	-	-	-	-	-	-	-
22.0	.8661	2	6	1 1/2	10	3467220	125.90	21.515 - 22.301	152.95	135.00	129.00	126.05	123.05	120.55	117.10
22.5	.8858	2	6	1 1/2	10	3467225	132.50	22.302 - 23.089	159.55	141.65	135.60	132.65	129.65	127.15	123.70
23.0	.9055	2	6	1 1/2	10	3467230	132.50	-	-	-	-	-	-	-	-
23.5	.9252	3	8	1 1/2	10	3467235	132.50	23.090 - 23.901	159.55	141.65	135.60	132.65	129.65	127.15	123.70
24.0	.9449	3	8	1 1/2	10	3467240	136.85	23.902 - 24.689	163.90	145.95	139.95	137.00	134.00	131.50	128.05
24.5	.9646	3	8	1 1/2	10	3467245	136.85	-	-	-	-	-	-	-	-
25.0	.9843	3	8	1 5/8	10 1/2	3467250	136.85	24.690 - 25.476	163.90	145.95	139.95	137.00	134.00	131.50	128.05
25.5	1.0039	3	8	1 5/8	10 1/2	3467255	148.70	25.477 - 27.076	175.75	157.80	151.80	148.85	145.80	143.30	139.85
26.0	1.0236	3	8	1 5/8	10 1/2	3467260	148.70	-	-	-	-	-	-	-	-
27.0	1.0630	3	8	1 5/8	10 1/2	3467270	148.70	-	-	-	-	-	-	-	-
28.0	1.1024	3	8	1 3/4	11	3467280	148.70	27.077 - 28.651	175.75	157.80	151.80	148.85	145.80	143.30	139.85
29.0	1.1417	3	8	1 3/4	11	3467290	165.65	28.652 - 30.239	192.70	174.80	168.75	165.80	162.80	160.30	156.85
30.0	1.1811	3	8	1 3/4	11	3467300	165.65	-	-	-	-	-	-	-	-
31.0	1.2205	4	8	1 7/8	11 1/2	3467310	167.80	30.240 - 31.826	194.85	176.90	170.90	167.95	164.95	162.45	159.00
32.0	1.2598	4	8	1 7/8	11 1/2	3467320	182.30	31.827 - 33.414	209.35	191.40	185.35	182.45	179.40	176.90	173.45
33.0	1.2992	4	8	1 7/8	11 1/2	3467330	182.30	-	-	-	-	-	-	-	-
34.0	1.3386	4	8	2	12	3467340	198.50	33.415 - 35.001	225.55	207.65	201.60	198.65	195.65	193.15	189.70
35.0	1.3780	4	8	2	12	3467350	198.50	-	-	-	-	-	-	-	-
36.0	1.4173	4	8	2	12	3467360	222.20	35.002 - 36.589	251.05	231.90	225.50	222.35	219.15	216.45	212.80
37.0	1.4567	4	8	2 1/8	12 1/2	3467370	229.65	36.590 - 38.176	258.50	239.35	232.95	229.80	226.60	223.90	220.25
38.0	1.4961	4	8	2 1/8	12 1/2	3467380	229.65	-	-	-	-	-	-	-	-
39.0	1.5354	4	8	2 1/8	12 1/2	3467390	310.80	38.177 - 39.776	339.65	320.50	314.05	310.95	307.70	305.05	301.35
40.0	1.5748	4	8	2 1/4	13	3467400	310.80	39.777 - 41.351	339.65	320.50	314.05	310.95	307.70	305.05	301.35
41.0	1.6142	4	8	2 1/4	13	3467410	310.80	-	-	-	-	-	-	-	-
42.0	1.6535	4	8	2 1/4	13	3467420	342.85	41.352 - 42.951	371.70	352.55	346.15	343.00	339.80	337.10	333.45
43.0	1.6929	4	10	2 3/8	13 1/2	3467430	342.85	42.952 - 44.526	371.70	352.55	346.15	343.00	339.80	337.10	333.45
44.0	1.7323	4	10	2 3/8	13 1/2	3467440	342.85	-	-	-	-	-	-	-	-

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Diameters up to 63mm - call us for price & availability.

Made in U.S.A.

CARBIDE TIPPED CNC STUB/SCREW MACHINE REAMERS

TYPE 3430 - STRAIGHT FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Polished flutes permit high volume chip load.



TYPE 3440 - LEFT SPIRAL FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Left spiral flutes tend to bridge interruptions. Used in through holes only.



BOTH TYPES:
Pin cross hole permits use in floating holders.
For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	PIN HOLE DIAM.	NO. OF FLUTES	LENGTH		STRAIGHT TYPE 3430 EDP NO.	LEFT SPIRAL TYPE 3440 EDP NO.	BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION				FLT	OAL					1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.1875	3/16	1/4	3/32	4	1*	2 1/4	343006	344006	\$52.15	.1770 - .2040	\$90.45	\$71.25	\$64.85	\$61.80	\$58.50	\$55.90
.2188	7/32	1/4	3/32	4	1*	2 1/4	343007	344007	52.15	.2041 - .2210	90.45	71.25	64.85	61.80	58.50	55.90
.2344	15/64	1/4	3/32	4	1*	2 1/4	34302344	34402344	52.15	.2211 - .2380	90.45	71.25	64.85	61.80	58.50	55.90
.2500	1/4	1/4	3/32	4	1*	2 1/4	343008	344008	52.15	.2381 - .2530	90.45	71.25	64.85	61.80	58.50	55.90
.2812	9/32	3/8	1/8	4	1*	2 1/4	343009	344009	52.15	.2531 - .2840	90.45	71.25	64.85	61.80	58.50	55.90
.3125	5/16	3/8	1/8	4	1	2 1/4	343010	344010	60.60	.2841 - .3150	98.95	79.75	73.30	70.25	66.95	64.35
.3438	11/32	3/8	1/8	4	1 1/4	2 1/2	343011	344011	61.15	.3151 - .3470	99.50	80.30	73.85	70.80	67.50	64.90
.3750	3/8	3/8	1/8	4	1 1/4	2 1/2	343012	344012	66.35	.3471 - .3780	104.65	85.45	79.05	75.95	72.70	70.10
.4062	13/32	1/2	3/16	4	1 1/4	2 1/2	343013	344013	67.25	.3781 - .4090	105.60	86.40	79.95	76.90	73.60	71.05
.4375	7/16	1/2	3/16	4	1 1/4	2 1/2	343014	344014	79.65	.4091 - .4410	118.00	98.80	92.35	89.30	86.00	83.40
.4688	15/32	1/2	3/16	4	1 1/4	2 1/2	343015	344015	79.65	.4411 - .4720	118.00	98.80	92.35	89.30	86.00	83.40
.5000	1/2	1/2	3/16	4	1 1/4	2 1/2	343016	344016	87.20	.4721 - .5030	126.55	106.80	100.20	97.10	93.70	91.05
.5312	17/32	5/8	1/4	6	1 1/2	3	343017	344017	87.20	.5031 - .5340	126.55	106.80	100.20	97.10	93.70	91.05
.5625	9/16	5/8	1/4	6	1 1/2	3	343018	344018	91.85	.5341 - .5660	131.20	111.50	104.90	101.75	98.35	95.70
.5938	19/32	5/8	1/4	6	1 1/2	3	343019	344019	91.85	.5661 - .5970	131.20	111.50	104.90	101.75	98.35	95.70
.6250	5/8	5/8	1/4	6	1 1/2	3	343020	344020	94.35	.5971 - .6280	133.70	114.00	107.40	104.25	100.85	98.20
.6562	21/32	5/8	1/4	6	1 1/2	3	343021	344021	94.35	.6281 - .6590	133.70	114.00	107.40	104.25	100.85	98.20
.6875	11/16	5/8	1/4	6	1 1/2	3	343022	344022	98.70	.6591 - .6910	138.05	118.35	111.75	108.60	105.20	102.55
.7188	23/32	3/4	5/16	6	1 1/2	3	343023	344023	98.70	.6911 - .7220	138.05	118.35	111.75	108.60	105.20	102.55
.7500	3/4	3/4	5/16	6	1 1/2	3	343024	344024	101.20	.7221 - .7530	140.55	120.85	114.25	111.10	107.70	105.05
.7812	25/32	3/4	5/16	6	1 1/2	3	343025	344025	101.20	.7531 - .7840	140.55	120.85	114.25	111.10	107.70	105.05
.8125	13/16	3/4	5/16	6	1 1/2	3	343026	344026	109.95	.7841 - .8160	149.35	129.60	123.00	119.85	116.50	113.85
.8438	27/32	3/4	5/16	6	1 1/2	3	343027	344027	109.95	.8161 - .8470	149.35	129.60	123.00	119.85	116.50	113.85
.8750	7/8	3/4	5/16	6	1 1/2	3	343028	344028	115.75	.8471 - .8780	155.10	135.40	128.80	125.65	122.30	119.60
.9062	29/32	3/4	5/16	6	1 1/2	3	343029	344029	115.75	.8781 - .9090	155.10	135.40	128.80	125.65	122.30	119.60
.9375	19/16	3/4	5/16	6	1 1/2	3	343030	344030	127.50	.9091 - .9410	166.90	147.15	140.55	137.40	134.05	131.40
.9688	31/32	3/4	5/16	8	1 1/2	3	343031	344031	127.50	.9411 - .9720	166.90	147.15	140.55	137.40	134.05	131.40
1.0000	1	3/4	5/16	8	1 1/2	3	343032	344032	133.80	.9721 - 1.0030	173.15	153.45	146.85	143.70	140.30	137.65
1.0625	1 1/16	3/4	5/16	8	1 1/2	3	343034	344034	133.80	1.0031 - 1.0660	173.15	153.45	146.85	143.70	140.30	137.65
1.1250	1 1/8	3/4	5/16	8	1 1/2	3	343036	344036	156.55	1.0661 - 1.1280	195.95	176.20	169.60	166.45	163.10	160.45
1.1875	1 3/16	3/4	5/16	8	1 1/2	3	343038	344038	163.25	1.1281 - 1.1905	202.60	182.90	176.30	173.15	169.75	167.10
1.2500	1 1/4	3/4	5/16	8	1 1/2	3	343040	344040	191.25	1.1906 - 1.2530	230.65	210.90	204.30	201.15	197.80	195.15
1.3125	1 5/16	3/4	5/16	8	1 1/2	3	343042	344042	191.25	1.2531 - 1.3155	230.65	210.90	204.30	201.15	197.80	195.15
1.3750	1 3/8	3/4	5/16	8	1 1/2	3	343044	344044	194.00	1.3156 - 1.3780	233.35	213.65	207.05	203.90	200.55	197.85
1.4375	1 7/16	3/4	5/16	8	1 1/2	3	343046	344046	226.10	1.3781 - 1.4405	265.50	245.75	239.15	236.05	232.65	230.00
1.5000	1 1/2	3/4	5/16	8	1 1/2	3	343048	344048	271.60	1.4406 - 1.5030	310.95	291.25	284.65	281.50	278.15	275.45

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CARBIDE TIPPED NAS 897 CHUCKING REAMERS

- TYPE 3407 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR NON-FERROUS
- TYPE 3408 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR CAST IRON
- TYPE 3409 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR STEEL

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with partial flute length carbide. Tool geometry and carbide grade appropriate for material being machined.



For reamer tolerances and closer tolerance pricing, see page 50.
Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH			NON-FERR. TYPE 3407 EDP NO.	CAST IRON TYPE 3408 EDP NO.	STEEL TYPE 3409 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL			FLT.	CARB.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1562	5/32	.1510	4	1	1/2	4	340705	340805	340905	\$52.30	.1560 - .1769	\$90.65	\$71.40	\$65.00	\$61.95	\$58.65	\$56.05
.1875	3/16	.1805	4	1 1/8	1/2	4 1/2	340706	340806	340906	48.00	.1770 - .2040	85.30	66.60	60.35	57.40	54.15	51.65
.2188	7/32	.2075	4	1 1/4	1/2	5	340707	340807	340907	48.00	.2041 - .2210	85.30	66.60	60.35	57.40	54.15	51.65
.2344	15/64	.2265	4	1 1/2	1/2	6	34072344	34082344	34092344	50.90	.2211 - .2380	88.20	69.50	63.25	60.30	57.05	54.55
.2500	1/4	.2405	4	1 1/2	1/2	6	340708	340808	340908	48.30	.2381 - .2530	85.60	66.90	60.65	57.70	54.50	51.95
.2812	9/32	.2485	4	1 1/2	1/2	6	340709	340809	340909	49.30	.2531 - .2840	86.60	67.90	61.65	58.65	55.45	52.95
.3125	5/16	.2792	4	1 1/2	1/2	6	340710	340810	340910	49.30	.2841 - .3150	86.60	67.90	61.65	58.65	55.45	52.95
.3125	5/16	.2792	6	1 1/2	1/2	6	340790	340890	340990	54.15	.2841 - .3150	91.50	72.80	66.55	63.55	60.35	57.85
.3438	11/32	.2792	4	1 1/2	5/8	6	340711	340811	340911	51.10	.3151 - .3470	88.45	69.75	63.50	60.50	57.30	54.80
.3438	11/32	.2792	6	1 1/2	5/8	6	340791	340891	340991	56.15	.3151 - .3470	93.45	74.75	68.50	65.55	62.35	59.80
.3750	3/8	.3105	4	1 3/4	5/8	7	340712	340812	340912	46.90	.3471 - .3780	81.15	64.00	58.25	55.50	52.55	50.25
.3750	3/8	.3105	6	1 3/4	5/8	7	340792	340892	340992	51.50	.3471 - .3780	85.75	68.60	62.85	60.15	57.20	54.90
.4062	13/32	.3105	4	1 3/4	5/8	7	340713	340813	340913	53.55	.3781 - .4090	90.85	72.20	65.90	62.95	59.75	57.20
.4062	13/32	.3105	6	1 3/4	5/8	7	340793	340893	340993	57.15	.3781 - .4090	94.45	75.75	69.50	66.55	63.35	60.80
.4375	7/16	.3730	6	1 3/4	5/8	7	340714	340814	340914	57.15	.4091 - .4410	94.45	75.75	69.50	66.55	63.35	60.80
.4688	15/32	.3730	6	1 3/4	5/8	7	340715	340815	340915	58.00	.4411 - .4720	95.30	76.60	70.35	67.35	64.15	61.65
.5000	1/2	.4355	6	2	5/8	8	340716	340816	340916	68.55	.4721 - .5030	109.60	89.05	82.15	78.90	75.35	72.60
.5312	17/32	.4355	6	2	5/8	8	340717	340817	340917	74.60	.5031 - .5340	115.65	95.10	88.20	84.90	81.40	78.60
.5625	9/16	.4355	6	2	5/8	8	340718	340818	340918	74.60	.5341 - .5660	115.65	95.10	88.20	84.90	81.40	78.60
.5938	19/32	.4355	6	2	5/8	8	340719	340819	340919	77.60	.5661 - .5970	118.70	98.10	91.20	87.95	84.40	81.65
.6250	5/8	.5615	6	2 1/4	5/8	9	340720	340820	340920	77.60	.5971 - .6280	118.70	98.10	91.20	87.95	84.40	81.65
.6562	21/32	.5615	6	2 1/4	5/8	9	340721	340821	340921	78.95	.6281 - .6590	120.05	99.45	92.55	89.30	85.75	83.00
.6875	11/16	.5615	6	2 1/4	5/8	9	340722	340822	340922	78.95	.6591 - .6910	120.05	99.45	92.55	89.30	85.75	83.00
.7188	23/32	.5615	6	2 1/4	5/8	9	340723	340823	340923	82.65	.6911 - .7220	123.75	103.15	96.25	93.00	89.45	86.70
.7500	3/4	.6245	6	2 1/2	3/4	9 1/2	340724	340824	340924	82.65	.7221 - .7530	123.75	103.15	96.25	93.00	89.45	86.70
.7812	25/32	.6245	6	2 1/2	3/4	9 1/2	340725	340825	340925	85.35	.7531 - .7840	126.40	105.85	98.95	95.70	92.15	89.40
.8125	13/16	.6245	6	2 1/2	3/4	9 1/2	340726	340826	340926	85.35	.7841 - .8160	126.40	105.85	98.95	95.70	92.15	89.40
.8438	27/32	.6245	6	2 1/2	3/4	9 1/2	340727	340827	340927	88.80	.8161 - .8470	129.85	109.30	102.40	99.10	95.60	92.80
.8750	7/8	.7495	6	2 5/8	3/4	10	340728	340828	340928	88.80	.8471 - .8780	129.85	109.30	102.40	99.10	95.60	92.80
.9062	29/32	.7495	6	2 5/8	3/4	10	340729	340829	340929	103.40	.8781 - .9090	144.50	123.90	117.00	113.75	110.20	107.45
.9375	15/16	.7495	8	2 5/8	3/4	10	340730	340830	340930	103.40	.9091 - .9410	144.50	123.90	117.00	113.75	110.20	107.45
.9688	31/32	.7495	8	2 5/8	3/4	10	340731	340831	340931	108.30	.9411 - .9720	149.35	128.75	121.90	118.60	115.10	112.30
1.0000	1	.8745	8	2 3/4	3/4	10 1/2	340732	340832	340932	108.30	.9721 - 1.0030	149.35	128.75	121.90	118.60	115.10	112.30
1.0625	1 1/16	.8745	8	2 3/4	3/4	10 1/2	340734	340834	340934	112.15	1.0031 - 1.0660	151.50	131.80	125.20	122.05	118.65	116.00
1.1250	1 1/8	.8745	8	2 7/8	7/8	11	340736	340836	340936	121.25	1.0661 - 1.1280	160.60	140.90	134.25	131.15	127.75	125.10
1.1875	1 3/16	.9995	8	2 7/8	7/8	11	340738	340838	340938	127.45	1.1281 - 1.1905	166.80	147.05	140.45	137.35	133.95	131.30
1.2500	1 1/4	.9995	8	3	7/8	11 1/2	340740	340840	340940	134.70	1.1906 - 1.2530	174.05	154.30	147.70	144.60	141.20	138.55
1.3125	1 5/16	.9995	8	3	7/8	11 1/2	340742	340842	340942	141.75	1.2531 - 1.3155	181.10	161.40	154.80	151.65	148.30	145.60
1.3750	1 3/8	.9995	8	3 1/4	7/8	12	340744	340844	340944	150.35	1.3156 - 1.3780	189.75	170.00	163.40	160.30	156.90	154.25
1.4375	1 7/16	.9995	8	3 1/4	7/8	12	340746	340846	340946	167.60	1.3781 - 1.4405	206.95	187.25	180.65	177.50	174.10	171.45
1.5000	1 1/2	1.2495	8	3 1/2	7/8	12 1/2	340748	340848	340948	177.20	1.4406 - 1.5030	216.55	196.80	190.20	187.10	183.70	181.05

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CARBIDE TIPPED NAS 897 CHUCKING REAMERS

TYPE 3457 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3458 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3459 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with flute length carbide. Tool geometry and carbide grade appropriate for material being machined. For step reamers, see page 104. For longer overall length reamers, see page 107.



For reamer tolerances and closer tolerance pricing, see page 50.
Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3457 EDP NO.	CAST IRON TYPE 3458 EDP NO.	STEEL TYPE 3459 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTION			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	.1805	4	1 1/8	4 1/2	345706	345806	345906	\$57.40	.1770 - .2040	\$95.75	\$76.50	\$70.10	\$67.05	\$63.75	\$61.15
.2188	7/32	.2075	4	1 1/4	5	345707	345807	345907	57.40	.2041 - .2210	95.75	76.50	70.10	67.05	63.75	61.15
.2344	15/64	.2265	4	1 1/2	6	34572344	34582344	34592344	57.40	.2211 - .2380	95.75	76.50	70.10	67.05	63.75	61.15
.2500	1/4	.2405	4	1 1/2	6	345708	345808	345908	57.40	.2381 - .2530	95.75	76.50	70.10	67.05	63.75	61.15
.2812	9/32	.2485	4	1 1/2	6	345709	345809	345909	58.65	.2531 - .2840	97.00	77.75	71.35	68.30	65.00	62.40
.3125	5/16	.2792	4	1 1/2	6	345710	345810	345910	58.65	.2841 - .3150	97.00	77.75	71.35	68.30	65.00	62.40
.3438	11/32	.2792	4	1 1/2	6	345711	345811	345911	60.75	.3151 - .3470	99.10	79.90	73.45	70.40	67.10	64.50
.3750	3/8	.3105	4	1 3/4	7	345712	345812	345912	60.75	.3471 - .3780	99.10	79.90	73.45	70.40	67.10	64.50
.4062	13/32	.3105	4	1 3/4	7	345713	345813	345913	63.75	.3781 - .4090	102.10	82.85	76.45	73.40	70.10	67.50
.4375	7/16	.3730	6	1 3/4	7	345714	345814	345914	69.00	.4091 - .4410	107.35	88.10	81.70	78.65	75.35	72.75
.4688	15/32	.3730	6	1 3/4	7	345715	345815	345915	74.55	.4411 - .4720	112.90	93.70	87.25	84.20	80.90	78.30
.5000	1/2	.4355	6	2	8	345716	345816	345916	79.90	.4721 - .5030	120.95	100.40	93.50	90.20	86.70	83.90
.5312	17/32	.4355	6	2	8	345717	345817	345917	82.15	.5031 - .5340	123.25	102.65	95.75	92.50	88.95	86.20
.5625	9/16	.4355	6	2	8	345718	345818	345918	82.15	.5341 - .5660	123.25	102.65	95.75	92.50	88.95	86.20
.5938	19/32	.4355	6	2	8	345719	345819	345919	85.25	.5661 - .5970	126.35	105.75	98.85	95.60	92.05	89.30
.6250	5/8	.5615	6	2 1/4	9	345720	345820	345920	85.25	.5971 - .6280	126.35	105.75	98.85	95.60	92.05	89.30
.6562	21/32	.5615	6	2 1/4	9	345721	345821	345921	86.85	.6281 - .6590	127.95	107.35	100.45	97.20	93.65	90.90
.6875	11/16	.5615	6	2 1/4	9	345722	345822	345922	86.85	.6591 - .6910	127.95	107.35	100.45	97.20	93.65	90.90
.7188	23/32	.5615	6	2 1/4	9	345723	345823	345923	90.80	.6911 - .7220	131.90	111.30	104.40	101.15	97.60	94.85
.7500	3/4	.6245	6	2 1/2	9 1/2	345724	345824	345924	90.80	.7221 - .7530	131.90	111.30	104.40	101.15	97.60	94.85
.7812	25/32	.6245	6	2 1/2	9 1/2	345725	345825	345925	93.90	.7531 - .7840	135.00	114.40	107.50	104.25	100.70	97.95
.8125	13/16	.6245	6	2 1/2	9 1/2	345726	345826	345926	93.90	.7841 - .8160	135.00	114.40	107.50	104.25	100.70	97.95
.8438	27/32	.6245	6	2 1/2	9 1/2	345727	345827	345927	97.70	.8161 - .8470	138.75	118.20	111.30	108.00	104.50	101.70
.8750	7/8	.7495	6	2 5/8	10	345728	345828	345928	97.70	.8471 - .8780	138.75	118.20	111.30	108.00	104.50	101.70
.9062	29/32	.7495	6	2 5/8	10	345729	345829	345929	113.75	.8781 - .9090	154.80	134.25	127.35	124.05	120.55	117.75
.9375	15/16	.7495	8	2 5/8	10	345730	345830	345930	113.75	.9091 - .9410	154.80	134.25	127.35	124.05	120.55	117.75
.9688	31/32	.7495	8	2 5/8	10	345731	345831	345931	119.20	.9411 - .9720	160.25	139.70	132.80	129.55	126.00	123.25
1.0000	1	.8745	8	2 3/4	10 1/2	345732	345832	345932	119.20	.9721 - 1.0030	160.25	139.70	132.80	129.55	126.00	123.25
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	345734	345834	345934	123.25	1.0031 - 1.0660	162.60	142.90	136.30	133.15	129.75	127.10
1.1250	1 1/8	.8745	8	2 7/8	11	345736	345836	345936	133.45	1.0661 - 1.1280	172.85	153.10	146.50	143.35	140.00	137.35
1.1875	1 3/16	.9995	8	2 7/8	11	345738	345838	345938	139.60	1.1281 - 1.1905	178.95	159.25	152.65	149.50	146.10	143.45
1.2500	1 1/4	.9995	8	3	11 1/2	345740	345840	345940	150.85	1.1906 - 1.2530	190.20	170.50	163.90	160.75	157.40	154.70
1.3125	1 5/16	.9995	8	3	11 1/2	345742	345842	345942	155.05	1.2531 - 1.3155	194.40	174.70	168.10	164.95	161.55	158.90
1.3750	1 3/8	.9995	8	3 1/4	12	345744	345844	345944	165.35	1.3156 - 1.3780	204.70	185.00	178.40	175.25	171.85	169.20
1.4375	1 7/16	.9995	8	3 1/4	12	345746	345846	345946	179.05	1.3781 - 1.4405	218.40	198.65	192.05	188.95	185.55	182.90
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	345748	345848	345948	184.25	1.4406 - 1.5030	223.65	203.90	197.30	194.15	190.80	188.15

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CARBIDE TIPPED NAS 897 CHUCKING REAMERS

TYPE 3472 - TAPER SHANK - STRAIGHT FLUTES - FOR NON-FERROUS

TYPE 3473 - TAPER SHANK - STRAIGHT FLUTES - FOR CAST IRON

TYPE 3474 - TAPER SHANK - STRAIGHT FLUTES - FOR STEEL

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with partial flute length carbide. Tool geometry and carbide grade appropriate for material being machined.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER NO.	NO. OF FLTS.	LENGTH			NON-FERR. TYPE 3472 EDP NO.	CAST IRON TYPE 3473 EDP NO.	STEEL TYPE 3474 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL			FLT.	CARB.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	1	4	1 1/2	1/2	6	347208	347308	347408	\$55.30	.2381 - .2530	\$92.65	\$73.95	\$67.70	\$64.70	\$61.50	\$59.00
.2812	9/32	1	4	1 1/2	1/2	6	347209	347309	347409	56.25	.2531 - .2840	93.55	74.85	68.60	65.60	62.40	59.90
.3125	5/16	1	4	1 1/2	1/2	6	347210	347310	347410	56.25	.2841 - .3150	93.55	74.85	68.60	65.60	62.40	59.90
.3438	11/32	1	4	1 1/2	5/8	6	347211	347311	347411	58.00	.3151 - .3470	95.30	76.60	70.35	67.35	64.15	61.65
.3750	3/8	1	4	1 3/4	5/8	7	347212	347312	347412	53.55	.3471 - .3780	87.80	70.65	64.90	62.15	59.20	56.90
.4062	13/32	1	4	1 3/4	5/8	7	347213	347313	347413	61.25	.3781 - .4090	98.60	79.90	73.65	70.65	67.45	64.95
.4375	7/16	1	6	1 3/4	5/8	7	347214	347314	347414	65.25	.4091 - .4410	102.55	83.85	77.60	74.60	71.40	68.90
.4688	15/32	1	6	1 3/4	5/8	7	347215	347315	347415	67.00	.4411 - .4720	104.30	85.60	79.35	76.40	73.15	70.65
.5000	1/2	1	6	2	5/8	8	347216	347316	347416	76.70	.4721 - .5030	117.75	97.20	90.30	87.00	83.50	80.70
.5312	17/32	1	6	2	5/8	8	347217	347317	347417	81.50	.5031 - .5340	122.55	102.00	95.10	91.80	88.30	85.50
.5625	9/16	1	6	2	5/8	8	347218	347318	347418	81.50	.5341 - .5660	122.55	102.00	95.10	91.80	88.30	85.50
.5938	19/32	1	6	2	5/8	8	347219	347319	347419	86.70	.5661 - .5970	127.75	107.20	100.30	97.00	93.50	90.70
.6250	5/8	2	6	2 1/4	5/8	9	347220	347320	347420	86.70	.5971 - .6280	127.75	107.20	100.30	97.00	93.50	90.70
.6562	21/32	2	6	2 1/4	5/8	9	347221	347321	347421	88.10	.6281 - .6590	129.20	108.60	101.70	98.45	94.90	92.15
.6875	11/16	2	6	2 1/4	5/8	9	347222	347322	347422	88.10	.6591 - .6910	129.20	108.60	101.70	98.45	94.90	92.15
.7188	23/32	2	6	2 1/4	5/8	9	347223	347323	347423	91.65	.6911 - .7220	132.70	112.15	105.25	102.00	98.45	95.70
.7500	3/4	2	6	2 1/2	3/4	9 1/2	347224	347324	347424	91.65	.7221 - .7530	132.70	112.15	105.25	102.00	98.45	95.70
.7812	25/32	2	6	2 1/2	3/4	9 1/2	347225	347325	347425	93.85	.7531 - .7840	134.90	114.30	107.45	104.15	100.65	97.85
.8125	13/16	2	6	2 1/2	3/4	9 1/2	347226	347326	347426	93.85	.7841 - .8160	134.90	114.30	107.45	104.15	100.65	97.85
.8438	27/32	2	6	2 1/2	3/4	9 1/2	347227	347327	347427	98.35	.8161 - .8470	139.45	118.85	111.95	108.70	105.15	102.40
.8750	7/8	2	6	2 5/8	3/4	10	347228	347328	347428	98.35	.8471 - .8780	139.45	118.85	111.95	108.70	105.15	102.40
.9062	29/32	2	6	2 5/8	3/4	10	347229	347329	347429	119.70	.8781 - .9090	160.80	140.20	133.30	130.05	126.50	123.75
.9375	15/16	3	8	2 5/8	3/4	10	347230	347330	347430	119.70	.9091 - .9410	160.80	140.20	133.30	130.05	126.50	123.75
.9688	31/32	3	8	2 5/8	3/4	10	347231	347331	347431	123.25	.9411 - .9720	164.30	143.70	136.85	133.55	130.05	127.25
1.0000	1	3	8	2 3/4	3/4	10 1/2	347232	347332	347432	123.25	.9721 - 1.0030	164.30	143.70	136.85	133.55	130.05	127.25
1.0625	1 1/16	3	8	2 3/4	3/4	10 1/2	347234	347334	347434	152.15	1.0031 - 1.0660	191.50	171.80	165.20	162.05	158.65	156.00
1.1250	1 1/8	3	8	2 7/8	7/8	11	347236	347336	347436	161.55	1.0661 - 1.1280	200.95	181.20	174.60	171.45	168.10	165.45
1.1875	1 3/16	3	8	2 7/8	7/8	11	347238	347338	347438	176.60	1.1281 - 1.1905	216.00	196.25	189.65	186.50	183.15	180.50
1.2500	1 1/4	4	8	3	7/8	11 1/2	347240	347340	347440	191.85	1.1906 - 1.2530	231.20	211.45	204.85	201.75	198.35	195.70
1.3125	1 5/16	4	8	3	7/8	11 1/2	347242	347342	347442	202.60	1.2531 - 1.3155	242.00	222.25	215.65	212.50	209.15	206.50
1.3750	1 3/8	4	8	3 1/4	7/8	12	347244	347344	347444	213.40	1.3156 - 1.3780	252.75	233.05	226.45	223.30	219.95	217.25
1.4375	1 7/16	4	8	3 1/4	7/8	12	347246	347346	347446	225.65	1.3781 - 1.4405	265.00	245.30	238.70	235.55	232.15	229.50
1.5000	1 1/2	4	8	3 1/2	7/8	12 1/2	347248	347348	347448	237.70	1.4406 - 1.5030	277.10	257.35	250.75	247.60	244.25	241.60
1.5625	1 9/16	4	8	3 1/2	7/8	12 1/2	347250	347350	347450	278.85	1.5031 - 1.5660	318.20	298.50	291.90	288.75	285.35	282.70
1.6250	1 5/8	4	8	3 3/4	7/8	13	347252	347352	347452	288.50	1.5661 - 1.6280	327.90	308.15	301.55	298.40	295.05	292.40
1.6875	1 11/16	4	8	3 3/4	7/8	13	347254	347354	347454	324.50	1.6281 - 1.6910	363.85	344.15	337.55	334.40	331.00	328.35
1.7500	1 3/4	4	10	4	7/8	13 1/2	347256	347356	347456	324.50	1.6911 - 1.7530	363.85	344.15	337.55	334.40	331.00	328.35
1.8125	1 13/16	4	10	4	7/8	13 1/2	347258	347358	347458	324.50	1.7531 - 1.8160	363.85	344.15	337.55	334.40	331.00	328.35
1.8750	1 7/8	4	10	4 1/4	7/8	14	347260	347360	347460	339.95	1.8161 - 1.8780	379.30	359.60	353.00	349.85	346.45	343.80
1.9375	1 15/16	4	10	4 1/4	7/8	14	347262	347362	347462	339.95	1.8781 - 1.9410	379.30	359.60	353.00	349.85	346.45	343.80
2.0000	2	4	12	4 1/4	7/8	14	347264	347364	347464	339.95	1.9411 - 2.0030	379.30	359.60	353.00	349.85	346.45	343.80

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CARBIDE TIPPED NAS 897 CHUCKING REAMERS

TYPE 3453 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3454 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3455 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece alloy steel bodies. Straight polished flutes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with flute long carbide. Tool geometry and carbide grade appropriate for material being machined.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3453 EDP NO.	CAST IRON TYPE 3454 EDP NO.	STEEL TYPE 3455 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL			FLT.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	1	4	1 1/2	6	345308	345408	345508	\$66.00	.2381 - .2530	\$104.35	\$85.15	\$78.70	\$75.65	\$72.35	\$69.80
.2812	9/32	1	4	1 1/2	6	345309	345409	345509	67.05	.2531 - .2840	105.35	86.15	79.75	76.70	73.40	70.80
.3125	5/16	1	4	1 1/2	6	345310	345410	345510	67.05	.2841 - .3150	105.35	86.15	79.75	76.70	73.40	70.80
.3438	11/32	1	4	1 1/2	6	345311	345411	345511	68.50	.3151 - .3470	106.85	87.65	81.20	78.15	74.85	72.30
.3750	3/8	1	4	1 3/4	7	345312	345412	345512	69.30	.3471 - .3780	107.65	88.45	82.00	78.95	75.65	73.05
.4062	13/32	1	4	1 3/4	7	345313	345413	345513	72.90	.3781 - .4090	111.25	92.05	85.60	82.55	79.25	76.70
.4375	7/16	1	6	1 3/4	7	345314	345414	345514	77.70	.4091 - .4410	116.05	96.80	90.40	87.35	84.05	81.45
.4688	15/32	1	6	1 3/4	7	345315	345415	345515	79.35	.4411 - .4720	117.70	98.45	92.05	89.00	85.70	83.10
.5000	1/2	1	6	2	8	345316	345416	345516	85.45	.4721 - .5030	126.50	105.90	99.05	95.75	92.25	89.45
.5312	17/32	1	6	2	8	345317	345417	345517	93.65	.5031 - .5340	134.75	114.15	107.25	104.00	100.45	97.70
.5625	9/16	1	6	2	8	345318	345418	345518	93.65	.5341 - .5660	134.75	114.15	107.25	104.00	100.45	97.70
.5938	19/32	1	6	2	8	345319	345419	345519	98.05	.5661 - .5970	139.10	118.50	111.65	108.35	104.85	102.05
.6250	5/8	2	6	2 1/4	9	345320	345420	345520	98.05	.5971 - .6280	139.10	118.50	111.65	108.35	104.85	102.05
.6562	21/32	2	6	2 1/4	9	345321	345421	345521	99.80	.6281 - .6590	140.85	120.30	113.40	110.10	106.60	103.80
.6875	11/16	2	6	2 1/4	9	345322	345422	345522	99.80	.6591 - .6910	140.85	120.30	113.40	110.10	106.60	103.80
.7188	23/32	2	6	2 1/4	9	345323	345423	345523	101.15	.6911 - .7220	142.20	121.65	114.75	111.45	107.95	105.15
.7500	3/4	2	6	2 1/2	9 1/2	345324	345424	345524	104.40	.7221 - .7530	145.50	124.90	118.00	114.75	111.20	108.45
.7812	25/32	2	6	2 1/2	9 1/2	345325	345425	345525	105.25	.7531 - .7840	146.35	125.75	118.85	115.60	112.05	109.30
.8125	13/16	2	6	2 1/2	9 1/2	345326	345426	345526	107.60	.7841 - .8160	148.70	128.10	121.20	117.95	114.40	111.65
.8438	27/32	2	6	2 1/2	9 1/2	345327	345427	345527	112.30	.8161 - .8470	153.40	132.80	125.90	122.65	119.10	116.35
.8750	7/8	2	6	2 5/8	10	345328	345428	345528	112.30	.8471 - .8780	153.40	132.80	125.90	122.65	119.10	116.35
.9062	29/32	3	6	2 5/8	10	345329	345429	345529	131.90	.8781 - .9090	172.95	152.40	145.50	142.20	138.70	135.90
.9375	15/16	3	8	2 5/8	10	345330	345430	345530	131.90	.9091 - .9410	172.95	152.40	145.50	142.20	138.70	135.90
.9688	31/32	3	8	2 5/8	10	345331	345431	345531	137.15	.9411 - .9720	178.25	157.65	150.80	147.50	144.00	141.20
1.0000	1	3	8	2 3/4	10 1/2	345332	345432	345532	137.15	.9721 - 1.0030	178.25	157.65	150.80	147.50	144.00	141.20
1.0625	1 1/16	3	8	2 3/4	10 1/2	345334	345434	345534	174.95	1.0031 - 1.0660	214.30	194.55	187.95	184.85	181.45	178.80
1.1250	1 1/8	3	8	2 7/8	11	345336	345436	345536	185.85	1.0661 - 1.1280	225.25	205.50	198.90	195.80	192.40	189.75
1.1875	1 3/16	3	8	2 7/8	11	345338	345438	345538	203.20	1.1281 - 1.1905	242.55	222.80	216.20	213.10	209.70	207.05
1.2500	1 1/4	4	8	3	11 1/2	345340	345440	345540	220.50	1.1906 - 1.2530	259.85	240.15	233.55	230.40	227.00	224.35
1.3125	1 5/16	4	8	3	11 1/2	345342	345442	345542	232.95	1.2531 - 1.3155	272.35	252.60	246.00	242.85	239.50	236.85
1.3750	1 3/8	4	8	3 1/4	12	345344	345444	345544	246.40	1.3156 - 1.3780	285.80	266.05	259.45	256.30	252.95	250.25
1.4375	1 7/16	4	8	3 1/4	12	345346	345446	345546	259.35	1.3781 - 1.4405	298.75	279.00	272.40	269.25	265.90	263.25
1.5000	1 1/2	4	8	3 1/2	12 1/2	345348	345448	345548	273.40	1.4406 - 1.5030	312.75	293.00	286.40	283.30	279.90	277.25

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*Quantities of 15 or more: price of fractional size in same size range.

CARBIDE TIPPED NAS 897 RIGHT SPIRAL CHUCKING REAMERS

TYPE 3442 - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3443 - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

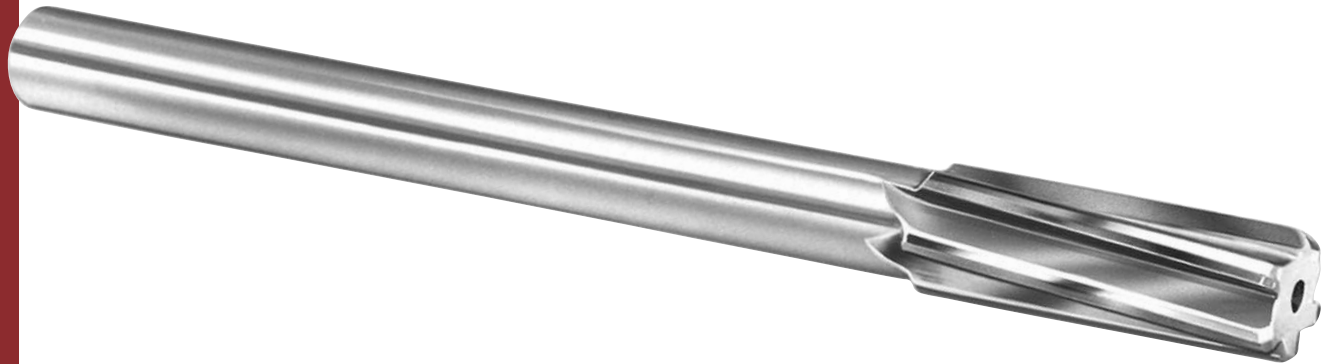
TYPE 3444 - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Right spiral polished flutes.

Right spiral flutes have a greater chip clearing ability for use with ductile materials, highly abrasive materials or blind holes. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with flute long carbide. Tool geometry and carbide grade appropriate for material being machined.

For step reamers, see page 105. For longer overall length reamers, see page 108.



Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3442 EDP NO.	CAST IRON TYPE 3443 EDP NO.	STEEL TYPE 3444 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION			FLT.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3125	5/16	.2792	4	1 1/2	6	344210	344310	344410	\$73.00	.2841 - .3150	\$108.95	\$90.90	\$84.90	\$82.05	\$78.95	\$76.50
.3438	11/32	.2792	4	1 1/2	6	344211	344311	344411	80.40	.3151 - .3470	116.35	98.35	92.30	89.45	86.35	83.95
.3750	3/8	.3105	4	1 3/4	7	344212	344312	344412	81.15	.3471 - .3780	117.10	99.10	93.05	90.20	87.10	84.65
.4062	13/32	.3105	4	1 3/4	7	344213	344313	344413	84.75	.3781 - .4090	120.70	102.70	96.65	93.80	90.70	88.25
.4375	7/16	.3730	6	1 3/4	7	344214	344314	344414	88.05	.4091 - .4410	124.00	106.00	99.95	97.10	94.00	91.60
.4688	15/32	.3730	6	1 3/4	7	344215	344315	344415	93.65	.4411 - .4720	129.60	111.55	105.55	102.70	99.60	97.15
.5000	1/2	.4355	6	2	8	344216	344316	344416	101.00	.4721 - .5030	139.30	120.10	113.70	110.60	107.35	104.75
.5312	17/32	.4355	6	2	8	344217	344317	344417	103.90	.5031 - .5340	142.20	123.00	116.60	113.50	110.25	107.65
.5625	9/16	.4355	6	2	8	344218	344318	344418	103.90	.5341 - .5660	142.20	123.00	116.60	113.50	110.25	107.65
.5938	19/32	.4355	6	2	8	344219	344319	344419	106.95	.5661 - .5970	145.30	126.05	119.65	116.60	113.30	110.70
.6250	5/8	.5615	6	2 1/4	9	344220	344320	344420	106.95	.5971 - .6280	145.30	126.05	119.65	116.60	113.30	110.70
.6562	21/32	.5615	6	2 1/4	9	344221	344321	344421	110.30	.6281 - .6590	148.65	129.45	123.00	119.95	116.65	114.05
.6875	11/16	.5615	6	2 1/4	9	344222	344322	344422	117.15	.6591 - .6910	155.45	136.25	129.85	126.75	123.50	120.90
.7188	23/32	.5615	6	2 1/4	9	344223	344323	344423	118.95	.6911 - .7220	157.25	138.05	131.65	128.60	125.30	122.70
.7500	3/4	.6245	6	2 1/2	9 1/2	344224	344324	344424	120.75	.7221 - .7530	159.05	139.85	133.45	130.40	127.10	124.50
.7812	25/32	.6245	6	2 1/2	9 1/2	344225	344325	344425	123.95	.7531 - .7840	162.30	143.10	136.65	133.60	130.30	127.70
.8125	13/16	.6245	6	2 1/2	9 1/2	344226	344326	344426	123.95	.7841 - .8160	162.30	143.10	136.65	133.60	130.30	127.70
.8438	27/32	.6245	6	2 1/2	9 1/2	344227	344327	344427	130.60	.8161 - .8470	168.95	149.75	143.30	140.25	136.95	134.40
.8750	7/8	.7495	6	2 5/8	10	344228	344328	344428	130.60	.8471 - .8780	168.95	149.75	143.30	140.25	136.95	134.40
.9062	29/32	.7495	6	2 5/8	10	344229	344329	344429	152.15	.8781 - .9090	190.50	171.30	164.90	161.80	158.50	155.95
.9375	15/16	.7495	8	2 5/8	10	344230	344330	344430	152.15	.9091 - .9410	190.50	171.30	164.90	161.80	158.50	155.95
.9688	31/32	.7495	8	2 5/8	10	344231	344331	344431	159.60	.9411 - .9720	197.95	178.75	172.30	169.25	165.95	163.40
1.0000	1	.8745	8	2 3/4	10 1/2	344232	344332	344432	159.60	.9721 - 1.0030	197.95	178.75	172.30	169.25	165.95	163.40
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	344234	344334	344434	187.60	1.0031 - 1.0660	225.95	206.75	200.30	197.25	193.95	191.35
1.1250	1 1/8	.8745	8	2 7/8	11	344236	344336	344436	193.40	1.0661 - 1.1280	231.75	212.55	206.10	203.05	199.75	197.20
1.1875	1 3/16	.9995	8	2 7/8	11	344238	344338	344438	203.30	1.1281 - 1.1905	241.65	222.40	216.00	212.95	209.65	207.05
1.2500	1 1/4	.9995	8	3	11 1/2	344240	344340	344440	215.15	1.1906 - 1.2530	253.45	234.25	227.85	224.75	221.50	218.90
1.3125	1 5/16	.9995	8	3	11 1/2	344242	344342	344442	238.00	1.2531 - 1.3155	276.35	257.15	250.70	247.65	244.35	241.80
1.3750	1 3/8	.9995	8	3 1/4	12	344244	344344	344444	260.75	1.3156 - 1.3780	299.10	279.90	273.45	270.40	267.10	264.50
1.4375	1 7/16	.9995	8	3 1/4	12	344246	344346	344446	276.30	1.3781 - 1.4405	314.60	295.40	289.00	285.90	282.65	280.05
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	344248	344348	344448	291.90	1.4406 - 1.5030	330.20	311.00	304.60	301.55	298.25	295.65

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CARBIDE TIPPED NAS 897 LEFT SPIRAL CHUCKING REAMERS

TYPE 3482 - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3483 - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3484 - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Left spiral polished flutes.

Left spiral flutes should only be used on through holes and very hard materials. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with flute long carbide. Tool geometry and carbide grade appropriate for material being machined.

For step reamers, see page 106. For longer overall length reamers, see page 109.



Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3482 EDP NO.	CAST IRON TYPE 3483 EDP NO.	STEEL TYPE 3484 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3125	5/16	.2792	4	1 1/2	6	348210	348310	348410	\$77.85	.2841 -.3150	\$116.20	\$97.00	\$90.55	\$87.50	\$84.20	\$81.60
.3438	11/32	.2792	4	1 1/2	6	348211	348311	348411	85.75	.3151 -.3470	124.10	104.90	98.45	95.40	92.10	89.55
.3750	3/8	.3105	4	1 3/4	7	348212	348312	348412	86.55	.3471 -.3780	124.90	105.70	99.25	96.20	92.90	90.30
.4062	13/32	.3105	4	1 3/4	7	348213	348313	348413	90.40	.3781 -.4090	128.75	109.50	103.10	100.05	96.75	94.15
.4375	7/16	.3730	6	1 3/4	7	348214	348314	348414	93.90	.4091 -.4410	132.25	113.05	106.60	103.55	100.25	97.70
.4688	15/32	.3730	6	1 3/4	7	348215	348315	348415	99.90	.4411 -.4720	138.20	119.00	112.60	109.50	106.25	103.65
.5000	1/2	.4355	6	2	8	348216	348316	348416	103.70	.4721 -.5030	143.05	123.35	116.70	113.60	110.20	107.55
.5312	17/32	.4355	6	2	8	348217	348317	348417	106.65	.5031 -.5340	146.05	126.30	119.70	116.55	113.20	110.55
.5625	9/16	.4355	6	2	8	348218	348318	348418	106.65	.5341 -.5660	146.05	126.30	119.70	116.55	113.20	110.55
.5938	19/32	.4355	6	2	8	348219	348319	348419	109.80	.5661 -.5970	149.15	129.45	122.85	119.70	116.30	113.65
.6250	5/8	.5615	6	2 1/4	9	348220	348320	348420	109.80	.5971 -.6280	149.15	129.45	122.85	119.70	116.30	113.65
.6562	21/32	.5615	6	2 1/4	9	348221	348321	348421	113.25	.6281 -.6590	152.65	132.90	126.30	123.15	119.80	117.15
.6875	11/16	.5615	6	2 1/4	9	348222	348322	348422	120.25	.6591 -.6910	159.65	139.90	133.30	130.15	126.80	124.15
.7188	23/32	.5615	6	2 1/4	9	348223	348323	348423	122.10	.6911 -.7220	161.50	141.75	135.15	132.00	128.65	126.00
.7500	3/4	.6245	6	2 1/2	9 1/2	348224	348324	348424	123.95	.7221 -.7530	163.35	143.60	137.00	133.85	130.50	127.85
.7812	25/32	.6245	6	2 1/2	9 1/2	348225	348325	348425	127.25	.7531 -.7840	166.65	146.90	140.30	137.15	133.80	131.15
.8125	13/16	.6245	6	2 1/2	9 1/2	348226	348326	348426	127.25	.7841 -.8160	166.65	146.90	140.30	137.15	133.80	131.15
.8438	27/32	.6245	6	2 1/2	9 1/2	348227	348327	348427	134.10	.8161 -.8470	173.50	153.75	147.15	144.00	140.65	138.00
.8750	7/8	.7495	6	2 5/8	10	348228	348328	348428	134.10	.8471 -.8780	173.50	153.75	147.15	144.00	140.65	138.00
.9062	29/32	.7495	6	2 5/8	10	348229	348329	348429	156.25	.8781 -.9090	195.60	175.90	169.30	166.15	162.75	160.10
.9375	15/16	.7495	8	2 5/8	10	348230	348330	348430	156.25	.9091 -.9410	195.60	175.90	169.30	166.15	162.75	160.10
.9688	31/32	.7495	8	2 5/8	10	348231	348331	348431	163.90	.9411 -.9720	203.25	183.55	176.95	173.80	170.40	167.75
1.0000	1	.8745	8	2 3/4	10 1/2	348232	348332	348432	163.90	.9721 -1.0030	203.25	183.55	176.95	173.80	170.40	167.75
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	348234	348334	348434	192.65	1.0031 -1.0660	232.00	212.30	205.70	202.55	199.15	196.50
1.1250	1 1/8	.8745	8	2 7/8	11	348236	348336	348436	198.60	1.0661 -1.1280	237.95	218.25	211.65	208.50	205.10	202.45
1.1875	1 3/16	.9995	8	2 7/8	11	348238	348338	348438	208.75	1.1281 -1.1905	248.10	228.40	221.80	218.65	215.25	212.60
1.2500	1 1/4	.9995	8	3	11 1/2	348240	348340	348440	220.90	1.1906 -1.2530	260.25	240.55	233.95	230.80	227.40	224.75
1.3125	1 5/16	.9995	8	3	11 1/2	348242	348342	348442	244.40	1.2531 -1.3155	283.75	264.05	257.45	254.30	250.90	248.25
1.3750	1 3/8	.9995	8	3 1/4	12	348244	348344	348444	267.75	1.3156 -1.3780	307.10	287.40	280.80	277.65	274.25	271.60
1.4375	1 7/16	.9995	8	3 1/4	12	348246	348346	348446	283.70	1.3781 -1.4405	323.05	303.30	296.70	293.60	290.20	287.55
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	348248	348348	348448	299.70	1.4406 -1.5030	339.05	319.35	312.75	309.60	306.20	303.55

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CARBIDE TIPPED NAS 897 RIGHT SPIRAL CHUCKING REAMERS

- TYPE 3432 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - FOR NON-FERROUS**
- TYPE 3436 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - FOR CAST IRON**
- TYPE 3438 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - FOR STEEL**

Carbide tips brazed to one piece hardened alloy steel bodies. Right spiral polished flutes.

Right spiral flutes have a greater chip clearing ability for use in blind holes. Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with partial flute length carbide. Tool geometry and carbide grade appropriate for material being machined.



Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.
For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLTS.	LENGTH			NON-FERR. TYPE 3432 EDP NO.	CAST IRON TYPE 3436 EDP NO.	STEEL TYPE 3438 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION			FLT	CARB	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	.1805	4	1 1/8	1/2	4 1/2	343206	343606	343806	\$60.70	.1770 - .2040	\$96.65	\$78.65	\$72.60	\$69.75	\$66.65	\$64.25
.2188	7/32	.2075	4	1 1/4	1/2	5	343207	343607	343807	60.70	.2041 - .2210	96.65	78.65	72.60	69.75	66.65	64.25
.2344	15/64	.2265	4	1 1/2	1/2	6	34322344	34362344	34382344	60.70	.2211 - .2380	96.65	78.65	72.60	69.75	66.65	64.25
.2500	1/4	.2405	4	1 1/2	1/2	6	343208	343608	343808	60.70	.2381 - .2530	96.65	78.65	72.60	69.75	66.65	64.25
.2812	9/32	.2485	4	1 1/2	1/2	6	343209	343609	343809	60.85	.2531 - .2840	96.80	78.80	72.75	69.90	66.80	64.40
.3125	5/16	.2792	4	1 1/2	1/2	6	343210	343610	343810	60.85	.2841 - .3150	96.80	78.80	72.75	69.90	66.80	64.40
.3438	11/32	.2792	4	1 1/2	5/8	6	343211	343611	343811	67.05	.3151 - .3470	102.95	84.95	78.95	76.05	73.00	70.55
.3750	3/8	.3105	4	1 3/4	5/8	7	343212	343612	343812	67.60	.3471 - .3780	103.55	85.55	79.55	76.65	73.55	71.15
.4062	13/32	.3105	4	1 3/4	5/8	7	343213	343613	343813	70.65	.3781 - .4090	106.60	88.55	82.55	79.65	76.60	74.15
.4375	7/16	.3730	6	1 3/4	5/8	7	343214	343614	343814	73.35	.4091 - .4410	109.30	91.30	85.25	82.40	79.30	76.90
.4688	15/32	.3730	6	1 3/4	5/8	7	343215	343615	343815	78.05	.4411 - .4720	114.00	96.00	89.95	87.10	84.00	81.60
.5000	1/2	.4355	6	2	5/8	8	343216	343616	343816	84.05	.4721 - .5030	122.40	103.15	96.75	93.70	90.40	87.80
.5312	17/32	.4355	6	2	5/8	8	343217	343617	343817	86.55	.5031 - .5340	124.90	105.70	99.25	96.20	92.90	90.30
.5625	9/16	.4355	6	2	5/8	8	343218	343618	343818	86.55	.5341 - .5660	124.90	105.70	99.25	96.20	92.90	90.30
.5938	19/32	.4355	6	2	5/8	8	343219	343619	343819	89.20	.5661 - .5970	127.55	108.35	101.90	98.85	95.55	93.00
.6250	5/8	.5615	6	2 1/4	5/8	9	343220	343620	343820	89.20	.5971 - .6280	127.55	108.35	101.90	98.85	95.55	93.00
.6562	21/32	.5615	6	2 1/4	5/8	9	343221	343621	343821	91.90	.6281 - .6590	130.20	111.00	104.60	101.55	98.25	95.65
.6875	11/16	.5615	6	2 1/4	5/8	9	343222	343622	343822	97.70	.6591 - .6910	136.00	116.80	110.40	107.35	104.05	101.45
.7188	23/32	.5615	6	2 1/4	5/8	9	343223	343623	343823	99.20	.6911 - .7220	137.50	118.30	111.90	108.80	105.55	102.95
.7500	3/4	.6245	6	2 1/2	3/4	9 1/2	343224	343624	343824	100.60	.7221 - .7530	138.90	119.70	113.30	110.25	106.95	104.35
.7812	25/32	.6245	6	2 1/2	3/4	9 1/2	343225	343625	343825	103.35	.7531 - .7840	141.65	122.45	116.05	112.95	109.70	107.10
.8125	13/16	.6245	6	2 1/2	3/4	9 1/2	343226	343626	343826	103.35	.7841 - .8160	141.65	122.45	116.05	112.95	109.70	107.10
.8438	27/32	.6245	6	2 1/2	3/4	9 1/2	343227	343627	343827	108.80	.8161 - .8470	147.15	127.95	121.50	118.45	115.15	112.60
.8750	7/8	.7495	6	2 5/8	3/4	10	343228	343628	343828	108.80	.8471 - .8780	147.15	127.95	121.50	118.45	115.15	112.60
.9062	29/32	.7495	6	2 5/8	3/4	10	343229	343629	343829	126.75	.8781 - .9090	165.10	145.90	139.45	136.40	133.10	130.55
.9375	15/16	.7495	8	2 5/8	3/4	10	343230	343630	343830	126.75	.9091 - .9410	165.10	145.90	139.45	136.40	133.10	130.55
.9688	31/32	.7495	8	2 5/8	3/4	10	343231	343631	343831	132.95	.9411 - .9720	171.30	152.10	145.65	142.60	139.30	136.75
1.0000	1	.8745	8	2 3/4	3/4	10 1/2	343232	343632	343832	132.95	.9721 - 1.0030	171.30	152.10	145.65	142.60	139.30	136.75
1.0625	1 1/16	.8745	8	2 3/4	3/4	10 1/2	343234	343634	343834	142.70	1.0031 - 1.0660	181.05	161.80	155.40	152.35	149.05	146.45
1.1250	1 1/8	.8745	8	2 7/8	7/8	11	343236	343636	343836	147.10	1.0661 - 1.1280	185.40	166.20	159.80	156.70	153.45	150.85
1.1875	1 3/16	.9995	8	2 7/8	7/8	11	343238	343638	343838	154.55	1.1281 - 1.1905	192.85	173.65	167.25	164.15	160.90	158.30
1.2500	1 1/4	.9995	8	3	7/8	11 1/2	343240	343640	343840	163.60	1.1906 - 1.2530	201.95	182.75	176.30	173.25	169.95	167.40
1.3125	1 5/16	.9995	8	3	7/8	11 1/2	343242	343642	343842	181.05	1.2531 - 1.3155	219.35	200.15	193.75	190.65	187.40	184.80
1.3750	1 3/8	.9995	8	3 1/4	7/8	12	343244	343644	343844	198.25	1.3156 - 1.3780	236.60	217.40	210.95	207.90	204.60	202.05
1.4375	1 7/16	.9995	8	3 1/4	7/8	12	343246	343646	343846	210.10	1.3781 - 1.4405	248.45	229.25	222.80	219.75	216.45	213.90
1.5000	1 1/2	1.2495	8	3 1/2	7/8	12 1/2	343248	343648	343848	221.95	1.4406 - 1.5030	260.30	241.10	234.65	231.60	228.30	225.70

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CARBIDE TIPPED NAS 897 LEFT SPIRAL CHUCKING REAMERS

TYPE 3433 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - FOR NON-FERROUS

TYPE 3437 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - FOR CAST IRON

TYPE 3439 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - FOR STEEL

Carbide tips brazed to one piece hardened alloy steel bodies. Left spiral polished flutes.

Left spiral flutes should only be used on through holes and very hard materials.
Finishes are much better as spiral flutes tend to bridge interruptions such as keyways, slots or intersecting holes.

NAS 897 chucking reamers manufactured to national aerospace standards 897 C with partial flute length carbide. Tool geometry and carbide grade appropriate for material being machined.



Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLTS.	LENGTH			NON-FERR. TYPE 3433 EDP NO.	CAST IRON TYPE 3437 EDP NO.	STEEL TYPE 3439 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT.	CARB.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.1875	3/16	.1805	4	1 1/8	1/2	4 1/2	343306	343706	343906	\$64.75	.1770 - .2040	\$103.10	\$83.90	\$77.45	\$74.40	\$71.10	\$68.50
.2188	7/32	.2075	4	1 1/4	1/2	5	343307	343707	343907	64.75	.2041 - .2210	103.10	83.90	77.45	74.40	71.10	68.50
.2344	15/64	.2265	4	1 1/2	1/2	6	34332344	34372344	34392344	64.75	.2211 - .2380	103.10	83.90	77.45	74.40	71.10	68.50
.2500	1/4	.2405	4	1 1/2	1/2	6	343308	343708	343908	64.75	.2381 - .2530	103.10	83.90	77.45	74.40	71.10	68.50
.2812	9/32	.2485	4	1 1/2	1/2	6	343309	343709	343909	64.90	.2531 - .2840	103.25	84.05	77.60	74.55	71.25	68.70
.3125	5/16	.2792	4	1 1/2	1/2	6	343310	343710	343910	64.90	.2841 - .3150	103.25	84.05	77.60	74.55	71.25	68.70
.3438	11/32	.2792	4	1 1/2	5/8	6	343311	343711	343911	71.50	.3151 - .3470	109.85	90.65	84.20	81.15	77.85	75.25
.3750	3/8	.3105	4	1 3/4	5/8	7	343312	343712	343912	72.15	.3471 - .3780	110.45	91.25	84.85	81.75	78.50	75.90
.4062	13/32	.3105	4	1 3/4	5/8	7	343313	343713	343913	75.35	.3781 - .4090	113.70	94.45	88.05	85.00	81.70	79.10
.4375	7/16	.3730	6	1 3/4	5/8	7	343314	343714	343914	78.25	.4091 - .4410	116.60	97.35	90.95	87.90	84.60	82.00
.4688	15/32	.3730	6	1 3/4	5/8	7	343315	343715	343915	83.25	.4411 - .4720	121.60	102.40	95.95	92.90	89.60	87.00
.5000	1/2	.4355	6	2	5/8	8	343316	343716	343916	86.30	.4721 - .5030	125.65	105.95	99.35	96.20	92.80	90.15
.5312	17/32	.4355	6	2	5/8	8	343317	343717	343917	88.85	.5031 - .5340	128.25	108.50	101.90	98.75	95.40	92.75
.5625	9/16	.4355	6	2	5/8	8	343318	343718	343918	88.85	.5341 - .5660	128.25	108.50	101.90	98.75	95.40	92.75
.5938	19/32	.4355	6	2	5/8	8	343319	343719	343919	91.60	.5661 - .5970	130.95	111.25	104.65	101.50	98.15	95.45
.6250	5/8	.5615	6	2 1/4	5/8	9	343320	343720	343920	91.60	.5971 - .6280	130.95	111.25	104.65	101.50	98.15	95.45
.6562	21/32	.5615	6	2 1/4	5/8	9	343321	343721	343921	94.35	.6281 - .6590	133.70	114.00	107.40	104.25	100.85	98.20
.6875	11/16	.5615	6	2 1/4	5/8	9	343322	343722	343922	100.30	.6591 - .6910	139.65	119.95	113.35	110.20	106.80	104.15
.7188	23/32	.5615	6	2 1/4	5/8	9	343323	343723	343923	101.85	.6911 - .7220	141.20	121.45	114.85	111.75	108.35	105.70
.7500	3/4	.6245	6	2 1/2	3/4	9 1/2	343324	343724	343924	103.30	.7221 - .7530	142.65	122.90	116.30	113.20	109.80	107.15
.7812	25/32	.6245	6	2 1/2	3/4	9 1/2	343325	343725	343925	106.10	.7531 - .7840	145.45	125.75	119.15	116.00	112.60	109.95
.8125	13/16	.6245	6	2 1/2	3/4	9 1/2	343326	343726	343926	106.10	.7841 - .8160	145.45	125.75	119.15	116.00	112.60	109.95
.8438	27/32	.6245	6	2 1/2	3/4	9 1/2	343327	343727	343927	111.75	.8161 - .8470	151.10	131.40	124.80	121.65	118.25	115.60
.8750	7/8	.7495	6	2 5/8	3/4	10	343328	343728	343928	111.75	.8471 - .8780	151.10	131.40	124.80	121.65	118.25	115.60
.9062	29/32	.7495	6	2 5/8	3/4	10	343329	343729	343929	130.15	.8781 - .9090	169.55	149.80	143.20	140.05	136.70	134.05
.9375	15/16	.7495	8	2 5/8	3/4	10	343330	343730	343930	130.15	.9091 - .9410	169.55	149.80	143.20	140.05	136.70	134.05
.9688	31/32	.7495	8	2 5/8	3/4	10	343331	343731	343931	136.55	.9411 - .9720	175.90	156.15	149.55	146.45	143.05	140.40
1.0000	1	.8745	8	2 3/4	3/4	10 1/2	343332	343732	343932	136.55	.9721 - 1.0030	175.90	156.15	149.55	146.45	143.05	140.40
1.0625	1 1/16	.8745	8	2 3/4	3/4	10 1/2	343334	343734	343934	146.50	1.0031 - 1.0660	185.85	166.15	159.55	156.40	153.05	150.35
1.1250	1 1/8	.8745	8	2 7/8	7/8	11	343336	343736	343936	151.00	1.0661 - 1.1280	190.40	170.65	164.05	160.90	157.55	154.90
1.1875	1 3/16	.9995	8	2 7/8	7/8	11	343338	343738	343938	158.65	1.1281 - 1.1905	198.05	178.30	171.70	168.55	165.20	162.55
1.2500	1 1/4	.9995	8	3	7/8	11 1/2	343340	343740	343940	168.00	1.1906 - 1.2530	207.35	187.65	181.05	177.90	174.50	171.85
1.3125	1 5/16	.9995	8	3	7/8	11 1/2	343342	343742	343942	185.85	1.2531 - 1.3155	225.25	205.50	198.90	195.80	192.40	189.75
1.3750	1 3/8	.9995	8	3 1/4	7/8	12	343344	343744	343944	203.60	1.3156 - 1.3780	242.95	223.25	216.65	213.50	210.10	207.45
1.4375	1 7/16	.9995	8	3 1/4	7/8	12	343346	343746	343946	215.75	1.3781 - 1.4405	255.10	235.40	228.80	225.65	222.25	219.60
1.5000	1 1/2	1.2495	8	3 1/2	7/8	12 1/2	343348	343748	343948	227.90	1.4406 - 1.5030	267.25	247.55	240.95	237.80	234.40	231.75

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*Quantities of 15 or more: price of fractional size in same size range.

CARBIDE TIPPED NAS 897 EXPANSION CHUCKING REAMERS

TYPE 3464 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3466 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3468 - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece alloy steel bodies. Straight polished flutes. Tool geometry and carbide grade appropriate for material being machined.

NAS 897 expansion reamers manufactured to national aerospace standards 897 C. Designed and manufactured for maximum tool life. Expansion reamers are recommended for reaming abrasive materials and as the diameter wears down, the reamer can be expanded many times by tightening the end adjusting screw and regrinding to its original size. Expansion reamers should not be considered adjustable for use in producing holes of several sizes.

TOOL DIAMETER	MINIMUM EXPANSION
5/16" - 15/32"	.006"
1/2" - 31/32"	.010"
1" - 1 1/2"	.013"
1 9/16" - 2 1/2"	.015"



Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter. For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3464 EDP NO.	CAST IRON TYPE 3466 EDP NO.	STEEL TYPE 3468 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.			FLT.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3125	5/16	.2792	4	1	6	346410	346610	346810	\$88.50	.2841 - .3150	\$126.85	\$107.65	\$101.20	\$98.15	\$94.85	\$92.30
.3438	11/32	.2792	4	1	6	346411	346611	346811	88.50	.3151 - .3470	126.85	107.65	101.20	98.15	94.85	92.30
.3750	3/8	.3105	4	1	7	346412	346612	346812	83.55	.3471 - .3780	119.50	101.50	95.50	92.60	89.50	87.10
.4062	13/32	.3105	4	1	7	346413	346613	346813	88.05	.3781 - .4090	124.00	106.00	99.95	97.10	94.00	91.60
.4375	7/16	.3730	6	1	7	346414	346614	346814	88.05	.4091 - .4410	124.00	106.00	99.95	97.10	94.00	91.60
.4688	15/32	.3730	6	1	7	346415	346615	346815	93.25	.4411 - .4720	129.20	111.20	105.20	102.30	99.20	96.80
.5000	1/2	.4355	6	1	8	346416	346616	346816	93.25	.4721 - .5030	129.20	111.20	105.20	102.30	99.20	96.80
.5312	17/32	.4355	6	1	8	346417	346617	346817	95.70	.5031 - .5340	131.65	113.65	107.60	104.75	101.65	99.20
.5625	9/16	.4355	6	1 1/8	8	346418	346618	346818	95.70	.5341 - .5660	131.65	113.65	107.60	104.75	101.65	99.20
.5938	19/32	.4355	6	1 1/8	8	346419	346619	346819	99.80	.5661 - .5970	135.75	117.75	111.70	108.85	105.75	103.35
.6250	5/8	.5615	6	1 1/4	9	346420	346620	346820	99.80	.5971 - .6280	135.75	117.75	111.70	108.85	105.75	103.35
.6562	21/32	.5615	6	1 1/4	9	346421	346621	346821	109.15	.6281 - .6590	145.10	127.10	121.05	118.20	115.10	112.70
.6875	11/16	.5615	6	1 1/4	9	346422	346622	346822	109.15	.6591 - .6910	145.10	127.10	121.05	118.20	115.10	112.70
.7188	23/32	.5615	6	1 1/4	9	346423	346623	346823	113.25	.6911 - .7220	149.20	131.20	125.15	122.30	119.20	116.80
.7500	3/4	.6245	6	1 3/8	9 1/2	346424	346624	346824	113.25	.7221 - .7530	149.20	131.20	125.15	122.30	119.20	116.80
.7812	25/32	.6245	6	1 3/8	9 1/2	346425	346625	346825	122.10	.7531 - .7840	158.00	140.00	134.00	131.10	128.05	125.60
.8125	13/16	.6245	6	1 3/8	9 1/2	346426	346626	346826	122.10	.7841 - .8160	158.00	140.00	134.00	131.10	128.05	125.60
.8438	27/32	.6245	6	1 3/8	9 1/2	346427	346627	346827	126.85	.8161 - .8470	162.80	144.80	138.75	135.90	132.80	130.40
.8750	7/8	.7495	6	1 1/2	10	346428	346628	346828	126.85	.8471 - .8780	162.80	144.80	138.75	135.90	132.80	130.40
.9062	29/32	.7495	6	1 1/2	10	346429	346629	346829	135.00	.8781 - .9090	170.95	152.95	146.95	144.05	140.95	138.55
.9375	15/16	.7495	8	1 1/2	10	346430	346630	346830	135.00	.9091 - .9410	170.95	152.95	146.95	144.05	140.95	138.55
.9688	31/32	.7495	8	1 1/2	10	346431	346631	346831	140.25	.9411 - .9720	176.20	158.15	152.15	149.30	146.20	143.75
1.0000	1	.8745	8	1 5/8	10 1/2	346432	346632	346832	140.25	.9721 - 1.0030	176.20	158.15	152.15	149.30	146.20	143.75
1.0312	1 1/32	.8745	8	1 5/8	10 1/2	346433	346633	346833	153.70	-	-	-	-	-	-	-
1.0625	1 1/16	.8745	8	1 5/8	10 1/2	346434	346634	346834	153.70	1.0031 - 1.0660	189.65	171.60	165.60	162.75	159.65	157.20
1.0938	1 1/32	.8745	8	1 3/4	11	346435	346635	346835	153.70	-	-	-	-	-	-	-
1.1250	1 1/8	.8745	8	1 3/4	11	346436	346636	346836	153.70	1.0661 - 1.1280	189.65	171.60	165.60	162.75	159.65	157.20
1.1875	1 3/16	.9995	8	1 3/4	11	346438	346638	346838	167.80	1.1281 - 1.1905	203.75	185.75	179.70	176.85	173.75	171.35
1.2500	1 1/4	.9995	8	1 7/8	11 1/2	346440	346640	346840	167.80	1.1906 - 1.2530	203.75	185.75	179.70	176.85	173.75	171.35
1.3125	1 5/16	.9995	8	1 7/8	11 1/2	346442	346642	346842	185.30	1.2531 - 1.3155	221.25	203.25	197.20	194.35	191.25	188.80
1.3750	1 3/8	.9995	8	2	12	346444	346644	346844	194.80	1.3156 - 1.3780	230.70	212.70	206.70	203.80	200.75	198.30
1.4375	1 7/16	.9995	8	2	12	346446	346646	346846	229.50	1.3781 - 1.4405	267.80	248.60	242.20	239.10	235.85	233.25
1.5000	1 1/2	1.2495	8	2 1/8	12 1/2	346448	346648	346848	236.00	1.4406 - 1.5030	274.30	255.10	248.70	245.65	242.35	239.75
1.5625	1 9/16	1.2495	8	2 1/8	12 1/2	346450	346650	346850	310.00	1.5031 - 1.5660	348.35	329.10	322.70	319.65	316.35	313.75
1.6250	1 5/8	1.2495	8	2 1/4	13	346452	346652	346852	310.00	1.5661 - 1.6280	348.35	329.10	322.70	319.65	316.35	313.75
1.6875	1 11/16	1.2495	8	2 1/4	13	346454	346654	346854	343.30	1.6281 - 1.6910	381.65	362.45	356.00	352.95	349.65	347.10
1.7500	1 3/4	1.2495	10	2 3/8	13 1/2	346456	346656	346856	343.30	1.6911 - 1.7530	381.65	362.45	356.00	352.95	349.65	347.10
1.8125	1 13/16	1.4995	10	2 3/8	13 1/2	346458	346658	346858	406.50	1.7531 - 1.8160	444.85	425.65	419.20	416.15	412.85	410.25
1.8750	1 7/8	1.4995	10	2 1/2	14	346460	346660	346860	406.50	1.8161 - 1.8780	444.85	425.65	419.20	416.15	412.85	410.25
1.9375	1 15/16	1.4995	10	2 1/2	14	346462	346662	346862	444.15	1.8781 - 1.9410	482.45	463.25	456.85	453.80	450.50	447.90
2.0000	2	1.4995	12	2 1/2	14	346464	346664	346864	444.15	1.9411 - 2.0030	482.45	463.25	456.85	453.80	450.50	447.90

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CARBIDE TIPPED NAS 897 EXPANSION CHUCKING REAMERS

TYPE 3461 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3462 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3463 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece alloy steel bodies. Straight polished flutes.
Tool geometry and carbide grade appropriate for material being machined.

TOOL DIAMETER		MINIMUM EXPANSION
5/16" - 15/32"		.006"
1/2" - 31/32"		.010"
1" - 1 1/2"		.013"
1 9/16" - 2 1/2"		.015"

NAS 897 expansion reamers manufactured to national aerospace standards 897 C. Designed and manufactured for maximum tool life. Expansion reamers are recommended for reaming abrasive materials and as the diameter wears down, the reamer can be expanded many times by tightening the end adjusting screw and regrinding to its original size. Expansion reamers should not be considered adjustable for use in producing holes of several sizes.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3461 EDP NO.	CAST IRON TYPE 3462 EDP NO.	STEEL TYPE 3463 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3750	3/8	1	4	1	7	346112	346212	346312	\$93.50	.3471 - .3780	\$129.45	\$111.45	\$105.40	\$102.55	\$99.45	\$97.00
.4062	13/32	1	4	1	7	346113	346213	346313	94.90	.3781 - .4090	130.85	112.80	106.80	103.95	100.85	98.40
.4375	7/16	1	6	1	7	346114	346214	346314	96.30	.4091 - .4410	132.25	114.20	108.20	105.35	102.25	99.80
.4688	15/32	1	6	1	7	346115	346215	346315	100.45	.4411 - .4720	136.40	118.40	112.40	109.50	106.45	104.00
.5000	1/2	1	6	1	8	346116	346216	346316	101.05	.4721 - .5030	137.00	119.00	112.95	110.10	107.00	104.60
.5312	17/32	1	6	1	8	346117	346217	346317	104.20	.5031 - .5340	140.15	122.15	116.15	113.25	110.20	107.75
.5625	9/16	1	6	1 1/8	8	346118	346218	346318	104.20	.5341 - .5660	140.15	122.15	116.15	113.25	110.20	107.75
.5938	19/32	1	6	1 1/8	8	346119	346219	346319	108.10	.5661 - .5970	144.05	126.05	120.05	117.15	114.05	111.65
.6250	5/8	2	6	1 1/4	9	346120	346220	346320	108.40	.5971 - .6280	144.35	126.35	120.30	117.45	114.35	111.95
.6562	21/32	2	6	1 1/4	9	346121	346221	346321	117.75	.6281 - .6590	153.70	135.70	129.65	126.80	123.70	121.30
.6875	11/16	2	6	1 1/4	9	346122	346222	346322	118.10	.6591 - .6910	154.05	136.05	130.00	127.15	124.05	121.65
.7188	23/32	2	6	1 1/4	9	346123	346223	346323	122.40	.6911 - .7220	158.30	140.30	134.30	131.40	128.35	125.90
.7500	3/4	2	6	1 3/8	9 1/2	346124	346224	346324	122.40	.7221 - .7530	158.30	140.30	134.30	131.40	128.35	125.90
.7812	25/32	2	6	1 3/8	9 1/2	346125	346225	346325	131.35	.7531 - .7840	167.30	149.30	143.25	140.40	137.30	134.85
.8125	13/16	2	6	1 3/8	9 1/2	346126	346226	346326	131.35	.7841 - .8160	167.30	149.30	143.25	140.40	137.30	134.85
.8438	27/32	2	6	1 3/8	9 1/2	346127	346227	346327	136.80	.8161 - .8470	172.70	154.70	148.70	145.80	142.75	140.30
.8750	7/8	2	6	1 1/2	10	346128	346228	346328	136.80	.8471 - .8780	172.70	154.70	148.70	145.80	142.75	140.30
.9062	29/32	2	6	1 1/2	10	346129	346229	346329	144.05	.8781 - .9090	180.00	162.00	155.95	153.10	150.00	147.60
.9375	15/16	3	8	1 1/2	10	346130	346230	346330	144.80	.9091 - .9410	180.75	162.75	156.70	153.85	150.75	148.30
.9688	31/32	3	8	1 1/2	10	346131	346231	346331	149.95	.9411 - .9720	185.90	167.85	161.85	159.00	155.90	153.45
1.0000	1	3	8	1 5/8	10 1/2	346132	346232	346332	149.95	.9721 - 1.0030	185.90	167.85	161.85	159.00	155.90	153.45
1.0312	1 1/32	3	8	1 5/8	10 1/2	346133	346233	346333	159.50	-	-	-	-	-	-	-
1.0625	1 1/16	3	8	1 5/8	10 1/2	346134	346234	346334	159.50	1.0031 - 1.0660	195.45	177.45	171.40	168.55	165.45	163.00
1.0938	1 3/32	3	8	1 3/4	11	346135	346235	346335	164.15	-	-	-	-	-	-	-
1.1250	1 1/8	3	8	1 3/4	11	346136	346236	346336	164.15	1.0661 - 1.1280	200.05	182.05	176.05	173.15	170.10	167.65
1.1875	1 3/16	3	8	1 3/4	11	346138	346238	346338	175.15	1.1281 - 1.1905	211.10	193.10	187.05	184.20	181.10	178.70
1.2500	1 1/4	4	8	1 7/8	11 1/2	346140	346240	346340	187.05	1.1906 - 1.2530	223.00	205.00	198.95	196.10	193.00	190.60
1.3125	1 5/16	4	8	1 7/8	11 1/2	346142	346242	346342	194.10	1.2531 - 1.3155	230.05	212.05	206.00	203.15	200.05	197.65
1.3750	1 3/8	4	8	2	12	346144	346244	346344	215.30	1.3156 - 1.3780	251.20	233.20	227.20	224.30	221.25	218.80
1.4375	1 7/16	4	8	2	12	346146	346246	346346	238.55	1.3781 - 1.4405	276.90	257.70	251.25	248.20	244.90	242.35
1.5000	1 1/2	4	8	2 1/8	12 1/2	346148	346248	346348	245.80	1.4406 - 1.5030	284.10	264.90	258.50	255.45	252.15	249.55
1.5625	1 9/16	4	8	2 1/8	12 1/2	346150	346250	346350	344.35	1.5031 - 1.5660	382.65	363.45	357.05	354.00	350.70	348.10
1.6250	1 5/8	4	8	2 1/4	13	346152	346252	346352	344.35	1.5661 - 1.6280	382.65	363.45	357.05	354.00	350.70	348.10
1.6875	1 11/16	4	8	2 1/4	13	346154	346254	346354	381.50	1.6281 - 1.6910	419.85	400.60	394.20	391.15	387.85	385.25
1.7500	1 3/4	4	10	2 3/8	13 1/2	346156	346256	346356	381.50	1.6911 - 1.7530	419.85	400.60	394.20	391.15	387.85	385.25
1.8125	1 13/16	4	10	2 3/8	13 1/2	346158	346258	346358	451.75	1.7531 - 1.8160	490.10	470.85	464.45	461.40	458.10	455.50
1.8750	1 7/8	4	10	2 1/2	14	346160	346260	346360	451.75	1.8161 - 1.8780	490.10	470.85	464.45	461.40	458.10	455.50
1.9375	1 15/16	4	10	2 1/2	14	346162	346262	346362	493.30	1.8781 - 1.9410	531.65	512.40	506.00	502.95	499.65	497.05
2.0000	2	4	12	2 1/2	14	346164	346264	346364	493.30	1.9411 - 2.0030	531.65	512.40	506.00	502.95	499.65	497.05

CARBIDE TIPPED COOLANT REAMERS

TYPE 3416 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR NON-FERROUS

TYPE 3426 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR CAST IRON

TYPE 3435 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR STEEL

Flute long carbide tips (.2841" tool diameter and larger) brazed to one piece hardened alloy steel bodies. Straight polished flutes.



Coolant feeding hole in each flute for flushing chips forward through the hole being reamed. Tool geometry and carbide grade appropriate for material being machined. For longer overall length reamers, see page 107.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3416 EDP NO.	CAST IRON TYPE 3426 EDP NO.	STEEL TYPE 3435 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.1875	3/16	.1805	4	1 1/4*	5	341606	342606	343506	\$136.40	.1770 - .2040	\$177.50	\$156.90	\$150.00	\$146.75	\$143.20	\$140.45
.2031	13/64	.1805	4	1 1/4*	5	34162031	34262031	34352031	136.40	-	-	-	-	-	-	-
.2188	7/32	.2075	4	1 1/4*	5	341607	342607	343507	136.40	.2041 - .2210	177.50	156.90	150.00	146.75	143.20	140.45
.2344	15/64	.2265	4	1 1/2*	6	34162344	34262344	34352344	136.40	.2211 - .2380	177.50	156.90	150.00	146.75	143.20	140.45
.2500	1/4	.2405	4	1 1/2*	6	341608	342608	343508	136.40	.2381 - .2530	177.50	156.90	150.00	146.75	143.20	140.45
.2656	17/64	.2485	4	1 1/2*	6	34162656	34262656	34352656	139.50	-	-	-	-	-	-	-
.2812	9/32	.2485	4	1 1/2*	6	341609	342609	343509	139.50	.2531 - .2840	180.60	160.00	153.15	149.85	146.35	143.55
.2969	19/64	.2792	4	1 1/2	6	34162969	34262969	34352969	151.35	-	-	-	-	-	-	-
.3125	5/16	.2792	4	1 1/2	6	341610	342610	343510	151.35	.2841 - .3150	192.45	171.85	165.00	161.70	158.15	155.40
.3281	21/64	.2792	4	1 1/2	6	34163281	34263281	34353281	151.35	-	-	-	-	-	-	-
.3438	11/32	.2792	4	1 1/2	6	341611	342611	343511	151.35	.3151 - .3470	192.45	171.85	165.00	161.70	158.15	155.40
.3594	23/64	.3105	4	1 3/4	7	34163594	34263594	34353594	151.35	-	-	-	-	-	-	-
.3750	3/8	.3105	4	1 3/4	7	341612	342612	343512	151.35	.3471 - .3780	192.45	171.85	165.00	161.70	158.15	155.40
.3906	25/64	.3105	4	1 3/4	7	34163906	34263906	34353906	155.15	-	-	-	-	-	-	-
.4062	13/32	.3105	4	1 3/4	7	341613	342613	343513	155.15	.3781 - .4090	196.20	175.65	168.75	165.50	161.95	159.20
.4219	27/64	.3730	6	1 3/4	7	34164219	34264219	34354219	158.95	-	-	-	-	-	-	-
.4375	7/16	.3730	6	1 3/4	7	341614	342614	343514	158.95	.4091 - .4410	200.00	179.40	172.55	169.25	165.75	162.95
.4531	29/64	.3730	6	1 3/4	7	34164531	34264531	34354531	158.95	-	-	-	-	-	-	-
.4688	15/32	.3730	6	1 3/4	7	341615	342615	343515	158.95	.4411 - .4720	200.00	179.40	172.55	169.25	165.75	162.95
.4844	31/64	.4355	6	2	8	34164844	34264844	34354844	158.95	-	-	-	-	-	-	-
.5000	1/2	.4355	6	2	8	341616	342616	343516	158.95	.4721 - .5030	200.00	179.40	172.55	169.25	165.75	162.95
.5156	33/64	.4355	6	2	8	34165156	34265156	34355156	168.10	-	-	-	-	-	-	-
.5312	17/32	.4355	6	2	8	341617	342617	343517	168.10	.5031 - .5340	209.15	188.60	181.70	178.40	174.90	172.10
.5625	9/16	.4355	6	2	8	341618	342618	343518	170.45	.5341 - .5660	211.50	190.95	184.05	180.75	177.25	174.45
.5938	19/32	.4355	6	2	8	341619	342619	343519	172.05	.5661 - .5970	213.10	192.55	185.65	182.35	178.85	176.05
.6250	5/8	.5615	6	2 1/4	9	341620	342620	343520	172.05	.5971 - .6280	213.10	192.55	185.65	182.35	178.85	176.05
.6562	21/32	.5615	6	2 1/4	9	341621	342621	343521	190.70	.6281 - .6590	231.75	211.20	204.30	201.00	197.50	194.70
.6875	11/16	.5615	6	2 1/4	9	341622	342622	343522	190.70	.6591 - .6910	231.75	211.20	204.30	201.00	197.50	194.70
.7188	23/32	.5615	6	2 1/4	9	341623	342623	343523	203.80	.6911 - .7220	244.85	224.30	217.40	214.10	210.60	207.80
.7500	3/4	.6245	6	2 1/2	9 1/2	341624	342624	343524	203.80	.7221 - .7530	244.85	224.30	217.40	214.10	210.60	207.80
.7812	25/32	.6245	6	2 1/2	9 1/2	341625	342625	343525	203.80	.7531 - .7840	244.85	224.30	217.40	214.10	210.60	207.80
.8125	13/16	.6245	6	2 1/2	9 1/2	341626	342626	343526	203.80	.7841 - .8160	244.85	224.30	217.40	214.10	210.60	207.80
.8438	27/32	.6245	6	2 1/2	9 1/2	341627	342627	343527	209.90	.8161 - .8470	251.00	230.40	223.50	220.25	216.70	213.95
.8750	7/8	.7495	6	2 5/8	10	341628	342628	343528	209.90	.8471 - .8780	251.00	230.40	223.50	220.25	216.70	213.95
.9062	29/32	.7495	6	2 5/8	10	341629	342629	343529	235.70	.8781 - .9090	276.80	256.20	249.30	246.05	242.50	239.75
.9375	15/16	.7495	8	2 5/8	10	341630	342630	343530	241.15	.9091 - .9410	282.25	261.65	254.75	251.50	247.95	245.20
.9688	31/32	.7495	8	2 5/8	10	341631	342631	343531	241.15	.9411 - .9720	282.25	261.65	254.75	251.50	247.95	245.20
1.0000	1	.8745	8	2 3/4	10 1/2	341632	342632	343532	241.15	.9721 - 1.0030	282.25	261.65	254.75	251.50	247.95	245.20
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341634	342634	343534	255.10	1.0031 - 1.0660	296.20	275.60	268.70	265.45	261.90	259.15
1.1250	1 1/8	.8745	8	2 7/8	11	341636	342636	343536	256.10	1.0661 - 1.1280	297.20	276.60	269.70	266.45	262.90	260.15
1.1875	1 3/16	.9995	8	2 7/8	11	341638	342638	343538	266.70	1.1281 - 1.1905	307.80	287.20	280.30	277.05	273.50	270.75
1.2500	1 1/4	.9995	8	3	11 1/2	341640	342640	343540	270.25	1.1906 - 1.2530	311.30	290.70	283.85	280.55	277.05	274.25
1.3125	1 5/16	.9995	8	3	11 1/2	341642	342642	343542	277.95	1.2531 - 1.3155	319.05	298.45	291.55	288.30	284.75	282.00
1.3750	1 3/8	.9995	8	3 1/4	12	341644	342644	343544	289.20	1.3156 - 1.3780	330.30	309.70	302.80	299.55	296.00	293.25
1.4375	1 7/16	.9995	8	3 3/4	12	341646	342646	343546	298.30	1.3781 - 1.4405	339.35	318.80	311.90	308.60	305.10	302.30
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341648	342648	343548	308.30	1.4406 - 1.5030	349.35	328.80	321.90	318.60	315.10	312.30

CARBIDE TIPPED COOLANT REAMERS

METRIC

TYPE 3416 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR NON-FERROUS
TYPE 3426 - STRAIGHT SHANK & FLUTES- THROUGH HOLES - FOR CAST IRON
TYPE 3435 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR STEEL



Detailed description and fractional sizes on page 94. Tolerances on page 50.
 Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3416 EDP NO.	CAST IRON TYPE 3426 EDP NO.	STEEL TYPE 3435 EDP NO.	ALL TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
4.5	.1772	.1704	4	1 1/4*	5	3416045	3426045	3435045	\$150.00	4.494 - 4.696	\$180.95	\$160.45	\$153.55	\$150.20	\$146.75	\$143.90	\$139.95
5.0	.1969	.1805	4	1 1/4*	5	3416050	3426050	3435050	150.00	4.697 - 5.182	180.95	160.45	153.55	150.20	146.75	143.90	139.95
5.5	.2165	.2075	4	1 1/4*	5	3416055	3426055	3435055	150.00	5.183 - 5.613	180.95	160.45	153.55	150.20	146.75	143.90	139.95
6.0	.2362	.2265	4	1 1/2*	6	3416060	3426060	3435060	150.00	5.614 - 6.045	180.95	160.45	153.55	150.20	146.75	143.90	139.95
-	-	.2405	4	1 1/2*	6	3416063	3426063	3435063	-	6.046 - 6.426	180.95	160.45	153.55	150.20	146.75	143.90	139.95
6.5	.2559	.2485	4	1 1/2*	6	3416065	3426065	3435065	153.15	6.427 - 7.214	184.05	163.55	156.65	153.30	149.85	147.00	143.05
7.0	.2756	.2485	4	1 1/2*	6	3416070	3426070	3435070	153.15	-	-	-	-	-	-	-	-
7.5	.2953	.2792	4	1 1/2	6	3416075	3426075	3435075	165.00	7.215 - 8.001	195.90	175.40	168.50	165.15	161.70	158.85	154.90
8.0	.3150	.2792	4	1 1/2	6	3416080	3426080	3435080	165.00	-	-	-	-	-	-	-	-
8.5	.3346	.2792	4	1 1/2	6	3416085	3426085	3435085	165.00	8.002 - 8.814	195.90	175.40	168.50	165.15	161.70	158.85	154.90
9.0	.3543	.3105	4	1 3/4	7	3416090	3426090	3435090	165.00	8.815 - 9.601	195.90	175.40	168.50	165.15	161.70	158.85	154.90
9.5	.3740	.3105	4	1 3/4	7	3416095	3426095	3435095	165.00	-	-	-	-	-	-	-	-
10.0	.3937	.3105	4	1 3/4	7	3416100	3426100	3435100	168.75	9.602 - 10.389	199.65	179.15	172.30	168.90	165.50	162.60	158.70
10.5	.4134	.3730	6	1 3/4	7	3416105	3426105	3435105	172.55	10.390 - 11.201	203.45	182.95	176.05	172.70	169.25	166.40	162.45
11.0	.4331	.3730	6	1 3/4	7	3416110	3426110	3435110	172.55	-	-	-	-	-	-	-	-
11.5	.4528	.3730	6	1 3/4	7	3416115	3426115	3435115	172.55	11.202 - 11.989	203.45	182.95	176.05	172.70	169.25	166.40	162.45
12.0	.4724	.4355	6	2	8	3416120	3426120	3435120	172.55	11.990 - 12.776	203.45	182.95	176.05	172.70	169.25	166.40	162.45
12.5	.4921	.4355	6	2	8	3416125	3426125	3435125	172.55	-	-	-	-	-	-	-	-
13.0	.5118	.4355	6	2	8	3416130	3426130	3435130	181.70	12.777 - 13.564	212.60	192.10	185.20	181.85	178.40	175.55	171.60
13.5	.5315	.4355	6	2	8	3416135	3426135	3435135	181.70	-	-	-	-	-	-	-	-
14.0	.5512	.4355	6	2	8	3416140	3426140	3435140	184.05	13.565 - 14.376	214.95	194.45	187.55	184.20	180.75	177.90	173.95
14.5	.5709	.4355	6	2	8	3416145	3426145	3435145	185.65	14.377 - 15.164	216.55	196.05	189.15	185.80	182.35	179.50	175.55
15.0	.5906	.4355	6	2	8	3416150	3426150	3435150	185.65	-	-	-	-	-	-	-	-
15.5	.6102	.5615	6	2 1/4	9	3416155	3426155	3435155	185.65	15.165 - 15.951	216.55	196.05	189.15	185.80	182.35	179.50	175.55
16.0	.6299	.5615	6	2 1/4	9	3416160	3426160	3435160	204.30	15.952 - 16.739	235.20	214.70	207.80	204.45	201.00	198.15	194.20
16.5	.6496	.5615	6	2 1/4	9	3416165	3426165	3435165	204.30	-	-	-	-	-	-	-	-
17.0	.6693	.5615	6	2 1/4	9	3416170	3426170	3435170	204.30	16.740 - 17.551	235.20	214.70	207.80	204.45	201.00	198.15	194.20
17.5	.6890	.5615	6	2 1/4	9	3416175	3426175	3435175	204.30	-	-	-	-	-	-	-	-
18.0	.7087	.5615	6	2 1/4	9	3416180	3426180	3435180	217.40	17.552 - 18.339	248.30	227.80	220.90	217.55	214.10	211.25	207.30
18.5	.7283	.6245	6	2 1/2	9 1/2	3416185	3426185	3435185	217.40	18.340 - 19.126	248.30	227.80	220.90	217.55	214.10	211.25	207.30
19.0	.7480	.6245	6	2 1/2	9 1/2	3416190	3426190	3435190	217.40	-	-	-	-	-	-	-	-
19.5	.7677	.6245	6	2 1/2	9 1/2	3416195	3426195	3435195	217.40	19.127 - 19.914	248.30	227.80	220.90	217.55	214.10	211.25	207.30
20.0	.7874	.6245	6	2 1/2	9 1/2	3416200	3426200	3435200	217.40	19.915 - 20.726	248.30	227.80	220.90	217.55	214.10	211.25	207.30
20.5	.8071	.6245	6	2 1/2	9 1/2	3416205	3426205	3435205	217.40	-	-	-	-	-	-	-	-
21.0	.8268	.6245	6	2 1/2	9 1/2	3416210	3426210	3435210	223.50	20.727 - 21.514	254.45	233.95	227.05	223.70	220.25	217.40	213.45
21.5	.8465	.6245	6	2 1/2	9 1/2	3416215	3426215	3435215	223.50	-	-	-	-	-	-	-	-
22.0	.8661	.7495	6	2 5/8	10	3416220	3426220	3435220	223.50	21.515 - 22.301	254.45	233.95	227.05	223.70	220.25	217.40	213.45
22.5	.8858	.7495	6	2 5/8	10	3416225	3426225	3435225	249.30	22.302 - 23.089	280.20	259.75	252.85	249.50	246.05	243.20	239.25
23.0	.9055	.7495	6	2 5/8	10	3416230	3426230	3435230	249.30	-	-	-	-	-	-	-	-
23.5	.9252	.7495	8	2 5/8	10	3416235	3426235	3435235	254.75	23.090 - 23.901	285.70	265.20	258.30	254.95	251.50	248.65	244.70
24.0	.9449	.7495	8	2 5/8	10	3416240	3426240	3435240	254.75	23.902 - 24.689	285.70	265.20	258.30	254.95	251.50	248.65	244.70
24.5	.9646	.7495	8	2 5/8	10	3416245	3426245	3435245	254.75	-	-	-	-	-	-	-	-
25.0	.9843	.8745	8	2 3/4	10 1/2	3416250	3426250	3435250	254.75	24.690 - 25.476	285.70	265.20	258.30	254.95	251.50	248.65	244.70
25.5	1.0039	.8745	8	2 3/4	10 1/2	3416255	3426255	3435255	268.70	25.477 - 27.076	299.65	279.15	272.25	268.90	265.45	262.60	258.65
26.0	1.0236	.8745	8	2 3/4	10 1/2	3416260	3426260	3435260	268.70	-	-	-	-	-	-	-	-
27.0	1.0630	.8745	8	2 3/4	10 1/2	3416270	3426270	3435270	268.70	-	-	-	-	-	-	-	-
28.0	1.1024	.8745	8	2 7/8	11	3416280	3426280	3435280	269.80	27.077 - 28.651	300.65	280.15	273.25	269.90	266.45	263.60	259.65
29.0	1.1417	.9995	8	2 7/8	11	3416290	3426290	3435290	280.30	28.652 - 30.239	311.20	290.70	283.85	280.50	277.05	274.20	270.25
30.0	1.1811	.9995	8	2 7/8	11	3416300	3426300	3435300	280.30	-	-	-	-	-	-	-	-
31.0	1.2205	.9995	8	3	11 1/2	3416310	3426310	3435310	283.85	30.240 - 31.826	314.75	294.25	287.35	284.00	280.55	277.70	273.75
32.0	1.2598	.9995	8	3	11 1/2	3416320	3426320	3435320	291.55	31.827 - 33.414	322.50	302.00	295.10	291.75	288.30	285.45	281.50
33.0	1.2992	.9995	8	3	11 1/2	3416330	3426330	3435330	291.55	-	-	-	-	-	-	-	-
34.0	1.3386	.9995	8	3 1/4	12	3416340	3426340	3435340	302.80	33.415 - 35.001	333.75	313.25	306.35	303.00	299.55	296.70	292.75
35.0	1.3780	.9995	8	3 1/4	12	3416350	3426350	3435350	302.80	-	-	-	-	-	-	-	-
36.0	1.4173	.9995	8	3 1/4	12	3416360	3426360	3435360	311.90	35.002 - 36.589	342.80	322.30	315.40	312.05	308.60	305.75	301.80
37.0	1.4567	1.2495	8	3 1/2	12 1/2	3416370	3426370	3435370	321.90	36.590 - 38.176	352.80	332.30	325.40	322.05	318.60	315.75	311.80
38.0	1.4961	1.2495	8	3 1/2	12 1/2	3416380	3426380	3435380	321.90	-	-	-	-	-	-	-	-

*1/2" carbide length.

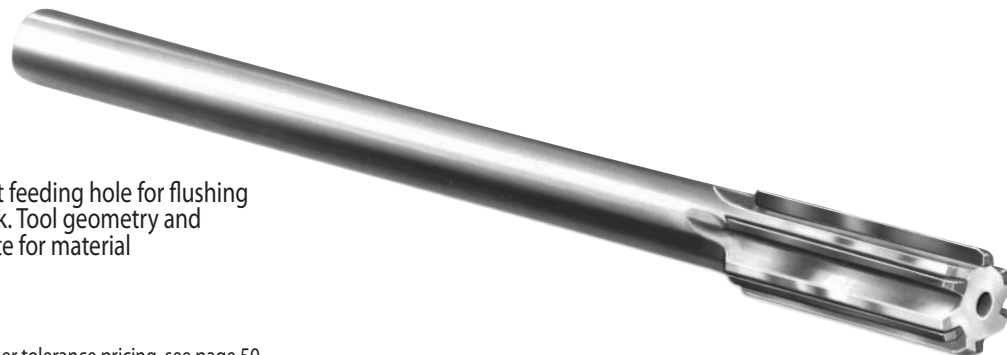
CARBIDE TIPPED COOLANT REAMERS

TYPE 3414 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR NON-FERROUS

TYPE 3424 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR CAST IRON

TYPE 3434 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR STEEL

Flute long carbide tips (.2841" tool diameter and larger) brazed to one piece hardened alloy steel bodies. Straight polished flutes.



For length center coolant feeding hole for flushing chips back towards shank. Tool geometry and carbide grade appropriate for material being machined.

For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3414 EDP NO.	CAST IRON TYPE 3424 EDP NO.	STEEL TYPE 3434 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.1875	3/16	.1805	4	1 1/4**	5	341406	342406	343406	\$131.45	.1770 - .2040	\$172.55	\$151.95	\$145.05	\$141.80	\$138.25	\$135.50
.2031	13/64	.1805	4	1 1/4**	5	34142031	34242031	34342031	131.45	-	-	-	-	-	-	-
.2188	7/32	.2075	4	1 1/4**	5	341407	342407	343407	131.45	.2041 - .2210	172.55	151.95	145.05	141.80	138.25	135.50
.2344	15/64	.2265	4	1 1/2**	6	34142344	34242344	34342344	131.45	.2211 - .2380	172.55	151.95	145.05	141.80	138.25	135.50
.2500	1/4	.2405	4	1 1/2**	6	341408	342408	343408	131.45	.2381 - .2530	172.55	151.95	145.05	141.80	138.25	135.50
.2656	17/64	.2485	4	1 1/2**	6	34142656	34242656	34342656	139.50	-	-	-	-	-	-	-
.2812	9/32	.2485	4	1 1/2**	6	341409	342409	343409	139.50	.2531 - .2840	180.60	160.00	153.15	149.85	146.35	143.55
.2969	19/64	.2792	4	1 1/2	6	34142969	34242969	34342969	147.35	-	-	-	-	-	-	-
.3125	5/16	.2792	4	1 1/2	6	341410	342410	343410	147.35	.2841 - .3150	188.40	167.85	160.95	157.65	154.15	151.35
.3281	21/64	.2792	4	1 1/2	6	34143281	34243281	34343281	148.50	-	-	-	-	-	-	-
.3438	11/32	.2792	4	1 1/2	6	341411	342411	343411	148.50	.3151 - .3470	189.60	169.00	162.10	158.85	155.30	152.55
.3594	23/64	.3105	4	1 3/4	7	34143594	34243594	34343594	150.00	-	-	-	-	-	-	-
.3750	3/8	.3105	4	1 3/4	7	341412	342412	343412	150.00	.3471 - .3780	191.10	170.50	163.65	160.35	156.85	154.05
.3906	25/64	.3105	4	1 3/4	7	34143906	34243906	34343906	150.55	-	-	-	-	-	-	-
.4062	13/32	.3105	4	1 3/4	7	341413	342413	343413	150.55	.3781 - .4090	191.60	171.00	164.15	160.85	157.35	154.55
.4219	27/64	.3730	6	1 3/4	7	34144219	34244219	34344219	152.05	-	-	-	-	-	-	-
.4375	7/16	.3730	6	1 3/4	7	341414	342414	343414	152.05	.4091 - .4410	193.10	172.55	165.65	162.35	158.85	156.05
.4531	29/64	.3730	6	1 3/4	7	34144531	34244531	34344531	153.40	-	-	-	-	-	-	-
.4688	15/32	.3730	6	1 3/4	7	341415	342415	343415	153.40	.4411 - .4720	194.45	173.90	167.00	163.70	160.20	157.40
.4844	31/64	.4355	6	2	8	34144844	34244844	34344844	155.15	-	-	-	-	-	-	-
.5000	1/2	.4355	6	2	8	341416	342416	343416	155.15	.4721 - .5030	196.20	175.65	168.75	165.50	161.95	159.20
.5156	33/64	.4355	6	2	8	34145156	34245156	34345156	158.60	-	-	-	-	-	-	-
.5312	17/32	.4355	6	2	8	341417	342417	343417	158.60	.5031 - .5340	199.65	179.10	172.20	168.90	165.40	162.60
.5625	9/16	.4355	6	2	8	341418	342418	343418	160.85	.5341 - .5660	201.95	181.35	174.45	171.20	167.65	164.90
.5938	19/32	.4355	6	2	8	341419	342419	343419	164.20	.5661 - .5970	205.30	184.70	177.85	174.55	171.00	168.25
.6250	5/8	.5615	6	2 1/4	9	341420	342420	343420	167.35	.5971 - .6280	208.40	187.80	180.95	177.65	174.15	171.35
.6562	21/32	.5615	6	2 1/4	9	341421	342421	343421	185.20	.6281 - .6590	226.30	205.70	198.85	195.55	192.00	189.25
.6875	11/16	.5615	6	2 1/4	9	341422	342422	343422	189.00	.6591 - .6910	230.10	209.50	202.60	199.35	195.80	193.05
.7188	23/32	.5615	6	2 1/4	9	341423	342423	343423	197.15	.6911 - .7220	238.20	217.65	210.75	207.50	203.95	201.20
.7500	3/4	.6245	6	2 1/2	9 1/2	341424	342424	343424	197.15	.7221 - .7530	238.20	217.65	210.75	207.50	203.95	201.20
.7812	25/32	.6245	6	2 1/2	9 1/2	341425	342425	343425	202.95	.7531 - .7840	244.00	223.45	216.55	213.30	209.75	207.00
.8125	13/16	.6245	6	2 1/2	9 1/2	341426	342426	343426	202.95	.7841 - .8160	244.00	223.45	216.55	213.30	209.75	207.00
.8438	27/32	.6245	6	2 1/2	9 1/2	341427	342427	343427	209.90	.8161 - .8470	251.00	230.40	223.50	220.25	216.70	213.95
.8750	7/8	.7495	6	2 5/8	10	341428	342428	343428	209.90	.8471 - .8780	251.00	230.40	223.50	220.25	216.70	213.95
.9062	29/32	.7495	6	2 5/8	10	341429	342429	343429	233.10	.8781 - .9090	274.20	253.60	246.70	243.45	239.90	237.15
.9375	15/16	.7495	8	2 5/8	10	341430	342430	343430	233.10	.9091 - .9410	274.20	253.60	246.70	243.45	239.90	237.15
.9688	31/32	.7495	8	2 5/8	10	341431	342431	343431	234.00	.9411 - .9720	275.10	254.50	247.65	244.35	240.85	238.05
1.0000	1	.8745	8	2 3/4	10 1/2	341432	342432	343432	234.00	.9721 - 1.0030	275.10	254.50	247.65	244.35	240.85	238.05
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341434	342434	343434	240.65	1.0031 - 1.0660	281.75	261.15	254.25	251.00	247.45	244.70
1.1250	1 1/8	.8745	8	2 7/8	11	341436	342436	343436	249.00	1.0661 - 1.1280	290.05	269.45	262.60	259.30	255.80	253.00
1.1875	1 3/16	.9995	8	2 7/8	11	341438	342438	343438	266.70	1.1281 - 1.1905	307.80	287.20	280.30	277.05	273.50	270.75
1.2500	1 1/4	.9995	8	3	11 1/2	341440	342440	343440	270.25	1.1906 - 1.2530	311.30	290.70	283.85	280.55	277.05	274.25
1.3125	1 5/16	.9995	8	3	11 1/2	341442	342442	343442	277.95	1.2531 - 1.3155	319.05	298.45	291.55	288.30	284.75	282.00
1.3750	1 3/8	.9995	8	3 1/4	12	341444	342444	343444	289.20	1.3156 - 1.3780	330.30	309.70	302.80	299.55	296.00	293.25
1.4375	1 7/16	.9995	8	3 1/4	12	341446	342446	343446	298.30	1.3781 - 1.4405	339.35	318.80	311.90	308.60	305.10	302.30
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341448	342448	343448	308.30	1.4406 - 1.5030	349.35	328.80	321.90	318.60	315.10	312.30

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CARBIDE TIPPED COOLANT REAMERS

METRIC

TYPE 3414 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR NON-FERROUS
TYPE 3424 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR CAST IRON
TYPE 3434 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR STEEL



Detailed description and fractional sizes on page 96. Tolerances on page 50.
 Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3414 EDP NO.	CAST IRON TYPE 3424 EDP NO.	STEEL TYPE 3434 EDP NO.	ALL TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH			FLT	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
4.5	.1772	.1704	4	1 ¼*	5	3414045	3424045	3434045	\$145.05	4.494 - 4.696	\$176.00	\$155.50	\$148.60	\$145.25	\$141.80	\$138.95	\$135.00
5.0	.1969	.1805	4	1 ¼*	5	3414050	3424050	3434050	145.05	4.697 - 5.182	176.00	155.50	148.60	145.25	141.80	138.95	135.00
5.5	.2165	.2075	4	1 ¼*	5	3414055	3424055	3434055	145.05	5.183 - 5.613	176.00	155.50	148.60	145.25	141.80	138.95	135.00
6.0	.2362	.2265	4	1 ½*	6	3414060	3424060	3434060	145.05	5.614 - 6.045	176.00	155.50	148.60	145.25	141.80	138.95	135.00
-	-	.2405	4	1 ½*	6	3414063	3424063	3434063	-	6.046 - 6.426	176.00	155.50	148.60	145.25	141.80	138.95	135.00
6.5	.2559	.2485	4	1 ½*	6	3414065	3424065	3434065	153.15	6.427 - 7.214	184.05	163.55	156.65	153.30	149.85	147.00	143.05
7.0	.2756	.2485	4	1 ½*	6	3414070	3424070	3434070	153.15	-	-	-	-	-	-	-	-
7.5	.2953	.2792	4	1 ½*	6	3414075	3424075	3434075	160.95	7.215 - 8.001	191.85	171.35	164.45	161.10	157.65	154.80	150.85
8.0	.3150	.2792	4	1 ½*	6	3414080	3424080	3434080	160.95	-	-	-	-	-	-	-	-
8.5	.3346	.2792	4	1 ½*	6	3414085	3424085	3434085	162.10	8.002 - 8.814	193.05	172.55	165.65	162.30	158.85	156.00	152.05
9.0	.3543	.3105	4	1 ¾*	7	3414090	3424090	3434090	163.65	8.815 - 9.601	194.55	174.05	167.15	163.80	160.35	157.50	153.55
9.5	.3740	.3105	4	1 ¾*	7	3414095	3424095	3434095	163.65	-	-	-	-	-	-	-	-
10.0	.3937	.3105	4	1 ¾*	7	3414100	3424100	3434100	164.15	9.602 - 10.389	195.05	174.55	167.65	164.30	160.85	158.00	154.05
10.5	.4134	.3730	6	1 ¾*	7	3414105	3424105	3434105	165.65	10.390 - 11.201	196.55	176.05	169.20	165.80	162.35	159.50	155.55
11.0	.4331	.3730	6	1 ¾*	7	3414110	3424110	3434110	165.65	-	-	-	-	-	-	-	-
11.5	.4528	.3730	6	1 ¾*	7	3414115	3424115	3434115	167.00	11.202 - 11.989	197.90	177.40	170.50	167.15	163.70	160.85	156.90
12.0	.4724	.4355	6	2	8	3414120	3424120	3434120	168.75	11.990 - 12.776	199.65	179.15	172.30	168.90	165.50	162.60	158.70
12.5	.4921	.4355	6	2	8	3414125	3424125	3434125	168.75	-	-	-	-	-	-	-	-
13.0	.5118	.4355	6	2	8	3414130	3424130	3434130	172.20	12.777 - 13.564	203.10	182.60	175.75	172.35	168.90	166.05	162.10
13.5	.5315	.4355	6	2	8	3414135	3424135	3434135	172.20	-	-	-	-	-	-	-	-
14.0	.5512	.4355	6	2	8	3414140	3424140	3434140	174.45	13.565 - 14.376	205.40	184.90	178.00	174.65	171.20	168.35	164.40
14.5	.5709	.4355	6	2	8	3414145	3424145	3434145	177.85	14.377 - 15.164	208.75	188.25	181.35	178.00	174.55	171.70	167.75
15.0	.5906	.4355	6	2	8	3414150	3424150	3434150	177.85	-	-	-	-	-	-	-	-
15.5	.6102	.5615	6	2 ¼	9	3414155	3424155	3434155	180.95	15.165 - 15.951	211.85	191.35	184.45	181.10	177.65	174.80	170.85
16.0	.6299	.5615	6	2 ¼	9	3414160	3424160	3434160	198.85	15.952 - 16.739	229.75	209.25	202.35	199.00	195.55	192.70	188.75
16.5	.6496	.5615	6	2 ¼	9	3414165	3424165	3434165	198.85	-	-	-	-	-	-	-	-
17.0	.6693	.5615	6	2 ¼	9	3414170	3424170	3434170	202.60	16.740 - 17.551	233.50	213.00	206.15	202.80	199.35	196.50	192.55
17.5	.6890	.5615	6	2 ¼	9	3414175	3424175	3434175	202.60	-	-	-	-	-	-	-	-
18.0	.7087	.5615	6	2 ¼	9	3414180	3424180	3434180	210.75	17.552 - 18.339	241.65	221.15	214.30	210.90	207.50	204.60	200.70
18.5	.7283	.6245	6	2 ½	9 ½	3414185	3424185	3434185	210.75	18.340 - 19.126	241.65	221.15	214.30	210.90	207.50	204.60	200.70
19.0	.7480	.6245	6	2 ½	9 ½	3414190	3424190	3434190	210.75	-	-	-	-	-	-	-	-
19.5	.7677	.6245	6	2 ½	9 ½	3414195	3424195	3434195	216.55	19.127 - 19.914	247.45	226.95	220.10	216.70	213.30	210.40	206.45
20.0	.7874	.6245	6	2 ½	9 ½	3414200	3424200	3434200	216.55	19.915 - 20.726	247.45	226.95	220.10	216.70	213.30	210.40	206.45
20.5	.8071	.6245	6	2 ½	9 ½	3414205	3424205	3434205	216.55	-	-	-	-	-	-	-	-
21.0	.8268	.6245	6	2 ½	9 ½	3414210	3424210	3434210	223.50	20.727 - 21.514	254.45	233.95	227.05	223.70	220.25	217.40	213.45
21.5	.8465	.6245	6	2 ½	9 ½	3414215	3424215	3434215	223.50	-	-	-	-	-	-	-	-
22.0	.8661	.7495	6	2 ¾	10	3414220	3424220	3434220	223.50	21.515 - 22.301	254.45	233.95	227.05	223.70	220.25	217.40	213.45
22.5	.8858	.7495	6	2 ¾	10	3414225	3424225	3434225	246.70	22.302 - 23.089	277.60	257.10	250.25	246.90	243.45	240.60	236.65
23.0	.9055	.7495	6	2 ¾	10	3414230	3424230	3434230	246.70	-	-	-	-	-	-	-	-
23.5	.9252	.7495	8	2 ¾	10	3414235	3424235	3434235	246.70	23.090 - 23.901	277.60	257.10	250.25	246.90	243.45	240.60	236.65
24.0	.9449	.7495	8	2 ¾	10	3414240	3424240	3434240	247.65	23.902 - 24.689	278.55	258.05	251.15	247.80	244.35	241.50	237.55
24.5	.9646	.7495	8	2 ¾	10	3414245	3424245	3434245	247.65	-	-	-	-	-	-	-	-
25.0	.9843	.8745	8	2 ¾	10 ½	3414250	3424250	3434250	247.65	24.690 - 25.476	278.55	258.05	251.15	247.80	244.35	241.50	237.55
25.5	1.0039	.8745	8	2 ¾	10 ½	3414255	3424255	3434255	254.25	25.477 - 27.076	285.20	264.70	257.80	254.45	251.00	248.15	244.20
26.0	1.0236	.8745	8	2 ¾	10 ½	3414260	3424260	3434260	254.25	-	-	-	-	-	-	-	-
27.0	1.0630	.8745	8	2 ¾	10 ½	3414270	3424270	3434270	254.25	-	-	-	-	-	-	-	-
28.0	1.1024	.8745	8	2 ¾	11	3414280	3424280	3434280	262.60	27.077 - 28.651	293.50	273.00	266.10	262.75	259.30	256.45	252.50
29.0	1.1417	.9995	8	2 ¾	11	3414290	3424290	3434290	280.30	28.652 - 30.239	311.20	290.70	283.85	280.50	277.05	274.20	270.25
30.0	1.1811	.9995	8	2 ¾	11	3414300	3424300	3434300	280.30	-	-	-	-	-	-	-	-
31.0	1.2205	.9995	8	3	11 ½	3414310	3424310	3434310	283.85	30.240 - 31.826	314.75	294.25	287.35	284.00	280.55	277.70	273.75
32.0	1.2598	.9995	8	3	11 ½	3414320	3424320	3434320	291.55	31.827 - 33.414	322.50	302.00	295.10	291.75	288.30	285.45	281.50
33.0	1.2992	.9995	8	3	11 ½	3414330	3424330	3434330	291.55	-	-	-	-	-	-	-	-
34.0	1.3386	.9995	8	3 ¼	12	3414340	3424340	3434340	302.80	33.415 - 35.001	333.75	313.25	306.35	303.00	299.55	296.70	292.75
35.0	1.3780	.9995	8	3 ¼	12	3414350	3424350	3434350	302.80	-	-	-	-	-	-	-	-
36.0	1.4173	.9995	8	3 ¼	12	3414360	3424360	3434360	311.90	35.002 - 36.589	342.80	322.30	315.40	312.05	308.60	305.75	301.80
37.0	1.4567	1.2495	8	3 ½	12 ½	3414370	3424370	3434370	321.90	36.590 - 38.176	352.80	332.30	325.40	322.05	318.60	315.75	311.80
38.0	1.4961	1.2495	8	3 ½	12 ½	3414380	3424380	3434380	321.90	-	-	-	-	-	-	-	-

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*1/2" carbide length.

CARBIDE TIPPED RIGHT SPIRAL COOLANT REAMERS

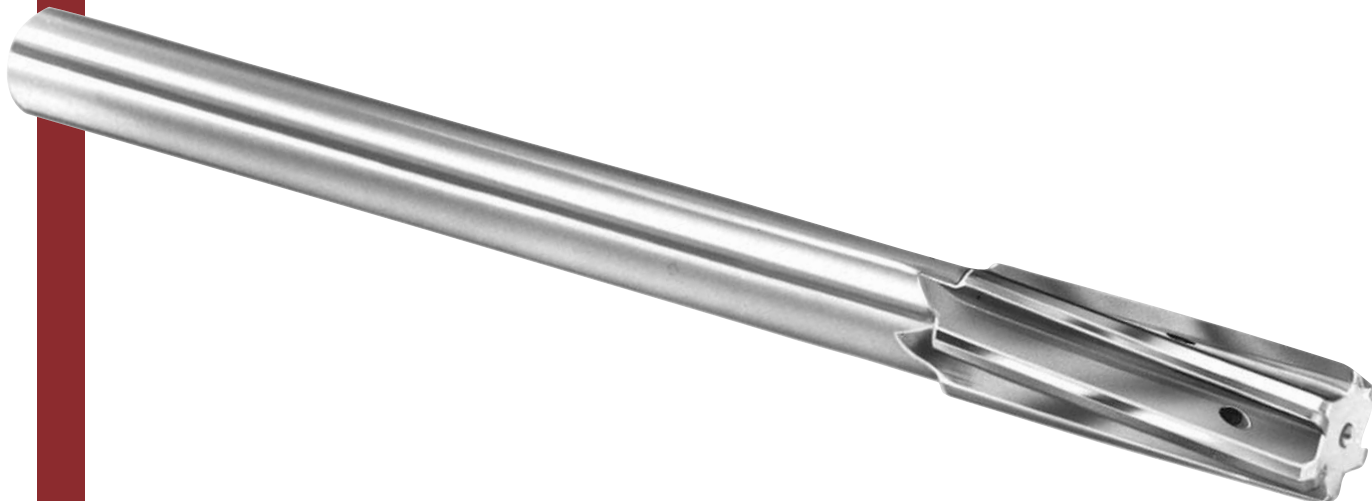
TYPE 3417 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - THROUGH HOLES - FOR NON-FERROUS

TYPE 3418 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - THROUGH HOLES - FOR CAST IRON

TYPE 3419 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - THROUGH HOLES - FOR STEEL

Flute long carbide tips (.2841" tool diameter and larger) brazed to one piece hardened alloy steel bodies.
Right spiral flutes.

Coolant feeding hole in each flute for flushing chips forward through the hole being reamed.
Tool geometry and carbide grade appropriate for material being machined.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3417 EDP NO.	CAST IRON TYPE 3418 EDP NO.	STEEL TYPE 3419 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT.	OAL.						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.2500	1/4	.2405	4	1 1/2*	6	341708	341808	341908	\$144.65	.2381 - .2530	\$185.70	\$165.15	\$158.25	\$155.00	\$151.45	\$148.70
.2812	9/32	.2485	4	1 1/2*	6	341709	341809	341909	153.45	.2531 - .2840	194.55	173.95	167.10	163.80	160.25	157.50
.3125	5/16	.2792	4	1 1/2	6	341710	341810	341910	162.10	.2841 - .3150	203.20	182.60	175.75	172.45	168.90	166.15
.3438	11/32	.2792	4	1 1/2	6	341711	341811	341911	163.40	.3151 - .3470	204.45	183.90	177.00	173.70	170.20	167.40
.3750	3/8	.3105	4	1 3/4	7	341712	341812	341912	165.05	.3471 - .3780	206.15	185.55	178.65	175.40	171.85	169.10
.4062	13/32	.3105	4	1 3/4	7	341713	341813	341913	165.55	.3781 - .4090	206.65	186.05	179.15	175.90	172.35	169.60
.4375	7/16	.3730	6	1 3/4	7	341714	341814	341914	167.25	.4091 - .4410	208.30	187.75	180.85	177.60	174.05	171.30
.4688	15/32	.3730	6	1 3/4	7	341715	341815	341915	168.75	.4411 - .4720	209.85	189.25	182.35	179.10	175.55	172.80
.5000	1/2	.4355	6	2	8	341716	341816	341916	170.70	.4721 - .5030	211.75	191.20	184.30	181.00	177.50	174.70
.5312	17/32	.4355	6	2	8	341717	341817	341917	176.90	.5031 - .5340	218.00	197.40	190.50	187.25	183.70	180.95
.5625	9/16	.4355	6	2	8	341718	341818	341918	176.90	.5341 - .5660	218.00	197.40	190.50	187.25	183.70	180.95
.5938	19/32	.4355	6	2	8	341719	341819	341919	183.95	.5661 - .5970	225.05	204.45	197.55	194.30	190.75	188.00
.6250	5/8	.5615	6	2 1/4	9	341720	341820	341920	183.95	.5971 - .6280	225.05	204.45	197.55	194.30	190.75	188.00
.6562	21/32	.5615	6	2 1/4	9	341721	341821	341921	207.80	.6281 - .6590	248.90	228.30	221.40	218.15	214.60	211.85
.6875	11/16	.5615	6	2 1/4	9	341722	341822	341922	207.80	.6591 - .6910	248.90	228.30	221.40	218.15	214.60	211.85
.7188	23/32	.5615	6	2 1/4	9	341723	341823	341923	216.90	.6911 - .7220	257.95	237.40	230.50	227.20	223.70	220.90
.7500	3/4	.6245	6	2 1/2	9 1/2	341724	341824	341924	216.90	.7221 - .7530	257.95	237.40	230.50	227.20	223.70	220.90
.7812	25/32	.6245	6	2 1/2	9 1/2	341725	341825	341925	233.70	.7531 - .7840	274.75	254.20	247.30	244.00	240.50	237.70
.8125	13/16	.6245	6	2 1/2	9 1/2	341726	341826	341926	236.55	.7841 - .8160	277.60	257.05	250.15	246.90	243.35	240.60
.8438	27/32	.6245	6	2 1/2	9 1/2	341727	341827	341927	241.00	.8161 - .8470	282.05	261.50	254.60	251.35	247.80	245.05
.8750	7/8	.7495	6	2 5/8	10	341728	341828	341928	244.80	.8471 - .8780	285.85	265.25	258.40	255.10	251.60	248.80
.9062	29/32	.7495	6	2 5/8	10	341729	341829	341929	259.30	.8781 - .9090	300.40	279.80	272.90	269.65	266.10	263.35
.9375	15/16	.7495	8	2 5/8	10	341730	341830	341930	271.75	.9091 - .9410	312.80	292.25	285.35	282.05	278.55	275.75
.9688	31/32	.7495	8	2 5/8	10	341731	341831	341931	272.50	.9411 - .9720	313.55	293.00	286.10	282.85	279.30	276.55
1.0000	1	.8745	8	2 3/4	10 1/2	341732	341832	341932	272.90	.9721 - 1.0030	314.00	293.40	286.50	283.25	279.70	276.95
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341734	341834	341934	314.75	1.0031 - 1.0660	355.80	335.25	328.35	325.10	321.55	318.80
1.1250	1 1/8	.8745	8	2 7/8	11	341736	341836	341936	316.10	1.0661 - 1.1280	357.15	336.60	329.70	326.40	322.90	320.10
1.1875	1 3/16	.9995	8	2 7/8	11	341738	341838	341938	329.10	1.1281 - 1.1905	370.20	349.60	342.70	339.45	335.90	333.15
1.2500	1 1/4	.9995	8	3	11 1/2	341740	341840	341940	333.50	1.1906 - 1.2530	374.55	354.00	347.10	343.80	340.30	337.50
1.3125	1 5/16	.9995	8	3	11 1/2	341742	341842	341942	343.05	1.2531 - 1.3155	384.15	363.55	356.65	353.40	349.85	347.10
1.3750	1 3/8	.9995	8	3 1/4	12	341744	341844	341944	356.90	1.3156 - 1.3780	398.00	377.40	370.50	367.25	363.70	360.95
1.4375	1 7/16	.9995	8	3 1/4	12	341746	341846	341946	368.10	1.3781 - 1.4405	409.15	388.60	381.70	378.40	374.90	372.10
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341748	341848	341948	380.45	1.4406 - 1.5030	421.50	400.95	394.05	390.75	387.25	384.45

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CARBIDE TIPPED RIGHT SPIRAL COOLANT REAMERS

TYPE 3411 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR NON-FERROUS

TYPE 3413 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR CAST IRON

TYPE 3415 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR STEEL

Flute long carbide tips (.2841" tool diameter and larger) brazed to one piece hardened alloy steel bodies. Right spiral flutes.

Full length center coolant feeding hole for flushing chips back towards shank.
Tool geometry and carbide grade appropriate for material being machined.
For longer overall length reamers see page 108.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLT.	LENGTH		NON-FERR. TYPE 3411 EDP NO.	CAST IRON TYPE 3413 EDP NO.	STEEL TYPE 3415 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT.	OAL						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.2500	1/4	.2405	4	1 1/2*	6	341108	341308	341508	\$135.00	.2381 - .2530	\$173.35	\$154.15	\$147.70	\$144.65	\$141.35	\$138.75
.2812	9/32	.2485	4	1 1/2*	6	341109	341309	341509	138.10	.2531 - .2840	175.10	156.55	150.35	147.40	144.25	141.75
.3125	5/16	.2792	4	1 1/2	6	341110	341310	341510	151.30	.2841 - .3150	189.65	170.45	164.00	160.95	157.65	155.10
.3438	11/32	.2792	4	1 1/2	6	341111	341311	341511	152.50	.3151 - .3470	190.85	171.60	165.20	162.15	158.85	156.25
.3750	3/8	.3105	4	1 3/4	7	341112	341312	341512	154.05	.3471 - .3780	192.40	173.20	166.75	163.70	160.40	157.80
.4062	13/32	.3105	4	1 3/4	7	341113	341313	341513	154.55	.3781 - .4090	192.85	173.65	167.25	164.15	160.90	158.30
.4375	7/16	.3730	6	1 3/4	7	341114	341314	341514	156.10	.4091 - .4410	194.45	175.20	168.80	165.75	162.45	159.85
.4688	15/32	.3730	6	1 3/4	7	341115	341315	341515	157.50	.4411 - .4720	195.85	176.65	170.20	167.15	163.85	161.25
.5000	1/2	.4355	6	2	8	341116	341316	341516	163.60	.4721 - .5030	202.95	183.20	176.60	173.50	170.10	167.45
.5312	17/32	.4355	6	2	8	341117	341317	341517	169.55	.5031 - .5340	208.90	189.20	182.55	179.45	176.05	173.40
.5625	9/16	.4355	6	2	8	341118	341318	341518	169.55	.5341 - .5660	208.90	189.20	182.55	179.45	176.05	173.40
.5938	19/32	.4355	6	2	8	341119	341319	341519	176.30	.5661 - .5970	215.65	195.95	189.35	186.20	182.80	180.15
.6250	5/8	.5615	6	2 1/4	9	341120	341320	341520	176.30	.5971 - .6280	215.65	195.95	189.35	186.20	182.80	180.15
.6562	21/32	.5615	6	2 1/4	9	341121	341321	341521	199.15	.6281 - .6590	238.50	218.80	212.20	209.05	205.70	203.00
.6875	11/16	.5615	6	2 1/4	9	341122	341322	341522	199.15	.6591 - .6910	238.50	218.80	212.20	209.05	205.70	203.00
.7188	23/32	.5615	6	2 1/4	9	341123	341323	341523	207.85	.6911 - .7220	247.20	227.50	220.90	217.75	214.35	211.70
.7500	3/4	.6245	6	2 1/2	9 1/2	341124	341324	341524	195.20	.7221 - .7530	232.15	213.65	207.45	204.50	201.30	198.85
.7812	25/32	.6245	6	2 1/2	9 1/2	341125	341325	341525	223.95	.7531 - .7840	263.30	243.60	237.00	233.85	230.45	227.80
.8125	13/16	.6245	6	2 1/2	9 1/2	341126	341326	341526	226.70	.7841 - .8160	266.05	246.35	239.75	236.60	233.20	230.55
.8438	27/32	.6245	6	2 1/2	9 1/2	341127	341327	341527	230.95	.8161 - .8470	270.30	250.60	244.00	240.85	237.50	234.80
.8750	7/8	.7495	6	2 5/8	10	341128	341328	341528	234.60	.8471 - .8780	273.95	254.20	247.60	244.50	241.10	238.45
.9062	29/32	.7495	6	2 5/8	10	341129	341329	341529	248.50	.8781 - .9090	287.85	268.15	261.55	258.40	255.00	252.35
.9375	15/16	.7495	8	2 5/8	10	341130	341330	341530	260.40	.9091 - .9410	299.80	280.05	273.45	270.30	266.95	264.30
.9688	31/32	.7495	8	2 5/8	10	341131	341331	341531	261.15	.9411 - .9720	300.50	280.80	274.20	271.05	267.65	265.00
1.0000	1	.8745	8	2 3/4	10 1/2	341132	341332	341532	261.55	.9721 - 1.0030	300.90	281.20	274.60	271.45	268.05	265.40
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341134	341334	341534	268.85	1.0031 - 1.0660	308.25	288.50	281.90	278.75	275.40	272.75
1.1250	1 1/8	.8745	8	2 7/8	11	341136	341336	341536	278.20	1.0661 - 1.1280	317.55	297.85	291.25	288.10	284.75	282.05
1.1875	1 3/16	.9995	8	2 7/8	11	341138	341338	341538	298.00	1.1281 - 1.1905	337.40	317.65	311.05	307.90	304.55	301.90
1.2500	1 1/4	.9995	8	3	11 1/2	341140	341340	341540	301.90	1.1906 - 1.2530	341.25	321.50	314.90	311.80	308.40	305.75
1.3125	1 5/16	.9995	8	3	11 1/2	341142	341342	341542	310.55	1.2531 - 1.3155	349.95	330.20	323.60	320.45	317.10	314.45
1.3750	1 3/8	.9995	8	3 1/4	12	341144	341344	341544	323.20	1.3156 - 1.3780	362.55	342.85	336.25	333.10	329.75	327.05
1.4375	1 7/16	.9995	8	3 1/4	12	341146	341346	341546	333.25	1.3781 - 1.4405	372.65	352.90	346.30	343.15	339.80	337.15
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341148	341348	341548	344.55	1.4406 - 1.5030	383.90	364.20	357.60	354.45	351.05	348.40

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*1/2" carbide length. **Quantities of 15 or more: price of fractional size in same size range.

CARBIDE TIPPED LEFT SPIRAL COOLANT REAMERS

TYPE 3427 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - THROUGH HOLES - FOR NON-FERROUS

TYPE 3428 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - THROUGH HOLES - FOR CAST IRON

TYPE 3429 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - THROUGH HOLES - FOR STEEL

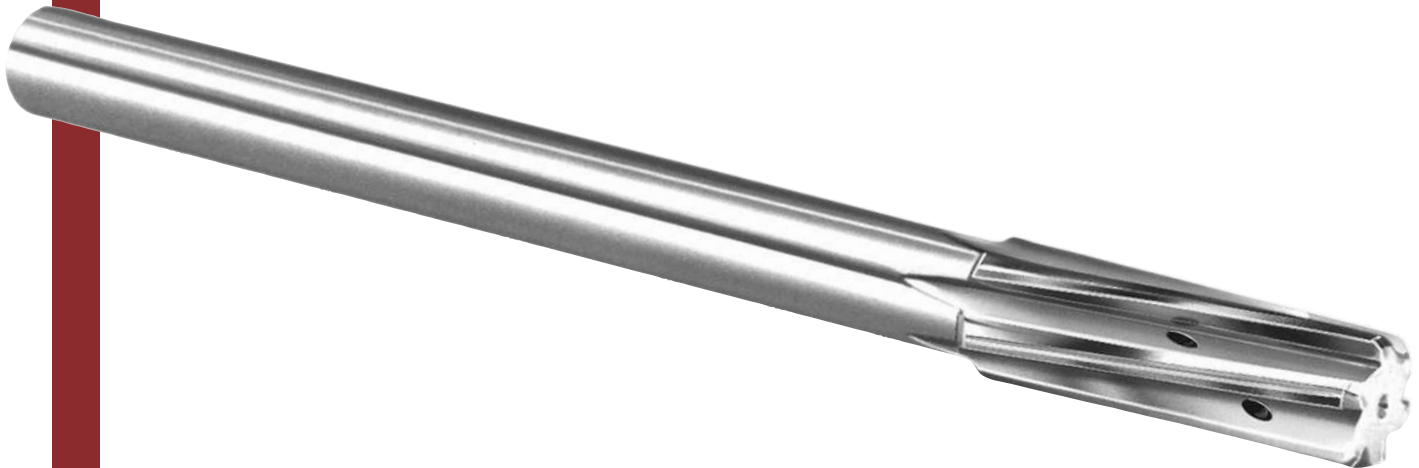
Flute long carbide tips (.2841" tool diameter and larger) brazed to one piece hardened alloy steel bodies.

Left spiral flutes.

Coolant feeding hole in each flute for flushing chips forward through the hole being reamed.

Tool geometry and carbide grade appropriate for material being machined.

For longer overall length reamers, see page 109.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3427 EDP NO.	CAST IRON TYPE 3428 EDP NO.	STEEL TYPE 3429 EDP NO.	ALL TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT.	OAL.						1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.2500	1/4	.2405	4	1 1/2*	6	342708	342808	342908	\$167.25	.2381 - .2530	\$208.30	\$187.75	\$180.85	\$177.60	\$174.05	\$171.30
.2812	9/32	.2485	4	1 1/2*	6	342709	342809	342909	177.40	.2531 - .2840	218.50	197.90	191.00	187.75	184.20	181.45
.3125	5/16	.2792	4	1 1/2	6	342710	342810	342910	187.40	.2841 - .3150	228.50	207.90	201.00	197.75	194.20	191.45
.3438	11/32	.2792	4	1 1/2	6	342711	342811	342911	188.85	.3151 - .3470	229.90	209.35	202.45	199.15	195.65	192.85
.3750	3/8	.3105	4	1 3/4	7	342712	342812	342912	190.75	.3471 - .3780	231.85	211.25	204.35	201.10	197.55	194.80
.4062	13/32	.3105	4	1 3/4	7	342713	342813	342913	191.50	.3781 - .4090	232.60	212.00	205.15	201.85	198.30	195.55
.4375	7/16	.3730	6	1 3/4	7	342714	342814	342914	193.35	.4091 - .4410	234.45	213.85	207.00	203.70	200.15	197.40
.4688	15/32	.3730	6	1 3/4	7	342715	342815	342915	195.05	.4411 - .4720	236.10	215.55	208.65	205.40	201.85	199.10
.5000	1/2	.4355	6	2	8	342716	342816	342916	197.55	.4721 - .5030	238.65	218.05	211.20	207.90	204.35	201.60
.5312	17/32	.4355	6	2	8	342717	342817	342917	201.70	.5031 - .5340	242.75	222.20	215.30	212.00	208.50	205.70
.5625	9/16	.4355	6	2	8	342718	342818	342918	204.60	.5341 - .5660	245.70	225.10	218.25	214.95	211.45	208.65
.5938	19/32	.4355	6	2	8	342719	342819	342919	208.90	.5661 - .5970	250.00	229.40	222.50	219.25	215.70	212.95
.6250	5/8	.5615	6	2 1/4	9	342720	342820	342920	212.75	.5971 - .6280	253.85	233.25	226.40	223.10	219.60	216.80
.6562	21/32	.5615	6	2 1/4	9	342721	342821	342921	235.60	.6281 - .6590	276.70	256.10	249.25	245.95	242.40	239.65
.6875	11/16	.5615	6	2 1/4	9	342722	342822	342922	240.40	.6591 - .6910	281.50	260.90	254.00	250.75	247.20	244.45
.7188	23/32	.5615	6	2 1/4	9	342723	342823	342923	245.55	.6911 - .7220	286.60	266.05	259.15	255.85	252.35	249.55
.7500	3/4	.6245	6	2 1/2	9 1/2	342724	342824	342924	250.75	.7221 - .7530	291.80	271.25	264.35	261.05	257.55	254.75
.7812	25/32	.6245	6	2 1/2	9 1/2	342725	342825	342925	255.00	.7531 - .7840	296.10	275.50	268.65	265.35	261.85	259.05
.8125	13/16	.6245	6	2 1/2	9 1/2	342726	342826	342926	258.15	.7841 - .8160	299.20	278.65	271.75	268.45	264.95	262.15
.8438	27/32	.6245	6	2 1/2	9 1/2	342727	342827	342927	262.85	.8161 - .8470	303.90	283.35	276.45	273.15	269.65	266.85
.8750	7/8	.7495	6	2 5/8	10	342728	342828	342928	267.05	.8471 - .8780	308.10	287.55	280.65	277.35	273.85	271.05
.9062	29/32	.7495	6	2 5/8	10	342729	342829	342929	282.75	.8781 - .9090	323.80	303.25	296.35	293.10	289.55	286.80
.9375	15/16	.7495	8	2 5/8	10	342730	342830	342930	296.50	.9091 - .9410	337.60	317.00	310.15	306.85	303.30	300.55
.9688	31/32	.7495	8	2 5/8	10	342731	342831	342931	297.30	.9411 - .9720	338.35	317.75	310.90	307.60	304.10	301.30
1.0000	1	.8745	8	2 3/4	10 1/2	342732	342832	342932	297.70	.9721 - 1.0030	338.75	318.20	311.30	308.05	304.50	301.75
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	342734	342834	342934	314.75	1.0031 - 1.0660	355.80	335.25	328.35	325.10	321.55	318.80
1.1250	1 1/8	.8745	8	2 7/8	11	342736	342836	342936	316.10	1.0661 - 1.1280	357.15	336.60	329.70	326.40	322.90	320.10
1.1875	1 3/16	.9995	8	2 7/8	11	342738	342838	342938	329.10	1.1281 - 1.1905	370.20	349.60	342.70	339.45	335.90	333.15
1.2500	1 1/4	.9995	8	3	11 1/2	342740	342840	342940	333.50	1.1906 - 1.2530	374.55	354.00	347.10	343.80	340.30	337.50
1.3125	1 5/16	.9995	8	3	11 1/2	342742	342842	342942	343.05	1.2531 - 1.3155	384.15	363.55	356.65	353.40	349.85	347.10
1.3750	1 3/8	.9995	8	3 1/4	12	342744	342844	342944	356.90	1.3156 - 1.3780	398.00	377.40	370.50	367.25	363.70	360.95
1.4375	1 7/16	.9995	8	3 1/4	12	342746	342846	342946	368.10	1.3781 - 1.4405	409.15	388.60	381.70	378.40	374.90	372.10
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	342748	342848	342948	380.45	1.4406 - 1.5030	421.50	400.95	394.05	390.75	387.25	384.45

CARBIDE TIPPED COOLANT REAMERS

TYPE 3490 - RIGHT SPIRAL FLUTE LONG CARBIDE

Flute long carbide tips brazed to one piece hardened alloy steel bodies.

Similar to Barber-Colman/Metcut OFC reamer. Full length coolant hole. Right spiral polished flutes: 2° to 5°. Positive face rake angles (behind center). Shank cross hole for use in floating holder.

Designed and manufactured to cut smooth accurate holes and maximize tool life.



Tool diameter tolerance: +.0003"/-.0000".
For closer tolerance pricing, see page 50.

TOOL DIAMETER		SHANK DIAM.	SHANK LEN.	NO. OF FLUTES	LENGTH		EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.				FLT	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3750	3/8	3/8	3/4	6	1/2	2 1/2	349012	\$127.75	.3181 - .3800	\$206.50	\$167.05	\$153.85	\$147.55	\$140.80	\$135.50
.4062	13/32	3/8	3/4	6	1/2	2 5/8	349013	129.60	.3801 - .4090	208.35	168.90	155.70	149.40	142.65	137.35
.4375	7/16	3/8	3/4	6	1/2	2 5/8	349014	129.60	.4091 - .4410	208.35	168.90	155.70	149.40	142.65	137.35
.4688	15/32	5/8	1	6	5/8	3 1/2	349015	133.15	.4411 - .4720	211.90	172.45	159.25	152.95	146.20	140.90
.5000	1/2	5/8	1	6	5/8	3 1/2	349016	133.15	.4721 - .5050	211.90	172.45	159.25	152.95	146.20	140.90
.5625	9/16	5/8	1	6	3/4	3 3/4	349018	145.55	.5051 - .5660	224.25	184.85	171.65	165.35	158.60	153.25
.6250	5/8	5/8	1	6	3/4	3 3/4	349020	145.55	.5661 - .6300	224.25	184.85	171.65	165.35	158.60	153.25
.6875	11/16	5/8	1	6	3/4	4 1/4	349022	161.50	.6301 - .6910	240.20	200.75	187.55	181.30	174.50	169.20
.7500	3/4	5/8	1	6	3/4	4 1/4	349024	161.50	.6911 - .7550	240.20	200.75	187.55	181.30	174.50	169.20
.8125	13/16	5/8	1	6	7/8	4 3/4	349026	170.35	.7551 - .8160	249.05	209.60	196.40	190.15	183.40	178.05
.8750	7/8	5/8	1	6	7/8	4 3/4	349028	170.35	.8161 - .8800	249.05	209.60	196.40	190.15	183.40	178.05
.9375	15/16	1	1 1/2	8	1	5 1/2	349030	204.15	.8801 - .9410	282.90	243.45	230.25	223.95	217.20	211.90
1.0000	1	1	1 1/2	8	1	5 1/2	349032	204.15	.9411 - 1.0050	282.90	243.45	230.25	223.95	217.20	211.90
1.0625	1 1/16	1	1 1/2	8	1 1/4	6	349034	225.90	1.0051 - 1.0660	308.05	266.85	253.10	246.55	239.50	233.95
1.1250	1 1/8	1	1 1/2	8	1 1/4	6	349036	225.90	1.0661 - 1.1300	308.05	266.85	253.10	246.55	239.50	233.95
1.1875	1 3/16	1	1 1/2	8	1 1/4	6	349038	231.50	1.1301 - 1.1900	313.65	272.50	258.70	252.15	245.10	239.55
1.2500	1 1/4	1	1 1/2	8	1 1/4	6	349040	231.50	1.1901 - 1.2550	313.65	272.50	258.70	252.15	245.10	239.55
1.3125	1 5/16	1	1 1/2	8	1 1/4	6	349042	248.20	1.2551 - 1.3155	330.35	289.20	275.45	268.90	261.85	256.30
1.3750	1 3/8	1	1 1/2	8	1 1/4	6	349044	248.20	1.3156 - 1.3800	330.35	289.20	275.45	268.90	261.85	256.30
1.4375	1 7/16	1	1 1/2	8	1 1/4	6	349046	264.85	1.3801 - 1.4405	347.00	305.85	292.05	285.50	278.45	272.90
1.5000	1 1/2	1	1 1/2	8	1 1/4	6	349048	264.85	1.4406 - 1.5050	347.00	305.85	292.05	285.50	278.45	272.90
1.5625	1 9/16	1	1 1/2	10	1 1/4	6	349050	277.80	1.5051 - 1.5660	359.95	318.80	305.00	298.45	291.40	285.85
1.6250	1 5/8	1	1 1/2	10	1 1/4	6	349052	277.80	1.5661 - 1.6300	359.95	318.80	305.00	298.45	291.40	285.85
1.6875	1 11/16	1	1 1/2	10	1 1/4	6	349054	294.50	1.6301 - 1.6910	376.65	335.50	321.70	315.15	308.10	302.55
1.7500	1 3/4	1	1 1/2	10	1 1/4	6	349056	294.50	1.6911 - 1.7550	376.65	335.50	321.70	315.15	308.10	302.55
1.8125	1 13/16	1	1 1/2	10	1 1/4	6	349058	309.30	1.7551 - 1.8160	391.45	350.30	336.50	329.95	322.90	317.35
1.8750	1 7/8	1	1 1/2	10	1 1/4	6	349060	309.30	1.8161 - 1.8800	391.45	350.30	336.50	329.95	322.90	317.35
1.9375	1 15/16	1	1 1/2	10	1 1/4	6	349062	324.05	1.8801 - 1.9410	406.20	365.05	351.30	344.75	337.70	332.15
2.0000	2	1	1 1/2	10	1 1/4	6	349064	324.05	1.9411 - 2.0150	406.20	365.05	351.30	344.75	337.70	332.15

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*Quantities of 15 or more: price of fractional size in same size range.

Made in U.S.A.

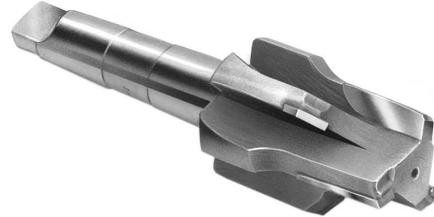
CARBIDE TIPPED PIPE TAP REAMERS

TYPE 3446 - STRAIGHT SHANK - STRAIGHT FLUTES

TYPE 3447 - TAPER SHANK - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies.

Cuts on reamer taper length and on chamfer diameters. Superior performance over high speed steel pipe tap reamers. Sizes 1/2 - 14 and under have three flutes. Sizes 3/4 - 14 and over have six flutes, with three cutting the taper and three cutting the chamfer.



PIPE TAP SIZE	TOOL DIAMETER	SMALL DIAMETER TAPER	LARGE DIAMETER TAPER	REAMER TAPER LENGTH	STRAIGHT SHANK - TYPE 3446					TAPER SHANK - TYPE 3447			
					SHANK DIAMETER	SHANK LENGTH	OVERALL LENGTH	EDP NO.	PRICE EACH	MORSE TAPER	OVERALL LENGTH	EDP NO.	PRICE EACH
1/8 - 27*	5/8	.318	.347	1 5/32	1/2	1 1/2	2 19/32	344601	\$151.65	2	4 11/32	344701	\$169.40
1/4 - 18*	3/4	.409	.450	2 1/32	1/2	1 1/2	2 29/32	344602	156.50	2	4 21/32	344702	175.05
3/8 - 18*	7/8	.543	.586	1 1/16	1/2	2	3 7/16	344603	172.85	2	4 11/16	344703	193.20
1/2 - 14*	1	.670	.725	7/8	1/2	2	3 7/8	344604	183.70	2	5 1/8	344704	205.70
3/4 - 14	1 1/4	.882	.937	7/8	1	2 1/2	4 5/8	344606	248.10	3	6 1/8	344706	277.40
1 - 11 1/2	1 1/2	1.107	1.173	1 1/16	1	2 1/2	5 1/16	344608	288.45	3	6 9/16	344708	322.95
1 - 11 1/2	1 1/2	1.107	1.173	1 1/16	-	-	-	-	-	4	7 9/16	344709	331.40
1 1/4 - 11 1/2	1 7/8	1.448	1.518	1 1/8	1 1/2	3	5 5/8	344610	344.40	3	6 5/8	344710	384.70
1 1/4 - 11 1/2	1 7/8	1.448	1.518	1 1/8	-	-	-	-	-	4	7 5/8	344711	413.05
1 1/2 - 11 1/2	2 1/8	1.687	1.757	1 1/8	1 1/2	3	5 7/8	344612	474.10	3	6 7/8	344712	531.45
1 1/2 - 11 1/2	2 1/8	1.687	1.757	1 1/8	-	-	-	-	-	4	7 7/8	344713	545.90
2 - 11 1/2	2 5/8	2.154	2.230	1 7/32	1 1/2	3	6 7/32	344616	537.10	3	7 3/32	344716	601.45
2 - 11 1/2	2 5/8	2.154	2.230	1 7/32	-	-	-	-	-	4	8 7/32	344717	617.65
2 1/2 - 8	3 1/8	2.561	2.670	1 3/4	1 1/2	3	6 3/4	344620	722.30	3	7 3/4	344720	808.85
2 1/2 - 8	3 1/8	2.561	2.670	1 3/4	-	-	-	-	-	4	8 3/4	344721	830.60
3 - 8	3 3/4	3.180	3.296	1 7/8	1 1/2	3	6 7/8	344624	745.00	3	7 7/8	344724	834.35

*3 flutes.

CARBIDE TIPPED JOBBERS REAMERS

TYPE 3403 - TAPER SHANK - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.



For reamer tolerances and closer tolerance pricing, see page 50.

TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH			TYPE 3403 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL			FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3750	3/8	1	4	2 1/2	5/8	5 13/16	340312	\$151.65	.3471 - .3780	\$189.95	\$170.75	\$164.35	\$161.25	\$158.00	\$155.40
.4375	7/16	1	4	2 3/4	5/8	6 1/8	340314	158.75	.4091 - .4410	197.10	177.90	171.45	168.40	165.10	162.50
.5000	1/2	1	6	3	5/8	6 7/16	340316	165.95	.4721 - .5030	204.30	185.10	178.65	175.60	172.30	169.75
.6250	5/8	2	6	3 1/2	5/8	7 9/16	340320	181.75	.5971 - .6280	220.05	200.85	194.45	191.35	188.10	185.50
.6875	11/16	2	6	3 7/8	5/8	8	340322	189.80	.6591 - .6910	228.15	208.95	202.50	199.45	196.15	193.55
.7500	3/4	2	6	4 3/16	3/4	8 3/8	340324	197.55	.7221 - .7530	235.90	216.70	210.25	207.20	203.90	201.35
.8125	13/16	2	6	4 9/16	3/4	8 13/16	340326	205.00	.7841 - .8160	243.35	224.15	217.70	214.65	211.35	208.80
.8750	7/8	2	6	4 7/8	3/4	9 3/16	340328	212.80	.8471 - .8780	251.10	231.90	225.50	222.40	219.15	216.55
.9375	15/16	3	8	5 1/8	3/4	10	340330	223.85	.9091 - .9410	255.10	242.95	236.55	233.50	230.20	227.60
1.0000	1	3	8	5 7/16	3/4	10 3/8	340332	228.45	.9721 - 1.0030	266.80	247.60	241.15	238.10	234.80	232.20

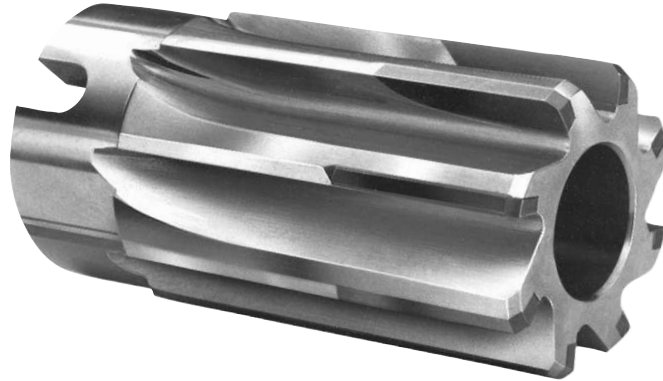
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CARBIDE TIPPED SHELL REAMERS

TYPE 3431 - STRAIGHT FLUTES

Carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.

Shell reamers are used with an arbor which is tapered to fit the hole in the reamer. Drive slot in the reamer engage lugs on the arbor to supplement the rotational drive from the tapered arbor. The space between the reamer's drive end and the arbor collar permits easy removal of the shell reamer by prying. For shell reamer arbors (straight or taper shank), contact us for pricing and availability.



Arbor hole tapered $\frac{1}{8}''$ per foot with drive slots.
Tool diameter tolerance thru 1": $+0.001''/+0.0005''$.
over 1": $+0.002''/+0.0006''$.

TOOL DIAMETER		HOLE DIAM. LG. END	FITS ARBOR NO.	NO. OF FLTS.	LENGTH			EDP NO.	PRICE EACH	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRAC.				FLT	CARB	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.7500	$\frac{3}{4}$	$\frac{3}{8}$	4	6	1 $\frac{3}{4}$	1	2 $\frac{1}{4}$	343124	\$190.15	.7221 - .7530	\$268.85	\$229.40	\$216.20	\$209.95	\$203.20	\$197.85
.7812	$\frac{25}{32}$	$\frac{3}{8}$	4	6	1 $\frac{3}{4}$	1	2 $\frac{1}{4}$	343125	193.85	.7531 - .7840	272.55	233.15	219.95	213.65	206.90	201.55
.8125	$\frac{13}{16}$	$\frac{1}{2}$	5	6	1 $\frac{15}{16}$	1	2 $\frac{1}{2}$	343126	193.85	.7841 - .8160	272.55	233.15	219.95	213.65	206.90	201.55
.8750	$\frac{7}{8}$	$\frac{1}{2}$	5	6	1 $\frac{15}{16}$	1	2 $\frac{1}{2}$	343128	208.75	.8161 - .8780	287.45	248.00	234.80	228.55	221.80	216.45
.9375	$\frac{15}{16}$	$\frac{1}{2}$	5	8	1 $\frac{15}{16}$	1	2 $\frac{1}{2}$	343130	208.75	.8781 - .9410	287.45	248.00	234.80	228.55	221.80	216.45
1.0000	1	$\frac{1}{2}$	5	8	1 $\frac{15}{16}$	1	2 $\frac{1}{2}$	343132	212.50	.9411 - 1.0030	291.25	251.80	238.60	232.30	225.55	220.25
1.0625	1 $\frac{1}{16}$	$\frac{5}{8}$	6	8	2 $\frac{1}{8}$	1	2 $\frac{3}{4}$	343134	219.95	1.0031 - 1.0660	298.65	259.20	246.00	239.75	232.95	227.65
1.1250	1 $\frac{1}{8}$	$\frac{5}{8}$	6	8	2 $\frac{1}{8}$	1	2 $\frac{3}{4}$	343136	223.65	1.0661 - 1.1280	302.35	262.90	249.70	243.45	236.65	231.35
1.1875	1 $\frac{3}{16}$	$\frac{5}{8}$	6	8	2 $\frac{1}{8}$	1 $\frac{1}{8}$	2 $\frac{3}{4}$	343138	227.40	1.1281 - 1.1905	306.15	266.70	253.50	247.20	240.45	235.15
1.2500	1 $\frac{1}{4}$	$\frac{5}{8}$	6	8	2 $\frac{1}{8}$	1 $\frac{1}{8}$	2 $\frac{3}{4}$	343140	242.30	1.1906 - 1.2530	321.05	281.60	268.40	262.10	255.35	250.05
1.3125	1 $\frac{5}{16}$	$\frac{3}{4}$	7	8	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343142	246.00	1.2531 - 1.3155	324.75	285.30	272.10	265.80	259.05	253.75
1.3750	1 $\frac{3}{8}$	$\frac{3}{4}$	7	8	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343144	253.40	1.3156 - 1.3780	332.15	292.70	279.50	273.20	266.45	261.15
1.4375	1 $\frac{7}{16}$	$\frac{3}{4}$	7	8	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343146	260.90	1.3781 - 1.4405	339.65	300.20	287.00	280.70	273.95	268.65
1.5000	1 $\frac{1}{2}$	$\frac{3}{4}$	7	8	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343148	272.10	1.4406 - 1.5030	350.80	311.35	298.15	291.90	285.15	279.80
1.5625	1 $\frac{9}{16}$	$\frac{3}{4}$	7	10	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343150	315.00	1.5031 - 1.5660	397.15	356.00	342.20	335.65	328.60	323.05
1.6250	1 $\frac{5}{8}$	$\frac{3}{4}$	7	10	2 $\frac{1}{4}$	1 $\frac{1}{8}$	3	343152	330.55	1.5661 - 1.6280	412.70	371.55	357.75	351.20	344.15	338.60
1.6875	1 $\frac{11}{16}$	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343154	357.85	1.6281 - 1.6910	440.00	398.85	385.05	378.50	371.45	365.90
1.7500	1 $\frac{3}{4}$	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343156	357.85	1.6911 - 1.7530	440.00	398.85	385.05	378.50	371.45	365.90
1.8125	1 $\frac{13}{16}$	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343158	384.95	1.7531 - 1.8160	467.10	425.95	412.20	405.65	398.60	393.05
1.8750	1 $\frac{7}{8}$	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343160	384.95	1.8161 - 1.8780	467.10	425.95	412.20	405.65	398.60	393.05
1.9375	1 $\frac{15}{16}$	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343162	412.25	1.8781 - 1.9410	494.40	453.25	439.50	432.95	425.90	420.35
2.0000	2	1	8	10	2 $\frac{3}{4}$	1 $\frac{1}{8}$	3 $\frac{1}{2}$	343164	412.25	1.9411 - 2.0030	494.40	453.25	439.50	432.95	425.90	420.35
2.0625	2 $\frac{1}{16}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343166	443.35	2.0031 - 2.0660	525.50	484.35	470.55	464.00	456.95	451.40
2.1250	2 $\frac{1}{8}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343168	443.35	2.0661 - 2.1280	525.50	484.35	470.55	464.00	456.95	451.40
2.1875	2 $\frac{3}{16}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343170	482.25	2.1281 - 2.1905	564.40	523.25	509.45	502.90	495.85	490.30
2.2500	2 $\frac{1}{4}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343172	482.25	2.1906 - 2.2530	564.40	523.25	509.45	502.90	495.85	490.30
2.3125	2 $\frac{5}{16}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343174	509.45	2.2531 - 2.3155	591.60	550.45	536.70	530.10	523.05	517.50
2.3750	2 $\frac{3}{8}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343176	509.45	2.3156 - 2.3780	591.60	550.45	536.70	530.10	523.05	517.50
2.4375	2 $\frac{7}{16}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343178	536.75	2.3781 - 2.4405	618.90	577.75	564.00	557.40	550.35	544.80
2.5000	2 $\frac{1}{2}$	1 $\frac{1}{4}$	9	12	2 $\frac{7}{8}$	1 $\frac{1}{8}$	3 $\frac{3}{4}$	343180	536.75	2.4406 - 2.5030	618.90	577.75	564.00	557.40	550.35	544.80
2.5625	2 $\frac{9}{16}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343182	589.20	2.5031 - 2.5660	671.35	630.15	616.40	609.85	602.80	597.25
2.6250	2 $\frac{5}{8}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343184	611.00	2.5661 - 2.6280	693.15	652.00	638.25	631.70	624.60	619.10
2.6875	2 $\frac{11}{16}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343186	634.80	2.6281 - 2.6910	716.95	675.80	662.00	655.45	648.40	642.85
2.7500	2 $\frac{3}{4}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343188	656.80	2.6911 - 2.7530	738.95	697.80	684.00	677.45	670.40	664.85
2.8125	2 $\frac{13}{16}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343190	679.90	2.7531 - 2.8160	762.05	720.90	707.10	700.55	693.50	687.95
2.8750	2 $\frac{7}{8}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343192	707.10	2.8161 - 2.8780	789.25	748.10	734.35	727.80	720.70	715.20
2.9375	2 $\frac{15}{16}$	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343194	734.40	2.8781 - 2.9410	816.55	775.40	761.65	755.10	748.00	742.50
3.0000	3	1 $\frac{1}{2}$	10	14	3 $\frac{1}{8}$	1 $\frac{1}{8}$	4	343196	761.70	2.9411 - 3.0030	843.85	802.70	788.95	782.40	775.30	769.80

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*Quantities of 15 or more: price of fractional size in same size range.

Made in U.S.A.

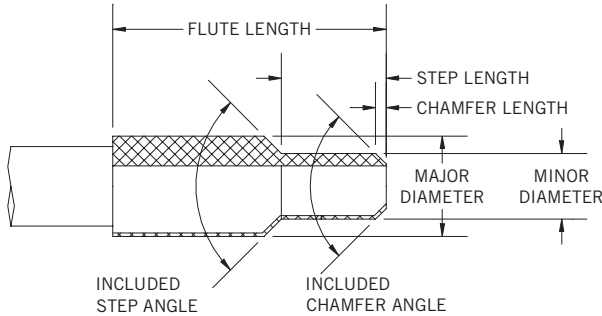
CARBIDE TIPPED STRAIGHT STEP REAMERS

TYPE 3457ST - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3458ST - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3459ST - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece alloy steel bodies. Straight polished flutes. Available with cutting or non-cutting pilots.



FILL IN BLANKS BELOW FOR ORDERING:

MAJOR DIAM. _____ (+.0003"/-.0000")

MINOR DIAM. CUTTING _____ (+.0003"/-.0000")

MINOR DIAM. NON-CUTTING _____ (+.000"/-.001")

STEP LENGTH _____ (+.005"/-.005")

INCL. STEP ANGLE _____

INCL. CHAMFER ANGLE _____

CHAMFER LENGTH _____

NOTES:

1. Order must indicate if pilot is cutting or non-cutting and identify material being machined.
2. The difference between major and minor diameter shall not exceed 6%, and must fall within dimensions shown for that particular tool.
3. Non-cutting pilot diameters may be smaller than cutting diameter range, but not less than non-cutting pilot minimum diameter dimension shown.
4. It is recommended that stock removal of 3% be the basis for selecting each cutting diameter.

Shank diameter tolerance thru 2 1/2" tool diameter: +.0000"/-.0010"
over 2 1/2" tool diameter: +.0000"/-.0015".

Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.
For closer tolerance pricing per tool diameter, see page 50.

MAJOR AND MINOR CUTTING DIAMETER RANGE	NON-CUT PILOT MIN. DIAM.	MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3457ST EDP NO.	CAST IRON TYPE 3458ST EDP NO.	STEEL TYPE 3459ST EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
				FLT	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.1770 - .2040	.1660	.1805	4	1 1/8	4 1/2	345706ST	345806ST	345906ST	\$154.15	\$115.70	\$102.85	\$96.75	\$90.15	\$85.00	\$77.45
.2041 - .2210	.1920	.2075	4	1 1/4	5	345707ST	345807ST	345907ST	154.15	115.70	102.85	96.75	90.15	85.00	77.45
.2211 - .2380	.2080	.2265	4	1 1/2	6	34572344ST	34582344ST	34592344ST	154.15	115.70	102.85	96.75	90.15	85.00	77.45
.2381 - .2530	.2240	.2405	4	1 1/2	6	345708ST	345808ST	345908ST	154.15	115.70	102.85	96.75	90.15	85.00	77.45
.2531 - .2840	.2380	.2485	4	1 1/2	6	345709ST	345809ST	345909ST	155.85	117.45	104.60	98.45	91.90	86.70	79.20
.2841 - .3150	.2670	.2792	4	1 1/2	6	345710ST	345810ST	345910ST	155.85	117.45	104.60	98.45	91.90	86.70	79.20
.3151 - .3470	.2960	.2792	4	1 1/2	6	345711ST	345811ST	345911ST	158.70	120.25	107.40	101.30	94.70	89.55	82.00
.3471 - .3780	.3260	.3105	4	1 3/4	7	345712ST	345812ST	345912ST	158.70	120.25	107.40	101.30	94.70	89.55	82.00
.3781 - .4090	.3550	.3105	4	1 3/4	7	345713ST	345813ST	345913ST	162.75	124.35	111.50	105.35	98.80	93.60	86.10
.4091 - .4410	.3850	.3730	6	1 3/4	7	345714ST	345814ST	345914ST	169.80	131.40	118.55	112.45	105.85	100.65	93.15
.4411 - .4720	.4150	.3730	6	1 3/4	7	345715ST	345815ST	345915ST	177.25	138.85	126.00	119.85	113.30	108.10	100.60
.4721 - .5030	.4440	.4355	6	2	8	345716ST	345816ST	345916ST	189.90	148.75	135.00	128.45	121.40	115.85	107.75
.5031 - .5340	.4730	.4355	6	2	8	345717ST	345817ST	345917ST	193.05	151.85	138.10	131.55	124.50	118.95	110.90
.5341 - .5660	.5020	.4355	6	2	8	345718ST	345818ST	345918ST	193.05	151.85	138.10	131.55	124.50	118.95	110.90
.5661 - .5970	.5320	.4355	6	2	8	345719ST	345819ST	345919ST	197.30	156.15	142.40	135.85	128.75	123.25	115.15
.5971 - .6280	.5610	.5615	6	2 1/4	9	345720ST	345820ST	345920ST	197.30	156.15	142.40	135.85	128.75	123.25	115.15
.6281 - .6590	.5900	.5615	6	2 1/4	9	345721ST	345821ST	345921ST	199.40	158.25	144.50	137.95	130.85	125.35	117.25
.6591 - .6910	.6200	.5615	6	2 1/4	9	345722ST	345822ST	345922ST	199.40	158.25	144.50	137.95	130.85	125.35	117.25
.6911 - .7220	.6500	.5615	6	2 1/4	9	345723ST	345823ST	345923ST	204.70	163.55	149.75	143.20	136.15	130.60	122.55
.7221 - .7530	.6790	.6245	6	2 1/2	9 1/2	345724ST	345824ST	345924ST	204.70	163.55	149.75	143.20	136.15	130.60	122.55
.7531 - .7840	.7080	.6245	6	2 1/2	9 1/2	345725ST	345825ST	345925ST	208.90	167.75	153.95	147.40	140.35	134.80	126.75
.7841 - .8160	.7370	.6245	6	2 1/2	9 1/2	345726ST	345826ST	345926ST	208.90	167.75	153.95	147.40	140.35	134.80	126.75
.8161 - .8470	.7670	.6245	6	2 1/2	9 1/2	345727ST	345827ST	345927ST	213.95	172.80	159.00	152.45	145.40	139.85	131.80
.8471 - .8780	.7970	.7495	6	2 3/8	10	345728ST	345828ST	345928ST	213.95	172.80	159.00	152.45	145.40	139.85	131.80
.8781 - .9090	.8260	.7495	6	2 3/8	10	345729ST	345829ST	345929ST	235.70	194.55	180.75	174.20	167.15	161.60	153.55
.9091 - .9410	.8550	.7495	8	2 3/8	10	345730ST	345830ST	345930ST	235.70	194.55	180.75	174.20	167.15	161.60	153.55
.9411 - .9720	.8850	.7495	8	2 3/8	10	345731ST	345831ST	345931ST	243.00	201.85	188.10	181.50	174.45	168.90	160.85
.9721 - 1.0030	.9140	.8745	8	2 3/4	10 1/2	345732ST	345832ST	345932ST	243.00	201.85	188.10	181.50	174.45	168.90	160.85
1.0031 - 1.0660	.9430	.8745	8	2 3/4	10 1/2	345734ST	345834ST	345934ST	245.05	205.60	192.40	186.10	179.35	174.05	166.30
1.0661 - 1.1280	1.0020	.8745	8	2 3/8	11	345736ST	345836ST	345936ST	258.90	219.45	206.25	199.95	193.20	187.90	180.15
1.1281 - 1.1905	1.0610	.9995	8	2 7/8	11	345738ST	345838ST	345938ST	267.10	227.65	214.45	208.15	201.40	196.10	188.35
1.1906 - 1.2530	1.1200	.9995	8	3	11 1/2	345740ST	345840ST	345940ST	282.40	242.95	229.75	223.45	216.70	211.40	203.65
1.2531 - 1.3155	1.1780	.9995	8	3	11 1/2	345742ST	345842ST	345942ST	288.05	248.60	235.40	229.10	222.35	217.05	209.30
1.3156 - 1.3780	1.2370	.9995	8	3 1/4	12	345744ST	345844ST	345944ST	301.95	262.50	249.30	243.05	236.25	230.95	223.25
1.3781 - 1.4405	1.2960	.9995	8	3 1/4	12	345746ST	345846ST	345946ST	320.30	280.85	267.65	261.40	254.60	249.30	241.60
1.4406 - 1.5030	1.3550	1.2495	8	3 1/2	12 1/2	345748ST	345848ST	345948ST	327.45	288.05	274.85	268.55	261.80	256.45	248.75

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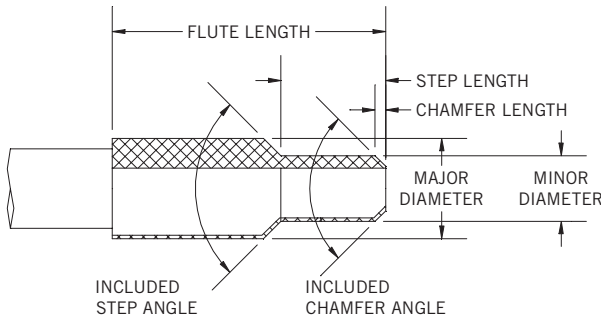
CARBIDE TIPPED RIGHT SPIRAL STEP REAMERS

TYPE 3442ST - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3443ST - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3444ST - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Right spiral polished flutes. Available with cutting or non-cutting pilots.



FILL IN BLANKS BELOW FOR ORDERING:

MAJOR DIAM. _____ (+.0003"/-.0000")

MINOR DIAM. CUTTING _____ (+.0003"/-.0000")

MINOR DIAM. NON-CUTTING _____ (+.000"/-.001")

STEP LENGTH _____ (+.005"/-.005")

INCL. STEP ANGLE _____

INCL. CHAMFER ANGLE _____

CHAMFER LENGTH _____

NOTES:

1. Order must indicate if pilot is cutting or non-cutting and identify material being machined.
2. The difference between major and minor diameter shall not exceed 6%, and must fall within dimensions shown for that particular tool.
3. Non-cutting pilot diameters may be smaller than cutting diameter range, but not less than non-cutting pilot minimum diameter dimension shown.
4. It is recommended that stock removal of 3% be the basis for selecting each cutting diameter.

Shank diameter tolerance thru ²³/₃₂" tool diameter: +.0000"/-.0010"
over ²³/₃₂" tool diameter: +.0000"/-.0015".

Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

For closer tolerance pricing per tool diameter, see page 50.

MAJOR AND MINOR CUTTING DIAMETER RANGE	NON-CUT PILOT MIN. DIAM.	MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3442ST EDP NO.	CAST IRON TYPE 3443ST EDP NO.	STEEL TYPE 3444ST EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
				FLT	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.2841 - .3150	.2670	.2792	4	1 1/2	6	344210ST	344310ST	344410ST	\$170.45	\$134.45	\$122.40	\$116.65	\$110.45	\$105.60	\$98.55
.3151 - .3470	.2960	.2792	4	1 1/2	6	344211ST	344311ST	344411ST	180.45	144.45	132.35	126.65	120.45	115.60	108.55
.3471 - .3780	.3260	.3105	4	1 3/4	7	344212ST	344312ST	344412ST	181.45	145.45	133.40	127.65	121.50	116.65	109.60
.3781 - .4090	.3550	.3105	4	1 3/4	7	344213ST	344313ST	344413ST	186.30	150.30	138.25	132.50	126.35	121.50	114.45
.4091 - .4410	.3850	.3730	6	1 3/4	7	344214ST	344314ST	344414ST	190.75	154.70	142.65	136.95	130.75	125.90	118.85
.4411 - .4720	.4150	.3730	6	1 3/4	7	344215ST	344315ST	344415ST	198.30	162.30	150.25	144.50	138.35	133.50	126.40
.4721 - .5030	.4440	.4355	6	2	8	344216ST	344316ST	344416ST	212.95	174.50	161.65	155.55	148.95	143.80	136.25
.5031 - .5340	.4730	.4355	6	2	8	344217ST	344317ST	344417ST	216.95	178.50	165.65	159.55	152.95	147.80	140.25
.5341 - .5660	.5020	.4355	6	2	8	344218ST	344318ST	344418ST	216.95	178.50	165.65	159.55	152.95	147.80	140.25
.5661 - .5970	.5320	.4355	6	2	8	344219ST	344319ST	344419ST	221.10	182.65	169.80	163.70	157.10	151.95	144.40
.5971 - .6280	.5610	.5615	6	2 1/4	9	344220ST	344320ST	344420ST	221.10	182.65	169.80	163.70	157.10	151.95	144.40
.6281 - .6590	.5900	.5615	6	2 1/4	9	344221ST	344321ST	344421ST	225.65	187.20	174.35	168.25	161.65	156.50	148.95
.6591 - .6910	.6200	.5615	6	2 1/4	9	344222ST	344322ST	344422ST	234.90	196.45	183.60	177.50	170.90	165.75	158.20
.6911 - .7220	.6500	.5615	6	2 1/4	9	344223ST	344323ST	344423ST	237.30	198.90	186.05	179.95	173.35	168.15	160.65
.7221 - .7530	.6790	.6245	6	2 1/2	9 1/2	344224ST	344324ST	344424ST	239.65	201.25	188.40	182.30	175.70	170.50	163.00
.7531 - .7840	.7080	.6245	6	2 1/2	9 1/2	344225ST	344325ST	344425ST	244.00	205.55	192.70	186.60	180.00	174.85	167.30
.7841 - .8160	.7370	.6245	6	2 1/2	9 1/2	344226ST	344326ST	344426ST	244.00	205.55	192.70	186.60	180.00	174.85	167.30
.8161 - .8470	.7670	.6245	6	2 1/2	9 1/2	344227ST	344327ST	344427ST	253.10	214.65	201.80	195.70	189.10	183.95	176.40
.8471 - .8780	.7970	.7495	6	2 5/8	10	344228ST	344328ST	344428ST	253.10	214.65	201.80	195.70	189.10	183.95	176.40
.8781 - .9090	.8260	.7495	6	2 5/8	10	344229ST	344329ST	344429ST	282.10	243.65	230.80	224.70	218.10	212.95	205.40
.9091 - .9410	.8550	.7495	8	2 5/8	10	344230ST	344330ST	344430ST	282.10	243.65	230.80	224.70	218.10	212.95	205.40
.9411 - .9720	.8850	.7495	8	2 5/8	10	344231ST	344331ST	344431ST	292.20	253.80	240.90	234.80	228.20	223.05	215.50
.9721 - 1.0030	.9140	.8745	8	2 3/4	10 1/2	344232ST	344332ST	344432ST	292.20	253.80	240.90	234.80	228.20	223.05	215.50
1.0031 - 1.0660	.9430	.8745	8	2 3/4	10 1/2	344234ST	344334ST	344434ST	329.90	291.50	278.65	272.50	265.95	260.75	253.25
1.0661 - 1.1280	1.0020	.8745	8	2 7/8	11	344236ST	344336ST	344436ST	337.75	299.35	286.45	280.35	273.75	268.60	261.05
1.1281 - 1.1905	1.0610	.9995	8	2 7/8	11	344238ST	344338ST	344438ST	351.15	312.75	299.90	293.75	287.20	282.00	274.50
1.1906 - 1.2530	1.1200	.9995	8	3	11 1/2	344240ST	344340ST	344440ST	367.00	328.55	315.70	309.60	303.00	297.85	290.30
1.2531 - 1.3155	1.1780	.9995	8	3	11 1/2	344242ST	344342ST	344442ST	398.05	359.60	346.75	340.65	334.05	328.90	321.35
1.3156 - 1.3780	1.2370	.9995	8	3 1/4	12	344244ST	344344ST	344444ST	428.70	390.30	377.40	371.30	364.70	359.55	352.00
1.3781 - 1.4405	1.2960	.9995	8	3 1/4	12	344246ST	344346ST	344446ST	449.60	411.20	398.35	392.25	385.65	380.50	372.95
1.4406 - 1.5030	1.3550	1.2495	8	3 1/2	12 1/2	344248ST	344348ST	344448ST	470.70	432.30	419.45	413.30	406.75	401.55	394.05

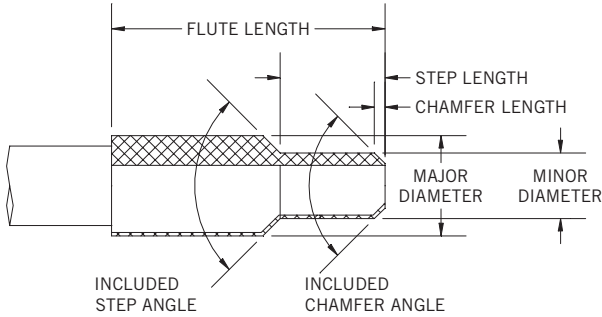
CARBIDE TIPPED LEFT SPIRAL STEP REAMERS

TYPE 3482ST - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3483ST - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3484ST - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Left spiral polished flutes. Available with cutting or non-cutting pilots.



FILL IN BLANKS BELOW FOR ORDERING:

MAJOR DIAM. _____ (+.0003"/-.0000")

MINOR DIAM. CUTTING _____ (+.0003"/-.0000")

MINOR DIAM. NON-CUTTING _____ (+.000"/-.001")

STEP LENGTH _____ (+.005"/-.005")

INCL. STEP ANGLE _____

INCL. CHAMFER ANGLE _____

CHAMFER LENGTH _____

NOTES:

1. Order must indicate if pilot is cutting or non-cutting and identify material being machined.
2. The difference between major and minor diameter shall not exceed 6%, and must fall within dimensions shown for that particular tool.
3. Non-cutting pilot diameters may be smaller than cutting diameter range, but not less than non-cutting pilot minimum diameter dimension shown.
4. It is recommended that stock removal of 3% be the basis for selecting each cutting diameter.

Shank diameter tolerance thru 2 3/2" tool diameter: $\pm .0000"/-.0010"$
 over 2 3/2" tool diameter: $\pm .0000"/-.0015"$

Shanks are ground to the next smallest shank diameter listed in NAS 897 if tool diameter is within .005" of shank diameter.

For closer tolerance pricing per tool diameter, see page 50.

MAJOR AND MINOR CUTTING DIAMETER RANGE	NON-CUT PILOT MIN. DIAM.	MAX SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3482ST EDP NO.	CAST IRON TYPE 3483ST EDP NO.	STEEL TYPE 3484ST EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
				FLT.	OAL				1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.2841 - .3150	.2670	.2792	4	1 1/2	6	348210ST	348310ST	348410ST	\$181.80	\$143.40	\$130.55	\$124.40	\$117.85	\$112.65	\$105.15
.3151 - .3470	.2960	.2792	4	1 1/2	6	348211ST	348311ST	348411ST	192.45	154.05	141.20	135.10	128.50	123.30	115.80
.3471 - .3780	.3260	.3105	4	1 3/4	7	348212ST	348312ST	348412ST	193.55	155.15	142.30	136.20	129.60	124.40	116.90
.3781 - .4090	.3550	.3105	4	1 3/4	7	348213ST	348313ST	348413ST	198.75	160.35	147.45	141.35	134.75	129.60	122.05
.4091 - .4410	.3850	.3730	6	1 3/4	7	348214ST	348314ST	348414ST	203.45	165.05	152.15	146.05	139.45	134.30	126.75
.4411 - .4720	.4150	.3730	6	1 3/4	7	348215ST	348315ST	348415ST	211.50	173.10	160.25	154.15	147.55	142.35	134.85
.4721 - .5030	.4440	.4355	6	2	8	348216ST	348316ST	348416ST	218.65	179.20	166.00	159.70	152.95	147.65	139.90
.5031 - .5340	.4730	.4355	6	2	8	348217ST	348317ST	348417ST	222.75	183.30	170.10	163.80	157.05	151.75	144.00
.5341 - .5660	.5020	.4355	6	2	8	348218ST	348318ST	348418ST	222.75	183.30	170.10	163.80	157.05	151.75	144.00
.5661 - .5970	.5320	.4355	6	2	8	348219ST	348319ST	348419ST	227.00	187.55	174.35	168.10	161.30	156.00	148.30
.5971 - .6280	.5610	.5615	6	2 1/4	9	348220ST	348320ST	348420ST	227.00	187.55	174.35	168.10	161.30	156.00	148.30
.6281 - .6590	.5900	.5615	6	2 1/4	9	348221ST	348321ST	348421ST	231.70	192.25	179.05	172.75	166.00	160.70	152.95
.6591 - .6910	.6200	.5615	6	2 1/4	9	348222ST	348322ST	348422ST	241.20	201.75	188.55	182.25	175.50	170.20	162.45
.6911 - .7220	.6500	.5615	6	2 1/4	9	348223ST	348323ST	348423ST	243.65	204.25	191.05	184.75	178.00	172.65	164.95
.7221 - .7530	.6790	.6245	6	2 1/2	9 1/2	348224ST	348324ST	348424ST	246.10	206.65	193.45	187.15	180.40	175.10	167.35
.7531 - .7840	.7080	.6245	6	2 1/2	9 1/2	348225ST	348325ST	348425ST	250.50	211.05	197.85	191.60	184.85	179.50	171.80
.7841 - .8160	.7370	.6245	6	2 1/2	9 1/2	348226ST	348326ST	348426ST	250.50	211.05	197.85	191.60	184.85	179.50	171.80
.8161 - .8470	.7670	.6245	6	2 1/2	9 1/2	348227ST	348327ST	348427ST	259.85	220.40	207.20	200.95	194.15	188.85	181.10
.8471 - .8780	.7970	.7495	6	2 5/8	10	348228ST	348328ST	348428ST	259.85	220.40	207.20	200.95	194.15	188.85	181.10
.8781 - .9090	.8260	.7495	6	2 5/8	10	348229ST	348329ST	348429ST	289.65	250.20	237.00	230.70	223.95	218.65	210.90
.9091 - .9410	.8550	.7495	8	2 5/8	10	348230ST	348330ST	348430ST	289.65	250.20	237.00	230.70	223.95	218.65	210.90
.9411 - .9720	.8850	.7495	8	2 5/8	10	348231ST	348331ST	348431ST	300.00	260.60	247.40	241.10	234.35	229.00	221.30
.9721 - 1.0030	.9140	.8745	8	2 3/4	10 1/2	348232ST	348332ST	348432ST	300.00	260.60	247.40	241.10	234.35	229.00	221.30
1.0031 - 1.0660	.9430	.8745	8	2 3/4	10 1/2	348234ST	348334ST	348434ST	338.75	299.30	286.10	279.80	273.05	267.75	260.00
1.0661 - 1.1280	1.0020	.8745	8	2 7/8	11	348236ST	348336ST	348436ST	346.80	307.35	294.15	287.85	281.10	275.80	268.05
1.1281 - 1.1905	1.0610	.9995	8	2 7/8	11	348238ST	348338ST	348438ST	360.55	321.10	307.90	301.65	294.85	289.55	281.85
1.1906 - 1.2530	1.1200	.9995	8	3	11 1/2	348240ST	348340ST	348440ST	376.80	337.40	324.15	317.90	311.15	305.80	298.10
1.2531 - 1.3155	1.1780	.9995	8	3	11 1/2	348242ST	348342ST	348442ST	408.70	369.25	356.05	349.75	343.00	337.70	329.95
1.3156 - 1.3780	1.2370	.9995	8	3 1/4	12	348244ST	348344ST	348444ST	440.15	400.75	387.55	381.25	374.50	369.15	361.45
1.3781 - 1.4405	1.2960	.9995	8	3 1/4	12	348246ST	348346ST	348446ST	461.65	422.20	409.00	402.75	396.00	390.65	382.95
1.4406 - 1.5030	1.3550	1.2495	8	3 1/2	12 1/2	348248ST	348348ST	348448ST	483.30	443.90	430.70	424.40	417.65	412.30	404.60

CARBIDE TIPPED VARIABLE LENGTH REAMERS

TYPE 3457EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR NON-FERROUS
TYPE 3458EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR CAST IRON
TYPE 3459EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - FOR STEEL

Same as types 3457, 3458, and 3459 on page 84 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.



DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3457EL EDP NO.	CAST IRON TYPE 3458EL EDP NO.	STEEL TYPE 3459EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.1121 - .1280*	.1099	4	1 1/2	345704EL	345804EL	345904EL	2 9/32 - 6	\$276.00	\$241.70	\$230.25	\$224.75	\$218.90	\$214.25
.1281 - .1435*	.1255	4	1 1/2	3457045EL	3458045EL	3459045EL	2 17/32 - 6 1/2	277.00	242.70	231.20	225.75	219.85	215.25
.1436 - .1590*	.1411	4	1 1/2	345705EL	345805EL	345905EL	2 17/32 - 7	281.55	247.25	235.75	230.30	224.40	219.80
.1591 - .1750*	.1567	4	1 1/2	3457055EL	3458055EL	3459055EL	2 29/32 - 8	286.85	252.55	241.10	235.60	229.75	225.10
.1751 - .1910*	.1724	4	1 1/2	345706EL	345806EL	345906EL	4 17/32 - 9	294.50	260.20	248.70	243.25	237.35	232.75
.1911 - .2210*	.1880	4	1 1/2	345707EL	345807EL	345907EL	5 1/32 - 10	304.45	270.15	258.65	253.20	247.30	242.70
.2211 - .2530*	.2193	4	1 1/2	345708EL	345808EL	345908EL	6 1/32 - 12	324.10	289.80	278.30	272.85	267.00	262.35
.2531 - .2840	.2505	4	1 1/2	345709EL	345809EL	345909EL	6 1/32 - 12	340.95	306.65	295.20	289.75	283.85	279.25
.2841 - .3150	.2792	4	1 1/2	345710EL	345810EL	345910EL	6 1/32 - 12	242.00	207.70	196.20	190.75	184.85	180.25
.3151 - .3470	.2792	4	1 1/2	345711EL	345811EL	345911EL	6 1/32 - 12	242.00	207.70	196.20	190.75	184.85	180.25
.3471 - .3780	.3105	4	1 3/4	345712EL	345812EL	345912EL	7 1/32 - 14	249.90	215.60	204.10	198.65	192.80	188.15
.3781 - .4090	.3105	4	1 3/4	345713EL	345813EL	345913EL	7 1/32 - 14	249.90	215.60	204.10	198.65	192.80	188.15
.4091 - .4410	.3730	6	1 3/4	345714EL	345814EL	345914EL	7 1/32 - 14	257.80	223.50	212.05	206.55	200.70	196.05
.4411 - .4720	.3730	6	1 3/4	345715EL	345815EL	345915EL	7 1/32 - 14	257.80	223.50	212.05	206.55	200.70	196.05
.4721 - .5030	.4355	6	2	345716EL	345816EL	345916EL	8 1/32 - 16	263.15	228.85	217.35	211.90	206.00	201.40
.5031 - .5340	.4355	6	2	345717EL	345817EL	345917EL	8 1/32 - 16	263.15	228.85	217.35	211.90	206.00	201.40
.5341 - .5660	.4355	6	2	345718EL	345818EL	345918EL	8 1/32 - 16	268.05	228.85	222.25	216.80	210.90	206.30
.5661 - .5970	.4355	6	2	345719EL	345819EL	345919EL	8 1/32 - 16	268.05	233.75	222.25	216.80	210.90	206.30
.5971 - .6280	.5615	6	2 1/4	345720EL	345820EL	345920EL	9 1/32 - 18	273.70	239.40	227.90	222.45	216.60	211.95
.6281 - .6590	.5615	6	2 1/4	345721EL	345821EL	345921EL	9 1/32 - 18	273.70	239.40	227.90	222.45	216.60	211.95
.6591 - .6910	.5615	6	2 1/4	345722EL	345822EL	345922EL	9 1/32 - 18	274.45	240.15	228.70	223.25	217.35	212.75
.6911 - .7220	.5615	6	2 1/4	345723EL	345823EL	345923EL	9 1/32 - 18	274.45	240.15	228.70	223.25	217.35	212.75
.7221 - .7530	.6245	6	2 1/2	345724EL	345824EL	345924EL	9 17/32 - 18	294.65	260.35	248.85	243.40	237.50	232.90

TYPE 3416EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - THROUGH HOLES - FOR NON-FERROUS
TYPE 3426EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - THROUGH HOLES - FOR CAST IRON
TYPE 3435EL - STRAIGHT SHANK - STRAIGHT FLUTE LONG CARBIDE - THROUGH HOLES - FOR STEEL

Same as types 3416, 3426, and 3435 on page 94 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.

DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3416EL EDP NO.	CAST IRON TYPE 3426EL EDP NO.	STEEL TYPE 3435EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.1751 - .1910*	.1724	4	1 1/2	341606EL	342606EL	343506EL	4 17/32 - 9	\$352.30	\$318.00	\$306.55	\$301.05	\$295.20	\$290.55
.1911 - .2210*	.1880	4	1 1/2	341607EL	342607EL	343507EL	5 1/32 - 10	365.90	331.60	320.10	314.65	308.75	304.15
.2211 - .2530*	.2193	4	1 1/2	341608EL	342608EL	343508EL	6 1/32 - 12	406.50	372.20	360.70	355.25	349.35	344.75
.2531 - .2840*	.2505	4	1 1/2	341609EL	342609EL	343509EL	6 1/32 - 12	426.15	391.85	380.40	374.90	369.05	364.40
.2841 - .3150	.2792	4	1 1/2	341610EL	342610EL	343510EL	6 1/32 - 12	315.15	280.85	269.35	263.90	258.00	253.40
.3151 - .3470	.2792	4	1 1/2	341611EL	342611EL	343511EL	6 1/32 - 12	315.15	280.85	269.35	263.90	258.00	253.40
.3471 - .3780	.3105	4	1 3/4	341612EL	342612EL	343512EL	7 1/32 - 14	321.35	287.05	275.60	270.15	264.25	259.65
.3781 - .4090	.3105	4	1 3/4	341613EL	342613EL	343513EL	7 1/32 - 14	321.35	287.05	275.60	270.15	264.25	259.65
.4091 - .4410	.3730	6	1 3/4	341614EL	342614EL	343514EL	7 1/32 - 14	322.70	288.40	276.90	271.45	265.60	260.95
.4411 - .4720	.3730	6	1 3/4	341615EL	342615EL	343515EL	7 1/32 - 14	322.70	288.40	276.90	271.45	265.60	260.95
.4721 - .5030	.4355	6	2	341616EL	342616EL	343516EL	8 1/32 - 16	351.05	316.75	305.25	299.80	293.95	289.30
.5031 - .5340	.4355	6	2	341617EL	342617EL	343517EL	8 1/32 - 16	351.05	316.75	305.25	299.80	293.95	289.30
.5341 - .5660	.4355	6	2	341618EL	342618EL	343518EL	8 1/32 - 16	353.50	319.20	307.70	302.25	296.40	291.75
.5661 - .5970	.4355	6	2	341619EL	342619EL	343519EL	8 1/32 - 16	353.50	319.20	307.70	302.25	296.40	291.75
.5971 - .6280	.5615	6	2 1/4	341620EL	342620EL	343520EL	9 1/32 - 18	360.50	326.20	314.70	309.25	303.40	298.75
.6281 - .6590	.5615	6	2 1/4	341621EL	342621EL	343521EL	9 1/32 - 18	360.50	326.20	314.70	309.25	303.40	298.75
.6591 - .6910	.5615	6	2 1/4	341622EL	342622EL	343522EL	9 1/32 - 18	364.40	330.10	318.65	313.20	307.30	302.70
.6911 - .7220	.5615	6	2 1/4	341623EL	342623EL	343523EL	9 1/32 - 18	364.40	330.10	318.65	313.20	307.30	302.70
.7221 - .7530	.6245	6	2 1/2	341624EL	342624EL	343524EL	9 17/32 - 18	379.40	345.10	333.60	328.15	322.30	317.65

CARBIDE TIPPED VARIABLE LENGTH REAMERS

TYPE 3442EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3443EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3444EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Same as types 3442, 3443, and 3444 on page 88 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.



DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3442EL EDP NO.	CAST IRON TYPE 3443EL EDP NO.	STEEL TYPE 3444EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.2211 - .2530*	.2193	4	1 1/2	344208EL	344308EL	344408EL	6 1/2 - 12	\$388.90	\$347.75	\$333.95	\$327.45	\$320.40	\$314.85
.2531 - .2840*	.2505	4	1 1/2	344209EL	344309EL	344409EL	6 1/2 - 12	409.15	368.00	354.20	347.70	340.60	335.10
.2841 - .3150	.2792	4	1 1/2	344210EL	344310EL	344410EL	6 1/2 - 12	290.35	249.20	235.50	228.90	221.85	216.30
.3151 - .3470	.2792	4	1 1/2	344211EL	344311EL	344411EL	6 1/2 - 12	290.35	249.20	235.50	228.90	221.85	216.30
.3471 - .3780	.3105	4	1 3/4	344212EL	344312EL	344412EL	7 1/2 - 14	299.90	258.70	244.95	238.40	231.35	225.80
.3781 - .4090	.3105	4	1 3/4	344213EL	344313EL	344413EL	7 1/2 - 14	299.90	258.70	244.95	238.40	231.35	225.80
.4091 - .4410	.3730	6	1 3/4	344214EL	344314EL	344414EL	7 1/2 - 14	309.40	268.25	254.45	247.85	240.80	235.25
.4411 - .4720	.3730	6	1 3/4	344215EL	344315EL	344415EL	7 1/2 - 14	309.40	268.25	254.45	247.85	240.80	235.25
.4721 - .5030	.4355	6	2	344216EL	344316EL	344416EL	8 1/2 - 16	315.75	274.60	260.80	254.25	247.25	241.65
.5031 - .5340	.4355	6	2	344217EL	344317EL	344417EL	8 1/2 - 16	315.75	274.60	260.80	254.25	247.25	241.65
.5341 - .5660	.4355	6	2	344218EL	344318EL	344418EL	8 1/2 - 16	321.65	280.50	266.70	260.10	253.10	247.50
.5661 - .5970	.4355	6	2	344219EL	344319EL	344419EL	8 1/2 - 16	321.65	280.50	266.70	260.10	253.10	247.50
.5971 - .6280	.5615	6	2 1/4	344220EL	344320EL	344420EL	9 1/2 - 18	328.45	287.30	273.50	267.00	259.90	254.40
.6281 - .6590	.5615	6	2 1/4	344221EL	344321EL	344421EL	9 1/2 - 18	328.45	287.30	273.50	267.00	259.90	254.40
.6591 - .6910	.5615	6	2 1/4	344222EL	344322EL	344422EL	9 1/2 - 18	329.35	288.20	274.40	267.90	260.80	255.30
.6911 - .7220	.5615	6	2 1/4	344223EL	344323EL	344423EL	9 1/2 - 18	329.35	288.20	274.40	267.90	260.80	255.30
.7221 - .7530	.6245	6	2 1/2	344224EL	344324EL	344424EL	9 1/2 - 18	353.55	312.40	298.60	292.05	285.05	279.45

TYPE 3411EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - BLIND HOLES - FOR NON-FERROUS

TYPE 3413EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - BLIND HOLES - FOR CAST IRON

TYPE 3415EL - STRAIGHT SHANK - RIGHT SPIRAL FLUTE LONG CARBIDE - BLIND HOLES - FOR STEEL

Same as types 3411, 3413, and 3415 on page 99 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.



DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3411EL EDP NO.	CAST IRON TYPE 3413EL EDP NO.	STEEL TYPE 3415EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.2211 - .2530*	.2193	4	1 1/2	341108EL	341308EL	341508EL	6 1/2 - 12	\$487.75	\$446.60	\$432.90	\$426.30	\$419.25	\$413.70
.2531 - .2840*	.2505	4	1 1/2	341109EL	341309EL	341509EL	6 1/2 - 12	511.40	470.25	456.45	449.90	442.80	437.30
.2841 - .3150	.2792	4	1 1/2	341110EL	341310EL	341510EL	6 1/2 - 12	378.15	337.00	323.25	316.70	309.60	304.10
.3151 - .3470	.2792	4	1 1/2	341111EL	341311EL	341511EL	6 1/2 - 12	378.15	337.00	323.25	316.70	309.60	304.10
.3471 - .3780	.3105	4	1 3/4	341112EL	341312EL	341512EL	7 1/2 - 14	385.65	344.45	330.70	324.15	317.10	311.55
.3781 - .4090	.3105	4	1 3/4	341113EL	341313EL	341513EL	7 1/2 - 14	385.65	344.45	330.70	324.15	317.10	311.55
.4091 - .4410	.3730	6	1 3/4	341114EL	341314EL	341514EL	7 1/2 - 14	387.25	346.10	332.30	325.80	318.70	313.20
.4411 - .4720	.3730	6	1 3/4	341115EL	341315EL	341515EL	7 1/2 - 14	387.25	346.10	332.30	325.80	318.70	313.20
.4721 - .5030	.4355	6	2	341116EL	341316EL	341516EL	8 1/2 - 16	421.25	380.10	366.30	359.80	352.75	347.20
.5031 - .5340	.4355	6	2	341117EL	341317EL	341517EL	8 1/2 - 16	421.25	380.10	366.30	359.80	352.75	347.20
.5341 - .5660	.4355	6	2	341118EL	341318EL	341518EL	8 1/2 - 16	424.20	383.05	369.25	362.75	355.65	350.15
.5661 - .5970	.4355	6	2	341119EL	341319EL	341519EL	8 1/2 - 16	424.20	383.05	369.25	362.75	355.65	350.15
.5971 - .6280	.5615	6	2 1/4	341120EL	341320EL	341520EL	9 1/2 - 18	432.60	391.45	377.65	371.15	364.05	358.55
.6281 - .6590	.5615	6	2 1/4	341121EL	341321EL	341521EL	9 1/2 - 18	432.60	391.45	377.65	371.15	364.05	358.55
.6591 - .6910	.5615	6	2 1/4	341122EL	341322EL	341522EL	9 1/2 - 18	437.30	396.15	382.35	375.85	368.75	363.25
.6911 - .7220	.5615	6	2 1/4	341123EL	341323EL	341523EL	9 1/2 - 18	437.30	396.15	382.35	375.85	368.75	363.25
.7221 - .7530	.6245	6	2 1/2	341124EL	341324EL	341524EL	9 1/2 - 18	455.30	414.10	400.35	393.80	386.75	381.20

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CARBIDE TIPPED VARIABLE LENGTH REAMERS

TYPE 3482EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR NON-FERROUS

TYPE 3483EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR CAST IRON

TYPE 3484EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - FOR STEEL

Same as types 3482, 3483, and 3484 on page 89 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.



DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3482EL EDP NO.	CAST IRON TYPE 3483EL EDP NO.	STEEL TYPE 3484EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.2211 - .2530*	.2193	4	1 1/2	348208EL	348308EL	348408EL	6 1/32 - 12	\$388.90	\$347.75	\$333.95	\$327.45	\$320.40	\$314.85
.2531 - .2840*	.2505	4	1 1/2	348209EL	348309EL	348409EL	6 1/32 - 12	409.15	368.00	354.20	347.70	340.60	335.10
.2841 - .3150	.2792	4	1 1/2	348210EL	348310EL	348410EL	6 1/32 - 12	290.35	249.20	235.50	228.90	221.85	216.30
.3151 - .3470	.2792	4	1 1/2	348211EL	348311EL	348411EL	6 1/32 - 12	290.35	249.20	235.50	228.90	221.85	216.30
.3471 - .3780	.3105	4	1 3/4	348212EL	348312EL	348412EL	7 1/32 - 14	299.90	258.70	244.95	238.40	231.35	225.80
.3781 - .4090	.3105	4	1 3/4	348213EL	348313EL	348413EL	7 1/32 - 14	299.90	258.70	244.95	238.40	231.35	225.80
.4091 - .4410	.3730	6	1 3/4	348214EL	348314EL	348414EL	7 1/32 - 14	309.40	268.25	254.45	247.85	240.80	235.25
.4411 - .4720	.3730	6	1 3/4	348215EL	348315EL	348415EL	7 1/32 - 14	309.40	268.25	254.45	247.85	240.80	235.25
.4721 - .5030	.4355	6	2	348216EL	348316EL	348416EL	8 1/32 - 16	315.75	274.60	260.80	254.25	247.25	241.65
.5031 - .5340	.4355	6	2	348217EL	348317EL	348417EL	8 1/32 - 16	315.75	274.60	260.80	254.25	247.25	241.65
.5341 - .5660	.4355	6	2	348218EL	348318EL	348418EL	8 1/32 - 16	321.65	280.50	266.70	260.10	253.10	247.50
.5661 - .5970	.4355	6	2	348219EL	348319EL	348419EL	8 1/32 - 16	321.65	280.50	266.70	260.10	253.10	247.50
.5971 - .6280	.5615	6	2 1/4	348220EL	348320EL	348420EL	9 1/32 - 18	328.45	287.30	273.50	267.00	259.90	254.40
.6281 - .6590	.5615	6	2 1/4	348221EL	348321EL	348421EL	9 1/32 - 18	328.45	287.30	273.50	267.00	259.90	254.40
.6591 - .6910	.5615	6	2 1/4	348222EL	348322EL	348422EL	9 1/32 - 18	329.35	288.20	274.40	267.90	260.80	255.30
.6911 - .7220	.5615	6	2 1/4	348223EL	348323EL	348423EL	9 1/32 - 18	329.35	288.20	274.40	267.90	260.80	255.30
.7221 - .7530	.6245	6	2 1/2	348224EL	348324EL	348424EL	9 17/32 - 18	353.55	312.40	298.60	292.05	285.05	279.45

TYPE 3427EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - THROUGH HOLES - FOR NON-FERROUS

TYPE 3428EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - THROUGH HOLES - FOR CAST IRON

TYPE 3429EL - STRAIGHT SHANK - LEFT SPIRAL FLUTE LONG CARBIDE - THROUGH HOLES - FOR STEEL

Same as types 3427, 3428, and 3429 on page 100 except with variable overall lengths. When ordering, specify desired length within overall length range. Eliminates need to special order reamers, saving time and money. These reamers have a controlled shank.



DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	NON-FERR. TYPE 3427EL EDP NO.	CAST IRON TYPE 3428EL EDP NO.	STEEL TYPE 3429EL EDP NO.	OVERALL LENGTH RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
.2211 - .2530*	.2193	4	1 1/2	342708EL	342808EL	342908EL	6 1/32 - 12	\$487.75	\$446.60	\$432.90	\$426.30	\$419.25	\$413.70
.2531 - .2840*	.2505	4	1 1/2	342709EL	342809EL	342909EL	6 1/32 - 12	511.40	470.25	456.45	449.90	442.80	437.30
.2841 - .3150	.2792	4	1 1/2	342710EL	342810EL	342910EL	6 1/32 - 12	378.15	337.00	323.25	316.70	309.60	304.10
.3151 - .3470	.2792	4	1 1/2	342711EL	342811EL	342911EL	6 1/32 - 12	378.15	337.00	323.25	316.70	309.60	304.10
.3471 - .3780	.3105	4	1 3/4	342712EL	342812EL	342912EL	7 1/32 - 14	385.65	344.45	330.70	324.15	317.10	311.55
.3781 - .4090	.3105	4	1 3/4	342713EL	342813EL	342913EL	7 1/32 - 14	385.65	344.45	330.70	324.15	317.10	311.55
.4091 - .4410	.3730	6	1 3/4	342714EL	342814EL	342914EL	7 1/32 - 14	387.25	346.10	332.30	325.80	318.70	313.20
.4411 - .4720	.3730	6	1 3/4	342715EL	342815EL	342915EL	7 1/32 - 14	387.25	346.10	332.30	325.80	318.70	313.20
.4721 - .5030	.4355	6	2	342716EL	342816EL	342916EL	8 1/32 - 16	421.25	380.10	366.30	359.80	352.75	347.20
.5031 - .5340	.4355	6	2	342717EL	342817EL	342917EL	8 1/32 - 16	421.25	380.10	366.30	359.80	352.75	347.20
.5341 - .5660	.4355	6	2	342718EL	342818EL	342918EL	8 1/32 - 16	424.20	383.05	369.25	362.75	355.65	350.15
.5661 - .5970	.4355	6	2	342719EL	342819EL	342919EL	8 1/32 - 16	424.20	383.05	369.25	362.75	355.65	350.15
.5971 - .6280	.5615	6	2 1/4	342720EL	342820EL	342920EL	9 1/32 - 18	432.60	391.45	377.65	371.15	364.05	358.55
.6281 - .6590	.5615	6	2 1/4	342721EL	342821EL	342921EL	9 1/32 - 18	432.60	391.45	377.65	371.15	364.05	358.55
.6591 - .6910	.5615	6	2 1/4	342722EL	342822EL	342922EL	9 1/32 - 18	437.30	396.15	382.35	375.85	368.75	363.25
.6911 - .7220	.5615	6	2 1/4	342723EL	342823EL	342923EL	9 1/32 - 18	437.30	396.15	382.35	375.85	368.75	363.25
.7221 - .7530	.6245	6	2 1/2	342724EL	342824EL	342924EL	9 17/32 - 18	455.30	414.10	400.35	393.80	386.75	381.20

FEEDS & SPEEDS CHARTS FOR DRILLS - CARBIDE TIPPED

Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all safety shields and glasses before performing these operations.

$RPM = SFPM * 3.82 / \text{Drill Diameter}$



CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE (INCHES PER REVOLUTION)					HOLE DIAMETER IN INCHES			
			GENERAL PURPOSE (G.P.)	1/8	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	250-350	.003	.005	.007	.008	.010	.011	.014	.017	.019
	MAGNESIUM ALLOY	50 - 90*	300-400	.003	.005	.006	.007	.008	.009	.013	.015	.016
	LEAD ALLOY	10 - 20*	350-450	.003	.005	.006	.007	.008	.009	.013	.015	.017
	NON-METAL AND PLASTIC	-	175-450	.002	.004	.005	.005	.006	.008	.009	.010	.012
	ZINC ALLOY - DIE CAST	80 - 100	300-400	.003	.005	.007	.009	.011	.012	.014	.016	.018
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	125-190	.002	.005	.007	.008	.009	.010	.012	.014	.016
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	225-400	.003	.005	.007	.008	.009	.010	.012	.014	.016
	NICKEL SILVER	10 - 100Rb	125-190	.002	.005	.007	.008	.009	.010	.012	.014	.016
	COPPER ALLOY - TOUGH	40 - 200*	125-190	.002	.005	.007	.008	.009	.010	.012	.014	.016
	DUCTILE CAST IRON - AUSTENITIC	120 - 275	-	-	-	-	-	-	-	-	-	-
CAST IRON	DUCTILE CAST IRON - FERRITIC	140 - 270	150-225	.002	.004	.006	.008	.010	.012	.014	.016	.018
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	-	-	-	-	-	-	-	-	-	-
	GRAY - PEARLITIC	220 - 320	130-225	.002	.004	.006	.007	.009	.010	.013	.016	.018
	GRAY - FERRITIC	120 - 220	125-190	.002	.005	.008	.009	.010	.011	.012	.014	.016
	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	100-150	.002	.004	.006	.007	.008	.010	.012	.014	.016
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	125-175	.003	.004	.008	.010	.012	.014	.017	.018	.019
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	-	-	-	-	-	-	-	-	-	-
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	-	-	-	-	-	-	-	-	-	-
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - 400 SERIES	135 - 325	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	100-150	.002	.004	.005	.006	.007	.008	.010	.012	.014
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	-	-	-	-	-	-	-	-	-	
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - 300 SERIES	135 - 375	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - PH SERIES	150 - 440	-	-	-	-	-	-	-	-	-	-
	TITANIUM ALLOY	110 - 380	-	-	-	-	-	-	-	-	-	-

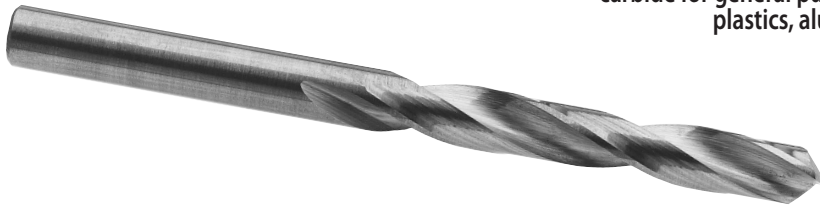
CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE (INCHES PER REVOLUTION)					HOLE DIAMETER IN INCHES			
			COOLANT FED (C.F.)	1/8	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	375-550	-	.004	.005	.006	.006	.007	.009	-	-
	MAGNESIUM ALLOY	50 - 90*	450-550	-	.005	.006	.007	.008	.009	.013	-	-
	LEAD ALLOY	10 - 20*	400-500	-	.004	.006	.007	.008	.009	.013	-	-
	NON-METAL AND PLASTIC	-	-	-	-	-	-	-	-	-	-	-
	ZINC ALLOY - DIE CAST	80 - 100	400-500	-	.004	.005	.006	.008	.009	.010	-	-
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	200-300	-	.004	.005	.006	.007	.008	.010	-	-
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	300-450	-	.004	.005	.006	.007	.008	.010	-	-
	NICKEL SILVER	10 - 100Rb	225-300	-	.004	.005	.006	.007	.008	.010	-	-
	COPPER ALLOY - TOUGH	40 - 200*	225-300	-	.004	.005	.006	.007	.008	.010	-	-
	DUCTILE CAST IRON - AUSTENITIC	120 - 275	-	-	-	-	-	-	-	-	-	-
CAST IRON	DUCTILE CAST IRON - FERRITIC	140 - 270	200-250	-	.004	.005	.006	.007	.008	.010	-	-
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	200-250	-	.004	.005	.006	.007	.008	.010	-	-
	GRAY - PEARLITIC	220 - 320	225-325	-	.004	.006	.008	.010	.012	.015	-	-
	GRAY - FERRITIC	120 - 220	200-250	-	.004	.006	.008	.008	.008	.010	-	-
	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	200-250	-	.004	.005	.006	.007	.008	.010	-	-
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	150-250	-	.005	.006	.008	.009	.010	.012	-	-
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	-	-	-	-	-	-	-	-	-	-
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	100-220	-	.005	.006	.007	.008	.010	.012	-	-
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	100-150	-	.005	.006	.007	.008	.010	.012	-	-
	STAINLESS STEEL - 400 SERIES	135 - 325	110-150	-	.004	.005	.006	.007	.008	.010	-	-
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	125-190	-	.004	.005	.006	.007	.007	.008	-	-
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	100-150	-	.0015	.002	.003	.004	.005	.006	-	-
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - 300 SERIES	135 - 375	-	-	-	-	-	-	-	-	-	-
	STAINLESS STEEL - PH SERIES	150 - 440	-	-	-	-	-	-	-	-	-	-
	TITANIUM ALLOY	110 - 380	-	-	-	-	-	-	-	-	-	-

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SOLID CARBIDE JOBBERS LENGTH TWIST DRILLS

TYPE 3860 - JOBBERS LENGTH - 118° POINT

Solid Carbide 20°-25° Helix jobbers drill manufactured with sub micrograin C2 carbide for general purpose drilling of non-ferrous alloys, cast iron, plastics, aluminum, steel, and highly abrasive materials. Chisel point centrality is within .001.



Tool diameter tolerance: +.0000 / -.0005
Included angle tolerance: +/- 2°
Lip Height TIV: +.0015 / -.0015
Metric tolerance: h7

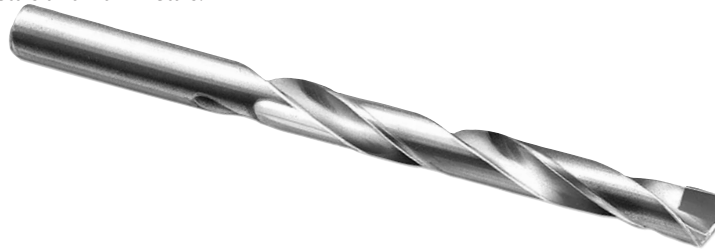
TOOL DIAMETER		LENGTH		TYPE 3860 EDP NO.	PRICE EACH	TOOL DIAMETER		LENGTH		TYPE 3860 EDP NO.	PRICE EACH	TOOL DIAMETER		LENGTH		TYPE 3860 EDP NO.	PRICE EACH
DEC.	FRAC./mm WIRE/LTR	FLT	OAL			DEC.	FRAC./mm WIRE/LTR	FLT	OAL			DEC.	FRAC./mm WIRE/LTR	FLT	OAL		
.0312	1/32	1/2	1 1/2	3860002	\$14.15	.1285	30	1 1/4	2 1/4	38601285	\$18.60	.2570	F	2	3 1/4	38602570	\$44.50
.0320	.67	1/2	1 1/2	386000320	14.15	.1360	29	1 3/8	2 1/2	38601360	18.85	.2610	G	2 1/8	3 1/2	38602610	45.20
.0330	.66	1/2	1 1/2	386000330	14.15	.1378	3.5mm	34	63	38600035	21.65	.2656	7/64	2 1/8	3 1/2	386017	39.75
.0350	.65	5/8	1 1/2	386000350	14.15	.1405	28	1 3/8	2 1/2	38601405	19.25	.2660	H	2 1/8	3 1/2	38602660	46.50
.0360	.64	5/8	1 1/2	386000360	14.15	.1406	3/64	1 3/8	2 1/2	386009	20.65	.2720	I	2 1/8	3 1/2	38602720	47.40
.0370	.63	5/8	1 1/2	386000370	14.15	.1440	27	1 3/8	2 1/2	38601440	20.00	.2756	7.0mm	54	89	3860070	53.00
.0380	.62	5/8	1 1/2	386000380	14.15	.1470	26	1 3/8	2 1/2	38601470	20.45	.2770	J	2 1/8	3 1/2	38602770	48.50
.0390	.61	5/8	1 1/2	386000390	14.15	.1495	25	1 3/8	2 1/2	38601495	20.50	.2810	K	2 1/8	3 1/2	38602810	48.95
.0394	1.0mm	19	38	38600010	16.95	.1520	24	1 3/8	2 1/2	38601520	21.15	.2812	3/32	2 1/8	3 1/2	386018	42.90
.0400	.60	3/4	1 1/2	38600400	14.15	.1540	23	1 3/8	2 1/2	38601540	21.90	.2900	L	2 1/8	3 1/2	38602900	51.30
.0410	.59	3/4	1 1/2	38600410	14.15	.1562	3/32	1 3/8	2 1/2	386010	21.65	.2950	M	2 3/8	3 3/4	38602950	53.05
.0420	.58	3/4	1 1/2	38600420	14.15	.1570	22	1 3/8	2 1/2	38601570	23.30	.2953	7.5mm	60	95	3860075	57.80
.0430	.57	3/4	1 1/2	38600430	14.15	.1575	4.0mm	34	63	3860040	25.85	.2969	19/64	2 3/8	3 3/4	386019	48.80
.0465	.56	3/4	1 1/2	38600465	14.15	.1590	21	1 3/8	2 1/2	38601590	23.60	.3020	N	2 3/8	3 3/4	38603020	56.30
.0469	3/64	3/4	1 1/2	386003	14.15	.1610	20	1 3/8	2 1/2	38601610	23.80	.3125	5/16	2 3/8	3 3/4	386020	51.85
.0520	.55	3/4	1 1/2	38600520	14.15	.1660	19	1 5/8	2 3/4	38601660	24.70	.3150	8.0mm	60	95	3860080	58.80
.0550	.54	3/4	1 1/2	38600550	14.15	.1695	18	1 5/8	2 3/4	38601695	24.90	.3160	O	2 3/8	3 3/4	38603160	59.55
.0591	1.5mm	19	38	38600015	16.85	.1719	17/64	1 5/8	2 3/4	386011	25.40	.3230	P	2 3/8	3 3/4	38603230	61.55
.0595	.53	3/4	1 1/2	38600595	14.15	.1730	17	1 5/8	2 3/4	38601730	25.40	.3281	21/64	2 1/2	4	386021	56.50
.0625	1/16	3/4	1 1/2	386004	13.35	.1770	16	1 5/8	2 3/4	38601770	25.85	.3320	Q	2 1/2	4	38603320	65.30
.0635	.52	3/4	1 1/2	38600635	14.15	.1772	4.5mm	41	70	3860045	28.65	.3346	8.5mm	63	101	3860085	69.70
.0670	.51	3/4	1 1/2	38600670	14.15	.1800	15	1 5/8	2 3/4	38601800	26.05	.3390	R	2 1/2	4	38603390	67.35
.0700	.50	7/8	1 3/4	38600700	14.50	.1820	14	1 5/8	2 3/4	38601820	25.90	.3438	11/32	2 1/2	4	386022	62.65
.0730	.49	7/8	1 3/4	38600730	14.90	.1850	13	1 5/8	2 3/4	38601850	26.45	.3480	S	2 1/2	4	38603480	74.00
.0760	.48	7/8	1 3/4	38600760	15.10	.1875	3/16	1 5/8	2 3/4	386012	25.50	.3543	9.0mm	70	108	3860090	79.40
.0781	5/64	7/8	1 3/4	386005	14.85	.1890	12	1 5/8	2 3/4	38601890	26.90	.3580	T	2 3/4	4 1/4	38603580	76.60
.0785	.47	7/8	1 3/4	38600785	15.10	.1910	11	1 5/8	2 3/4	38601910	27.35	.3594	23/64	2 3/4	4 1/4	386023	68.30
.0787	2.0mm	22	44	3860020	17.90	.1935	10	1 5/8	2 3/4	38601935	27.80	.3680	U	2 3/4	4 1/4	38603680	78.10
.0810	.46	7/8	1 3/4	38600810	15.10	.1960	9	1 3/4	3	38601960	28.40	.3740	9.5mm	70	108	3860095	82.20
.0820	.45	7/8	1 3/4	38600820	15.35	.1969	5.0mm	44	76	3860050	31.90	.3750	3/8	2 3/4	4 1/4	386024	74.15
.0860	.44	1	2	38600860	15.95	.1990	8	1 3/4	3	38601990	29.10	.3770	V	2 3/4	4 1/4	38603770	86.25
.0890	.43	1	2	38600890	15.95	.2010	7	1 3/4	3	38602010	29.45	.3860	W	2 7/8	4 1/2	38603860	91.40
.0935	.42	1	2	38600935	16.05	.2031	13/64	1 3/4	3	386013	31.10	.3906	25/64	2 7/8	4 1/2	386025	83.85
.0938	3/32	1	2	386006	15.25	.2040	6	1 3/4	3	38602040	30.65	.3937	10.0mm	73	114	3860100	97.70
.0960	.41	1	2	38600960	16.10	.2055	5	1 3/4	3	38602055	31.10	.3970	X	2 7/8	4 1/2	38603670	98.90
.0980	.40	1	2	38600980	16.25	.2090	4	1 3/4	3	38602090	31.85	.4040	Y	2 7/8	4 1/2	38604040	98.20
.0984	2.5mm	25	50	3860025	18.50	.2130	3	1 3/4	3	38602130	32.70	.4062	13/32	2 7/8	4 1/2	386026	93.05
.0995	.39	1 1/4	2 1/4	38600995	16.40	.2165	5.5mm	44	76	3860055	36.05	.4130	Z	2 7/8	4 1/2	38604130	108.45
.1015	.38	1 1/4	2 1/4	38601015	16.45	.2188	7/32	1 3/4	3	386014	32.15	.4134	10.5mm	73	114	3860105	111.95
.1040	.37	1 1/4	2 1/4	38601040	16.45	.2210	2	1 3/4	3	38602210	33.95	.4219	27/64	2 7/8	4 1/2	386027	101.80
.1065	.36	1 1/4	2 1/4	38601065	16.45	.2280	1	1 3/4	3	38602280	35.75	.4331	11.0mm	73	114	3860110	124.80
.1094	7/64	1 1/4	2 1/4	386007	16.75	.2340	A	2	3 1/4	38602340	39.60	.4375	7/16	2 7/8	4 1/2	386028	110.25
.1100	.35	1 1/4	2 1/4	38601100	16.75	.2344	15/64	2	3 1/4	386015	35.65	.4528	11.5mm	76	120	3860115	136.30
.1110	.34	1 1/4	2 1/4	38601110	17.20	.2362	6.0mm	51	82	3860060	39.90	.4531	29/64	3	4 3/4	386029	119.40
.1130	.33	1 1/4	2 1/4	38601130	17.20	.2380	B	2	3 1/4	38602380	40.65	.4688	15/32	3	4 3/4	386030	128.60
.1160	.32	1 1/4	2 1/4	38601160	17.65	.2420	C	2	3 1/4	38602420	40.80	.4724	12.0mm	76	120	3860120	144.95
.1181	3.0mm	31	57	3860030	20.50	.2460	D	2	3 1/4	38602460	41.95	.4844	31/64	3	4 3/4	386031	132.35
.1200	.31	1 1/4	2 1/4	38601200	17.85	.2500	E	2	3 1/4	386016	36.35	.4921	12.5mm	76	120	3860125	160.95
.1250	1/8	1 1/4	2 1/4	386008	17.45	.2559	6.5mm	51	82	3860065	47.30	.5000	1/2	3	4 3/4	386032	135.75

CARBIDE TIPPED JOBBERS LENGTH TWIST DRILLS

TYPE 3600 - JOBBERS LENGTH - 118° POINT
TYPE 3601 - JOBBERS LENGTH - 135° SPLIT POINT

Carbide tip brazed to hardened tool steel bodies.

Smooth flutes for effective chip flow. Precision ground to insure concentricity of tip & body. For drilling cast iron, non-ferrous metals and non-metals. (Not usually recommended for drilling steel.)



Overall length tolerance: +1/4"/-1/8".

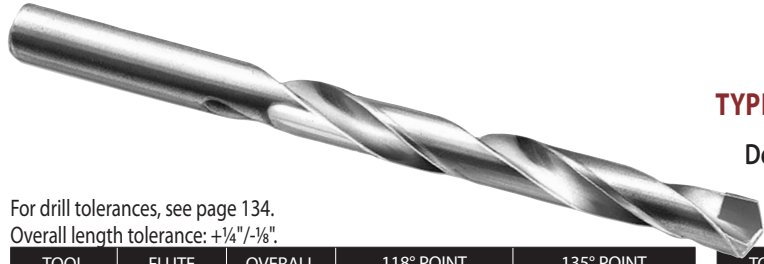
For drill tolerances, see page 134.

For smaller sizes and solid carbide drills see page 111.

TOOL DIAMETER			LENGTH		118° POINT		135° POINT		TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH	DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH
.1160		32	1 5/8	2 3/4	360232	\$15.35	360332	\$18.00	.2720		I	2 7/8	4 1/8	360409	\$22.90	360509	\$26.45
.1200		31	1 5/8	2 3/4	360231	13.80	360331	16.10	.2770		J	2 7/8	4 1/8	360410	23.40	360510	27.10
.1250	1/8		1 5/8	2 3/4	360008	14.20	360108	16.60	.2810		K	2 15/16	4 1/4	360411	23.40	360511	27.10
.1285		30	1 5/8	2 3/4	360230	14.50	360330	16.80	.2812	9/32		2 15/16	4 1/4	360018	22.25	360118	25.80
.1360		29	1 3/4	2 7/8	360229	15.00	360329	17.30	.2900		L	2 15/16	4 1/4	360412	23.40	360512	27.10
.1405		28	1 3/4	2 7/8	360228	15.10	360328	17.65	.2950		M	3 1/16	4 3/8	360413	25.75	360513	29.95
.1406	9/64		1 3/4	2 7/8	360009	15.35	360109	17.90	.2969	19/64		3 1/16	4 3/8	360019	24.65	360119	28.55
.1440		27	1 7/8	3	360227	15.55	360327	18.05	.3020		N	3 1/16	4 3/8	360414	25.15	360514	29.25
.1470		26	1 7/8	3	360226	14.40	360326	16.80	.3125	5/16		3 3/16	4 1/2	360020	24.10	360120	28.00
.1495		25	1 7/8	3	360225	14.40	360325	16.80	.3160		O	3 3/16	4 1/2	360415	24.80	360515	28.60
.1520		24	2	3 1/8	360224	15.55	360324	18.05	.3230		P	3 3/16	4 5/8	360416	26.40	360516	30.60
.1540		23	2	3 1/8	360223	15.10	360323	17.65	.3281	21/64		3 3/16	4 5/8	360021	25.55	360121	29.75
.1562	5/32		2	3 1/8	360010	15.05	360110	17.65	.3320		Q	3 7/16	4 3/4	360417	26.95	360517	31.35
.1570		22	2	3 1/8	360222	16.75	360322	19.45	.3390		R	3 7/16	4 3/4	360418	26.40	360518	30.60
.1590		21	2 1/8	3 1/4	360221	15.95	360321	18.60	.3438	11/32		3 7/16	4 3/4	360022	25.55	360122	29.75
.1610		20	2 1/8	3 1/4	360220	16.45	360320	19.05	.3480		S	3 1/2	4 7/8	360419	28.40	360519	33.05
.1660		19	2 1/8	3 1/4	360219	16.45	360319	19.05	.3580		T	3 1/2	4 7/8	360420	29.00	360520	33.75
.1695		18	2 1/8	3 1/4	360218	16.45	360318	19.05	.3594	23/64		3 1/2	4 7/8	360023	27.20	360123	31.65
.1719	11/64		2 1/8	3 1/4	360011	16.45	360111	19.05	.3680		U	3 5/8	5	360421	27.85	360521	32.35
.1730		17	2 3/16	3 3/8	360217	16.45	360317	19.05	.3750	3/8		3 5/8	5	360024	27.20	360124	31.65
.1770		16	2 3/16	3 3/8	360216	15.95	360316	18.60	.3770		V	3 5/8	5	360422	28.40	360522	33.05
.1800		15	2 3/16	3 3/8	360215	16.75	360315	19.45	.3860		W	3 3/4	5 1/8	360423	31.20	360523	36.10
.1820		14	2 3/16	3 3/8	360214	15.95	360314	18.60	.3906	25/64		3 3/4	5 1/8	360025	29.60	360125	34.45
.1850		13	2 3/16	3 1/2	360213	17.65	360313	18.60	.3970		X	3 3/4	5 1/8	360424	29.90	360524	34.65
.1875	3/16		2 3/16	3 1/2	360012	15.95	360112	18.60	.4040		Y	3 7/8	5 1/4	360425	31.20	360525	36.10
.1890		12	2 5/16	3 1/2	360212	18.40	360312	19.45	.4062	13/32		3 7/8	5 1/4	360026	29.60	360126	34.45
.1910		11	2 5/16	3 1/2	360211	17.00	360311	19.65	.4130		Z	3 7/8	5 1/4	360426	34.50	360526	40.00
.1935		10	2 7/16	3 5/8	360210	16.75	360310	19.45	.4219	27/64		3 15/16	5 3/8	360027	32.20	360127	37.40
.1960		9	2 7/16	3 5/8	360209	17.00	360309	19.65	.4375	7/16		4 1/16	5 1/2	360028	32.20	360128	37.40
.1990		8	2 7/16	3 5/8	360208	17.00	360308	19.65	.4531	29/64		4 3/16	5 5/8	360029	36.95	360129	42.85
.2010		7	2 7/16	3 5/8	360207	17.00	360307	19.65	.4688	15/32		4 5/16	5 3/4	360030	36.20	360130	41.95
.2031	13/64		2 7/16	3 5/8	360013	17.60	360113	20.30	.4844	31/64		4 3/8	5 7/8	360031	40.45	360131	47.00
.2040		6	2 1/2	3 3/4	360206	17.35	360306	20.20	.5000	1/2		4 1/2	6	360032	44.50	360132	47.00
.2055		5	2 1/2	3 3/4	360205	17.60	360305	19.65	.5156	33/64		4 13/16	6 5/8	360033	57.95	360133	67.35
.2090		4	2 1/2	3 3/4	360204	17.35	360304	20.20	.5312	17/32		4 13/16	6 5/8	360034	57.95	360134	67.35
.2130		3	2 1/2	3 3/4	360203	17.60	360303	19.65	.5469	35/64		4 13/16	6 5/8	360035	58.50	360135	67.90
.2188	7/32		2 1/2	3 3/4	360014	17.60	360114	20.30	.5625	9/16		4 13/16	6 5/8	360036	58.50	360136	67.90
.2210		2	2 5/8	3 7/8	360202	18.25	360302	21.20	.5781	37/64		4 13/16	6 5/8	360037	64.60	360137	75.10
.2280		1	2 5/8	3 7/8	360201	18.00	360301	20.85	.5938	19/32		5 3/16	7 1/8	360038	62.80	360138	72.95
.2340		A	2 5/8	3 7/8	360401	19.90	360501	23.00	.6094	39/64		5 3/16	7 1/8	360039	74.25	360139	86.20
.2344	15/64		2 5/8	3 7/8	360015	18.90	360115	22.00	.6250	5/8		5 3/16	7 1/8	360040	71.20	360140	82.55
.2380		B	2 3/4	4	360402	19.90	360502	23.00	.6406	41/64		5 3/16	7 1/8	360041	82.10	360141	95.35
.2420		C	2 3/4	4	360403	19.90	360503	23.00	.6562	21/32		5 3/16	7 1/8	360042	72.35	360142	84.00
.2460		D	2 3/4	4	360404	19.40	360504	22.60	.6719	43/64		5 5/8	7 5/8	360043	94.15	360143	109.40
.2500	1/4	E	2 3/4	4	360016	18.90	360116	22.00	.6875	11/16		5 5/8	7 5/8	360044	73.80	360144	85.60
.2570	1/47	F	2 7/8	4 1/8	360406	22.35	360506	25.90	.7031	45/64		5 5/8	7 5/8	360045	86.20	360145	95.90
.2610		G	2 7/8	4 1/8	360407	22.90	360507	26.45	.7188	23/32		5 5/8	7 5/8	360046	87.10	360146	96.80
.2656	17/64		2 7/8	4 1/8	360017	21.00	360117	24.00	.7344	47/64		5 5/8	7 5/8	360047	87.60	360147	97.40
.2660		H	2 7/8	4 1/8	360408	23.40	360508	27.10	.7500	3/4		5 13/16	8	360048	88.90	360148	98.80

CARBIDE TIPPED JOBBERS LENGTH TWIST DRILLS

METRIC



TYPE 3600 - JOBBERS LENGTH - 118° POINT
TYPE 3601 - JOBBERS LENGTH - 135° SPLIT POINT

Detailed description and fractional sizes on page 112.
 (Not usually recommended for steel.)

For drill tolerances, see page 134.
 Overall length tolerance: $+\frac{1}{4}"/-\frac{1}{8}"$.

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH	mm	INCH	mm	INCH	TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH
3.0	.1181	41	1 5/8	70	2 3/4	3600030	19.10	3601030	\$19.50
3.1	.1220	41	1 5/8	70	2 3/4	3600031	19.95	3601031	20.25
3.2	.1260	41	1 5/8	70	2 3/4	3600032	19.95	3601032	20.25
3.3	.1299	44	1 3/4	73	2 7/8	3600033	19.95	3601033	20.25
3.4	.1339	44	1 3/4	73	2 7/8	3600034	19.95	3601034	20.25
3.5	.1378	44	1 3/4	73	2 7/8	3600035	18.40	3601035	19.10
3.6	.1417	48	1 7/8	76	3	3600036	19.10	3601036	19.50
3.7	.1457	48	1 7/8	76	3	3600037	19.10	3601037	19.50
3.8	.1496	48	1 7/8	76	3	3600038	19.10	3601038	19.50
3.9	.1535	51	2	79	3 1/8	3600039	19.10	3601039	19.50
4.0	.1575	54	2 1/8	83	3 1/4	3600040	18.00	3601040	18.40
4.1	.1614	54	2 1/8	83	3 1/4	3600041	17.30	3601041	19.65
4.2	.1654	54	2 1/8	83	3 1/4	3600042	18.40	3601042	19.65
4.3	.1693	54	2 1/8	83	3 1/4	3600043	18.40	3601043	19.65
4.4	.1732	56	2 3/16	86	3 3/8	3600044	18.40	3601044	19.65
4.5	.1772	56	2 3/16	86	3 3/8	3600045	19.10	3601045	19.65
4.6	.1811	56	2 3/16	86	3 3/8	3600046	20.80	3601046	21.05
4.7	.1850	59	2 5/16	89	3 1/2	360213	17.65	360313	18.60
4.8	.1890	59	2 5/16	89	3 1/2	360212	18.40	360312	19.45
4.9	.1929	62	2 7/16	92	3 5/8	3600049	20.80	3601049	21.05
5.0	.1969	62	2 7/16	92	3 5/8	3600050	19.95	3601050	20.50
5.1	.2008	62	2 7/16	92	3 5/8	3600051	21.60	3601051	21.95
5.2	.2047	64	2 1/2	95	3 3/4	3600052	21.60	3601052	21.95
5.3	.2087	64	2 1/2	95	3 3/4	3600053	21.60	3601053	21.95
5.4	.2126	64	2 1/2	95	3 3/4	3600054	21.60	3601054	21.95
5.5	.2165	64	2 1/2	95	3 3/4	3600055	21.20	3601055	21.40
5.6	.2205	67	2 5/8	98	3 7/8	3600056	22.25	3601056	22.70
5.7	.2244	67	2 5/8	98	3 7/8	3600057	22.25	3601057	22.70
5.8	.2283	67	2 5/8	98	3 7/8	3600058	22.25	3601058	22.70
5.9	.2323	67	2 5/8	98	3 7/8	3600059	22.25	3601059	22.70
6.0	.2362	70	2 3/4	102	4	3600060	22.00	3601060	23.20
6.1	.2402	70	2 3/4	102	4	3600061	23.25	3601061	23.85
6.2	.2441	70	2 3/4	102	4	3600062	23.25	3601062	23.85
6.3	.2480	70	2 3/4	102	4	3600063	23.25	3601063	23.85
6.4	.2520	73	2 7/8	105	4 1/8	3600064	23.25	3601064	23.85
6.5	.2559	73	2 7/8	105	4 1/8	3600065	22.75	3601065	23.20
6.6	.2598	73	2 7/8	105	4 1/8	3600066	24.30	3601066	27.25
6.7	.2638	73	2 7/8	105	4 1/8	3600067	24.30	3601067	27.25
6.8	.2677	73	2 7/8	105	4 1/8	3600068	24.30	3601068	27.25
6.9	.2717	73	2 7/8	105	4 1/8	3600069	24.30	3601069	27.25
7.0	.2756	73	2 7/8	105	4 1/8	3600070	23.80	3601070	27.25
7.1	.2795	75	2 15/16	108	4 1/4	3600071	24.90	3601071	27.25
7.2	.2835	75	2 15/16	108	4 1/4	3600072	24.90	3601072	27.25
7.3	.2874	75	2 15/16	108	4 1/4	3600073	24.90	3601073	27.25
7.4	.2913	78	3 1/16	111	4 3/8	3600074	24.90	3601074	29.50
7.5	.2953	78	3 1/16	111	4 3/8	3600075	24.90	3601075	29.50
7.6	.2992	78	3 1/16	111	4 3/8	3600076	26.10	3601076	29.50
7.7	.3031	81	3 3/16	114	4 1/2	3600077	26.10	3601077	29.50
7.8	.3071	81	3 3/16	114	4 1/2	3600078	26.10	3601078	29.50
7.9	.3110	81	3 3/16	114	4 1/2	3600079	26.10	3601079	29.50
8.0	.3150	81	3 3/16	114	4 1/2	3600080	25.50	3601080	29.50
8.1	.3189	84	3 5/16	117	4 5/8	3600081	27.85	3601081	31.40
8.2	.3228	84	3 5/16	117	4 5/8	3600082	27.85	3601082	31.40
8.3	.3268	84	3 5/16	117	4 5/8	3600083	27.85	3601083	31.40
8.4	.3307	87	3 7/16	121	4 3/4	3600084	27.85	3601084	31.40
8.5	.3346	87	3 7/16	121	4 3/4	3600085	26.65	3601085	31.40
8.6	.3386	87	3 7/16	121	4 3/4	3600086	27.85	3601086	31.40

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH	mm	INCH	mm	INCH	TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH
8.7	.3425	87	3 7/16	121	4 3/4	3600087	\$27.85	3601087	\$31.40
8.8	.3465	89	3 1/2	124	4 7/8	3600088	27.85	3601088	31.40
8.9	.3504	89	3 1/2	124	4 7/8	3600089	27.85	3601089	33.35
9.0	.3543	89	3 1/2	124	4 7/8	3600090	27.20	3601090	33.35
9.1	.3583	89	3 1/2	124	4 7/8	3600091	30.20	3601091	33.35
9.2	.3622	92	3 5/8	127	5	3600092	30.20	3601092	33.35
9.3	.3661	92	3 5/8	127	5	3600093	30.20	3601093	33.35
9.4	.3701	92	3 5/8	127	5	3600094	30.20	3601094	33.35
9.5	.3740	92	3 5/8	127	5	3600095	29.60	3601095	33.35
9.6	.3780	95	3 3/4	130	5 1/8	3600096	30.65	3601096	36.45
9.7	.3819	95	3 3/4	130	5 1/8	3600097	30.65	3601097	36.45
9.8	.3858	95	3 3/4	130	5 1/8	3600098	30.65	3601098	36.45
9.9	.3898	95	3 3/4	130	5 1/8	3600099	30.65	3601099	36.45
10.0	.3937	95	3 3/4	130	5 1/8	3601000	30.65	3601100	36.45
10.1	.3976	98	3 7/8	133	5 1/4	3600101	36.55	3601101	37.50
10.2	.4016	98	3 7/8	133	5 1/4	3600102	36.55	3601102	37.50
10.3	.4055	98	3 7/8	133	5 1/4	3600103	36.55	3601103	37.50
10.4	.4094	98	3 7/8	133	5 1/4	3600104	36.55	3601104	39.30
10.5	.4134	98	3 7/8	133	5 1/4	3600105	35.35	3601105	39.30
10.6	.4173	100	3 15/16	137	5 3/8	3600106	40.05	3601106	40.70
10.7	.4213	100	3 15/16	137	5 3/8	3600107	40.05	3601107	40.70
10.8	.4252	103	4 1/16	140	5 1/2	3600108	40.05	3601108	40.70
10.9	.4291	103	4 1/16	140	5 1/2	3600109	40.05	3601109	40.70
11.0	.4331	103	4 1/16	140	5 1/2	3600110	38.30	3601110	39.30
11.1	.4370	103	4 1/16	140	5 1/2	3600111	44.65	3601111	45.35
11.2	.4409	106	4 3/16	143	5 5/8	3600112	44.65	3601112	45.70
11.3	.4449	106	4 3/16	143	5 5/8	3600113	44.65	3601113	45.70
11.4	.4488	106	4 3/16	143	5 5/8	3600114	44.65	3601114	44.35
11.5	.4528	106	4 3/16	143	5 5/8	3600115	42.90	3601115	44.35
11.6	.4567	110	4 5/16	146	5 3/4	3600116	48.65	3601116	49.40
11.7	.4606	110	4 5/16	146	5 3/4	3600117	48.65	3601117	49.40
11.8	.4646	110	4 5/16	146	5 3/4	3600118	48.65	3601118	49.40
11.9	.4685	110	4 5/16	146	5 3/4	3600119	48.65	3601119	49.40
12.0	.4724	111	4 3/8	149	5 7/8	3600120	46.50	3601120	49.65
12.1	.4764	111	4 3/8	149	5 7/8	3600121	50.60	3601121	51.30
12.2	.4803	111	4 3/8	149	5 7/8	3600122	50.60	3601122	51.30
12.3	.4843	111	4 3/8	149	5 7/8	3600123	50.60	3601123	51.30
12.4	.4882	114	4 1/2	152	6	3600124	50.60	3601124	51.30
12.5	.4921	114	4 1/2	152	6	3600125	48.20	3601125	49.65
12.6	.4961	114	4 1/2	152	6	3600126	52.35	3601126	53.05
12.7	.5000	114	4 1/2	152	6	360032	44.50	360132	47.00
12.8	.5039	114	4 1/2	152	6	3600128	57.45	3601128	73.20
12.9	.5079	114	4 1/2	152	6	3600129	57.45	3601129	73.20
13.0	.5118	114	4 1/2	152	6	3600130	57.45	3601130	73.20
13.5	.5315	122	4 13/16	168	6 5/8	3600135	74.35	3601135	80.20
14.0	.5512	122	4 13/16	168	6 5/8	3600140	78.80	3601140	85.10
14.5	.5709	122	4 13/16	168	6 5/8	3600145	84.55	3601145	91.45
15.0	.5906	132	5 3/16	181	7 1/8	3600150	84.55	3601150	91.45
15.5	.6102	132	5 3/16	181	7 1/8	3600155	85.70	3601155	92.50
16.0	.6299	132	5 3/16	181	7 1/8	3600160	87.25	3601160	94.15
16.5	.6496	132	5 3/16	181	7 1/8	3600165	87.25	3601165	94.15
17.0	.6693	143	5 5/8	194	7 5/8	3600170	90.60	3601170	97.90
17.5	.6890	143	5 5/8	194	7 5/8	3600175	90.60	3601175	97.90
18.0	.7087	143	5 5/8	194	7 5/8	3600180	91.60	3601180	98.80
18.5	.7283	143	5 5/8	194	7 5/8	3600185	92.10	3601185	99.45
19.0	.7480	148	5 13/16	203	8	3600190	93.30	3601190	100.85

CARBIDE TIPPED TANGED JOBBERS LENGTH TWIST DRILLS

TYPE 3690 - TANGED JOBBERS LENGTH - 118° POINT

TYPE 3691 - TANGED JOBBERS LENGTH - 135° SPLIT POINT

Same as Types 3600 and 3601 on page 112, except all tools are tanged.
 Designed for applications requiring ASA split sleeve drill drivers.
 (Not usually recommended for steel.)

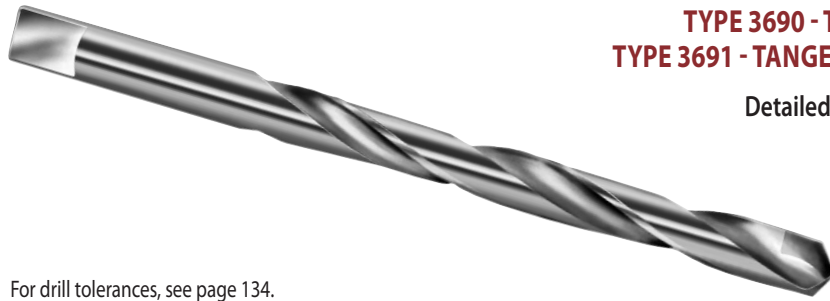


For drill tolerances, see page 134.
 Overall length tolerance: $\pm 1/4'' - 1/8''$.

TOOL DIAMETER		WIRE LETTER	LENGTH		118° POINT		135° POINT		TOOL DIAMETER		WIRE LETTER	LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION		FLUTE	OVER-ALL	TYPE 3690 EDP NO.	PRICE EACH	TYPE 3691 EDP NO.	PRICE EACH	DECIMAL	FRACTION		FLUTE	OVER-ALL	TYPE 3690 EDP NO.	PRICE EACH	TYPE 3691 EDP NO.	PRICE EACH
.1250	1/8	30	1 5/8	2 3/4	369008	\$16.25	369108	\$19.10	.2770	J	2 7/8	4 1/8	369410	\$26.85	369510	\$31.15	
.1285	3/32		1 5/8	2 3/4	369230	16.65	369330	19.30	.2810		K	2 15/16	4 1/4	369411	26.90	369511	31.15
.1360			29	1 3/4	2 7/8	369229	17.25	369329	19.90			.2812	L	2 15/16	4 1/4	369018	25.65
.1405	1/16	28	1 3/4	2 7/8	369228	17.35	369328	20.35	.2900	M	2 15/16	4 1/4		369412	26.85	369512	31.15
.1406		27	1 3/4	2 7/8	369009	17.65	369109	20.60	.2950		N	3 1/16		4 3/8	369413	29.60	369513
.1440	5/64	26	1 7/8	3	369227	17.85	369327	20.80	.2969	O		3 1/16	4 3/8	369019	28.40	369119	32.80
.1470		25	1 7/8	3	369226	16.60	369326	19.30	.3020			P	3 1/16	4 3/8	369414	28.90	369514
.1495	3/32	24	2	3 1/8	369224	17.85	369324	20.80	.3125	Q	3 3/16		4 1/2	369020	27.70	369120	32.20
.1520		23	2	3 1/8	369223	17.40	369323	20.35	.3160		R		3 3/16	4 1/2	369415	28.50	369515
.1540	1/16	22	2	3 1/8	369010	17.30	369110	20.35	.3230	S		3 5/16	4 5/8	369416	30.40	369516	35.20
.1562		21	2 1/8	3 1/4	369221	18.35	369321	21.40	.3281			T	3 5/16	4 5/8	369021	29.40	369121
.1570	5/32	20	2 1/8	3 1/4	369220	18.90	369320	21.95	.3320	U	3 7/16		4 3/4	369417	31.00	369517	36.05
.1590		19	2 1/8	3 1/4	369219	18.90	369319	21.95	.3390		V		3 7/16	4 3/4	369418	30.40	369518
.1660	3/16	18	2 1/8	3 1/4	369218	18.90	369318	21.95	.3438	W		3 7/16	4 3/4	369022	29.40	369122	34.25
.1695		17	2 1/8	3 1/4	369011	18.90	369111	21.95	.3480			X	3 1/2	4 7/8	369419	32.70	369519
.1719	1/8	16	2 3/16	3 3/8	369217	18.90	369317	21.95	.3580	Y	3 1/2		4 7/8	369420	33.30	369520	38.80
.1730		15	2 3/16	3 3/8	369216	18.35	369316	21.40	.3594		Z		3 1/2	4 7/8	369023	31.25	369123
.1770	5/32	14	2 3/16	3 3/8	369214	18.35	369314	21.40	.3680	Z		3 5/8	5	369421	32.10	369521	37.15
.1800		13	2 5/16	3 1/2	369213	20.40	369313	21.40	.3750			Z	3 5/8	5	369024	31.25	369124
.1820	3/16	12	2 5/16	3 1/2	369012	18.35	369112	21.40	.3770	Z	3 5/8		5	369422	32.70	369522	38.05
.1850		11	2 5/16	3 1/2	369212	21.15	369312	22.45	.3860		Z		3 3/4	5 1/8	369423	35.90	369523
.1875	7/32	10	2 5/16	3 1/2	369011	18.90	369111	21.95	.3906	Z		3 3/4	5 1/8	369025	34.00	369125	39.60
.1890		9	2 7/16	3 3/8	369211	19.55	369311	22.65	.3970			Z	3 3/4	5 1/8	369424	34.35	369524
.1910	1/8	8	2 7/16	3 3/8	369208	19.55	369308	22.65	.4040	Z	3 7/8		5 1/4	369425	35.90	369525	41.50
.1935		7	2 7/16	3 3/8	369207	19.55	369307	22.65	.4062		Z		3 7/8	5 1/4	369026	34.00	369126
.1960	5/32	6	2 7/16	3 3/8	369010	20.25	369110	21.40	.4130	Z		3 7/8	5 1/4	369426	39.65	369526	46.00
.1990		5	2 1/2	3 3/4	369206	19.95	369306	23.25	.4219			Z	3 15/16	5 3/8	369027	37.05	369127
.2010	3/16	4	2 1/2	3 3/4	369205	20.30	369305	22.65	.4375	Z	4 1/16		5 1/2	369028	37.05	369128	43.00
.2031		3	2 1/2	3 3/4	369204	19.95	369304	23.25	.4531		Z		4 3/16	5 5/8	369029	42.50	369129
.2040	7/32	2	2 1/2	3 3/4	369014	20.25	369114	23.45	.4688	Z		4 3/16	5 5/8	369030	41.65	369130	48.25
.2055		1	2 5/8	3 7/8	369201	20.70	369301	24.00	.4844			Z	4 3/8	5 7/8	369031	46.50	369131
.2090	1/8	A	2 5/8	3 7/8	369401	22.90	369501	26.50	.5000	Z	4 1/2		6	369032	51.15	369132	54.05
.2130		2	2 5/8	3 7/8	369202	21.05	369302	24.35	.5156		Z		4 1/2	6	369427	47.25	369527
.2188	5/32	1	2 5/8	3 7/8	369201	20.70	369301	24.00	.5312	Z		4 13/16	6 5/8	369033	66.65	369133	77.45
.2210		1	2 5/8	3 7/8	369201	20.70	369301	24.00	.5469			Z	4 13/16	6 5/8	369034	66.65	369134
.2280	3/16	A	2 5/8	3 7/8	369401	22.90	369501	26.50	.5625	Z	4 13/16		6 5/8	369035	67.25	369135	78.20
.2340		2	2 1/2	3 3/4	369014	20.25	369114	23.45	.5781		Z		4 13/16	6 5/8	369036	67.25	369136
.2344	1/8	B	2 3/4	4	369402	22.90	369502	26.50	.5938	Z		4 13/16	6 5/8	369037	74.25	369137	86.40
.2380		1	2 5/8	3 7/8	369201	20.70	369301	24.00	.6094			Z	5 3/16	7 1/8	369038	72.30	369138
.2420	5/32	C	2 3/4	4	369403	22.90	369503	26.50	.6250	Z	5 3/16		7 1/8	369039	85.35	369139	99.10
.2460		3	2 1/2	3 3/4	369203	20.30	369303	22.65	.6406		Z		5 3/16	7 1/8	369040	81.90	369140
.2500	7/32	D	2 3/4	4	369404	22.35	369504	25.85	.6562	Z		5 3/16	7 1/8	369041	94.45	369141	109.60
.2570		2	2 1/2	3 3/4	369014	20.25	369114	23.45	.6719			Z	5 3/16	7 1/8	369042	83.25	369142
.2610	1/8	E	2 3/4	4	369016	21.75	369116	25.25	.6875	Z	5 3/8		7 5/8	369043	108.40	369143	125.80
.2656		1	2 5/8	3 7/8	369201	20.70	369301	24.00	.7031		Z		5 3/8	7 5/8	369044	84.85	369144
.2660	5/32	F	2 7/8	4 1/8	369406	25.65	369506	29.90	.7188	Z		5 3/8	7 5/8	369045	99.20	369145	110.25
.2720		1	2 7/8	4 1/8	369407	26.30	369507	30.45	.7344			Z	5 3/8	7 5/8	369046	100.20	369146
.2720	3/16	G	2 7/8	4 1/8	369407	26.30	369507	30.45	.7500	Z	5 3/8		7 5/8	369047	100.75	369147	112.00
.2720		1	2 7/8	4 1/8	369408	26.85	369508	31.15	.7500		Z		5 3/8	7 5/8	369048	102.35	369148
.2720	7/32	H	2 7/8	4 1/8	369408	26.85	369508	31.15	.7500	Z		5 3/8	7 5/8	369048	102.35	369148	113.70
.2720		1	2 7/8	4 1/8	369409	26.30	369509	30.45	.7500			Z	5 13/16	8	369048	102.35	369148

CARBIDE TIPPED TANGED JOBBERS LENGTH TWIST DRILLS

METRIC



TYPE 3690 - TANGED JOBBERS LENGTH - 118° POINT
TYPE 3691 - TANGED JOBBERS LENGTH - 135° SPLIT POINT

Detailed description and fractional sizes on page 114.
 (Not usually recommended for steel.)

For drill tolerances, see page 134.
 Overall length tolerance: +¼" / -⅛"

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT		TOOL DIAMETER	FLUTE LENGTH	OVERALL LENGTH	118° POINT		135° POINT				
mm	INCH	mm	INCH	mm	INCH	TYPE 3690 EDP NO.	PRICE EACH	TYPE 3691 EDP NO.	PRICE EACH				TYPE 3690 EDP NO.	PRICE EACH	TYPE 3691 EDP NO.	PRICE EACH			
3.2	.1260	41	1 5/8	70	2 3/4	3690032	\$23.05	3691032	\$23.25	8.4	.3307	87	3 7/16	121	4 3/4	3690084	\$32.05	3691084	\$36.05
3.3	.1299	44	1 3/4	73	2 7/8	3690033	23.05	3691033	23.25	8.5	.3346	87	3 7/16	121	4 3/4	3690085	30.65	3691085	36.05
3.4	.1339	44	1 3/4	73	2 7/8	3690034	23.05	3691034	23.25	8.6	.3386	87	3 7/16	121	4 3/4	3690086	32.05	3691086	36.05
3.5	.1378	44	1 3/4	73	2 7/8	3690035	21.15	3691035	21.90	8.7	.3425	87	3 7/16	121	4 3/4	3690087	32.05	3691087	36.05
3.6	.1417	48	1 7/8	76	3	3690036	22.00	3691036	22.35	8.8	.3465	89	3 1/2	124	4 7/8	3690088	32.05	3691088	36.05
3.7	.1457	48	1 7/8	76	3	3690037	22.00	3691037	22.35	8.9	.3504	89	3 1/2	124	4 7/8	3690089	32.05	3691089	38.30
3.8	.1496	48	1 7/8	76	3	3690038	22.00	3691038	22.35	9.0	.3543	89	3 1/2	124	4 7/8	3690090	31.25	3691090	38.30
3.9	.1535	51	2	79	3 1/8	3690039	22.00	3691039	22.35	9.1	.3583	89	3 1/2	124	4 7/8	3690091	34.70	3691091	38.30
4.0	.1575	54	2 1/8	83	3 1/4	3690040	20.70	3691040	21.30	9.2	.3622	92	3 5/8	127	5	3690092	34.70	3691092	38.30
4.1	.1614	54	2 1/8	83	3 1/4	3690041	19.90	3691041	22.60	9.3	.3661	92	3 5/8	127	5	3690093	34.70	3691093	38.30
4.2	.1654	54	2 1/8	83	3 1/4	3690042	21.15	3691042	22.60	9.4	.3701	92	3 5/8	127	5	3690094	34.70	3691094	38.30
4.3	.1693	54	2 1/8	83	3 1/4	3690043	21.15	3691043	22.60	9.5	.3740	92	3 5/8	127	5	3690095	34.00	3691095	38.30
4.4	.1732	56	2 3/16	86	3 3/8	3690044	21.15	3691044	22.60	9.6	.3780	95	3 3/4	130	5 1/8	3690096	35.30	3691096	41.85
4.5	.1772	56	2 3/16	86	3 3/8	3690045	22.00	3691045	22.60	9.7	.3819	95	3 3/4	130	5 1/8	3690097	35.30	3691097	41.85
4.6	.1811	56	2 3/16	86	3 3/8	3690046	23.95	3691046	24.20	9.8	.3858	95	3 3/4	130	5 1/8	3690098	35.30	3691098	41.85
4.7	.1850	59	2 5/16	89	3 1/2	369213	20.40	369313	21.40	9.9	.3898	95	3 3/4	130	5 1/8	3690099	35.30	3691099	41.85
4.8	.1890	59	2 5/16	89	3 1/2	369212	21.15	369312	22.45	10.0	.3937	95	3 3/4	130	5 1/8	3690100	35.30	3691100	41.85
4.9	.1929	62	2 7/16	92	3 5/8	3690049	23.95	3691049	24.20	10.1	.3976	98	3 7/8	133	5 1/4	3690101	41.95	3691101	43.05
5.0	.1969	62	2 7/16	92	3 5/8	3690050	22.95	3691050	23.60	10.2	.4016	98	3 7/8	133	5 1/4	3690102	41.95	3691102	43.05
5.1	.2008	62	2 7/16	92	3 5/8	3690051	24.85	3691051	25.25	10.3	.4055	98	3 7/8	133	5 1/4	3690103	41.95	3691103	43.05
5.2	.2047	64	2 1/2	95	3 3/4	3690052	24.85	3691052	25.25	10.4	.4094	98	3 7/8	133	5 1/4	3690104	42.00	3691104	45.20
5.3	.2087	64	2 1/2	95	3 3/4	3690053	24.85	3691053	25.25	10.5	.4134	98	3 7/8	133	5 1/4	3690105	40.65	3691105	45.20
5.4	.2126	64	2 1/2	95	3 3/4	3690054	24.85	3691054	25.25	10.6	.4173	100	3 15/16	137	5 3/8	3690106	46.15	3691106	46.80
5.5	.2165	64	2 1/2	95	3 3/4	3690055	24.30	3691055	24.65	10.7	.4213	100	3 15/16	137	5 3/8	3690107	46.15	3691107	46.80
5.6	.2205	67	2 5/8	98	3 7/8	3690056	25.60	3691056	26.15	10.8	.4252	103	4 1/16	140	5 1/2	3690108	46.15	3691108	46.80
5.7	.2244	67	2 5/8	98	3 7/8	3690057	25.60	3691057	26.15	10.9	.4291	103	4 1/16	140	5 1/2	3690109	46.15	3691109	46.80
5.8	.2283	67	2 5/8	98	3 7/8	3690058	25.60	3691058	26.15	11.0	.4331	103	4 1/16	140	5 1/2	3690110	44.05	3691110	45.20
5.9	.2323	67	2 5/8	98	3 7/8	3690059	25.60	3691059	26.15	11.1	.4370	103	4 1/16	140	5 1/2	3690111	51.35	3691111	52.05
6.0	.2362	70	2 3/4	102	4	3690060	25.30	3691060	26.75	11.2	.4409	106	4 3/16	143	5 5/8	3690112	51.40	3691112	52.55
6.1	.2402	70	2 3/4	102	4	3690061	26.75	3691061	27.40	11.3	.4449	106	4 3/16	143	5 5/8	3690113	51.40	3691113	52.55
6.2	.2441	70	2 3/4	102	4	3690062	26.75	3691062	27.40	11.4	.4488	106	4 3/16	143	5 5/8	3690114	51.35	3691114	50.95
6.3	.2480	70	2 3/4	102	4	3690063	26.75	3691063	27.40	11.5	.4528	106	4 3/16	143	5 5/8	3690115	49.30	3691115	50.95
6.4	.2520	73	2 7/8	105	4 1/8	3690064	26.75	3691064	27.40	11.6	.4567	110	4 5/16	146	5 3/4	3690116	55.80	3691116	56.75
6.5	.2559	73	2 7/8	105	4 1/8	3690065	26.20	3691065	26.75	11.7	.4606	110	4 5/16	146	5 3/4	3690117	55.80	3691117	56.75
6.6	.2598	73	2 7/8	105	4 1/8	3690066	27.95	3691066	31.35	11.8	.4646	110	4 5/16	146	5 3/4	3690118	55.80	3691118	56.75
6.7	.2638	73	2 7/8	105	4 1/8	3690067	27.95	3691067	31.35	11.9	.4685	110	4 5/16	146	5 3/4	3690119	55.80	3691119	56.75
6.8	.2677	73	2 7/8	105	4 1/8	3690068	27.95	3691068	31.35	12.0	.4724	111	4 3/8	149	5 7/8	3690120	53.50	3691120	57.10
6.9	.2717	73	2 7/8	105	4 1/8	3690069	27.95	3691069	31.35	12.5	.4921	114	4 1/2	152	6	3690125	55.45	3691125	57.10
7.0	.2756	73	2 7/8	105	4 1/8	3690070	27.35	3691070	31.35	13.0	.5118	114	4 1/2	152	6	3690130	66.10	3691130	84.20
7.1	.2795	75	2 15/16	108	4 1/4	3690071	28.65	3691071	31.35	13.5	.5315	122	4 13/16	168	6 5/8	3690135	85.45	3691135	92.25
7.2	.2835	75	2 15/16	108	4 1/4	3690072	28.65	3691072	31.35	14.0	.5512	122	4 13/16	168	6 5/8	3690140	90.70	3691140	97.80
7.3	.2874	75	2 15/16	108	4 1/4	3690073	28.65	3691073	31.35	14.5	.5709	122	4 13/16	168	6 5/8	3690145	97.25	3691145	105.15
7.4	.2913	78	3 1/16	111	4 3/8	3690074	28.60	3691074	33.90	15.0	.5906	132	5 3/16	181	7 1/8	3690150	97.25	3691150	105.15
7.5	.2953	78	3 1/16	111	4 3/8	3690075	28.60	3691075	33.90	15.5	.6102	132	5 3/16	181	7 1/8	3690155	98.55	3691155	106.35
7.6	.2992	78	3 1/16	111	4 3/8	3690076	30.00	3691076	33.90	16.0	.6299	132	5 3/16	181	7 1/8	3690160	100.30	3691160	108.30
7.7	.3031	81	3 3/16	114	4 1/2	3690077	30.00	3691077	33.90	16.5	.6496	132	5 3/16	181	7 1/8	3690165	100.30	3691165	108.30
7.8	.3071	81	3 3/16	114	4 1/2	3690078	30.00	3691078	33.90	17.0	.6693	143	5 5/8	194	7 5/8	3690170	104.20	3691170	112.65
7.9	.3110	81	3 3/16	114	4 1/2	3690079	30.00	3691079	33.90	17.5	.6890	143	5 5/8	194	7 5/8	3690175	104.20	3691175	112.65
8.0	.3150	81	3 3/16	114	4 1/2	3690080	29.35	3691080	33.90	18.0	.7087	143	5 5/8	194	7 5/8	3690180	105.30	3691180	113.70
8.1	.3189	84	3 5/16	117	4 5/8	3690081	32.05	3691081	36.05	18.5	.7283	143	5 5/8	194	7 5/8	3690185	105.90	3691185	114.30
8.2	.3228	84	3 5/16	117	4 5/8	3690082	32.05	3691082	36.05	19.0	.7480	148	5 13/16	203	8	3690190	107.30	3691190	116.00
8.3	.3268	84	3 5/16	117	4 5/8	3690083	32.05	3691083	36.05	-	-	-	-	-	-	-	-	-	-

CARBIDE TIPPED TAPER LENGTH TWIST DRILLS

TYPE 3630 - TAPER LENGTH - 118° POINT
TYPE 3631 - TAPER LENGTH - 135° SPLIT POINT

Carbide tip brazed to hardened tool steel bodies.

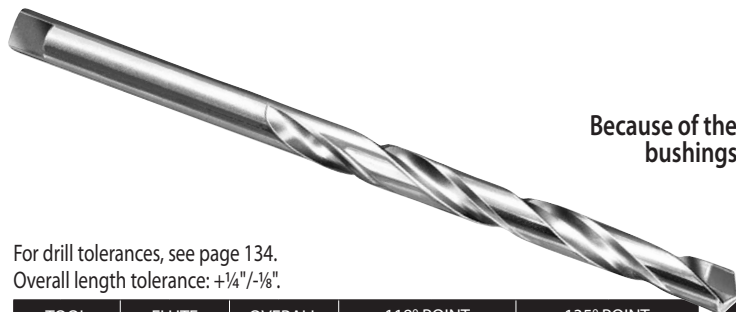
Smooth flutes for effective chip flow. Precision ground to ensure concentricity of tip & body. All tools are tapered. For drilling cast iron, non-ferrous metals and non-metals. (Not usually recommended for drilling steel.)



For drill tolerances, see page 134.
Overall length tolerance: +1/4" / -1/8".

TOOL DIAMETER		WIRE LETTER	LENGTH		118° POINT			135° POINT									
DECIMAL	FRACTION		FLUTE	OVER-ALL	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH	DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH
.1250	1/8		2 3/4	5 1/8	363008	\$19.10	363108	\$22.65	.3160		O	4 1/8	6 1/2	363415	\$43.10	363515	\$46.60
.1285		30	3	5 3/8	363230	25.35	363330	27.35	.3230		P	4 1/8	6 1/2	363416	43.10	363516	46.60
.1360		29	3	5 3/8	363229	25.35	363329	27.35	.3281	21/64		4 1/8	6 1/2	363021	32.75	363121	40.55
.1405		28	3	5 3/8	363228	25.35	363328	27.35	.3320		Q	4 1/8	6 1/2	363417	43.10	363517	46.60
.1406	9/64		3	5 3/8	363009	22.00	363109	23.85	.3390		R	4 1/8	6 1/2	363418	43.10	363518	46.60
.1440		27	3	5 3/8	363227	25.35	363327	27.35	.3438	11/32		4 1/8	6 1/2	363022	32.75	363122	41.05
.1470		26	3	5 3/8	363226	25.35	363326	27.35	.3480		S	4 1/4	6 3/4	363419	47.20	363519	50.95
.1495		25	3	5 3/8	363225	25.35	363325	27.35	.3580		T	4 1/4	6 3/4	363420	47.20	363520	50.95
.1520		24	3	5 3/8	363224	25.35	363324	27.35	.3594	23/64		4 1/4	6 3/4	363023	36.90	363123	44.35
.1540		23	3	5 3/8	363223	25.35	363323	27.35	.3680		U	4 1/4	6 3/4	363421	47.20	363521	50.95
.1562	5/32		3	5 3/8	363010	20.20	363110	23.85	.3750	3/8		4 1/4	6 3/4	363024	36.90	363124	44.35
.1570		22	3 3/8	5 3/4	363222	26.25	363322	28.40	.3770		V	4 3/8	7	363422	50.60	363522	54.70
.1590		21	3 3/8	5 3/4	363221	26.25	363321	28.40	.3860		W	4 3/8	7	363423	50.60	363523	54.70
.1610		20	3 3/8	5 3/4	363220	26.25	363320	28.40	.3906	25/64		4 3/8	7	363025	39.60	363125	47.60
.1660		19	3 3/8	5 3/4	363219	26.25	363319	28.40	.3970		X	4 3/8	7	363424	50.60	363524	54.70
.1695		18	3 3/8	5 3/4	363218	26.25	363318	28.40	.4040		Y	4 3/8	7	363425	50.60	363525	54.70
.1719	11/64		3 3/8	5 3/4	363011	20.50	363111	24.70	.4062	13/32		4 3/8	7	363026	39.60	363126	47.60
.1730		17	3 3/8	5 3/4	363217	26.25	363317	28.40	.4130		Z	4 3/8	7 1/4	363426	58.25	363526	62.85
.1770		16	3 3/8	5 3/4	363216	26.25	363316	28.40	.4219	27/64		4 3/8	7 1/4	363027	45.70	363127	54.70
.1800		15	3 3/8	5 3/4	363215	26.25	363315	28.40	.4375	7/16		4 3/8	7 1/4	363028	45.70	363128	54.70
.1820		14	3 3/8	5 3/4	363214	26.25	363314	28.40	.4531	29/64		4 3/4	7 1/2	363029	50.35	363129	60.40
.1850		13	3 3/8	5 3/4	363213	26.25	363313	28.40	.4688	15/32		4 3/4	7 1/2	363030	50.35	363130	60.40
.1875	3/16		3 3/8	5 3/4	363012	20.50	363112	24.70	.4844	31/64		4 3/4	7 3/4	363031	52.85	363131	63.35
.1890		12	3 3/8	6	363212	27.70	363312	29.90	.5000	1/2		4 3/4	7 3/4	363032	52.85	363132	63.35
.1910		11	3 3/8	6	363211	27.70	363311	29.90	.5156	33/64		4 3/4	8	363033	56.70	363133	66.80
.1935		10	3 3/8	6	363210	27.70	363310	29.90	.5312	17/32		4 3/4	8	363034	57.95	363134	66.80
.1960		9	3 3/8	6	363209	27.70	363309	29.90	.5469	35/64		4 7/8	8 1/4	363035	58.50	363135	70.30
.1990		8	3 3/8	6	363208	27.70	363308	29.90	.5625	9/16		4 7/8	8 1/4	363036	58.50	363136	70.30
.2010		7	3 3/8	6	363207	27.70	363307	29.90	.5781	37/64		4 7/8	8 3/4	363037	61.65	363137	74.25
.2031	13/64		3 3/8	6	363013	21.70	363113	26.00	.5938	19/32		4 7/8	8 3/4	363038	62.80	363138	74.25
.2040		6	3 3/8	6	363206	27.70	363306	29.90	.6094	39/64		4 7/8	8 3/4	363039	71.20	363139	85.50
.2055		5	3 3/8	6	363205	27.70	363305	29.90	.6250	5/8		4 7/8	8 3/4	363040	71.20	363140	85.50
.2090		4	3 3/8	6	363204	27.70	363304	29.90	.6406	41/64		5 1/8	9	363041	73.85	363141	87.00
.2130		3	3 3/8	6	363203	27.70	363303	29.90	.6562	21/32		5 1/8	9	363042	76.00	363142	87.00
.2188	7/32		3 3/8	6	363014	21.70	363114	26.00	.6719	43/64		5 3/8	9 1/4	363043	76.40	363143	87.95
.2210		2	3 3/4	6 1/8	363202	31.35	363302	33.95	.6875	11/16		5 3/8	9 1/4	363044	73.80	363144	87.95
.2280		1	3 3/4	6 1/8	363201	31.35	363301	33.95	.7031	45/64		5 3/8	9 1/2	363045	74.55	363145	89.55
.2340		A	3 3/4	6 1/8	363401	31.35	363501	33.95	.7188	23/32		5 3/8	9 1/2	363046	75.30	363146	90.45
.2344	15/64		3 3/4	6 1/8	363015	24.65	363115	29.50	.7344	47/64		5 7/8	9 3/4	363047	75.75	363147	91.05
.2380		B	3 3/4	6 1/8	363402	31.35	363502	33.95	.7500	3/4		5 7/8	9 3/4	363048	76.95	363148	92.35
.2420		C	3 3/4	6 1/8	363403	31.35	363503	33.95	.7656	49/64		6	9 7/8	363049	97.45	363149	105.30
.2460		D	3 3/4	6 1/8	363404	31.35	363504	33.95	.7812	25/32		6	9 7/8	363050	97.45	363150	105.30
.2500	1/4		3 3/4	6 1/8	363016	24.65	363116	29.50	.7969	51/64		6 1/8	10	363051	97.85	363151	105.75
.2570		F	3 3/4	6 1/4	363406	35.05	363506	37.90	.8125	13/16		6 1/8	10	363052	87.90	363152	105.75
.2610		G	3 7/8	6 1/4	363407	35.05	363507	37.90	.8281	53/64		6 1/8	10	363053	97.85	363153	105.75
.2656	17/64		3 7/8	6 1/4	363017	27.60	363117	33.05	.8438	27/32		6 1/8	10	363054	97.85	363154	105.75
.2660		H	3 7/8	6 1/4	363408	35.05	363508	37.90	.8594	55/64		6 1/8	10	363055	103.60	363155	111.85
.2720		I	3 7/8	6 1/4	363409	35.05	363509	37.90	.8750	7/8		6 1/8	10	363056	93.00	363156	111.85
.2770		J	3 7/8	6 1/4	363410	35.05	363510	37.90	.8906	57/64		6 1/8	10	363057	107.10	363157	115.70
.2810		K	3 7/8	6 1/4	363411	35.05	363511	37.90	.9062	29/32		6 1/8	10	363058	107.10	363158	115.70
.2812	9/32		3 7/8	6 1/4	363018	27.60	363118	33.05	.9219	59/64		6 1/8	10 3/4	363059	108.70	363159	117.35
.2900		L	4	6 3/8	363412	38.00	363512	41.05	.9375	15/16		6 1/8	10 3/4	363060	97.65	363160	117.35
.2950		M	4	6 3/8	363413	38.00	363513	41.05	.9531	61/64		6 3/8	11	363061	113.80	363161	122.90
.2969	19/64		4	6 3/8	363019	29.75	363119	35.60	.9688	31/32		6 3/8	11	363062	113.80	363162	122.90
.3020		N	4	6 3/8	363414	38.00	363514	41.05	.9844	63/64		6 3/8	11	363063	117.40	363163	126.70
.3125	5/16		4	6 3/8	363020	29.75	363120	35.60	1.0000	1		6 3/8	11	363064	105.40	363164	126.70

CARBIDE TIPPED TAPER LENGTH TWIST DRILLS METRIC



TYPE 3630 - TAPER LENGTH - 118° POINT
TYPE 3631 - TAPER LENGTH - 135° SPLIT POINT

Because of the greater length, it increases the drill reach through drill bushings. Detailed description and fractional sizes on page 116.
 (Not usually recommended for steel.)

For drill tolerances, see page 134.
 Overall length tolerance: +¼"/-½".

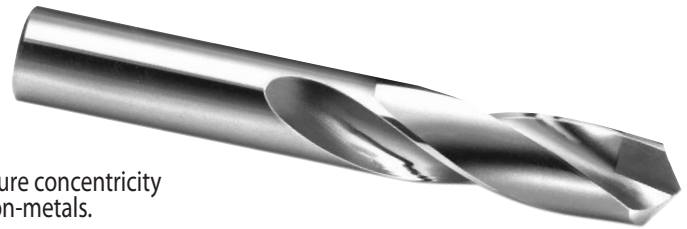
TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT		TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH	mm	INCH	mm	INCH	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH	mm	INCH	mm	INCH	mm	INCH	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH
3.2	.1260	76	3	137	5 3/8	3630032	\$23.40	3631032	\$25.20	8.6	.3386	105	4 1/8	165	6 1/2	3630086	\$38.20	3631086	\$41.30
3.3	.1299	76	3	137	5 3/8	3630033	23.40	3631033	25.20	8.7	.3425	105	4 1/8	165	6 1/2	3630087	38.20	3631087	41.30
3.4	.1339	76	3	137	5 3/8	3630034	23.40	3631034	25.20	8.8	.3465	108	4 1/4	171	6 3/4	3630088	38.20	3631088	41.30
3.5	.1378	76	3	137	5 3/8	3630035	22.70	3631035	24.60	8.9	.3504	108	4 1/4	171	6 3/4	3630089	38.20	3631089	41.30
3.6	.1417	76	3	137	5 3/8	3630036	22.70	3631036	24.60	9.0	.3543	108	4 1/4	171	6 3/4	3630090	37.60	3631090	45.25
3.7	.1457	76	3	137	5 3/8	3630037	22.70	3631037	24.60	9.1	.3583	108	4 1/4	171	6 3/4	3630091	41.85	3631091	45.25
3.8	.1496	76	3	137	5 3/8	3630038	22.70	3631038	24.60	9.2	.3622	108	4 1/4	171	6 3/4	3630092	41.85	3631092	45.25
3.9	.1535	76	3	137	5 3/8	3630039	22.70	3631039	24.60	9.3	.3661	108	4 1/4	171	6 3/4	3630093	41.85	3631093	45.25
4.0	.1575	86	3 3/8	146	5 3/4	3630040	22.20	3631040	24.05	9.4	.3701	108	4 1/4	171	6 3/4	3630094	41.85	3631094	45.25
4.1	.1614	86	3 3/8	146	5 3/4	3630041	23.40	3631041	25.20	9.5	.3740	108	4 1/4	171	6 3/4	3630095	38.50	3631095	45.25
4.2	.1654	86	3 3/8	146	5 3/4	3630042	23.40	3631042	25.20	9.6	.3780	111	4 3/8	178	7	3630096	43.95	3631096	47.50
4.3	.1693	86	3 3/8	146	5 3/4	3630043	23.40	3631043	25.20	9.7	.3819	111	4 3/8	178	7	3630097	43.95	3631097	47.50
4.4	.1732	86	3 3/8	146	5 3/4	3630044	24.65	3631044	26.50	9.8	.3858	111	4 3/8	178	7	3630098	43.95	3631098	47.50
4.5	.1772	86	3 3/8	146	5 3/4	3630045	24.65	3631045	26.50	9.9	.3898	111	4 3/8	178	7	3630099	43.95	3631099	47.50
4.6	.1811	86	3 3/8	146	5 3/4	3630046	24.65	3631046	26.50	10.0	.3937	111	4 3/8	178	7	3630100	40.40	3631100	48.55
4.7	.1850	86	3 3/8	146	5 3/4	3632113	26.25	3633113	28.40	10.1	.3976	111	4 3/8	178	7	3630101	44.95	3631101	48.55
4.8	.1890	92	3 3/8	152	6	3632112	27.70	3633112	29.90	10.2	.4016	111	4 3/8	178	7	3630102	46.90	3631102	50.70
4.9	.1929	92	3 3/8	152	6	3630049	24.65	3631049	26.50	10.3	.4055	111	4 3/8	178	7	3630103	46.90	3631103	50.70
5.0	.1969	92	3 3/8	152	6	3630050	25.80	3631050	26.50	10.4	.4094	117	4 5/8	184	7 1/4	3630104	49.00	3631104	52.85
5.1	.2008	92	3 3/8	152	6	3630051	25.60	3631051	27.65	10.5	.4134	117	4 5/8	184	7 1/4	3630105	46.05	3631105	52.85
5.2	.2047	92	3 3/8	152	6	3630052	23.00	3631052	27.65	10.6	.4173	117	4 5/8	184	7 1/4	3630106	51.30	3631106	55.40
5.3	.2087	92	3 3/8	152	6	3630053	25.60	3631053	27.65	10.7	.4213	117	4 5/8	184	7 1/4	3630107	51.30	3631107	55.40
5.4	.2126	92	3 3/8	152	6	3630054	25.60	3631054	27.65	10.8	.4252	117	4 5/8	184	7 1/4	3630108	51.30	3631108	55.40
5.5	.2165	92	3 3/8	152	6	3630055	27.50	3631055	27.65	10.9	.4291	117	4 5/8	184	7 1/4	3630109	51.30	3631109	55.40
5.6	.2205	95	3 3/4	156	6 1/8	3630056	25.60	3631056	27.65	11.0	.4331	117	4 5/8	184	7 1/4	3630110	49.80	3631110	55.75
5.7	.2244	95	3 3/4	156	6 1/8	3630057	25.60	3631057	27.65	11.5	.4528	121	4 3/4	190	7 1/2	3630115	55.85	3631115	61.60
5.8	.2283	95	3 3/4	156	6 1/8	3630058	25.60	3631058	27.65	12.0	.4724	121	4 3/4	197	7 3/4	3630120	60.40	3631120	64.60
5.9	.2323	95	3 3/4	156	6 1/8	3630059	26.65	3631059	28.85	12.5	.4921	121	4 3/4	197	7 3/4	3630125	62.60	3631125	64.60
6.0	.2362	95	3 3/4	156	6 1/8	3630060	28.55	3631060	30.00	13.0	.5118	121	4 3/4	203	8	3630130	64.20	3631130	68.15
6.1	.2402	95	3 3/4	156	6 1/8	3630061	28.40	3631061	30.65	13.5	.5315	121	4 3/4	203	8	3630135	68.20	3631135	68.15
6.2	.2441	95	3 3/4	156	6 1/8	3630062	28.40	3631062	30.65	14.0	.5512	124	4 7/8	210	8 1/4	3630140	72.40	3631140	75.50
6.3	.2480	95	3 3/4	156	6 1/8	3630063	28.40	3631063	30.65	14.5	.5709	124	4 7/8	222	8 3/4	3630145	77.60	3631145	80.95
6.4	.2520	98	3 7/8	159	6 1/4	3630064	31.15	3631064	33.70	15.0	.5906	124	4 7/8	222	8 3/4	3630150	77.60	3631150	80.95
6.5	.2559	98	3 7/8	159	6 1/4	3630065	29.60	3631065	33.70	15.5	.6102	124	4 7/8	222	8 3/4	3630155	88.05	3631155	91.85
6.6	.2598	98	3 7/8	159	6 1/4	3630066	32.15	3631066	34.60	16.0	.6299	130	5 1/8	229	9	3630160	88.05	3631160	92.45
6.7	.2638	98	3 7/8	159	6 1/4	3630067	32.15	3631067	34.60	16.5	.6496	130	5 1/8	229	9	3630165	94.00	3631165	92.45
6.8	.2677	98	3 7/8	159	6 1/4	3630068	32.15	3631068	34.60	17.0	.6693	137	5 3/8	235	9 1/4	3630170	91.20	3631170	95.25
6.9	.2717	98	3 7/8	159	6 1/4	3630069	32.15	3631069	34.60	17.5	.6890	143	5 5/8	241	9 1/2	3630175	91.20	3631175	95.25
7.0	.2756	98	3 7/8	159	6 1/4	3630070	30.85	3631070	33.70	18.0	.7087	143	5 5/8	241	9 1/2	3630180	93.20	3631180	97.15
7.1	.2795	98	3 7/8	159	6 1/4	3630071	32.15	3631071	34.60	18.5	.7283	149	5 7/8	248	9 3/4	3630185	95.20	3631185	99.20
7.2	.2835	102	4	162	6 3/8	3630072	32.15	3631072	34.60	19.0	.7480	149	5 7/8	248	9 3/4	3630190	95.20	3631190	99.20
7.3	.2874	102	4	162	6 3/8	3630073	32.15	3631073	34.60	19.5	.7677	152	6	251	9 7/8	3630195	109.35	3631195	118.10
7.4	.2913	102	4	162	6 3/8	3630074	32.15	3631074	34.60	20.0	.7874	156	6 1/8	254	10	3630200	109.80	3631200	118.60
7.5	.2953	102	4	162	6 3/8	3630075	32.70	3631075	36.45	20.5	.8071	156	6 1/8	254	10	3630205	109.80	3631205	118.60
7.6	.2992	102	4	162	6 3/8	3630076	33.65	3631076	36.45	21.0	.8268	156	6 1/8	254	10	3630210	109.80	3631210	118.60
7.7	.3031	102	4	162	6 3/8	3630077	33.65	3631077	36.45	21.5	.8465	156	6 1/8	254	10	3630215	109.80	3631215	118.60
7.8	.3071	102	4	162	6 3/8	3630078	33.65	3631078	36.45	22.0	.8661	156	6 1/8	254	10	3630220	116.20	3631220	125.45
7.9	.3110	102	4	162	6 3/8	3630079	33.65	3631079	36.45	22.5	.8858	156	6 1/8	254	10	3630225	120.25	3631225	129.85
8.0	.3150	105	4 1/8	165	6 1/2	3630080	33.20	3631080	36.45	23.0	.9055	156	6 1/8	254	10	3630230	120.25	3631230	129.85
8.1	.3189	105	4 1/8	165	6 1/2	3630081	33.65	3631081	36.45	23.5	.9252	156	6 1/8	273	10 3/4	3630235	121.95	3631235	131.65
8.2	.3228	105	4 1/8	165	6 1/2	3630082	35.90	3631082	38.75	24.0	.9449	162	6 3/8	279	11	3630240	127.70	3631240	137.95
8.3	.3268	105	4 1/8	165	6 1/2	3630083	35.90	3631083	38.75	24.5	.9646	162	6 3/8	279	11	3630245	127.70	3631245	137.95
8.4	.3307	105	4 1/8	165	6 1/2	3630084	35.90	3631084	38.75	25.0	.9843	162	6 3/8	279	11	3630250	131.65	3631250	142.25
8.5	.3346	105	4 1/8	165	6 1/2	3630085	34.70	3631085	41.30	-	-	-	-	-	-	-	-	-	-

CARBIDE TIPPED STUB LENGTH TWIST DRILLS

TYPE 3640 - STUB LENGTH - 118° POINT
TYPE 3641 - STUB LENGTH - 135° SPLIT POINT

Carbide tip brazed to hardened tool steel bodies.

Smooth flutes for effective chip flow. Precision ground to ensure concentricity of tip & body. For drilling cast iron, non-ferrous metals and non-metals. Excellent starting drill. Ideal for exact location shallow drilling. (Not usually recommended for drilling steel.)
 For drill tolerances, see page 134.



TOOL DIAMETER			LENGTH		118° POINT		135° POINT		
DECIMAL	FRACTIONAL	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH	
.1160		32	7/8	1 7/8	364232	\$19.45	364332	\$21.55	
.1200		31	7/8	1 7/8	364231	19.45	364331	21.55	
.1250	1/8		7/8	1 7/8	364008	15.20	364108	16.50	
.1285		30	15/16	1 15/16	364230	20.50	364330	22.70	
.1360		29	15/16	1 15/16	364229	20.50	364329	22.70	
.1405		28	15/16	1 15/16	364228	20.50	364328	22.70	
.1406	9/64		15/16	1 15/16	364009	18.40	364109	21.70	
.1440		27	1	2 1/16	364227	20.50	364327	22.70	
.1470		26	1	2 1/16	364226	20.50	364326	22.70	
.1495		25	1	2 1/16	364225	20.50	364325	22.70	
.1520		24	1	2 1/16	364224	20.50	364324	22.70	
.1540		23	1	2 1/16	364223	20.50	364323	22.70	
.1562	5/32		1	2 1/16	364010	16.20	364110	17.60	
.1570		22	1 1/16	2 1/8	364222	20.50	364322	22.70	
.1590		21	1 1/16	2 1/8	364221	20.50	364321	22.70	
.1610		20	1 1/16	2 1/8	364220	23.85	364320	26.55	
.1660		19	1 1/16	2 1/8	364219	23.85	364319	26.55	
.1695		18	1 1/16	2 1/8	364218	23.85	364318	26.55	
.1719	11/64		1 1/16	2 1/8	364011	21.90	364111	23.60	
.1730		17	1 1/16	2 3/16	364217	24.35	364317	27.00	
.1770		16	1 1/16	2 3/16	364216	24.35	364316	27.00	
.1800		15	1 1/16	2 3/16	364215	24.35	364315	27.00	
.1820		14	1 1/16	2 3/16	364214	24.35	364314	27.00	
.1850		13	1 1/16	2 3/16	364213	24.35	364313	27.00	
.1875	3/16		1 1/16	2 3/16	364012	16.95	364112	18.60	
.1890		12	1 3/16	2 1/4	364212	24.15	364312	26.75	
.1910		11	1 3/16	2 1/4	364211	24.15	364311	26.75	
.1935		10	1 3/16	2 1/4	364210	24.15	364310	26.75	
.1960		9	1 3/16	2 1/4	364209	24.15	364309	26.75	
.1990		8	1 3/16	2 1/4	364208	24.15	364308	26.75	
.2010		7	1 3/16	2 1/4	364207	22.25	364307	26.75	
.2031	13/64		1 3/16	2 1/4	364013	21.90	364113	23.60	
.2040		6	1 1/4	2 3/8	364206	24.35	364306	27.00	
.2055		5	1 1/4	2 3/8	364205	24.35	364305	27.00	
.2090		4	1 1/4	2 3/8	364204	24.35	364304	27.00	
.2130		3	1 1/4	2 3/8	364203	22.25	364303	26.75	
.2188	7/32		1 1/4	2 3/8	364014	18.20	364114	20.30	
.2210		2	1 1/4	2 3/8	364202	24.15	364302	26.75	
.2280		1	1 1/4	2 3/8	364201	22.25	364301	26.75	
.2340		A	1 1/4	2 3/8	364401	24.15	364501	26.75	
.2344	15/64		1 1/4	2 3/8	364015	20.30	364115	24.15	
.2380		B	1 3/8	2 1/2	364402	24.15	364502	26.75	
.2420		C	1 3/8	2 1/2	364403	24.15	364503	26.75	
.2460		D	1 3/8	2 1/2	364404	22.25	364504	26.75	
.2500	1/4		E	1 3/8	2 1/2	364016	18.55	364116	21.50
.2570		F	1 1/2	2 5/8	364406	25.80	364506	31.00	
.2610		G	1 1/2	2 5/8	364407	25.80	364507	31.00	
.2656	17/64		1 1/2	2 5/8	364017	22.60	364117	26.80	
.2660		H	1 1/2	2 5/8	364408	25.05	364508	31.00	
.2720		I	1 1/2	2 5/8	364409	25.80	364509	31.00	
.2770		J	1 1/2	2 5/8	364410	27.95	364510	31.00	
.2810		K	1 1/2	2 5/8	364411	27.95	364511	31.00	
.2812	9/32		1 1/2	2 5/8	364018	21.40	364118	24.85	
.2900		L	1 1/2	2 3/4	364412	28.80	364512	32.00	
.2950		M	1 1/2	2 3/4	364413	28.80	364513	32.00	
.2969	19/64		1 1/2	2 3/4	364019	25.80	364119	30.75	
.3020		N	1 5/8	2 13/16	364414	33.05	364514	36.75	
.3125	5/16		1 5/8	2 13/16	364020	22.75	364120	26.45	
.3160		O	1 3/4	2 15/16	364415	31.90	364515	38.40	
.3230		P	1 3/4	2 15/16	364416	34.50	364516	38.40	
.3281	21/64		1 3/4	2 15/16	364021	28.05	364121	32.60	

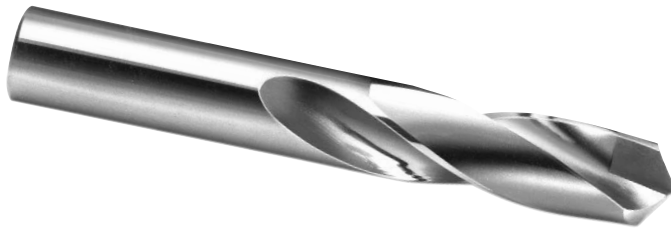
TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTIONAL	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH
.3320		Q	1 11/16	3	364417	\$31.90	364517	\$38.40
.3390		R	1 11/16	3	364418	31.90	364518	38.40
.3438	11/32		1 11/16	3	364022	26.55	364122	30.75
.3480		S	1 3/4	3 1/16	364419	34.95	364519	38.85
.3580		T	1 3/4	3 1/16	364420	34.95	364520	38.85
.3594	23/64		1 3/4	3 1/16	364023	28.90	364123	33.65
.3680		U	1 13/16	3 1/8	364421	32.75	364521	39.35
.3750	3/8		1 13/16	3 1/8	364024	27.15	364124	31.50
.3770		V	1 7/8	3 1/4	364422	40.25	364522	44.65
.3860		W	1 7/8	3 1/4	364423	37.25	364523	44.80
.3906	25/64		1 7/8	3 1/4	364025	32.20	364125	37.45
.3970		X	1 15/16	3 3/8	364424	37.25	364524	44.65
.4040		Y	1 15/16	3 3/8	364425	40.25	364525	44.65
.4062	13/32		1 15/16	3 3/8	364026	32.20	364126	37.45
.4130		Z	2	3 3/8	364426	45.80	364526	50.90
.4219	27/64		2	3 3/8	364027	35.70	364127	40.65
.4375	7/16		2 1/16	3 7/16	364028	34.45	364128	38.20
.4531	29/64		2 1/16	3 7/16	364029	45.90	364129	58.95
.4688	15/32		2 1/8	3 7/8	364030	49.00	364130	57.00
.4844	31/64		2 3/16	3 11/16	364031	43.95	364131	56.50
.5000	1/2		2 1/4	3 3/4	364032	46.90	364132	54.55
.5156	29/64		2 3/8	3 7/8	364033	66.85	364133	74.35
.5312	17/32		2 3/8	3 7/8	364034	58.45	364134	65.95
.5469	35/64		2 1/2	4	364035	66.85	364135	74.35
.5625	9/16		2 1/2	4	364036	58.45	364136	65.95
.5781	37/64		2 5/8	4 1/8	364037	78.05	364137	86.80
.5938	19/32		2 5/8	4 1/8	364038	67.05	364138	75.60
.6094	39/64		2 3/4	4 1/4	364039	78.05	364139	86.80
.6250	5/8		2 3/4	4 1/4	364040	67.05	364140	75.60
.6406	41/64		2 7/8	4 1/2	364041	93.10	364141	103.60
.6562	21/32		2 7/8	4 1/2	364042	80.60	364142	90.95
.6719	43/64		2 7/8	4 5/8	364043	95.50	364143	106.20
.6875	11/16		2 7/8	4 5/8	364044	82.75	364144	93.30
.7031	45/64		3	4 3/4	364045	107.95	364145	119.90
.7188	23/32		3	4 3/4	364046	93.80	364146	108.90
.7344	47/64		3 1/8	5	364047	108.00	364147	120.25
.7500	3/4		3 1/8	5	364048	94.00	364148	105.90
.7656	49/64		3 1/4	5 1/8	364049	115.65	364149	128.65
.7812	25/32		3 1/4	5 1/8	364050	116.15	364150	134.80
.7969	51/64		3 3/8	5 1/4	364051	129.40	364151	144.00
.8125	13/16		3 3/8	5 1/4	364052	116.25	364152	131.15
.8281	53/64		3 1/2	5 3/8	364053	126.80	364153	140.95
.8438	27/32		3 1/2	5 3/8	364054	127.35	364154	147.85
.8594	55/64		3 1/2	5 1/2	364055	141.95	364155	158.00
.8750	7/8		3 1/2	5 1/2	364056	127.55	364156	143.80
.8906	57/64		3 5/8	5 3/8	364057	136.20	364157	151.50
.9062	29/32		3 5/8	5 3/8	364058	136.75	364158	158.75
.9219	59/64		3 3/4	5 3/4	364059	152.40	364159	169.60
.9375	15/16		3 3/4	5 3/4	364060	136.90	364160	154.50
.9531	61/64		3 7/8	5 7/8	364061	152.40	364161	169.60
.9688	31/32		3 7/8	5 7/8	364062	144.50	364162	167.80
.9844	63/64		4	6	364063	161.05	364163	179.25
1.0000	1		4	6	364064	144.70	364164	163.25
1.0312	1 1/32*		4	6 1/4	364066	201.80	364166	224.50
1.0625	1 1/16*		4	6 1/4	364068	181.30	364168	204.45
1.0938	1 3/32*		4	6 3/8	364070	224.00	364170	249.20
1.1250	1 1/8*		4	6 3/8	364072	201.25	364172	226.85
1.1562	1 5/32*		4 1/4	6 3/8	364074	273.45	364174	304.15
1.1875	1 3/16*		4 1/4	6 3/8	364076	245.65	364176	275.30
1.2188	1 7/32*		4 3/8	6 3/4	364078	273.45	364178	304.15
1.2500	1 1/4*		4 3/8	6 3/4	364080	245.65	364180	275.30

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CARBIDE TIPPED STUB LENGTH TWIST DRILLS METRIC

TYPE 3640 - STUB LENGTH - 118° POINT
TYPE 3641 - STUB LENGTH - 135° SPLIT POINT

Detailed description and fractional sizes on page 118.



For drill tolerances, see page 134.

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT		TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH	mm	INCH	mm	INCH	TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH	mm	INCH	mm	INCH	mm	INCH	TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH
3.0	.1181	22	⁷ / ₁₆	48	1 ⁷ / ₈	3640030	\$21.15	3641030	\$23.30	8.1	.3189	43	1 ¹¹ / ₁₆	75	2 ¹⁵ / ₁₆	3640081	\$32.15	3641081	35.30
3.1	.1220	22	⁷ / ₁₆	48	1 ⁷ / ₈	3640031	21.15	3641031	23.30	8.2	.3228	43	1 ¹¹ / ₁₆	75	2 ¹⁵ / ₁₆	3640082	32.15	3641082	35.30
3.2	.1260	24	¹⁵ / ₁₆	49	1 ¹⁵ / ₁₆	3640032	21.15	3641032	23.30	8.3	.3268	43	1 ¹¹ / ₁₆	75	2 ¹⁵ / ₁₆	3640083	32.15	3641083	35.30
3.3	.1299	24	¹⁵ / ₁₆	49	1 ¹⁵ / ₁₆	3640033	21.15	3641033	23.30	8.4	.3307	43	1 ¹¹ / ₁₆	76	3	3640084	32.15	3641084	35.30
3.4	.1339	24	¹⁵ / ₁₆	49	1 ¹⁵ / ₁₆	3640034	21.15	3641034	23.30	8.5	.3346	43	1 ¹¹ / ₁₆	76	3	3640085	28.85	3641085	32.60
3.5	.1378	24	¹⁵ / ₁₆	49	1 ¹⁵ / ₁₆	3640035	19.00	3641035	21.70	8.6	.3386	43	1 ¹¹ / ₁₆	76	3	3640086	32.15	3641086	35.30
3.6	.1417	25	1	52	2 ¹ / ₁₆	3640036	21.15	3641036	23.30	8.7	.3425	43	1 ¹¹ / ₁₆	76	3	3640087	32.70	3641087	36.00
3.7	.1457	25	1	52	2 ¹ / ₁₆	3640037	21.15	3641037	23.30	8.8	.3465	44	1 ³ / ₄	78	3 ¹ / ₁₆	3640088	32.70	3641088	36.00
3.8	.1496	25	1	52	2 ¹ / ₁₆	3640038	21.15	3641038	23.30	8.9	.3504	44	1 ³ / ₄	78	3 ¹ / ₁₆	3640089	32.70	3641089	36.00
3.9	.1535	25	1	52	2 ¹ / ₁₆	3640039	21.15	3641039	23.30	9.0	.3543	44	1 ³ / ₄	78	3 ¹ / ₁₆	3640090	29.40	3641090	33.65
4.0	.1575	27	1 ¹ / ₁₆	54	2 ¹ / ₈	3640040	19.00	3641040	21.80	9.1	.3583	44	1 ³ / ₄	78	3 ¹ / ₁₆	3640091	32.70	3641091	36.00
4.1	.1614	27	1 ¹ / ₁₆	54	2 ¹ / ₈	3640041	25.20	3641041	27.70	9.2	.3622	46	1 ¹³ / ₁₆	79	3 ¹ / ₁₆	3640092	32.70	3641092	36.00
4.2	.1654	27	1 ¹ / ₁₆	54	2 ¹ / ₈	3640042	25.20	3641042	27.70	9.3	.3661	46	1 ¹³ / ₁₆	79	3 ¹ / ₁₆	3640093	32.70	3641093	36.00
4.3	.1693	27	1 ¹ / ₁₆	54	2 ¹ / ₈	3640043	25.20	3641043	27.70	9.4	.3701	46	1 ¹³ / ₁₆	79	3 ¹ / ₁₆	3640094	32.70	3641094	36.00
4.4	.1732	29	1 ¹ / ₈	56	2 ³ / ₁₆	3640044	25.20	3641044	27.70	9.5	.3740	46	1 ¹³ / ₁₆	79	3 ¹ / ₁₆	3640095	29.40	3641095	33.65
4.5	.1772	29	1 ¹ / ₈	56	2 ³ / ₁₆	3640045	22.60	3641045	25.90	9.6	.3780	48	1 ⁷ / ₈	83	3 ¹ / ₄	3640096	36.40	3641096	40.10
4.6	.1811	29	1 ¹ / ₈	56	2 ³ / ₁₆	3640046	25.20	3641046	27.70	9.7	.3819	48	1 ⁷ / ₈	83	3 ¹ / ₄	3640097	36.40	3641097	40.10
4.7	.1850	29	1 ¹ / ₈	56	2 ³ / ₁₆	364213	24.35	364313	27.00	9.8	.3858	48	1 ⁷ / ₈	83	3 ¹ / ₄	3640098	36.40	3641098	40.10
4.8	.1890	30	1 ³ / ₁₆	57	2 ¹ / ₄	364212	24.15	364312	26.75	9.9	.3898	48	1 ⁷ / ₈	83	3 ¹ / ₄	3640099	36.40	3641099	40.10
4.9	.1929	30	1 ³ / ₁₆	57	2 ¹ / ₄	3640049	25.20	3641049	27.70	10.0	.3937	49	1 ¹⁵ / ₁₆	84	3 ⁹ / ₁₆	3640100	32.70	3641100	37.45
5.0	.1969	30	1 ³ / ₁₆	57	2 ¹ / ₄	3640050	22.60	3641050	25.90	10.5	.4134	51	2	86	3 ³ / ₈	3640105	36.55	3641105	40.65
5.1	.2008	30	1 ³ / ₁₆	57	2 ¹ / ₄	3640051	25.20	3641051	27.70	11.0	.4331	52	2 ¹ / ₁₆	87	3 ⁷ / ₁₆	3640110	36.55	3641110	40.65
5.2	.2047	32	1 ¹ / ₄	60	2 ³ / ₈	3640052	25.20	3641052	27.70	11.5	.4528	54	2 ¹ / ₈	90	3 ⁹ / ₁₆	3640115	51.45	3641115	57.00
5.3	.2087	32	1 ¹ / ₄	60	2 ³ / ₈	3640053	25.20	3641053	27.70	12.0	.4724	56	2 ³ / ₁₆	94	3 ¹ / ₁₆	3640120	49.20	3641120	54.55
5.4	.2126	32	1 ¹ / ₄	60	2 ³ / ₈	3640054	25.20	3641054	27.70	12.5	.4921	57	2 ¹ / ₄	95	3 ³ / ₄	3640125	49.20	3641125	54.55
5.5	.2165	32	1 ¹ / ₄	60	2 ³ / ₈	3640055	22.60	3641055	25.90	13.0	.5118	60	2 ³ / ₈	98	3 ⁷ / ₈	3640130	60.75	3641130	65.95
5.6	.2205	33	1 ⁵ / ₁₆	62	2 ⁷ / ₁₆	3640056	25.20	3641056	27.70	13.5	.5315	60	2 ³ / ₈	98	3 ⁷ / ₈	3640135	59.65	3641135	65.95
5.7	.2244	33	1 ⁵ / ₁₆	62	2 ⁷ / ₁₆	3640057	25.20	3641057	27.70	14.0	.5512	64	2 ¹ / ₂	102	4	3640140	59.65	3641140	65.95
5.8	.2283	33	1 ⁵ / ₁₆	62	2 ⁷ / ₁₆	3640058	25.20	3641058	27.70	14.5	.5709	67	2 ⁵ / ₈	105	4 ¹ / ₈	3640145	80.15	3641145	88.25
5.9	.2323	33	1 ⁵ / ₁₆	62	2 ⁷ / ₁₆	3640059	25.20	3641059	27.70	15.0	.5906	67	2 ⁵ / ₈	105	4 ¹ / ₈	3640150	80.15	3641150	88.25
6.0	.2363	35	1 ³ / ₈	64	2 ¹ / ₂	3640060	21.15	3641060	24.15	15.5	.6102	70	2 ³ / ₄	108	4 ¹ / ₄	3640155	90.40	3641155	99.60
6.1	.2402	35	1 ³ / ₈	64	2 ¹ / ₂	3640061	26.05	3641061	28.80	16.0	.6299	73	2 ⁷ / ₈	114	4 ¹ / ₂	3640160	101.85	3641160	112.30
6.2	.2441	35	1 ³ / ₈	64	2 ¹ / ₂	3640062	26.05	3641062	28.80	16.5	.6496	73	2 ⁷ / ₈	114	4 ¹ / ₂	3640165	101.85	3641165	112.30
6.3	.2480	35	1 ³ / ₈	64	2 ¹ / ₂	3640063	26.05	3641063	28.80	17.0	.6693	73	2 ⁷ / ₈	117	4 ⁵ / ₈	3640170	101.85	3641170	112.30
6.4	.2520	37	1 ⁷ / ₁₆	67	2 ⁵ / ₈	3640064	26.05	3641064	28.80	17.5	.6890	76	3	121	4 ³ / ₄	3640175	112.35	3641175	123.75
6.5	.2559	37	1 ⁷ / ₁₆	67	2 ⁵ / ₈	3640065	23.40	3641065	26.80	18.0	.7087	76	3	121	4 ³ / ₄	3640180	112.35	3641180	123.75
6.6	.2598	37	1 ⁷ / ₁₆	67	2 ⁵ / ₈	3640066	26.05	3641066	28.80	18.5	.7283	79	3 ¹ / ₈	127	5	3640185	122.70	3641185	135.25
6.7	.2638	37	1 ⁷ / ₁₆	67	2 ⁵ / ₈	3640067	26.05	3641067	28.80	19.0	.7480	79	3 ¹ / ₈	127	5	3640190	122.70	3641190	135.25
6.8	.2677	38	1 ¹ / ₂	68	2 ¹ / ₁₆	3640068	26.05	3641068	28.80	19.5	.7677	83	3 ¹ / ₄	130	5 ¹ / ₈	3640195	135.75	3641195	149.60
6.9	.2717	38	1 ¹ / ₂	68	2 ¹ / ₁₆	3640069	26.05	3641069	28.80	20.0	.7874	86	3 ³ / ₈	133	5 ¹ / ₄	3640200	151.75	3641200	167.15
7.0	.2756	38	1 ¹ / ₂	68	2 ¹ / ₁₆	3640070	23.40	3641070	26.80	20.5	.8071	86	3 ³ / ₈	133	5 ¹ / ₄	3640205	151.75	3641205	167.15
7.1	.2795	38	1 ¹ / ₂	68	2 ¹ / ₁₆	3640071	26.05	3641071	28.80	21.0	.8268	89	3 ¹ / ₂	137	5 ³ / ₈	3640210	166.60	3641210	183.55
7.2	.2835	40	1 ⁹ / ₁₆	70	2 ³ / ₄	3640072	29.90	3641072	33.00	21.5	.8465	89	3 ¹ / ₂	140	5 ¹ / ₂	3640215	166.60	3641215	183.55
7.3	.2874	40	1 ⁹ / ₁₆	70	2 ³ / ₄	3640073	29.90	3641073	33.00	22.0	.8661	89	3 ¹ / ₂	140	5 ¹ / ₂	3640220	166.60	3641220	183.55
7.4	.2913	40	1 ⁹ / ₁₆	70	2 ³ / ₄	3640074	29.90	3641074	33.00	22.5	.8858	92	3 ⁵ / ₈	143	5 ³ / ₈	3640225	171.40	3641225	188.80
7.5	.2953	40	1 ⁹ / ₁₆	70	2 ³ / ₄	3640075	26.90	3641075	30.75	23.0	.9055	92	3 ⁵ / ₈	143	5 ³ / ₈	3640230	171.40	3641230	188.80
7.6	.2992	41	1 ⁵ / ₈	71	2 ¹³ / ₁₆	3640076	29.90	3641076	33.00	23.5	.9252	95	3 ³ / ₄	146	5 ³ / ₄	3640235	175.60	3641235	193.50
7.7	.3031	41	1 ⁵ / ₈	71	2 ¹³ / ₁₆	3640077	29.90	3641077	33.00	24.0	.9449	98	3 ⁷ / ₈	149	5 ⁷ / ₈	3640240	178.90	3641240	197.20
7.8	.3071	41	1 ⁵ / ₈	71	2 ¹³ / ₁₆	3640078	29.90	3641078	33.00	24.5	.9646	98	3 ⁷ / ₈	149	5 ⁷ / ₈	3640245	178.90	3641245	197.20
7.9	.3110	41	1 ⁵ / ₈	71	2 ¹³ / ₁₆	3640079	29.90	3641079	33.00	25.0	.9843	102	4	152	6	3640250	189.00	3641250	208.05
8.0	.3150	43	1 ¹¹ / ₁₆	75	2 ¹⁵ / ₁₆	3640080	26.90	3641080	30.75	-	-	-	-	-	-	-	-	-	-

CARBIDE TIPPED TAPER SHANK TWIST DRILLS

TYPE 3660 - TAPER SHANK - 118° POINT
TYPE 3661 - TAPER SHANK - 135° SPLIT POINT

Carbide tip brazed to hardened tool steel bodies. Smooth flutes for effective chip flow. Precision ground to ensure concentricity of tip & body. For drilling cast iron, non-ferrous metals and non-metals. (Not usually recommended for drilling steel.)



For extra long flutes, see page 125.
 For drill tolerances, see page 134.

TOOL DIAMETER		MORSE TAPER	LENGTH		118° POINT		135° POINT	
DECIMAL	Frac.		FLUTE	OVER-ALL	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
.2500	1/4	1	2 7/8	6 1/8	366016	\$40.00	366116	\$45.35
.2656	17/64	1	3	6 1/4	366017	40.90	366117	46.35
.2812	9/32	1	3	6 1/4	366018	40.90	366118	46.35
.2969	19/64	1	3 1/8	6 3/8	366019	40.90	366119	46.35
.3125	5/16	1	3 1/8	6 3/8	366020	40.90	366120	46.35
.3281	21/64	1	3 1/4	6 1/2	366021	52.00	366121	58.90
.3438	11/32	1	3 1/4	6 1/2	366022	52.00	366122	58.90
.3594	23/64	1	3 1/2	6 3/4	366023	52.00	366123	58.90
.3750	3/8	1	3 1/2	6 3/4	366024	52.00	366124	58.90
.3906	25/64	1	3 5/8	7	366025	60.20	366125	68.25
.4062	13/32	1	3 5/8	7	366026	60.20	366126	68.25
.4219	27/64	1	3 7/8	7 1/4	366027	60.20	366127	68.25
.4375	7/16	1	3 7/8	7 1/4	366028	60.20	366128	68.25
.4531	29/64	1	4 1/8	7 1/2	366029	73.15	366129	82.95
.4688	15/32	1	4 1/8	7 1/2	366030	73.15	366130	82.95
.4844	31/64	2	4 3/8	8 1/4	366031	73.15	366131	82.95
.5000	1/2	2	4 3/8	8 1/4	366032	77.55	366132	76.75
.5156	33/64	2	4 5/8	8 1/2	366033	71.00	366133	85.15
.5312	17/32	2	4 5/8	8 1/2	366034	60.75	366134	78.90
.5469	35/64	2	4 7/8	8 3/4	366035	71.95	366135	86.40
.5625	9/16	2	4 7/8	8 3/4	366036	61.25	366136	79.95
.5781	37/64	2	4 7/8	8 3/4	366037	75.30	366137	90.45
.5938	19/32	2	4 7/8	8 3/4	366038	64.00	366138	83.75
.6094	39/64	2	4 7/8	8 3/4	366039	87.30	366139	104.75
.6250	5/8	2	4 7/8	8 3/4	366040	74.50	366140	96.95
.6406	41/64	2	5 1/8	9	366041	88.70	366141	106.45
.6562	21/32	2	5 1/8	9	366042	72.60	366142	98.55
.6719	43/64	2	5 3/8	9 1/4	366043	89.65	366143	107.80
.6875	11/16	2	5 3/8	9 1/4	366044	74.90	366144	99.80
.7031	45/64	2	5 5/8	9 1/2	366045	92.20	366145	110.60
.7188	23/32	2	5 5/8	9 1/2	366046	76.70	366146	102.40
.7344	47/64	2	5 7/8	9 3/4	366047	94.00	366147	112.85
.7500	3/4	2	5 7/8	9 3/4	366048	78.40	366148	104.50
.7656	49/64	2	6	9 7/8	366049	100.00	366149	120.00
.7812	25/32	2	6	9 7/8	366050	84.85	366150	111.10
.7969	51/64	3	6 1/8	10 3/4	366051	101.00	366151	121.25
.8125	13/16	3	6 1/8	10 3/4	366052	85.75	366152	112.25

TOOL DIAMETER		MORSE TAPER	LENGTH		118° POINT		135° POINT	
DECIMAL	Frac.		FLUTE	OVER-ALL	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
.8281	53/64	3	6 1/8	10 3/4	366053	\$101.00	366153	\$121.25
.8438	27/32	3	6 1/8	10 3/4	366054	87.60	366154	112.25
.8594	55/64	3	6 1/8	10 3/4	366055	106.75	366155	128.10
.8750	7/8	3	6 1/8	10 3/4	366056	93.10	366156	118.60
.8906	57/64	3	6 1/8	10 3/4	366057	110.25	366157	132.35
.9062	29/32	3	6 1/8	10 3/4	366058	100.10	366158	122.60
.9219	59/64	3	6 1/8	10 3/4	366059	112.35	366159	134.70
.9375	15/16	3	6 1/8	10 3/4	366060	106.90	366160	124.80
.9531	61/64	3	6 3/8	11	366061	117.80	366161	141.35
.9688	31/32	3	6 3/8	11	366062	106.90	366162	130.85
.9844	63/64	3	6 3/8	11	366063	120.80	366163	145.05
1.0000	1	3	6 3/8	11	366064	105.20	366164	134.30
1.0156	1 1/64	3	6 1/2	11 1/8	366065	187.10	366165	211.95
1.0312	1 1/32	3	6 1/2	11 1/8	366066	162.70	366166	184.35
1.0469	1 3/64	3	6 5/8	11 1/4	366067	191.80	366167	217.25
1.0625	1 1/16	3	6 5/8	11 1/4	366068	138.05	366168	174.95
1.0781	1 5/64	4	6 7/8	12 1/2	366069	207.95	366169	235.65
1.0938	1 3/32	4	6 7/8	12 1/2	366070	180.90	366170	204.95
1.1094	1 7/64	4	7 1/8	12 3/4	366071	212.65	366171	240.85
1.1250	1 1/8	4	7 1/8	12 3/4	366072	152.80	366172	193.95
1.1406	1 9/64	4	7 1/4	12 7/8	366073	238.65	366173	270.45
1.1562	1 5/32	4	7 1/4	12 7/8	366074	207.55	366174	235.15
1.1719	1 11/64	4	7 3/8	13	366075	243.30	366175	275.55
1.1875	1 3/16	4	7 3/8	13	366076	175.05	366176	221.95
1.2031	1 13/64	4	7 1/2	13 1/8	366077	256.15	366177	290.10
1.2188	1 7/32	4	7 1/2	13 1/8	366078	222.65	366178	252.25
1.2344	1 15/64	4	7 1/2	13 1/2	366079	260.70	366179	295.40
1.2500	1 1/4	4	7 7/8	13 1/2	366080	187.30	366180	237.80
1.2812	1 9/32	4	8 1/2	14 1/8	366082	318.00	366182	360.30
1.3125	1 5/16	4	8 5/8	14 1/4	366084	276.60	366184	313.20
1.3438	1 11/32	4	8 3/4	14 3/8	366086	341.55	366186	387.00
1.3750	1 3/8	4	8 7/8	14 1/2	366088	297.00	366188	336.50
1.4062	1 13/32	4	9	14 5/8	366090	367.50	366190	416.45
1.4375	1 7/16	4	9 1/8	14 3/4	366092	319.60	366192	362.10
1.4688	1 15/32	4	9 1/4	14 7/8	366094	391.15	366194	443.05
1.5000	1 1/2	4	9 3/8	15	366096	340.10	366196	385.25
-	-	-	-	-	-	-	-	-

TYPE 3668 - SMALLER TAPER SIZE - 118° POINT

Same as Type 3660, except reduced to the next smaller Morse taper number.

For drill tolerances, see page 134.

TOOL DIAMETER		MORSE TAPER	LENGTH		TYPE 3668 EDP NO.	PRICE EACH
DECIMAL	Frac.		FLUTE	OVERALL		
.4844	31/64	1	4 3/8	7 3/4	366831	\$87.85
.5000	1/2	1	4 3/8	7 3/4	366832	69.00
.5156	33/64	1	4 5/8	8	366833	85.20
.5312	17/32	1	4 5/8	8	366834	72.95
.5469	35/64	1	4 7/8	8 1/4	366835	86.40
.5625	9/16	1	4 7/8	8 1/4	366836	73.50
.7969	51/64	2	6 1/8	10	366851	121.25
.8125	13/16	2	6 1/8	10	366852	102.90
.8281	53/64	2	6 1/8	10	366853	121.25
.8438	27/32	2	6 1/8	10	366854	105.05

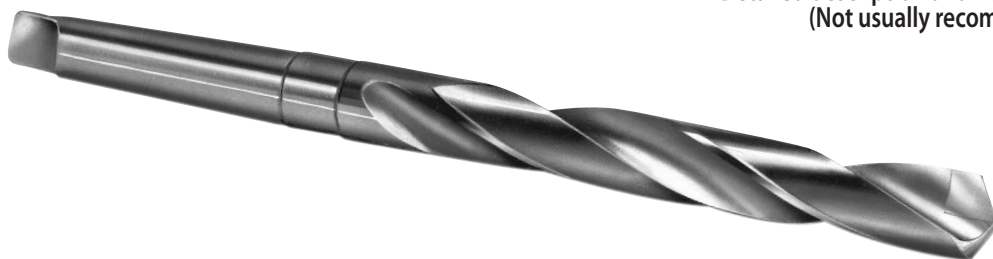
TOOL DIAMETER		MORSE TAPER	LENGTH		TYPE 3668 EDP NO.	PRICE EACH
DECIMAL	Frac.		FLUTE	OVERALL		
.8594	55/64	2	6 1/8	10	366855	\$128.10
.8750	7/8	2	6 1/8	10	366856	111.80
.8906	57/64	2	6 1/8	10	366857	132.30
.9062	29/32	2	6 1/8	10	366858	120.20
1.0938	1 1/32	3	6 7/8	11 1/2	366870	255.20
1.1250	1 1/8	3	7 1/8	11 3/4	366872	183.40
1.1562	1 5/32	3	7 1/4	11 7/8	366874	249.00
1.1875	1 3/16	3	7 3/8	12	366876	210.05
1.2188	1 7/32	3	7 1/2	12 1/8	366878	267.20
1.2500	1 1/4	3	7 7/8	12 1/2	366880	224.75

CARBIDE TIPPED TAPER SHANK TWIST DRILLS

METRIC

TYPE 3660 - TAPER SHANK - 118° POINT
TYPE 3661 - TAPER SHANK - 135° SPLIT POINT

Detailed description and fractional sizes on page 120.
 (Not usually recommended for drilling steel.)



For drill tolerances, see page 134.

TOOL DIAMETER		MORSE TAPER	FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH		mm	INCH	mm	INCH	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
13.0	.5118	2	117	4 5/8	216	8 1/2	3660130	\$72.35	3661130	86.90
13.5	.5315	2	117	4 5/8	216	8 1/2	3660135	67.05	3661135	80.45
14.0	.5512	2	124	4 7/8	222	8 3/4	3660140	68.00	3661140	81.55
14.5	.5709	2	124	4 7/8	222	8 3/4	3660145	76.80	3661145	92.25
15.0	.5906	2	124	4 7/8	222	8 3/4	3660150	71.20	3661150	85.40
15.5	.6102	2	124	4 7/8	222	8 3/4	3660155	89.05	3661155	106.80
16.0	.6299	2	130	5 1/8	229	9	3660160	90.45	3661160	108.60
16.5	.6496	2	130	5 1/8	229	9	3660165	83.85	3661165	100.50
17.0	.6693	2	137	5 3/8	235	9 1/4	3660170	91.50	3661170	109.95
17.5	.6890	2	143	5 5/8	241	9 1/2	3660175	94.00	3661175	112.85
18.0	.7087	2	143	5 5/8	241	9 1/2	3660180	87.05	3661180	104.50
18.5	.7283	2	149	5 7/8	248	9 3/4	3660185	95.90	3661185	115.05
19.0	.7480	2	149	5 7/8	248	9 3/4	3660190	88.80	3661190	106.55

TOOL DIAMETER		MORSE TAPER	FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH		mm	INCH	mm	INCH	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
20.0	.7874	3	156	6 1/8	273	10 3/4	3660200	\$103.00	3661200	\$123.65
21.0	.8268	3	156	6 1/8	273	10 3/4	3660210	103.00	3661210	123.65
22.0	.8661	3	156	6 1/8	273	10 3/4	3660220	100.75	3661220	121.00
23.0	.9055	3	156	6 1/8	273	10 3/4	3660230	104.15	3661230	125.05
24.0	.9449	3	162	6 3/8	279	11	3660240	120.20	3661240	144.15
25.0	.9843	3	162	6 3/8	279	11	3660250	123.25	3661250	147.95
26.0	1.0236	3	165	6 1/2	283	11 1/8	3660260	184.70	3661260	221.60
28.0	1.1024	4	181	7 1/8	324	12 3/4	3660280	204.75	3661280	245.65
30.0	1.1811	4	187	7 3/8	330	13	3660300	246.65	3661300	295.85
32.0	1.2598	4	216	8 1/2	359	14 1/8	3660320	306.20	3661320	367.50
34.0	1.3386	4	222	8 3/4	365	14 3/8	3660340	328.85	3661340	394.75
36.0	1.4173	4	232	9 1/8	375	14 3/4	3660360	376.55	3661360	451.90
38.0	1.4961	4	238	9 3/8	381	15	3660380	391.60	3661380	470.10

CARBIDE TIPPED HARD STEEL DIE DRILLS

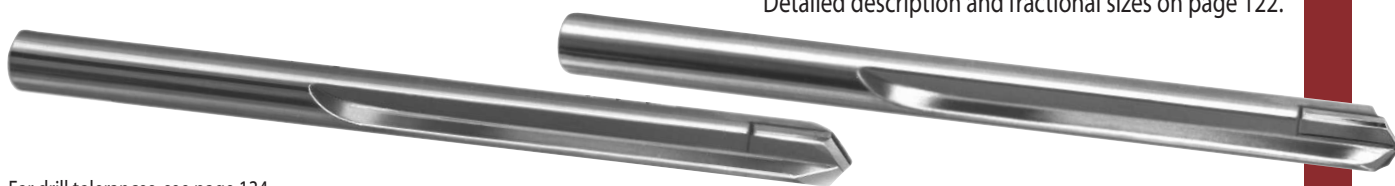
TYPE 3670 - 118° POINT NEGATIVE EDGE

For steels in the range of 50 Rc to 65 Rc.

TYPE 3672 - 118° POINT POSITIVE EDGE

For cast iron, high temperature alloys and steels up to 50 Rc.

Detailed description and fractional sizes on page 122.



For drill tolerances, see page 134.

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		NEG. 118° PT TYPE 3670 EDP NO.	POS. 118° PT TYPE 3672 EDP NO.	BOTH TYPES PRICE
mm	INCH	mm	INCH	mm	INCH			
5.0	.1969	38	1 1/2	89	3 1/2	3670050	3672050	\$30.00
5.5	.2165	45	1 3/4	95	3 3/4	3670055	3672055	33.45
6.0	.2362	51	2	102	4	3670060	3672060	33.65
6.5	.2559	51	2	102	4	3670065	3672065	35.60
7.0	.2756	57	2 1/4	108	4 1/4	3670070	3672070	35.60
7.5	.2953	57	2 1/4	108	4 1/4	3670075	3672075	37.25
8.0	.3150	64	2 1/2	114	4 1/2	3670080	3672080	40.25
8.5	.3346	70	2 3/4	121	4 3/4	3670085	3672085	40.25
9.0	.3543	70	2 3/4	121	4 3/4	3670090	3672090	42.85
9.5	.3740	76	3	127	5	3670095	3672095	40.60

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		NEG. 118° PT TYPE 3670 EDP NO.	POS. 118° PT TYPE 3672 EDP NO.	BOTH TYPES PRICE
mm	INCH	mm	INCH	mm	INCH			
10.0	.3937	76	3	133	5 1/4	3670100	3672100	\$50.00
10.5	.4134	76	3	133	5 1/4	3670105	3672105	57.95
11.0	.4331	76	3	140	5 1/2	3670110	3672110	81.55
11.5	.4528	76	3	140	5 1/2	3670115	3672115	61.10
12.0	.4724	83	3 1/4	146	5 3/4	3670120	3672120	74.60
12.5	.4921	89	3 1/2	152	6	3670125	3672125	74.60
13.0	.5118	89	3 1/2	152	6	3670130	3672130	85.60
13.5	.5315	89	3 1/2	152	6	3670135	3672135	85.60
14.0	.5512	89	3 1/2	152	6	3670140	3672140	88.60
-	-	-	-	-	-	-	-	-

CARBIDE TIPPED HARD STEEL DIE DRILLS

TYPE 3670 - 118° PT. NEGATIVE EDGE

For steels in the range of 50 Rc to 65 Rc.

TYPE 3672 - 118° PT. POSITIVE EDGE

For cast iron, high temperature alloys and steels up to 50 Rc.

TYPE 3671 - 140° PT. NEGATIVE EDGE

For steels in the range of 50 Rc to 65 Rc.

TYPE 3673 - 140° PT. POSITIVE EDGE

For cast iron, high temperature alloys and steels up to 50 Rc.

Heavy duty hardened tool steel bodies provide shock resilient support for the thick, long carbide tip. Straight flutes and straight shank. Drill body diameter is smaller than tool diameter.

Die drills may be run at speeds from 75 to 100 SFPM. Apply light feed (.001-.003 I.P.R.) with steady pressure. Flood the point with coolant and withdraw frequently to clear chips



For metric sizes, see page 121.
For drill tolerances, see page 134.

TOOL DIAMETER		LENGTH		NEG. 118° POINT TYPE 3670 EDP NO.	POS. 118° POINT TYPE 3672 EDP NO.	BOTH TYPES PRICE	NEG. 140° POINT TYPE 3671 EDP NO.	POS. 140° POINT TYPE 3673 EDP NO.	BOTH TYPES PRICE
DECIMAL	FRACTION	FLUTE	OVERALL						
.0625	1/16*	-	1 1/2	367004	-	\$27.25	367104	-	\$27.25
.0781	5/64*	-	1 1/2	367005	-	27.25	367105	-	27.25
.0938	3/32*	-	2	367006	-	29.90	367106	-	29.90
.1094	7/64*	-	2	367007	-	29.90	367107	-	29.90
.1250	1/8*	-	2	367008	-	30.90	367108	-	30.90
.1406	9/64*	-	2	367009	-	30.90	367109	-	30.90
.1562	5/32*	-	2	367010	-	32.40	367110	-	32.40
.1719	11/64*	-	2 3/8	367011	-	32.40	367111	-	32.40
.1875	3/16	1 1/2	3 1/2	367012	367212	29.45	367112	367312	29.45
.2031	13/64	1 1/2	3 1/2	367013	367213	29.45	367113	367313	29.45
.2188	7/32	1 3/4	3 3/4	367014	367214	30.40	367114	367314	30.40
.2344	15/64	1 3/4	3 3/4	367015	367215	31.35	367115	367315	31.35
.2500	1/4	2	4	367016	367216	31.35	367116	367316	31.35
.2656	17/64	2	4	367017	367217	33.20	367117	367317	33.20
.2812	9/32	2 1/4	4 1/4	367018	367218	33.20	367118	367318	33.20
.2969	19/64	2 1/4	4 1/4	367019	367219	34.70	367119	367319	34.70
.3125	5/16	2 1/2	4 1/2	367020	367220	34.70	367120	367320	34.70
.3281	21/64	2 1/2	4 1/2	367021	367221	36.95	367121	367321	36.95
.3438	11/32	2 3/4	4 3/4	367022	367222	36.95	367122	367322	36.95
.3594	23/64	2 3/4	4 3/4	367023	367223	39.75	367123	367323	39.75
.3750	3/8	3	5	367024	367224	39.75	367124	367324	39.75
.3906	25/64	3	5	367025	367225	44.85	367125	367325	44.85
.4062	13/32	3	5 1/4	367026	367226	46.55	367126	367326	46.55
.4219	21/64	3	5 1/4	367027	367227	50.25	367127	367327	50.25
.4375	7/16	3	5 1/2	367028	367228	54.05	367128	367328	54.05
.4531	29/64	3	5 1/2	367029	367229	56.60	367129	367329	56.60
.4688	15/32	3 1/4	5 3/4	367030	367230	59.30	367130	367330	59.30
.4844	31/64	3 1/4	5 3/4	367031	367231	71.95	367131	367331	71.95
.5000	1/2	3 1/2	6	367032	367232	69.60	367132	367332	69.60
.5312	17/32	3 1/2	6	367034	367234	79.80	367134	367334	79.80
.5625	9/16	3 1/2	6	367036	367236	82.55	367136	367336	82.55
.5938	19/32	4	7	367038	367238	87.35	367138	367338	87.35
.6250	5/8	4	7	367040	367240	90.00	367140	367340	90.00
.6562	21/32	4 1/2	7 1/2	367042	367242	96.30	367142	367342	96.30
.6875	11/16	4 1/2	7 1/2	367044	367244	98.90	367144	367344	98.90
.7188	23/32	4 3/4	8	367046	367246	103.65	367146	367346	103.65
.7500	3/4	4 3/4	8	367048	367248	106.45	367148	367348	106.45
.7812	25/32	4 3/4	8	367050	367250	205.65	367150	367350	205.65
.8125	13/16	4 3/4	8	367052	367252	190.90	367152	367352	190.90
.8750	7/8	4 3/4	8	367056	367256	194.80	367156	367356	194.80
.9375	15/16	4 3/4	8	367060	367260	217.05	367160	367360	217.05
1.0000	1	4 3/4	8	367064	367264	230.30	367164	367364	230.30

SOLID CARBIDE DIE DRILLS

TYPE 3893 - 140° POINT

Two straight flutes. Designed for drilling abrasive and tough materials.



CARBIDE TIPPED SPADE DRILLS

TYPE 3674 - 120° POINT

Carbide tip brazed to tool steel bodies. Cam relieved 120° point. Drill body diameter is smaller than tool diameter to prevent gauling.

TYPE 3675 - 140° POINT

Same as Type 3674 above, except with 140° cam relieved point designed for drilling abrasive and tough materials.

BOTH TYPES: For shallow holes, approximately 2 tool diameters deep. The short heavy construction allows more rigid hole drilling for tough applications where longer length drills are not needed.



TOOL DIAMETER		LENGTH		TYPE 3893 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL		
.0469	3/64	1/2	1 1/2	389303	\$12.45
.0625	1/16	5/8	1 3/4	389304	12.45
.0781	5/64	3/4	1 3/4	389305	12.85
.0938	3/32	3/4	1 3/4	389306	13.40
.1094	7/64	7/8	1 7/8	389307	14.00
.1250	1/8	7/8	1 7/8	389308	14.75
.1406	9/64	1	2	389309	17.40
.1562	5/32	1	2 1/8	389310	18.20
.1719	11/64	1 1/8	2 1/8	389311	22.30
.1875	3/16	1 1/8	2 1/4	389312	24.25
.2031	13/64	1 3/16	2 1/4	389313	26.85
.2188	7/32	1 1/4	2 1/2	389314	27.95
.2344	15/64	1 5/16	2 1/2	389315	32.50
.2500	1/4	1 3/8	2 1/2	389316	30.60
.2656	17/64	1 7/16	2 3/4	389317	50.05
.2812	9/32	1 1/2	2 3/4	389318	51.80
.2969	19/64	1 9/16	2 3/4	389319	54.45
.3125	5/16	1 5/8	2 3/4	389320	47.65
.3281	21/64	1 3/4	3	389321	56.70
.3438	11/32	1 3/4	3	389322	59.40
.3594	23/64	1 3/4	3	389323	65.75
.3750	3/8	1 7/8	3	389324	62.75
.3906	25/64	2	3 1/4	389325	73.70
.4062	13/32	2	3 1/4	389326	81.80
.4219	27/64	2	3 1/2	389327	83.90
.4375	7/16	2 1/16	3 1/2	389328	84.05
.4531	29/64	2 1/8	3 3/4	389329	103.20
.4688	15/32	2 1/8	3 3/4	389330	103.55
.4844	31/64	2 1/4	3 3/4	389331	104.35
.5000	1/2	2 1/4	3 3/4	389332	93.00

TOOL DIAMETER		OVERALL LENGTH	120° PT.	140° PT.	BOTH TYPES PRICE
DECIMAL	FRAC.		TYPE 3674 EDP NO.	TYPE 3675 EDP NO.	
.0938	3/32*	2	367406	367506	\$19.10
.1094	7/64*	2	367407	367507	19.40
.1250	1/8*	2	367408	367508	19.40
.1406	9/64*	2	367409	367509	21.10
.1562	5/32*	2	367410	367510	24.25
.1719	11/64*	3	367411	367511	25.85
.1875	3/16*	3	367412	367512	30.65
.2031	13/64*	3	367413	367513	34.45
.2188	7/32	3 1/2	367414	367514	34.85
.2344	15/64	3 1/2	367415	367515	35.40
.2500	1/4	4	367416	367516	36.40
.2656	17/64	4	367417	367517	36.95
.2812	9/32	4	367418	367518	38.10
.2969	19/64	4	367419	367519	38.80
.3125	5/16	4	367420	367520	39.75
.3281	21/64	4	367421	367521	41.70
.3438	11/32	4	367422	367522	43.15
.3594	23/64	4	367423	367523	44.50
.3750	3/8	4	367424	367524	45.95
.3906	25/64	4	367425	367525	47.10
.4062	13/32	4	367426	367526	53.45
.4219	27/64	4	367427	367527	55.45
.4375	7/16	4 1/2	367428	367528	62.25
.4531	29/64	4 1/2	367429	367529	64.80
.4688	15/32	4 1/2	367430	367530	67.80
.4844	31/64	4 1/2	367431	367531	74.40
.5000	1/2	5	367432	367532	80.40

CARBIDE TIPPED AIRCRAFT EXTENSION DRILLS

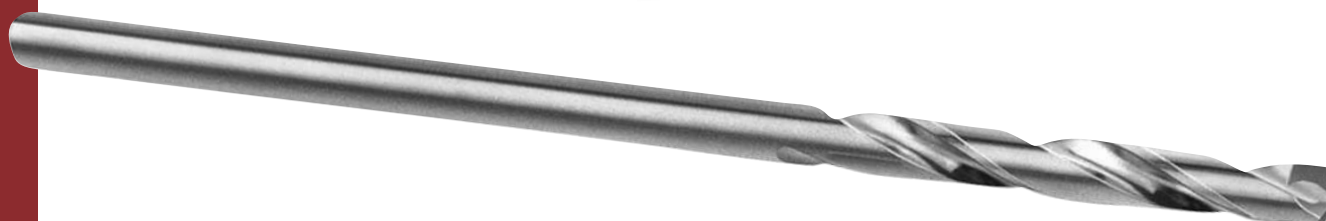
TYPE 3610 - 135° SPLIT POINT - 6" OVERALL LENGTH

6" overall length aircraft extension drill. 135° split point per NAS 907 specifications.



TYPE 3611 - 135° SPLIT POINT - 12" OVERALL LENGTH

Same as Type 3610 above, except 12" overall length.



BOTH TYPES: For drilling holes where reach is normally not accessible with jobbers or taper length drills. Feeds should be light to medium range. Not recommended for deep hole applications or for drilling steel.

For drill tolerances, see page 134.

TOOL DIAMETER				6" OVERALL LENGTH				12" OVERALL LENGTH				TOOL DIAMETER				6" OVERALL LENGTH				12" OVERALL LENGTH			
DECIMAL	FRAC.	WIRE LETTER	FLUTE LENGTH	TYPE 3610 EDP NO.	PRICE EACH	TYPE 3611 EDP NO.	PRICE EACH	DECIMAL	FRAC.	WIRE LETTER	FLUTE LENGTH	TYPE 3610 EDP NO.	PRICE EACH	TYPE 3611 EDP NO.	PRICE EACH	DECIMAL	FRAC.	WIRE LETTER	FLUTE LENGTH	TYPE 3610 EDP NO.	PRICE EACH	TYPE 3611 EDP NO.	PRICE EACH
.1160		32	1 5/8	361232	\$25.60	361332	\$30.20	.2380		B	2 3/4	361402	\$33.10	361502	\$38.90	.2380		B	2 3/4	361402	\$33.10	361502	\$38.90
.1200		31	1 5/8	361231	22.90	361331	26.95	.2420		C	2 3/4	361403	33.10	361503	38.90	.2420		C	2 3/4	361403	33.10	361503	38.90
.1250	1/8		1 5/8	361008	17.80	361108	20.95	.2460		D	2 3/4	361404	32.50	361504	38.20	.2460		D	2 3/4	361404	32.50	361504	38.20
.1285		30	1 5/8	361230	24.15	361330	28.40	.2500	1/4	E	2 3/4	361016	23.75	361116	27.95	.2500	1/4	E	2 3/4	361016	23.75	361116	27.95
.1360		29	1 3/4	361229	24.90	361329	29.35	.2570		F	2 7/8	361406	33.95	361506	40.00	.2570		F	2 7/8	361406	33.95	361506	40.00
.1405		28	1 3/4	361228	25.35	361328	29.80	.2610		G	2 7/8	361407	34.70	361507	40.90	.2610		G	2 7/8	361407	34.70	361507	40.90
.1406	9/64		1 3/4	361009	19.25	361109	22.70	.2656	17/64		2 7/8	361017	25.35	361117	29.80	.2656	17/64		2 7/8	361017	25.35	361117	29.80
.1440		27	1 7/8	361227	25.90	361327	30.45	.2660		H	2 7/8	361408	35.50	361508	41.70	.2660		H	2 7/8	361408	35.50	361508	41.70
.1470		26	1 7/8	361226	25.35	361326	29.80	.2720		I	2 7/8	361409	34.70	361509	40.90	.2720		I	2 7/8	361409	34.70	361509	40.90
.1495		25	1 7/8	361225	25.35	361325	29.80	.2770		J	2 7/8	361410	35.50	361510	41.70	.2770		J	2 7/8	361410	35.50	361510	41.70
.1520		24	2	361224	25.90	361324	30.45	.2810		K	2 15/16	361411	35.50	361511	41.70	.2810		K	2 15/16	361411	35.50	361511	41.70
.1540		23	2	361223	25.35	361323	29.80	.2812	9/32		2 15/16	361018	25.35	361118	29.80	.2812	9/32		2 15/16	361018	25.35	361118	29.80
.1562	5/32		2	361010	18.90	361110	22.25	.2900		L	2 15/16	361412	35.50	361512	41.70	.2900		L	2 15/16	361412	35.50	361512	41.70
.1570		22	2	361222	27.70	361322	32.60	.2950		M	3 1/16	361413	39.05	361513	46.00	.2950		M	3 1/16	361413	39.05	361513	46.00
.1590		21	2 1/8	361221	26.90	361321	31.65	.2969	19/64		3 1/16	361019	27.50	361119	32.35	.2969	19/64		3 1/16	361019	27.50	361119	32.35
.1610		20	2 1/8	361220	27.50	361320	32.35	.3020		N	3 1/16	361414	38.20	361514	44.95	.3020		N	3 1/16	361414	38.20	361514	44.95
.1660		19	2 1/8	361219	27.50	361319	32.35	.3125	5/16		3 3/16	361020	27.50	361120	32.35	.3125	5/16		3 3/16	361020	27.50	361120	32.35
.1695		18	2 1/8	361218	27.50	361318	32.35	.3160		O	3 3/16	361415	36.35	361515	42.70	.3160		O	3 3/16	361415	36.35	361515	42.70
.1719	11/64		2 1/8	361011	20.60	361111	24.20	.3230		P	3 5/16	361416	38.70	361516	45.50	.3230		P	3 5/16	361416	38.70	361516	45.50
.1730		17	2 3/16	361217	27.50	361317	32.35	.3281	21/64		3 5/16	361021	29.25	361121	34.45	.3281	21/64		3 5/16	361021	29.25	361121	34.45
.1770		16	2 3/16	361216	26.90	361316	31.65	.3320		Q	3 7/16	361417	39.70	361517	46.70	.3320		Q	3 7/16	361417	39.70	361517	46.70
.1800		15	2 3/16	361215	27.70	361315	32.60	.3390		R	3 7/16	361418	38.70	361518	45.50	.3390		R	3 7/16	361418	38.70	361518	45.50
.1820		14	2 3/16	361214	26.90	361314	31.65	.3438	11/32		3 7/16	361022	29.25	361122	34.45	.3438	11/32		3 7/16	361022	29.25	361122	34.45
.1850		13	2 5/16	361213	26.90	361313	31.65	.3480		S	3 1/2	361419	41.80	361519	49.15	.3480		S	3 1/2	361419	41.80	361519	49.15
.1875	3/16		2 5/16	361012	20.15	361112	23.75	.3580		T	3 1/2	361420	42.85	361520	50.40	.3580		T	3 1/2	361420	42.85	361520	50.40
.1890		12	2 5/16	361212	28.00	361312	33.00	.3594	23/64		3 1/2	361023	31.15	361123	36.60	.3594	23/64		3 1/2	361023	31.15	361123	36.60
.1910		11	2 5/16	361211	28.35	361311	33.40	.3680		U	3 5/8	361421	41.25	361521	48.50	.3680		U	3 5/8	361421	41.25	361521	48.50
.1935		10	2 7/16	361210	28.00	361310	33.00	.3750	3/8		3 5/8	361024	31.15	361124	36.60	.3750	3/8		3 5/8	361024	31.15	361124	36.60
.1960		9	2 7/16	361209	28.35	361309	33.40	.3770		V	3 5/8	361422	41.80	361522	49.15	.3770		V	3 5/8	361422	41.80	361522	49.15
.1990		8	2 7/16	361208	28.35	361308	33.40	.3860		W	3 3/4	361423	44.85	361523	52.80	.3860		W	3 3/4	361423	44.85	361523	52.80
.2010		7	2 7/16	361207	28.35	361307	33.40	.3906	25/64		3 3/4	361025	32.05	361125	37.75	.3906	25/64		3 3/4	361025	32.05	361125	37.75
.2031	13/64		2 7/16	361013	22.05	361113	25.90	.3970		X	3 3/4	361424	42.50	361524	50.00	.3970		X	3 3/4	361424	42.50	361524	50.00
.2040		6	2 1/2	361206	29.10	361306	34.30	.4040		Y	3 7/8	361425	44.10	361525	51.85	.4040		Y	3 7/8	361425	44.10	361525	51.85
.2055		5	2 1/2	361205	28.35	361305	33.40	.4062	13/32		3 7/8	361026	31.55	361126	37.20	.4062	13/32		3 7/8	361026	31.55	361126	37.20
.2090		4	2 1/2	361204	26.65	361304	31.35	.4130		Z	3 7/8	361426	49.70	361526	58.45	.4130		Z	3 7/8	361426	49.70	361526	58.45
.2130		3	2 1/2	361203	28.35	361303	33.40	.4219	27/64		3 15/16	361027	34.70	361127	40.90	.4219	27/64		3 15/16	361027	34.70	361127	40.90
.2188	7/32		2 1/2	361014	22.05	361114	25.90	.4375	7/16		4 1/16	361028	34.70	361128	40.90	.4375	7/16		4 1/16	361028	34.70	361128	40.90
.2210		2	2 5/8	361202	27.85	361302	32.75	.4531	29/64		4 3/16	361029	39.90	361129	47.00	.4531	29/64		4 3/16	361029	39.90	361129	47.00
.2280		1	2 5/8	361201	27.50	361301	32.35	.4688	15/32		4 5/16	361030	39.05	361130	46.00	.4688	15/32		4 5/16	361030	39.05	361130	46.00
.2340		A	2 5/8	361401	33.10	361501	38.90	.4844	31/64		4 3/8	361031	43.80	361131	51.60	.4844	31/64		4 3/8	361031	43.80	361131	51.60
.2344	15/64		2 5/8	361015	23.75	361115	27.95	.5000	1/2		4 1/2	361032	43.80	361132	51.60	.5000	1/2		4 1/2	361032	43.80	361132	51.60

CARBIDE TIPPED EXTRA LONG FLUTE TAPER SHANK DRILLS



TYPE 3664 - TAPER SHANK - 118° POINT - 8" FLUTE LENGTH

Carbide tip brazed to hardened tool steel bodies. Same heavy duty construction as standard flute length taper shank drill. Designed for application requiring extended reach and use with drill bushings.

For drill tolerances, see page 134.
For standard flute length, see page 120.

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3664 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.5000	1/2	8	12	2	366432	\$149.10
.5156	33/64	8	12	2	366433	182.70
.5312	17/32	8	12	2	366434	172.40
.5469	35/64	8	12	2	366435	182.70
.5625	9/16	8	12	2	366436	172.40
.5781	37/64	8	12	2	366437	182.70
.5938	19/32	8	12	2	366438	172.40
.6094	39/64	8	12	2	366439	241.85
.6250	5/8	8	12	2	366440	228.20
.6406	41/64	8	12	2	366441	253.95

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3664 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.6562	21/32	8	12	2	366442	\$239.55
.6719	43/64	8	12	2	366443	253.95
.6875	11/16	8	12	2	366444	239.55
.7031	45/64	8	12	2	366445	266.70
.7188	23/32	8	12	2	366446	251.55
.7344	47/64	8	12	2	366447	266.70
.7500	3/4	8	12	2	366448	251.55
.7656	49/64	8	12	2	366449	280.00
.7812	25/32	8	12	2	366450	264.15
-	-	-	-	-	-	-

TYPE 3665 - TAPER SHANK - 118° POINT - 11" FLUTE LENGTH

For drill tolerances, see page 134.

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3665 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.6094	39/64	11	14 3/4	2	366539	\$258.80
.6250	5/8	11	14 3/4	2	366540	244.20
.6406	41/64	11	14 3/4	2	366541	271.80
.6562	21/32	11	14 3/4	2	366542	256.40
.6719	43/64	11	14 3/4	2	366543	271.80
.6875	11/16	11	14 3/4	2	366544	256.40
.7031	45/64	11	14 3/4	2	366545	285.35
.7188	23/32	11	14 3/4	2	366546	269.15
.7344	47/64	11	14 3/4	2	366547	285.35
.7500	3/4	11	14 3/4	2	366548	269.15
.7656	49/64	11	14 3/4	2	366549	299.60
.7812	25/32	11	14 3/4	2	366550	282.60
.7969	51/64	11	15 1/2	3	366551	327.45
.8125	13/16	11	15 1/2	3	366552	308.90

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3665 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.8281	53/64	11	15 1/2	3	366553	\$327.45
.8438	27/32	11	15 1/2	3	366554	308.90
.8594	55/64	11	15 1/2	3	366555	327.45
.8750	7/8	11	15 1/2	3	366556	308.90
.8906	57/64	11	15 1/2	3	366557	399.95
.9062	29/32	11	15 1/2	3	366558	377.30
.9219	59/64	11	15 1/2	3	366559	399.95
.9375	15/16	11	15 1/2	3	366560	377.30
.9531	61/64	11	15 1/2	3	366561	420.00
.9688	31/32	11	15 1/2	3	366562	396.20
.9844	63/64	11	15 1/2	3	366563	420.00
1.0000	1	11	15 1/2	3	366564	396.20
1.0312	1 1/32	11	15 1/2	3	366566	408.10
1.0625	1 1/16	11	15 1/2	3	366568	420.35

CARBIDE TIPPED STRAIGHT FLUTE COOLANT DRILLS



TYPE 3658 - 125° 4 FACET POINT - EXTRA LONG LENGTH

Carbide tip brazed to hardened tool steel bodies. Self centering point with polished straight flutes for hole straightness and chip removal capacity. Shank diameter is same size as tool diameter. Drill body diameter is smaller than tool diameter. Two coolant holes.

Tool and shank diameter tolerances: +.000"/-.001"

TOOL DIAMETER		LENGTH		TYPE 3658 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRAC.	FLUTE	OVERALL			
.3125	5/16	8	10	365820	\$253.75	.3100 - .3160
.3438	11/32	8	10	365822	253.75	.3281 - .3460
.3750	3/8	9	11	365824	268.10	.3594 - .3770
.4062	13/32	9	11	365826	305.20	.3906 - .4080
.4375	7/16	9	11	365828	305.20	.4200 - .4390
.4688	15/32	9 3/4	12	365830	322.35	.4531 - .4710
.5000	1/2	9 3/4	12	365832	322.35	.4800 - .5030
.5312	17/32	9 3/4	12	365834	345.95	.5118 - .5330

TOOL DIAMETER		LENGTH		TYPE 3658 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRAC.	FLUTE	OVERALL			
.5625	9/16	10 3/4	13	365836	\$372.65	.5430 - .5650
.6250	5/8	10 3/4	13	365840	393.45	.6070 - .6270
.6875	11/16	11 3/4	14	365844	409.70	.6693 - .6900
.7500	3/4	11 3/4	14	365848	433.60	.7320 - .7530
.8125	13/16	12 3/4	15	365852	460.45	.7953 - .8160
.8750	7/8	12 3/4	15	365856	496.20	.8570 - .8780
.9375	15/16	13 3/4	16	365860	530.20	.9180 - .9390
1.0000	1	13 3/4	16	365864	574.15	.9820 - 1.0030

CARBIDE TIPPED STRAIGHT FLUTE COOLANT DRILLS

TYPE 3650 - 125° 4 FACET POINT - LONG LENGTH

Carbide tip brazed to hardened tool steel bodies. Self centering point with polished straight flutes for hole straightness and chip removal capacity. Shank diameter is same size as tool diameter. Drill body diameter is smaller than tool diameter. Two coolant holes. Where possible use shorter length
Type 3652 for greater rigidity.



TOOL DIAMETER		LENGTH		TYPE 3650 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTIONAL	FLUTE	OVERALL			
.2500	1/4	4 5/8	6 1/8	365016	\$175.80	.2490 - .2530
.2656	17/64	4 3/4	6 1/4	365017	175.80	-
.2812	9/32	4 3/4	6 1/4	365018	175.80	.2640 - .2840
.2969	19/64	4 7/8	6 3/8	365019	175.80	-
.3125	5/16	4 7/8	6 3/8	365020	175.80	.2950 - .3160
.3281	21/64	5	6 1/2	365021	169.25	-
.3438	11/32	5	6 1/2	365022	169.25	.3260 - .3460
.3594	23/64	5 1/4	6 3/4	365023	164.95	-
.3750	3/8	5 1/4	6 3/4	365024	171.20	.3540 - .3770
.3906	25/64	5 1/2	7	365025	169.25	-
.4062	13/32	5 1/2	7	365026	169.25	.3850 - .4080
.4219	27/64	5 3/4	7 1/4	365027	174.65	-
.4375	7/16	5 3/4	7 1/4	365028	174.65	.4100 - .4390
.4531	29/64	5 3/4	7 1/2	365029	185.70	-
.4688	15/32	5 3/4	7 1/2	365030	185.70	.4391 - .4724
.4844	31/64	5 3/4	7 3/4	365031	191.25	-
.5000	1/2	5 3/4	7 3/4	365032	191.25	.4725 - .5030
.5156	33/64	6	8	365033	205.20	-
.5312	17/32	6	8	365034	205.20	.5031 - .5330
.5469	35/64	6 1/4	8 1/4	365035	212.55	-
.5625	9/16	6 1/4	8 1/4	365036	216.15	.5331 - .5650

TOOL DIAMETER		LENGTH		TYPE 3650 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTIONAL	FLUTE	OVERALL			
.5781	37/64	6 3/4	8 3/4	365037	\$255.90	-
.5938	19/32	6 3/4	8 3/4	365038	260.25	.5651 - .5950
.6094	39/64	6 3/4	8 3/4	365039	255.90	-
.6250	5/8	6 3/4	8 3/4	365040	260.25	.5951 - .6270
.6406	41/64	7	9	365041	269.70	-
.6562	21/32	7	9	365042	274.35	.6271 - .6570
.6719	43/64	7 1/4	9 1/4	365043	288.75	-
.6875	11/16	7 1/4	9 1/4	365044	293.85	.6571 - .6900
.7031	45/64	7 1/2	9 1/2	365045	299.75	-
.7188	23/32	7 1/2	9 1/2	365046	304.80	.6901 - .7220
.7344	47/64	7 3/4	9 3/4	365047	302.25	-
.7500	3/4	7 3/4	9 3/4	365048	307.50	.7221 - .7530
.7656	49/64	7 7/8	9 7/8	365049	327.00	-
.7812	25/32	7 7/8	9 7/8	365050	327.00	.7531 - .7840
.8125	13/16	8	10	365052	332.50	.7841 - .8160
.8438	27/32	8	10	365054	351.95	.8161 - .8470
.8750	7/8	8	10	365056	360.20	.8471 - .8780
.9062	29/32	8	10	365058	399.15	.8781 - .9090
.9375	15/16	8 3/4	10 3/4	365060	415.65	.9091 - .9390
.9688	31/32	9	11	365062	419.65	.9391 - .9700
1.0000	1	9	11	365064	419.65	.9701 - 1.0030

TYPE 3652 - 125° 4 FACET POINT - SHORT LENGTH

Same as Type 3650 above, except shorter length.



BOTH TYPES ON THIS PAGE:

Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER		LENGTH		TYPE 3652 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTIONAL	FLUTE	OVERALL			
.2500	1/4	2 1/2	4 29/32	365216	\$160.50	.2490 - .2530
.2656	17/64	2 3/4	5 5/32	365217	160.50	-
.2812	9/32	2 3/4	5 5/32	365218	160.50	.2640 - .2840
.2969	19/64	3 3/16	5 19/32	365219	160.50	-
.3125	5/16	3 3/16	5 19/32	365220	160.50	.2950 - .3160
.3281	21/64	3 7/16	5 27/32	365221	160.50	-
.3438	11/32	3 7/16	5 27/32	365222	160.50	.3260 - .3460
.3594	23/64	3 5/8	6 1/32	365223	162.20	-
.3750	3/8	3 5/8	6 1/32	365224	162.20	.3540 - .3770
.3906	25/64	3 7/8	6 5/32	365225	166.25	-
.4062	13/32	3 7/8	6 5/32	365226	166.25	.3850 - .4080
.4219	27/64	4 1/16	6 15/32	365227	171.90	-
.4375	7/16	4 1/16	6 15/32	365228	171.90	.4100 - .4390
.4531	29/64	4 5/16	6 23/32	365229	183.00	-
.4688	15/32	4 5/16	6 23/32	365230	183.00	.4391 - .4724
.4844	31/64	4 1/2	6 29/32	365231	188.40	-
.5000	1/2	4 1/2	6 29/32	365232	188.40	.4725 - .5030
.5156	33/64	4 13/16	7 7/32	365233	196.25	-
.5312	17/32	4 13/16	7 7/32	365234	199.65	.5031 - .5330
.5469	35/64	4 13/16	7 7/32	365235	207.05	-
.5625	9/16	4 13/16	7 7/32	365236	210.60	.5331 - .5650

TOOL DIAMETER		LENGTH		TYPE 3652 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTIONAL	FLUTE	OVERALL			
.5781	37/64	5 3/16	7 19/32	365237	\$248.15	-
.5938	19/32	5 3/16	7 19/32	365238	252.35	.5651 - .5950
.6094	39/64	5 3/16	7 19/32	365239	248.15	-
.6250	5/8	5 3/16	7 19/32	365240	252.35	.5951 - .6270
.6406	41/64	5 3/16	7 19/32	365241	266.05	-
.6562	21/32	5 3/16	7 19/32	365242	266.05	.6271 - .6570
.6719	43/64	5 5/8	8 1/32	365243	287.85	-
.6875	11/16	5 5/8	8 1/32	365244	288.25	.6571 - .6900
.7031	45/64	5 5/8	8 1/32	365245	296.45	-
.7188	23/32	5 5/8	8 1/32	365246	296.45	.6901 - .7220
.7344	47/64	6 1/16	8 15/32	365247	299.35	-
.7500	3/4	6 1/16	8 15/32	365248	299.35	.7221 - .7530
.7656	49/64	6 1/16	8 9/16	365249	313.40	-
.7812	25/32	6 1/16	8 9/16	365250	318.85	.7531 - .7840
.8125	13/16	6 1/16	8 9/16	365252	324.15	.7841 - .8160
.8438	27/32	6 1/2	9	365254	343.70	.8161 - .8470
.8750	7/8	6 1/2	9	365256	351.95	.8471 - .8780
.9062	29/32	6 15/16	9 7/16	365258	376.70	.8781 - .9090
.9375	15/16	6 15/16	9 7/16	365260	404.60	.9091 - .9390
.9688	31/32	6 15/16	9 7/16	365262	421.20	.9391 - .9700
1.0000	1	7 3/8	9 7/8	365264	432.25	.9701 - 1.0030

CARBIDE TIPPED STRAIGHT FLUTE COOLANT DRILLS

METRIC

TYPE 3650 - 125° 4 FACET POINT - LONG LENGTH

Carbide tip brazed to hardened tool steel bodies. Self centering point with polished straight flutes for hole straightness and chip removal capacity. Shank diameter is same size as tool diameter. Drill body diameter is smaller than tool diameter. Two coolant holes. Where possible use shorter length Type 3652 for greater rigidity.



TOOL DIAMETER	LENGTH				TYPE 3650 EDP NO.	PRICE EACH	METRIC SIZE RANGE*	
	FLUTE		OVERALL					
mm	INCH	mm	INCH	mm	INCH			
**6.5	.2559	117	4 3/8	156	6 1/8	3650065	\$183.20	-
7.0	.2756	121	4 3/4	159	6 1/4	3650070	183.20	6.706 - 7.214
7.5	.2953	124	4 7/8	162	6 3/8	3650075	183.20	7.493 - 8.026
8.0	.3150	124	4 7/8	162	6 3/8	3650080	183.20	-
8.5	.3346	127	5	165	6 1/2	3650085	176.90	8.280 - 8.788
9.0	.3543	133	5 1/4	171	6 3/4	3650090	176.90	8.992 - 9.576
9.5	.3740	133	5 1/4	171	6 3/4	3650095	176.90	-
10.0	.3937	140	5 1/2	178	7	3650100	176.90	9.779 - 10.363
10.5	.4134	146	5 3/4	184	7 1/4	3650105	183.20	10.414 - 11.151
11.0	.4331	146	5 3/4	184	7 1/4	3650110	183.20	-
11.5	.4528	146	5 3/4	191	7 1/2	3650115	197.95	11.153 - 12.000
12.0	.4724	146	5 3/4	191	7 1/2	3650120	197.95	-
12.5	.4921	146	5 3/4	197	7 3/4	3650125	202.25	12.002 - 12.776
13.0	.5118	152	6	203	8	3650130	214.75	12.779 - 13.538
13.5	.5315	152	6	203	8	3650135	214.75	-
14.0	.5512	159	6 1/4	210	8 1/4	3650140	225.30	13.541 - 14.351
14.5	.5709	171	6 3/4	222	8 3/4	3650145	273.70	14.354 - 15.113
15.0	.5906	171	6 3/4	222	8 3/4	3650150	273.70	-
15.5	.6102	171	6 3/4	222	8 3/4	3650155	273.70	15.116 - 15.926

TOOL DIAMETER	LENGTH				TYPE 3650 EDP NO.	PRICE EACH	METRIC SIZE RANGE*	
	FLUTE		OVERALL					
mm	INCH	mm	INCH	mm	INCH			
16.0	.6299	178	7	229	9	3650160	\$280.05	15.928 - 16.688
16.5	.6496	178	7	229	9	3650165	280.05	-
17.0	.6693	184	7 1/4	235	9 1/4	3650170	299.05	16.690 - 17.526
17.5	.6890	184	7 1/4	235	9 1/4	3650175	299.05	-
18.0	.7087	191	7 1/2	241	9 1/2	3650180	313.80	17.529 - 18.339
18.5	.7283	197	7 3/4	248	9 3/4	3650185	315.85	18.341 - 19.126
19.0	.7480	197	7 3/4	248	9 3/4	3650190	315.85	-
19.5	.7677	200	7 7/8	251	9 7/8	3650195	334.90	19.129 - 19.914
20.0	.7874	203	8	254	10	3650200	339.05	19.916 - 20.726
20.5	.8071	203	8	254	10	3650205	339.05	-
21.0	.8268	203	8	254	10	3650210	358.00	20.729 - 21.514
21.5	.8465	203	8	254	10	3650215	358.00	-
22.0	.8661	203	8	254	10	3650220	366.45	21.516 - 22.301
22.5	.8858	203	8	254	10	3650225	404.35	22.304 - 23.089
23.0	.9055	203	8	254	10	3650230	404.35	-
23.5	.9252	222	8 3/4	273	10 3/4	3650235	419.10	23.091 - 23.851
24.0	.9449	229	9	279	11	3650240	435.90	23.853 - 24.638
24.5	.9646	229	9	279	11	3650245	435.90	-
25.0	.9843	229	9	279	11	3650250	435.90	24.641 - 25.476

TYPE 3652 - 125° 4 FACET POINT - SHORT LENGTH

Same as Type 3650 above, except shorter length.



BOTH TYPES ON THIS PAGE:

Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER	LENGTH				TYPE 3652 EDP NO.	PRICE EACH	METRIC SIZE RANGE*	
	FLUTE		OVERALL					
mm	INCH	mm	INCH	mm	INCH			
**6.5	.2559	64	2 1/2	125	4 29/32	3652065	\$183.20	-
7.0	.2756	70	2 3/4	131	5 5/32	3652070	183.20	6.706 - 7.214
7.5	.2953	81	3 3/16	142	5 19/32	3652075	183.20	7.493 - 8.026
8.0	.3150	81	3 3/16	142	5 19/32	3652080	183.20	-
8.5	.3346	87	3 7/16	148	5 27/32	3652085	176.90	8.280 - 8.788
9.0	.3543	92	3 5/8	153	6 1/32	3652090	176.90	8.992 - 9.576
9.5	.3740	92	3 5/8	153	6 1/32	3652095	176.90	-
10.0	.3937	98	3 7/8	159	6 9/32	3652100	176.90	9.779 - 10.363
10.5	.4134	103	4 1/16	164	6 15/32	3652105	183.20	10.414 - 11.151
11.0	.4331	103	4 1/16	164	6 15/32	3652110	183.20	-
11.5	.4528	109	4 5/16	171	6 23/32	3652115	197.95	11.153 - 12.000
12.0	.4724	109	4 5/16	171	6 23/32	3652120	197.95	-
12.5	.4921	114	4 1/2	175	6 29/32	3652125	202.25	12.002 - 12.776
13.0	.5118	122	4 13/16	183	7 7/32	3652130	214.75	12.779 - 13.538
13.5	.5315	122	4 13/16	183	7 7/32	3652135	214.75	-
14.0	.5512	122	4 13/16	183	7 7/32	3652140	225.35	13.541 - 14.351
14.5	.5709	131	5 3/16	193	7 19/32	3652145	273.70	14.354 - 15.113
15.0	.5906	131	5 3/16	193	7 19/32	3652150	273.70	-
15.5	.6102	131	5 3/16	193	7 19/32	3652155	273.70	15.116 - 15.926

TOOL DIAMETER	LENGTH				TYPE 3652 EDP NO.	PRICE EACH	METRIC SIZE RANGE*	
	FLUTE		OVERALL					
mm	INCH	mm	INCH	mm	INCH			
16.0	.6299	131	5 3/16	193	7 19/32	3652160	\$280.05	15.928 - 16.688
16.5	.6496	131	5 3/16	193	7 19/32	3652165	280.05	-
17.0	.6693	143	5 5/8	204	8 1/32	3652170	299.05	16.690 - 17.526
17.5	.6890	143	5 5/8	204	8 1/32	3652175	299.05	-
18.0	.7087	143	5 5/8	204	8 1/32	3652180	313.80	17.529 - 18.339
18.5	.7283	154	6 1/16	215	8 15/32	3652185	315.85	18.341 - 19.126
19.0	.7480	154	6 1/16	215	8 15/32	3652190	315.85	-
19.5	.7677	154	6 1/16	217	8 9/16	3652195	334.85	19.129 - 19.914
20.0	.7874	154	6 1/16	217	8 9/16	3652200	339.05	19.916 - 20.726
20.5	.8071	154	6 1/16	217	8 9/16	3652205	339.05	-
21.0	.8268	165	6 1/2	229	9	3652210	358.00	20.729 - 21.514
21.5	.8465	165	6 1/2	229	9	3652215	358.00	-
22.0	.8661	165	6 1/2	229	9	3652220	366.45	21.516 - 22.301
22.5	.8858	176	6 15/16	240	9 7/16	3652225	404.30	22.304 - 23.089
23.0	.9055	176	6 15/16	240	9 7/16	3652230	404.30	-
23.5	.9252	176	6 15/16	240	9 7/16	3652235	419.10	23.091 - 23.851
24.0	.9449	176	6 15/16	240	9 7/16	3652240	435.90	23.853 - 24.638
24.5	.9646	176	6 15/16	240	9 7/16	3652245	432.25	-
25.0	.9843	187	7 3/8	251	9 7/8	3652250	435.90	24.641 - 25.476

CARBIDE TIPPED COOLANT TWIST DRILLS



TOOL DIAMETER		LENGTH		125° 4 FACET PT.		135° SPLIT PT.		DECIMAL SIZE RANGE*
DECIMAL	FRAC.	FLUTE	OVERALL	TYPE 3656 EDP NO.	PRICE EACH	TYPE 3657 EDP NO.	PRICE EACH	
.2500	1/4	3 3/4	6 1/8	365616	\$176.35	365716	\$210.65	-
.2812	9/32	3 7/8	6 1/4	365618	176.35	365718	207.35	.2650 - .2840
.3125	5/16	4	6 3/8	365620	176.35	365720	207.35	.2953 - .3150
.3438	11/32	4 1/8	6 1/2	365622	176.35	365722	207.35	.3280 - .3460
.3750	3/8	4 1/4	6 3/4	365624	176.35	365724	207.35	.3543 - .3770
.4062	13/32	4 3/8	7	365626	176.35	365726	222.50	.3900 - .4080
.4375	7/16	4 5/8	7 1/4	365628	176.35	365728	222.50	.4130 - .4390
.4688	15/32	4 7/8	7 1/2	365630	187.45	365730	222.20	.4391 - .4710
.5000	1/2	5	7 3/4	365632	193.00	365732	222.30	.4711 - .5020
.5312	17/32	5 1/4	8	365634	207.20	365734	238.45	.5021 - .5330
.5625	9/16	5 3/8	8 1/4	365636	218.35	365736	251.25	.5331 - .5640
.5938	19/32	5 5/8	8 1/2	365638	260.35	365738	296.30	.5641 - .5940
.6250	5/8	5 3/4	8 3/4	365640	260.35	365740	296.30	.5941 - .6260
.6562	21/32	5 7/8	9	365642	276.90	365742	315.20	.6261 - .6570
.6875	11/16	6	9 1/4	365644	296.65	365744	337.60	.6571 - .6900
.7188	23/32	6 3/16	9 1/2	365646	309.05	365746	346.25	.6901 - .7210
.7500	3/4	6 3/8	9 3/4	365648	310.75	365748	348.15	.7211 - .7520

TYPE 3656 - 125° 4 FACET POINT LONG LENGTH

Carbide tip brazed to hardened tool steel bodies with polished right spiral flutes. Self centering point. Shank and body diameters are same size as tool diameter. Two coolant holes. Heavy web with slow spiral for best rigidity and improved chip removal.

TYPE 3657 - 135° SPLIT POINT LONG LENGTH

Same as Type 3656 above, except with 135° cam relieved split point.

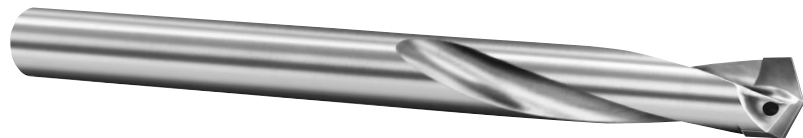
Tool and shank diameter tolerances: +.000"/-.001".

*Call for decimal size pricing.

TYPE 3654 - 125° 4 FACET POINT - STUB LENGTH

TYPE 3655 - 135° SPLIT POINT - STUB LENGTH

Same as Type 3656 & 3657 above, except shorter length and shank & body diameters are smaller than tool diameter.



Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER		FLUTE LENGTH	SHANK & BODY DIAM.	OVER-ALL LENGTH	125° 4 FACET PT.		135° SPLIT PT.	
DECIMAL	FRAC.				TYPE 3654 EDP NO.	PRICE EACH	TYPE 3655 EDP NO.	PRICE EACH
.2500	1/4	1 17/32	.2344	3 15/16	365416	\$163.60	365516	\$201.15
.2656	17/64	1 19/32	.2500	4	365417	186.55	365517	214.75
.2812	9/32	1 19/32	.2656	4	365418	175.30	365518	212.30
.2969	19/64	1 3/4	.2812	4 5/32	365419	186.55	365519	214.75
.3125	5/16	1 3/4	.2969	4 5/32	365420	175.30	365520	212.30
.3281	21/64	1 15/16	.3125	4 11/32	365421	186.55	365521	214.75
.3438	11/32	1 15/16	.3281	4 11/32	365422	175.30	365522	212.30
.3594	23/64	2 1/8	.3438	4 17/32	365423	186.55	365523	223.45
.3750	3/8	2 1/8	.3594	4 17/32	365424	175.30	365524	212.30
.3906	25/64	2 5/32	.3750	4 11/16	365425	186.55	365525	236.45
.4062	13/32	2 9/32	.3906	4 11/16	365426	175.30	365526	227.70
.4219	27/64	2 1/2	.4062	4 29/32	365427	186.55	365527	236.45
.4375	7/16	2 1/2	.4219	4 29/32	365428	175.30	365528	227.70
.4531	29/64	2 21/32	.4375	5 1/16	365429	197.40	365529	236.45
.4688	15/32	2 21/32	.4531	5 1/16	365430	186.60	365530	227.70
.4844	31/64	2 13/16	.4688	5 7/32	365431	201.75	365531	236.45
.5000	1/2	2 13/16	.4844	5 7/32	365432	192.15	365532	227.70
.5156	33/64	3	.5000	5 13/32	365433	199.50	365533	236.45
.5312	17/32	3	.5156	5 13/32	365434	192.15	365534	227.70
.5469	35/64	3 1/8	.5312	5 17/32	365435	199.50	365535	236.45
.5625	9/16	3 1/8	.5469	5 17/32	365436	192.15	365536	227.70
.5781	37/64	3 9/32	.5625	5 11/16	365437	214.75	365537	247.25
.5938	19/32	3 9/32	.5781	5 11/16	365438	205.65	365538	241.05
.6094	39/64	3 7/16	.5938	5 27/32	365439	214.75	365539	247.25
.6250	5/8	3 7/16	.6094	5 27/32	365440	205.65	365540	241.05
.6406	41/64	3 21/32	.6250	6 1/16	365441	214.75	365541	247.25
.6562	21/32	3 21/32	.6406	6 1/16	365442	205.65	365542	241.05

TOOL DIAMETER		FLUTE LENGTH	SHANK & BODY DIAM.	OVER-ALL LENGTH	125° 4 FACET PT.		135° SPLIT PT.	
DECIMAL	FRAC.				TYPE 3654 EDP NO.	PRICE EACH	TYPE 3655 EDP NO.	PRICE EACH
.6719	43/64	3 13/16	.6562	6 7/32	365443	\$214.75	365543	\$247.25
.6875	11/16	3 13/16	.6719	6 7/32	365444	205.65	365544	241.05
.7031	45/64	3 15/16	.6875	6 11/32	365445	238.65	365545	273.35
.7188	23/32	3 15/16	.7031	6 11/32	365446	229.95	365546	265.40
.7344	47/64	4 1/8	.7188	6 17/32	365447	238.65	365547	273.35
.7500	3/4	4 1/8	.7344	6 17/32	365448	229.95	365548	265.40
.7656	49/64	4 9/32	.7500	6 25/32	365449	238.65	365549	273.35
.7812	25/32	4 9/32	.7656	6 25/32	365450	229.95	365550	265.40
.7969	51/64	4 7/16	.7812	6 15/16	365451	284.20	365551	316.75
.8125	13/16	4 7/16	.7969	6 15/16	365452	274.25	365552	309.55
.8281	53/64	4 19/32	.8125	7 3/32	365453	284.20	365553	316.75
.8438	27/32	4 19/32	.8281	7 3/32	365454	274.25	365554	309.55
.8594	55/64	4 11/16	.8438	7 3/16	365455	284.20	365555	316.75
.8750	7/8	4 11/16	.8594	7 3/16	365456	274.25	365556	309.55
.8906	57/64	4 7/8	.8750	7 3/8	365457	301.50	365557	336.30
.9062	29/32	4 7/8	.8906	7 3/8	365458	292.00	365558	327.25
.9219	59/64	5 1/32	.9062	7 17/32	365459	301.50	365559	336.30
.9375	15/16	5 1/32	.9219	7 17/32	365460	292.00	365560	327.25
.9531	61/64	5 3/16	.9375	7 11/16	365461	318.90	365561	353.60
.9688	31/32	5 3/16	.9531	7 11/16	365462	307.35	365562	342.65
.9844	63/64	5 5/16	.9688	7 13/16	365463	318.90	365563	353.60
1.0000	1	5 5/16	.9844	7 13/16	365464	307.35	365564	342.65
1.0312	1 1/32	5 11/16	1.0000	8 3/16	365466	331.75	365566	367.00
1.0625	1 1/16	5 11/16	1.0000	8 3/16	365468	342.65	365568	378.15
1.0938	1 3/32	5 11/16	1.0000	8 3/16	365470	351.60	365570	386.95
1.1250	1 1/8	5 11/16	1.0000	8 3/16	365472	364.85	365572	400.25
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CARBIDE TIPPED COOLANT TWIST DRILLS

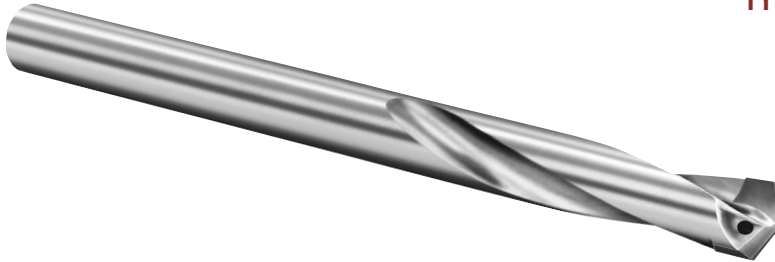
METRIC

TYPE 3654 - 125° 4 FACET POINT - STUB LENGTH

Carbide tip brazed to hardened tool steel bodies with polished right spiral flutes. Self centering point. Shank and body diameters are smaller than tool diameter. Two coolant holes. Heavy web with slow spiral for best rigidity and improved chip removal.

TYPE 3655 - 135° SPLIT POINT - STUB LENGTH

Same as Type 3654 above, except with 135° cam relieved split point.



Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER		FLUTE LENGTH		SHANK & BODY DIAM.		OVERALL LENGTH		125° 4 FACET POINT		135° SPLIT POINT	
mm	INCH	mm	INCH	mm	INCH	mm	INCH	TYPE 3654 EDP NO.	PRICE EACH	TYPE 3655 EDP NO.	PRICE EACH
6.5	.2559	39	1 17/32	6.0	.2362	100	3 15/16	3654065	\$175.75	3655065	\$206.00
7.0	.2756	40	1 19/32	6.5	.2559	102	4	3654070	186.55	3655070	214.75
7.5	.2953	40	1 19/32	7.0	.2756	102	4	3654075	186.55	3655075	214.75
8.0	.3150	44	1 3/4	7.5	.2953	106	4 5/32	3654080	186.55	3655080	214.75
8.5	.3346	49	1 15/16	8.0	.3150	110	4 11/32	3654085	186.55	3655085	223.45
9.0	.3543	49	1 15/16	8.5	.3346	110	4 11/32	3654090	186.55	3655090	223.45
9.5	.3740	54	2 1/8	9.0	.3543	115	4 17/32	3654095	186.55	3655095	223.45
10.0	.3937	58	2 9/32	9.5	.3740	119	4 11/16	3654100	186.55	3655100	236.45
10.5	.4134	58	2 9/32	10.0	.3937	119	4 11/16	3654105	186.55	3655105	236.45
11.0	.4331	64	2 1/2	10.5	.4134	125	4 29/32	3654110	186.55	3655110	236.45
11.5	.4528	67	2 21/32	11.0	.4331	129	5 1/16	3654115	197.40	3655115	236.45
12.0	.4724	67	2 21/32	11.5	.4528	129	5 1/16	3654120	197.40	3655120	236.45
12.5	.4921	71	2 13/16	12.0	.4724	133	5 7/32	3654125	201.75	3655125	236.45
13.0	.5118	76	3	12.5	.4921	137	5 13/32	3654130	199.50	3655130	236.45
13.5	.5315	76	3	13.0	.5118	137	5 13/32	3654135	199.50	3655135	236.45
14.0	.5512	79	3 1/8	13.5	.5315	140	5 17/32	3654140	199.50	3655140	236.45
14.5	.5709	83	3 9/32	14.0	.5512	144	5 11/16	3654145	214.75	3655145	247.25
15.0	.5906	83	3 9/32	14.5	.5709	144	5 11/16	3654150	214.75	3655150	247.25
15.5	.6102	87	3 7/16	15.0	.5906	148	5 27/32	3654155	214.75	3655155	247.25
16.0	.6299	87	3 7/16	15.5	.6102	148	5 27/32	3654160	214.75	3655160	247.25
16.5	.6496	93	3 21/32	16.0	.6299	154	6 1/16	3654165	214.75	3655165	247.25
17.0	.6693	93	3 21/32	16.5	.6496	154	6 1/16	3654170	214.75	3655170	247.25
17.5	.6890	97	3 13/16	17.0	.6693	158	6 7/32	3654175	214.75	3655175	273.35
18.0	.7087	100	3 15/16	17.5	.6890	161	6 11/32	3654180	238.65	3655180	273.35
18.5	.7283	100	3 15/16	18.0	.7087	161	6 11/32	3654185	238.65	3655185	273.35
19.0	.7480	105	4 1/8	18.5	.7283	166	6 17/32	3654190	238.65	3655190	273.35
19.5	.7677	109	4 9/32	19.0	.7480	172	6 25/32	3654195	238.65	3655195	273.35
20.0	.7874	109	4 9/32	19.5	.7677	172	6 25/32	3654200	238.65	3655200	316.75
20.5	.8071	113	4 7/16	20.0	.7874	176	6 15/16	3654205	284.20	3655205	316.75
21.0	.8268	117	4 19/32	20.5	.8071	180	7 3/32	3654210	284.20	3655210	316.75
21.5	.8465	117	4 19/32	21.0	.8268	180	7 3/32	3654215	284.20	3655215	316.75
22.0	.8661	119	4 11/16	21.5	.8465	183	7 3/16	3654220	284.20	3655220	316.75
22.5	.8858	124	4 7/8	22.0	.8661	187	7 3/8	3654225	301.50	3655225	336.30
23.0	.9055	124	4 7/8	22.5	.8858	187	7 3/8	3654230	301.50	3655230	336.30
23.5	.9252	128	5 1/2	23.0	.9055	191	7 17/32	3654235	301.50	3655235	336.30
24.0	.9449	132	5 3/16	23.5	.9252	195	7 11/16	3654240	318.90	3655240	353.60
24.5	.9646	132	5 3/16	24.0	.9449	195	7 11/16	3654245	318.90	3655245	353.60
25.0	.9843	135	5 3/16	24.5	.9646	198	7 13/16	3654250	318.90	3655250	353.60
26.0	1.0236	144	5 11/16	25.5	1.0039	208	8 3/16	3654260	342.65	3655260	377.50

CARBIDE TIPPED CORE DRILLS FOR NON-FERROUS & CAST IRON

TYPE 3620 - FOUR SPIRAL FLUTES - STRAIGHT SHANK

TYPE 3622 - FOUR SPIRAL FLUTES - TAPER SHANK

Carbide tips brazed to hardened tool steel bodies. Right spiral flutes with 118° included chamfer angle.

Core drills, with increased flute capacity, remove more material from a cored or cast hole than a reamer. This often eliminates a final reaming or boring operation. Types 3620 and 3622 core drills are specifically designed for cast iron, non-ferrous and high temperature alloy applications. For steel applications, refer to Types 3621 and 3623 on pages 132 & 133.



Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER		MIN. CUT DIAM.	LENGTH			TYPE 3620		TYPE 3622		BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL		FLT	CARB	OAL	SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.3750	3/8*	.262	3 1/2	5/8	6 3/4	3/8	362012	1	362212	\$101.10	.3471 - .3780	\$138.05	\$119.50	\$113.30	\$110.40	\$107.20	\$104.70
.4062	13/32*	.284	3 5/8	5/8	7	13/32	362013	1	362213	101.10	.3781 - .4090	138.05	119.50	113.30	110.40	107.20	104.70
.4375	7/16*	.306	3 7/8	3/4	7 1/4	7/16	362014	1	362214	101.10	.4091 - .4410	138.05	119.50	113.30	110.40	107.20	104.70
.4688	15/32*	.328	4 1/8	3/4	7 1/2	15/32	362015	1	362215	101.10	.4411 - .4720	138.05	119.50	113.30	110.40	107.20	104.70
.5000	1/2	.350	4 3/8	3/4	8 1/4	1/2	362016	2	362216	101.10	.4721 - .5030	138.05	119.50	113.30	110.40	107.20	104.70
.5312	17/32	.372	4 3/8	3/4	8 1/4	17/32	362017	2	362217	101.55	.5031 - .5340	138.50	120.00	113.80	110.85	107.65	105.15
.5625	9/16	.394	4 3/8	3/4	8 1/4	9/16	362018	2	362218	101.55	.5341 - .5660	138.50	120.00	113.80	110.85	107.65	105.15
.5938	19/32	.416	4 3/8	3/4	8 1/4	19/32	362019	2	362219	106.60	.5661 - .5970	143.55	125.05	118.85	115.90	112.70	110.20
.6250	5/8	.438	4 3/8	3/4	8 1/4	5/8	362020	2	362220	106.60	.5971 - .6280	143.55	125.05	118.85	115.90	112.70	110.20
.6562	21/32	.459	4 3/8	3/4	8 1/4	21/32	362021	2	362221	107.90	.6281 - .6590	144.85	126.35	120.15	117.20	114.00	111.50
.6875	11/16	.481	4 3/8	7/8	8 1/4	11/16	362022	2	362222	108.80	.6591 - .6910	145.75	127.25	121.05	118.10	114.90	112.40
.7188	23/32	.503	4 3/8	7/8	8 1/4	23/32	362023	2	362223	108.80	.6911 - .7220	145.75	127.25	121.05	118.10	114.90	112.40
.7500	3/4	.525	4 3/8	7/8	8 1/4	3/4	362024	2	362224	108.80	.7221 - .7530	145.75	127.25	121.05	118.10	114.90	112.40
.7812	25/32	.547	4 3/8	7/8	8 1/4	25/32	362025	2	362225	111.20	.7531 - .7840	148.20	129.65	123.45	120.50	117.35	114.85
.8125	13/16	.569	4 7/8	7/8	9 1/2	13/16	362026	3	362226	114.30	.7841 - .8160	151.30	132.75	126.55	123.60	120.45	117.95
.8438	27/32	.591	4 7/8	7/8	9 1/2	27/32	362027	3	362227	120.45	.8161 - .8470	157.40	138.90	132.70	129.75	126.55	124.05
.8750	7/8	.612	4 7/8	7/8	9 1/2	7/8	362028	3	362228	120.45	.8471 - .8780	157.40	138.90	132.70	129.75	126.55	124.05
.9062	29/32	.634	4 7/8	7/8	9 1/2	29/32	362029	3	362229	121.20	.8781 - .9090	158.15	139.65	133.45	130.50	127.30	124.80
.9375	15/16	.656	4 7/8	7/8	9 1/2	15/16	362030	3	362230	121.20	.9091 - .9410	158.15	139.65	133.45	130.50	127.30	124.80
.9688	31/32	.678	4 7/8	7/8	9 1/2	31/32	362031	3	362231	125.65	.9411 - .9720	162.60	144.10	137.90	134.95	131.75	129.30
1.0000	1	.700	4 7/8	7/8	9 1/2	1	362032	3	362232	128.00	.9721 - 1.0030	164.95	146.45	140.25	137.30	134.10	131.60
1.0312	1 1/32	.722	4 7/8	7/8	9 1/2	1 1/32	362033	3	362233	129.05	1.0031 - 1.0340	166.00	147.50	141.30	138.35	135.15	132.70
1.0625	1 1/16	.744	4 7/8	7/8	9 1/2	1 1/16	362034	3	362234	130.85	1.0341 - 1.0660	167.85	149.30	143.10	140.15	137.00	134.50
1.0938	1 3/32	.766	4 7/8	1	10 1/2	1 3/32	362035	4	362235	152.40	1.0661 - 1.0970	189.40	170.85	164.65	161.70	158.55	156.05
1.1250	1 1/8	.787	4 7/8	1	10 1/2	1 1/8	362036	4	362236	152.40	1.0971 - 1.1280	189.40	170.85	164.65	161.70	158.55	156.05
1.1562	1 1/32	.809	4 7/8	1	10 1/2	1 1/32	362037	4	362237	166.40	1.1281 - 1.1590	203.35	184.85	178.65	175.70	172.50	170.00
1.1875	1 3/16	.831	4 7/8	1	10 1/2	1 3/16	362038	4	362238	171.25	1.1591 - 1.1905	208.20	189.70	183.50	180.55	177.35	174.85
1.2188	1 7/32	.853	4 7/8	1	10 1/2	1 7/32	362039	4	362239	171.85	1.1906 - 1.2220	208.80	190.30	184.10	181.15	177.95	175.45
1.2500	1 1/4	.875	4 7/8	1	10 1/2	1 1/4	362040	4	362240	172.50	1.2221 - 1.2530	209.50	190.95	184.75	181.80	178.65	176.15
1.2812	1 9/32	.897	4 7/8	1	10 1/2	1 9/32	362041	4	362241	184.85	1.2531 - 1.2840	221.80	203.30	197.10	194.15	190.95	188.45
1.3125	1 5/16	.919	4 7/8	1	10 1/2	1 5/16	362042	4	362242	190.00	1.2841 - 1.3150	226.95	208.45	202.25	199.30	196.10	193.60
1.3438	1 11/32	.940	4 7/8	1	10 1/2	1 11/32	362043	4	362243	194.00	1.3151 - 1.3470	230.95	212.45	206.25	203.30	200.10	197.60
1.3750	1 3/8	.962	4 7/8	1	10 1/2	1 3/8	362044	4	362244	198.70	1.3471 - 1.3780	235.65	217.10	210.90	208.00	204.80	202.30
1.4062	1 13/32	.984	4 7/8	1	10 1/2	1 13/32	362045	4	362245	203.20	1.3781 - 1.4090	240.20	221.65	215.45	212.50	209.35	206.85
1.4375	1 7/16	1.006	4 7/8	1	10 1/2	1 7/16	362046	4	362246	209.20	1.4091 - 1.4410	246.15	227.65	221.45	218.50	215.30	212.80
1.4688	1 15/32	1.025	4 7/8	1	10 1/2	1 15/32	362047	4	362247	215.40	1.4411 - 1.4720	252.35	233.85	227.65	224.70	221.50	219.00
1.5000	1 1/2	1.050	4 7/8	1	10 1/2	1 1/2	362048	4	362248	220.00	1.4721 - 1.5030	256.95	238.45	232.25	229.30	226.10	223.60

CARBIDE TIPPED CORE DRILLS FOR NON-FERROUS & CAST IRON

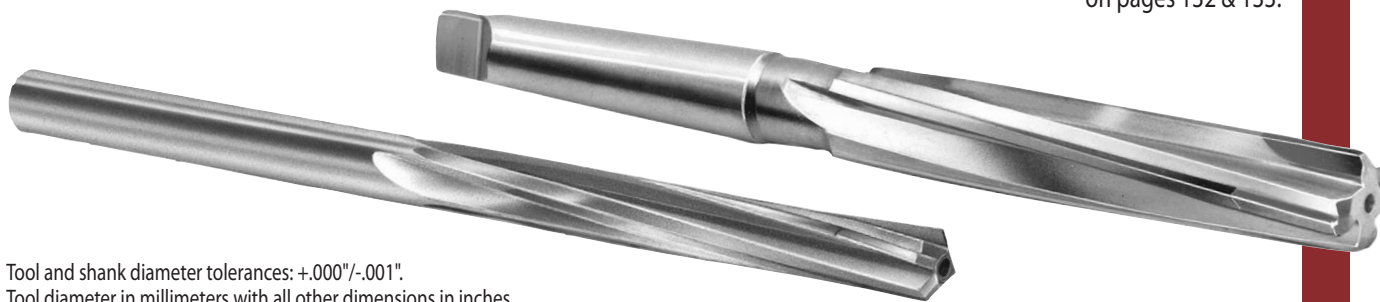
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TYPE 3620 - FOUR SPIRAL FLUTES - STRAIGHT SHANK

TYPE 3622 - FOUR SPIRAL FLUTES - TAPER SHANK

Carbide tips brazed to hardened tool steel bodies. Right spiral flutes with 118° included chamfer angle.

Core drills, with increased flute capacity, remove more material from a cored or cast hole than a reamer. This often eliminates a final reaming or boring operation. Types 3620 and 3622 core drills are specifically designed for cast iron, non-ferrous and high temperature alloy applications. For steel applications, refer to Types 3621 and 3623 on pages 132 & 133.



Tool and shank diameter tolerances: +.000"/-.001".

Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAMETER		MIN. CUT DIAM.	LENGTH			TYPE 3620			TYPE 3622		BOTH TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH		FLT	CARB	OAL	SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.	1 PC.			2 PC.	3 PC.	4 PC.	5-7	8-14	15+	
9.0*	.3543	.262	3 1/2	5/8	6 3/4	3/8	3620090	1	3622090	\$113.30	8.815-9.601	\$141.15	\$122.70	\$116.50	\$113.50	\$110.40	\$107.80	\$104.25	
10.0*	.3937	.284	3 3/8	5/8	7	13/32	3620100	1	3622100	113.30	9.602-10.389	141.15	122.70	116.50	113.50	110.40	107.80	104.25	
11.0*	.4331	.306	3 7/8	3/4	7 1/4	7/16	3620110	1	3622110	113.30	10.390-11.201	141.15	122.70	116.50	113.50	110.40	107.80	104.25	
-*	-	.328	4 1/8	3/4	7 1/2	15/32	3620119	1	3622119	-	11.202-11.989	141.15	122.70	116.50	113.50	110.40	107.80	104.25	
12.0	.4724	.350	4 3/8	3/4	8 1/4	1/2	3620120	2	3622120	113.30	11.990-12.776	141.15	122.70	116.50	113.50	110.40	107.80	104.25	
13.0	.5118	.372	4 3/8	3/4	8 1/4	17/32	3620130	2	3622130	113.80	12.777-13.564	141.60	123.15	116.95	113.95	110.85	108.25	104.70	
14.0	.5512	.394	4 3/8	3/4	8 1/4	9/16	3620140	2	3622140	113.80	13.565-14.376	141.60	123.15	116.95	113.95	110.85	108.25	104.70	
15.0	.5906	.416	4 3/8	3/4	8 1/4	19/32	3620150	2	3622150	118.85	14.377-15.164	146.65	128.20	122.00	119.00	115.90	113.30	109.75	
-	-	.438	4 3/8	3/4	8 1/4	5/8	3620159	2	3622159	-	15.165-15.951	146.65	128.20	122.00	119.00	115.90	113.30	109.75	
16.0	.6299	.459	4 3/8	3/4	8 1/4	21/32	3620160	2	3622160	120.15	15.952-16.739	147.95	129.50	123.30	120.30	117.20	114.60	111.05	
17.0	.6693	.481	4 3/8	7/8	8 1/4	11/16	3620170	2	3622170	121.05	16.740-17.551	148.85	130.40	124.20	121.20	118.10	115.50	111.95	
18.0	.7087	.503	4 3/8	7/8	8 1/4	23/32	3620180	2	3622180	121.05	17.552-18.339	148.85	130.40	124.20	121.20	118.10	115.50	111.95	
19.0	.7480	.525	4 3/8	7/8	8 1/4	3/4	3620190	2	3622190	121.05	18.340-19.126	148.85	130.40	124.20	121.20	118.10	115.50	111.95	
-	-	.547	4 3/8	7/8	8 1/4	25/32	3620199	2	3622199	-	19.127-19.914	151.30	132.85	126.65	123.60	120.50	117.95	114.40	
20.0	.7874	.569	4 7/8	7/8	9 1/2	13/16	3620200	3	3622200	126.55	19.915-20.726	154.40	135.95	129.75	126.70	123.60	121.05	117.50	
21.0	.8268	.591	4 7/8	7/8	9 1/2	27/32	3620210	3	3622210	132.70	20.727-21.514	160.50	142.05	135.85	132.85	129.75	127.15	123.60	
22.0	.8661	.612	4 7/8	7/8	9 1/2	7/8	3620220	3	3622220	132.70	21.515-22.301	160.50	142.05	135.85	132.85	129.75	127.15	123.60	
23.0	.9055	.634	4 7/8	7/8	9 1/2	29/32	3620230	3	3622230	133.45	22.302-23.089	161.25	142.80	136.60	133.60	130.50	127.90	124.35	
-	-	.656	4 7/8	7/8	9 1/2	15/16	3620239	3	3622239	-	23.090-23.901	161.25	142.80	136.60	133.60	130.50	127.90	124.35	
24.0	.9449	.678	4 7/8	7/8	9 1/2	31/32	3620240	3	3622240	137.90	23.902-24.689	165.70	147.25	141.05	138.05	134.95	132.40	128.80	
25.0	.9843	.700	4 7/8	7/8	9 1/2	1	3620250	3	3622250	140.25	24.690-25.476	168.05	149.60	143.40	140.40	137.30	134.70	131.15	
26.0	1.0236	.722	4 7/8	7/8	9 1/2	1 1/32	3620260	3	3622260	141.30	25.477-26.264	169.10	150.65	144.45	141.45	138.35	135.80	132.20	
27.0	1.0630	.744	4 7/8	7/8	9 1/2	1 1/16	3620270	3	3622270	143.10	26.265-27.076	170.95	152.50	146.30	143.25	140.15	137.60	134.05	
-	-	.766	4 7/8	1	10 1/2	1 3/32	3620279	4	3622279	-	27.077-27.864	192.50	174.05	167.85	164.80	161.70	159.15	155.60	
28.0	1.1024	.787	4 7/8	1	10 1/2	1 1/8	3620280	4	3622280	164.65	27.865-28.651	192.50	174.05	167.85	164.80	161.70	159.15	155.60	
29.0	1.1417	.809	4 7/8	1	10 1/2	1 5/32	3620290	4	3622290	178.65	28.652-29.439	206.45	188.00	181.80	178.80	175.70	173.10	169.55	
30.0	1.1811	.831	4 7/8	1	10 1/2	1 3/16	3620300	4	3622300	183.50	29.440-30.239	211.30	192.85	186.65	183.65	180.55	177.95	174.40	
31.0	1.2205	.853	4 7/8	1	10 1/2	1 7/32	3620310	4	3622310	184.10	30.240-31.039	211.90	193.45	187.25	184.25	181.15	178.55	175.00	
-	-	.875	4 7/8	1	10 1/2	1 1/4	3620319	4	3622319	-	31.040-31.826	212.60	194.15	187.95	184.90	181.80	179.25	175.70	
32.0	1.2598	.897	4 7/8	1	10 1/2	1 9/32	3620320	4	3622320	197.10	31.827-32.614	224.90	206.45	200.25	197.25	194.15	191.55	188.00	
33.0	1.2992	.919	4 7/8	1	10 1/2	1 5/16	3620330	4	3622330	202.25	32.615-33.401	230.05	211.60	205.40	202.40	199.30	196.70	193.15	
34.0	1.3386	.940	4 7/8	1	10 1/2	1 11/32	3620340	4	3622340	206.25	33.402-34.214	234.05	215.60	209.40	206.40	203.30	200.70	197.15	
35.0	1.3780	.962	4 7/8	1	10 1/2	1 3/8	3620350	4	3622350	210.90	34.215-35.001	238.75	220.30	214.10	211.10	208.00	205.40	201.85	
-	-	.984	4 7/8	1	10 1/2	1 13/32	3620359	4	3622359	-	35.002-35.789	243.30	224.85	218.65	215.60	212.50	209.95	206.40	
36.0	1.4173	1.006	4 7/8	1	10 1/2	1 7/16	3620360	4	3622360	221.45	35.790-36.601	249.25	230.80	224.60	221.60	218.50	215.90	212.35	
37.0	1.4567	1.025	4 7/8	1	10 1/2	1 15/32	3620370	4	3622370	227.65	36.602-37.389	255.45	237.00	230.80	227.80	224.70	222.10	218.55	
38.0	1.4961	1.050	4 7/8	1	10 1/2	1 1/2	3620380	4	3622380	232.25	37.390-38.176	260.05	241.60	235.40	232.40	229.30	226.70	223.15	

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*3 flutes.

CARBIDE TIPPED CORE DRILLS FOR STEEL

TYPE 3621 - FOUR SPIRAL FLUTES - STRAIGHT SHANK

TYPE 3623 - FOUR SPIRAL FLUTES - TAPER SHANK

Carbide tips brazed to hardened tool steel bodies. Right spiral flutes with 118° included chamfer angle.

Core drills, with increased flute capacity, remove more material from a cored or cast hole than a reamer. This often eliminates a final reaming or boring operation. Types 3621 and 3623 core drills are specifically designed for steel applications. For cast iron non-ferrous and high temperature alloy applications, refer to Types 3620 and 3622 on pages 130 and 131.



Tool and shank diameter tolerances: +.000"/-.001".

TOOL DIAMETER		MIN. CUT DIAM.	LENGTH			TYPE 3621		TYPE 3623		BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DEC.	FRACTIONAL		FLT	CARB	OAL	SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14**
.3750	3/8*	.262	3 1/2	5/8	6 3/4	3/8	362112	1	362312	\$111.30	.3471 - .3780	\$148.25	129.75	123.55	\$120.60	\$117.40	\$114.90
.4062	13/32*	.284	3 5/8	5/8	7	13/32	362113	1	362313	111.30	.3781 - .4090	148.25	129.75	123.55	120.60	117.40	114.90
.4375	7/16*	.306	3 7/8	3/4	7 1/4	7/16	362114	1	362314	111.30	.4091 - .4410	148.25	129.75	123.55	120.60	117.40	114.90
.4688	15/32*	.328	4 1/8	3/4	7 1/2	15/32	362115	1	362315	111.30	.4411 - .4720	148.25	129.75	123.55	120.60	117.40	114.90
.5000	1/2	.350	4 3/8	3/4	8 1/4	1/2	362116	2	362316	111.30	.4721 - .5030	148.25	129.75	123.55	120.60	117.40	114.90
.5312	17/32	.372	4 3/8	3/4	8 1/4	17/32	362117	2	362317	111.65	.5031 - .5340	148.65	130.10	123.90	120.95	117.80	115.30
.5625	9/16	.394	4 3/8	3/4	8 1/4	9/16	362118	2	362318	111.65	.5341 - .5660	148.65	130.10	123.90	120.95	117.80	115.30
.5938	19/32	.416	4 3/8	3/4	8 1/4	19/32	362119	2	362319	117.35	.5661 - .5970	154.30	135.80	129.60	126.65	123.45	120.95
.6250	5/8	.438	4 3/8	3/4	8 1/4	5/8	362120	2	362320	117.35	.5971 - .6280	154.30	135.80	129.60	126.65	123.45	120.95
.6562	21/32	.459	4 3/8	3/4	8 1/4	21/32	362121	2	362321	118.60	.6281 - .6590	155.60	137.05	130.85	127.90	124.75	122.25
.6875	11/16	.481	4 3/8	7/8	8 1/4	11/16	362122	2	362322	119.65	.6591 - .6910	156.65	138.10	131.90	128.95	125.80	123.30
.7188	23/32	.503	4 3/8	7/8	8 1/4	23/32	362123	2	362323	119.65	.6911 - .7220	156.65	138.10	131.90	128.95	125.80	123.30
.7500	3/4	.525	4 3/8	7/8	8 1/4	3/4	362124	2	362324	119.65	.7221 - .7530	156.65	138.10	131.90	128.95	125.80	123.30
.7812	25/32	.547	4 3/8	7/8	8 1/4	25/32	362125	2	362325	122.25	.7531 - .7840	159.20	140.70	134.50	131.55	128.35	125.85
.8125	13/16	.569	4 7/8	7/8	9 1/2	13/16	362126	3	362326	125.70	.7841 - .8160	162.70	144.15	137.95	135.00	131.85	129.35
.8438	27/32	.591	4 7/8	7/8	9 1/2	27/32	362127	3	362327	132.45	.8161 - .8470	169.40	150.90	144.70	141.75	138.55	136.10
.8750	7/8	.612	4 7/8	7/8	9 1/2	7/8	362128	3	362328	132.45	.8471 - .8780	169.40	150.90	144.70	141.75	138.55	136.10
.9062	29/32	.634	4 7/8	7/8	9 1/2	29/32	362129	3	362329	133.30	.8781 - .9090	170.25	151.75	145.55	142.60	139.40	136.90
.9375	15/16	.656	4 7/8	7/8	9 1/2	15/16	362130	3	362330	133.30	.9091 - .9410	170.25	151.75	145.55	142.60	139.40	136.90
.9688	31/32	.678	4 7/8	7/8	9 1/2	31/32	362131	3	362331	138.20	.9411 - .9720	175.15	156.65	150.45	147.50	144.30	141.85
1.0000	1	.700	4 7/8	7/8	9 1/2	1	362132	3	362332	140.85	.9721 - 1.0030	177.80	159.30	153.10	150.15	146.95	144.45
1.0312	1 1/32	.722	4 7/8	7/8	9 1/2	1 1/32	362133	3	362333	141.90	1.0031 - 1.0340	178.85	160.35	154.15	151.20	148.00	145.55
1.0625	1 1/16	.744	4 7/8	7/8	9 1/2	1 1/16	362134	3	362334	143.85	1.0341 - 1.0660	180.85	162.30	156.10	153.15	150.00	147.50
1.0938	1 3/32	.766	4 7/8	1	10 1/2	1 3/32	362135	4	362335	167.60	1.0661 - 1.0970	204.55	186.05	179.85	176.90	173.75	171.25
1.1250	1 1/8	.787	4 7/8	1	10 1/2	1 1/8	362136	4	362336	175.25	1.0971 - 1.1280	212.20	193.70	187.50	184.55	181.35	178.85
1.1562	1 3/32	.809	4 7/8	1	10 1/2	1 3/32	362137	4	362337	183.05	1.1281 - 1.1590	220.00	201.45	195.25	192.35	189.15	186.65
1.1875	1 3/16	.831	4 7/8	1	10 1/2	1 3/16	362138	4	362338	188.40	1.1591 - 1.1905	225.35	206.85	200.65	197.70	194.50	192.00
1.2188	1 7/32	.853	4 7/8	1	10 1/2	1 7/32	362139	4	362339	189.10	1.1906 - 1.2220	226.05	207.50	201.30	198.35	195.20	192.70
1.2500	1 1/4	.875	4 7/8	1	10 1/2	1 1/4	362140	4	362340	189.75	1.2221 - 1.2530	226.70	208.20	202.00	199.05	195.90	193.40
1.2812	1 9/32	.897	4 7/8	1	10 1/2	1 9/32	362141	4	362341	203.30	1.2531 - 1.2840	240.25	221.75	215.55	212.60	209.40	206.90
1.3125	1 5/16	.919	4 7/8	1	10 1/2	1 5/16	362142	4	362342	208.95	1.2841 - 1.3150	245.95	227.40	221.20	218.25	215.10	212.60
1.3438	1 11/32	.940	4 7/8	1	10 1/2	1 11/32	362143	4	362343	213.40	1.3151 - 1.3470	250.40	231.85	225.65	222.70	219.55	217.05
1.3750	1 3/8	.962	4 7/8	1	10 1/2	1 3/8	362144	4	362344	218.55	1.3471 - 1.3780	255.55	237.00	230.80	227.85	224.70	222.20
1.4062	1 13/32	.984	4 7/8	1	10 1/2	1 13/32	362145	4	362345	223.60	1.3781 - 1.4090	260.60	242.05	235.85	232.90	229.75	227.25
1.4375	1 7/16	1.006	4 7/8	1	10 1/2	1 7/16	362146	4	362346	230.15	1.4091 - 1.4410	267.10	248.55	242.35	239.45	236.25	233.75
1.4688	1 15/32	1.025	4 7/8	1	10 1/2	1 15/32	362147	4	362347	236.95	1.4411 - 1.4720	273.90	255.40	249.20	246.25	243.05	240.55
1.5000	1 1/2	1.050	4 7/8	1	10 1/2	1 1/2	362148	4	362348	242.00	1.4721 - 1.5030	278.95	260.45	254.25	251.30	248.10	245.60

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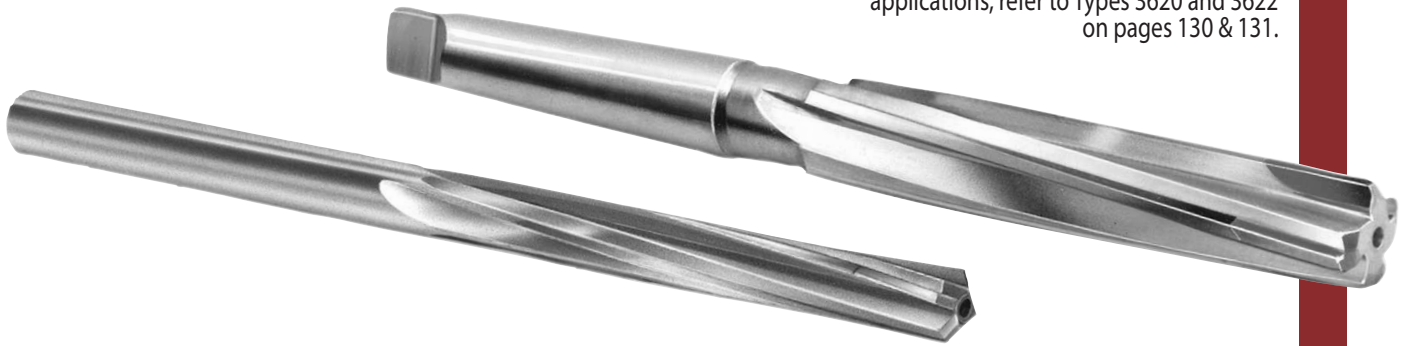
CARBIDE TIPPED CORE DRILLS FOR STEEL METRIC

TYPE 3621 - FOUR SPIRAL FLUTES - STRAIGHT SHANK

TYPE 3623 - FOUR SPIRAL FLUTES - TAPER SHANK

Carbide tips brazed to hardened tool steel bodies. Right spiral flutes with 118° included chamfer angle.

Core drills, with increased flute capacity, remove more material from a cored or cast hole than a reamer. This often eliminates a final reaming or boring operation. Types 3621 and 3623 core drills are specifically designed for steel applications. For cast iron, non-ferrous and high temperature alloy applications, refer to Types 3620 and 3622 on pages 130 & 131.



Tool and shank diameter tolerances: +.000"/-.001"

Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAMETER		MIN. CUT DIAM.	LENGTH			TYPE 3621		TYPE 3623		BOTH TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH		FLT	CARB	OAL	SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
9.0*	.3543	.262	3 1/2	5/8	6 3/4	3/8	3621090	1	3623090	\$123.55	8.815 - 9.601	\$151.35	\$132.90	\$126.70	\$123.70	\$120.60	\$118.00	\$114.45
10.0*	.3937	.284	3 5/8	5/8	7	13/32	3621100	1	3623100	123.55	9.602 - 10.389	151.35	132.90	126.70	123.70	120.60	118.00	114.45
11.0*	.4331	.306	3 7/8	3/4	7 1/4	7/16	3621110	1	3623110	123.55	10.390 - 11.201	151.35	132.90	126.70	123.70	120.60	118.00	114.45
-*	-	.328	4 1/8	3/4	7 1/2	15/32	3621119	1	3623119	-	11.202 - 11.989	151.35	132.90	126.70	123.70	120.60	118.00	114.45
12.0	.4724	.350	4 3/8	3/4	8 1/4	1/2	3621120	2	3623120	123.55	11.990 - 12.776	151.35	132.90	126.70	123.70	120.60	118.00	114.45
13.0	.5118	.372	4 3/8	3/4	8 1/4	17/32	3621130	2	3623130	123.90	12.777 - 13.564	151.75	133.30	127.10	124.05	120.95	118.40	114.85
14.0	.5512	.394	4 3/8	3/4	8 1/4	9/16	3621140	2	3623140	123.90	13.565 - 14.376	151.75	133.30	127.10	124.05	120.95	118.40	114.85
15.0	.5906	.416	4 3/8	3/4	8 1/4	19/32	3621150	2	3623150	129.60	14.377 - 15.164	157.40	138.95	132.75	129.75	126.65	124.05	120.50
-	-	.438	4 3/8	3/4	8 1/4	5/8	3621159	2	3623159	-	15.165 - 15.951	157.40	138.95	132.75	129.75	126.65	124.05	120.50
16.0	.6299	.459	4 3/8	3/4	8 1/4	21/32	3621160	2	3623160	130.85	15.952 - 16.739	158.70	140.25	134.05	131.00	127.90	125.35	121.80
17.0	.6693	.481	4 3/8	7/8	8 1/4	11/16	3621170	2	3623170	131.90	16.740 - 17.551	159.75	141.30	135.10	132.05	128.95	126.40	122.85
18.0	.7087	.503	4 3/8	7/8	8 1/4	23/32	3621180	2	3623180	131.90	17.552 - 18.339	159.75	141.30	135.10	132.05	128.95	126.40	122.85
19.0	.7480	.525	4 3/8	7/8	8 1/4	3/4	3621190	2	3623190	131.90	18.340 - 19.126	159.75	141.30	135.10	132.05	128.95	126.40	122.85
-	-	.547	4 3/8	7/8	8 1/4	25/32	3621199	2	3623199	-	19.127 - 19.914	162.30	143.85	137.65	134.65	131.55	128.95	125.40
20.0	.7874	.569	4 7/8	7/8	9 1/2	13/16	3621200	3	3623200	137.95	19.915 - 20.726	165.80	147.35	141.15	138.10	135.00	132.45	128.90
21.0	.8268	.591	4 7/8	7/8	9 1/2	27/32	3621210	3	3623210	144.70	20.727 - 21.514	172.50	154.05	147.85	144.85	141.75	139.20	135.65
22.0	.8661	.612	4 7/8	7/8	9 1/2	7/8	3621220	3	3623220	144.70	21.515 - 22.301	172.50	154.05	147.85	144.85	141.75	139.20	135.65
23.0	.9055	.634	4 7/8	7/8	9 1/2	29/32	3621230	3	3623230	145.55	22.302 - 23.089	173.35	154.90	148.70	145.70	142.60	140.00	136.45
-	-	.656	4 7/8	7/8	9 1/2	15/16	3621239	3	3623239	-	23.090 - 23.901	173.35	154.90	148.70	145.70	142.60	140.00	136.45
24.0	.9449	.678	4 7/8	7/8	9 1/2	31/32	3621240	3	3623240	150.45	23.902 - 24.689	178.25	159.80	153.60	150.60	147.50	144.95	141.35
25.0	.9843	.700	4 7/8	7/8	9 1/2	1	3621250	3	3623250	153.10	24.690 - 25.476	180.90	162.45	156.25	153.25	150.15	147.55	144.00
26.0	1.0236	.722	4 7/8	7/8	9 1/2	1 1/32	3621260	3	3623260	154.15	25.477 - 26.264	181.95	163.50	157.30	154.30	151.20	148.65	145.10
27.0	1.0630	.744	4 7/8	7/8	9 1/2	1 1/16	3621270	3	3623270	156.10	26.265 - 27.076	183.95	165.50	159.30	156.25	153.15	150.60	147.05
-	-	.766	4 7/8	1	10 1/2	1 3/32	3621279	4	3623279	-	27.077 - 27.864	207.65	189.25	183.05	180.00	176.90	174.35	170.80
28.0	1.1024	.787	4 7/8	1	10 1/2	1 1/8	3621280	4	3623280	187.50	27.865 - 28.651	215.30	196.85	190.65	187.65	184.55	181.95	178.40
29.0	1.1417	.809	4 7/8	1	10 1/2	1 5/32	3621290	4	3623290	195.25	28.652 - 29.439	223.10	204.65	198.45	195.45	192.35	189.75	186.20
30.0	1.1811	.831	4 7/8	1	10 1/2	1 3/16	3621300	4	3623300	200.65	29.440 - 30.239	228.45	210.00	203.80	200.80	197.70	195.10	191.55
31.0	1.2205	.853	4 7/8	1	10 1/2	1 7/32	3621310	4	3623310	201.30	30.240 - 31.039	229.15	210.70	204.50	201.45	198.35	195.80	192.25
-	-	.875	4 7/8	1	10 1/2	1 1/4	3621319	4	3623319	-	31.040 - 31.826	229.80	211.40	205.20	202.15	199.05	196.50	192.95
32.0	1.2598	.897	4 7/8	1	10 1/2	1 9/32	3621320	4	3623320	215.55	31.827 - 32.614	243.35	224.90	218.70	215.70	212.60	210.00	206.45
33.0	1.2992	.919	4 7/8	1	10 1/2	1 5/16	3621330	4	3623330	221.20	32.615 - 33.401	249.05	230.60	224.40	221.35	218.25	215.70	212.15
34.0	1.3386	.940	4 7/8	1	10 1/2	1 11/32	3621340	4	3623340	225.65	33.402 - 34.214	253.50	235.05	228.85	225.80	222.70	220.15	216.60
35.0	1.3780	.962	4 7/8	1	10 1/2	1 3/8	3621350	4	3623350	230.80	34.215 - 35.001	258.65	240.20	234.00	230.95	227.85	225.30	221.75
-	-	.984	4 7/8	1	10 1/2	1 13/32	3621359	4	3623359	-	35.002 - 35.789	263.70	245.25	239.05	236.00	232.90	230.35	226.80
36.0	1.4173	1.006	4 7/8	1	10 1/2	1 7/16	3621360	4	3623360	242.35	35.790 - 36.601	270.20	251.75	245.55	242.50	239.45	236.85	233.30
37.0	1.4567	1.025	4 7/8	1	10 1/2	1 15/32	3621370	4	3623370	249.20	36.602 - 37.389	277.00	258.55	252.35	249.35	246.25	243.65	240.10
38.0	1.4961	1.050	4 7/8	1	10 1/2	1 1/2	3621380	4	3623380	254.25	37.390 - 38.176	282.05	263.60	257.40	254.40	251.30	248.70	245.15

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*3 flutes.

CARBIDE TIPPED REDUCED SHANK DIAMETER DRILLS

STUB LENGTH, JOBBERS LENGTH & HARD STEEL DIE DRILLS
1/4", 3/8", 1/2" OR 3/4" SHANK DIAMETER

For use in a wide variety of drill chuck diameters.



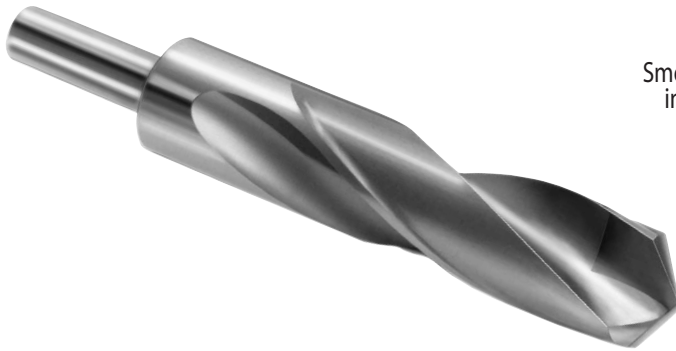
SHANK DIAM.	TOOL DIAMETER		STUB LENGTH DRILLS (see page 118)				JOBBER'S LENGTH DRILLS (see page 112)				HARD STEEL DIE DRILLS (see page 122)					
	DECIMAL	FRAC.	OVERALL LENGTH	118° PT.		135° PT.		OVERALL LENGTH	118° PT.		135° PT.		OVERALL LENGTH	118° PT.	135° PT.	PRICE EACH
				TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH		TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH		TYPE 3670 EDP NO.	TYPE 3672 EDP NO.	
1/4	.2812	9/32	2 1/16	3640618	\$32.10	3641618	\$37.30	4 1/4	3600618	\$33.40	3601618	\$38.70	-	-	-	-
	.3125	5/16	2 13/16	3640620	34.20	3641620	39.70	4 1/2	3600620	36.15	3601620	42.00	4 1/2	3670620	3672620	\$52.10
	.3438	11/32	3	3640622	39.75	3641622	46.05	4 3/4	3600622	38.35	3601622	44.65	4 3/4	3670622	3672622	55.45
	.3750	3/8	3 1/8	3640624	40.75	3641624	47.25	5	3600624	40.80	3601624	47.45	5	3670624	3672624	59.65
	.4062	13/32	3 5/16	3640626	48.25	3641626	56.25	5 1/4	3600626	44.40	3601626	51.65	5 1/4	3670626	3672626	69.85
	.4375	7/16	3 7/16	3640628	51.70	3641628	57.35	5 1/2	3600628	48.35	3601628	56.05	5 1/2	3670628	3672628	81.05
	.4688	15/32	3 5/8	3640630	73.50	3641630	85.45	5 3/4	3600630	54.30	3601630	62.85	5 3/4	3670630	3672630	88.95
	.5000	1/2	3 3/4	3640632	70.35	3641632	81.85	6	3600632	66.75	3601632	70.45	6	3670632	3672632	104.35
3/8	.4062	13/32	3 5/16	3640726	48.25	3641726	56.25	5 1/4	3600726	44.40	3601726	51.65	-	-	-	-
	.4375	7/16	3 7/16	3640728	51.70	3641728	57.35	5 1/2	3600728	48.35	3601728	56.05	5 1/2	3670728	3672728	81.05
	.4688	15/32	3 5/8	3640730	73.50	3641730	85.45	5 3/4	3600730	54.30	3601730	62.85	5 3/4	3670730	3672730	88.95
	.5000	1/2	3 3/4	3640732	70.35	3641732	81.85	6	3600732	66.80	3601732	70.40	6	3670732	3672732	104.35
	.5312	17/32	3 7/8	3640734	87.70	3641734	98.75	6 5/8	3600734	86.95	3601734	101.05	6	3670734	3672734	119.70
	.5625	9/16	4	3640736	87.70	3641736	98.75	6 3/8	3600736	87.80	3601736	101.90	6	3670736	3672736	123.85
	.5938	19/32	4 1/8	3640738	100.60	3641738	113.45	7 1/8	3600738	94.30	3601738	109.40	7	3670738	3672738	131.05
	.6250	5/8	4 1/4	3640740	100.60	3641740	113.45	7 1/8	3600740	106.80	3601740	123.85	7	3670740	3672740	135.05
	.6562	21/32	4 1/2	3640742	120.95	3641742	136.45	7 1/8	3600742	108.60	3601742	126.00	7 1/2	3670742	3672742	144.50
	.6875	11/16	4 5/8	3640744	124.10	3641744	139.95	7 5/8	3600744	110.65	3601744	128.40	7 1/2	3670744	3672744	148.40
1/2	.7188	23/32	4 3/4	3640746	140.70	3641746	163.35	7 5/8	3600746	130.60	3601746	145.20	8	3670746	3672746	155.45
	.7500	3/4	5	3640748	141.05	3641748	158.85	8	3600748	133.45	3601748	148.25	8	3670748	3672748	159.65
	.5312	17/32	3 7/8	3640834	87.70	3641834	98.75	6 5/8	3600834	86.95	3601834	101.05	-	-	-	-
	.5625	9/16	4	3640836	87.70	3641836	98.75	6 5/8	3600836	87.80	3601836	101.90	6	3670836	3672836	123.85
	.5938	19/32	4 1/8	3640838	100.60	3641838	113.45	7 1/8	3600838	94.30	3601838	109.40	7	3670838	3672838	131.05
	.6250	5/8	4 1/4	3640840	100.60	3641840	113.45	7 1/8	3600840	106.80	3601840	123.85	7	3670840	3672840	135.05
	.6562	21/32	4 1/2	3640842	120.95	3641842	136.45	7 1/8	3600842	108.60	3601842	126.00	7 1/2	3670842	3672842	144.50
	.6875	11/16	4 5/8	3640844	124.10	3641844	139.95	7 5/8	3600844	110.65	3601844	128.40	7 1/2	3670844	3672844	148.40
	.7188	23/32	4 3/4	3640846	140.70	3641846	163.35	7 5/8	3600846	130.60	3601846	145.20	8	3670846	3672846	155.45
	.7500	3/4	5	3640848	141.05	3641848	158.85	8	3600848	133.45	3601848	148.25	8	3670848	3672848	159.65
3/4	.8125	13/16	5 1/4	3640852	174.35	3641852	196.75	-	-	-	-	-	8	3670852	3672852	286.30
	.8750	7/8	5 1/2	3640856	191.35	3641856	215.65	-	-	-	-	-	8	3670856	3672856	292.25
	.9375	15/16	5 3/4	3640860	205.35	3641860	231.75	-	-	-	-	-	8	3670860	3672860	325.65
	1.0000	1	6	3640864	217.00	3641864	244.85	-	-	-	-	-	8	3670864	3672864	345.45
	.8125	13/16	5 1/4	3640952	174.35	3641952	196.75	-	-	-	-	-	8	3670952	3672952	286.30
	.8750	7/8	5 1/2	3640956	191.35	3641956	215.70	-	-	-	-	-	8	3670956	3672956	292.25
	.9375	15/16	5 3/4	3640960	205.35	3641960	231.75	-	-	-	-	-	8	3670960	3672960	325.65
	1.0000	1	6	3640964	217.00	3641964	244.85	-	-	-	-	-	8	3670964	3672964	345.45
1/2	1.0625	1 1/16	6 1/4	3640968	271.95	3641968	306.60	-	-	-	-	-	-	-	-	-
	1.1250	1 1/8	6 3/8	3640972	301.90	3641972	340.35	-	-	-	-	-	-	-	-	-
	1.1875	1 3/16	6 5/8	3640976	368.40	3641976	413.00	-	-	-	-	-	-	-	-	-
	1.2500	1 1/4	6 3/4	3640980	368.40	3641980	413.00	-	-	-	-	-	-	-	-	-
								-	-	-	-	-	-	-	-	-

DRILL TOLERANCES & STANDARDS

DRILL DIAMETER RANGE (INCH)	DRILL DIAMETER TOLERANCES	INCLUDED ANGLE	LIP HEIGHT T.I.V.	ALL DIMENSIONAL & ELEMENT TOLERANCES CONFORM TO ONE OR MORE OF THE FOLLOWING STANDARDS, UNLESS OTHERWISE SPECIFIED ON SELECTED TYPES: • ASME/ANSI B94.11M • ISO - INTERNATIONAL STANDARDS ORGANIZATION • NAS 907 - NATIONAL AEROSPACE STANDARDS • USCTI - UNITED STATES CUTTING TOOL INSTITUTE
THRU 1/8"	+0.0000"/-0.0005"	+5°/-5°	.0020"	
OVER 1/8" THRU 1/4"	+0.0000"/-0.0007"	+5°/-5°	.0030"	
OVER 1/4" THRU 1/2"	+0.0000"/-0.0010"	+5°/-5°	.0040"	
OVER 1/2" THRU 1"	+0.0000"/-0.0012"	+3°/-3°	.0050"	
OVER 1" THRU 1 1/2"	+0.0000"/-0.0015"	+3°/-3°	.0060"	

CARBIDE TIPPED SILVER & DEMING DRILLS

TYPE 3616 - 118° POINT



Carbide tip brazed to hardened tool steel bodies.

Smooth flutes for effective chip flow. Precision ground to insure concentricity of tip & body. For drilling cast iron, non-ferrous metals and non-metals. Shank size of 1/2" x 2 1/4" allows larger diameter drills to be used in 1/2" and larger drill chucks. (Not usually recommended for steel.)

TYPE 3618 - 135° SPLIT POINT

Same as Type 3616 above, except designed for drilling abrasive and tough materials.

For drill tolerances, see page 134.

TOOL DIAMETER		LENGTH		118° POINT		135° POINT	
DECIMAL	FRAC.	FLUTE	OVERALL	TYPE 3616 EDP NO.	PRICE EACH	TYPE 3618 EDP NO.	PRICE EACH
.5000	1/2	3 1/8	6	361632	\$53.35	361832	\$61.30
.5312	17/32	3 1/8	6	361634	78.05	361834	89.75
.5625	9/16	3 1/8	6	361636	80.90	361836	93.05
.5938	19/32	3 1/8	6	361638	84.15	361838	96.75
.6250	5/8	3 1/8	6	361640	93.45	361840	107.45
.6562	21/32	3 1/8	6	361642	101.30	361842	116.50
.6875	11/16	3 1/8	6	361644	105.30	361844	121.10
.7188	23/32	3 1/8	6	361646	109.20	361846	125.60
.7500	3/4	3 1/8	6	361648	114.45	361848	131.60
.7812	25/32	3 1/8	6	361650	126.20	361850	145.10
.8125	13/16	3 1/8	6	361652	126.50	361852	145.45
.8438	27/32	3 1/8	6	361654	126.50	361854	145.45
.8750	7/8	3 1/8	6	361656	131.55	361856	151.25

TOOL DIAMETER		LENGTH		118° POINT		135° POINT	
DECIMAL	FRAC.	FLUTE	OVERALL	TYPE 3616 EDP NO.	PRICE EACH	TYPE 3618 EDP NO.	PRICE EACH
.9062	29/32	3 1/8	6	361658	\$134.75	361858	\$155.00
.9375	15/16	3 1/8	6	361660	136.10	361860	156.50
.9688	31/32	3 1/8	6	361662	140.70	361862	161.75
1.0000	1	3 1/8	6	361664	143.70	361864	165.25
1.0312	1 1/32	3 1/8	6	361666	138.75	361866	159.55
1.0625	1 1/16	3 1/8	6	361668	150.40	361868	172.95
1.0938	1 3/32	3 1/8	6	361670	154.00	361870	177.10
1.1250	1 1/8	3 1/8	6	361672	157.00	361872	180.55
1.1562	1 5/32	3 1/8	6	361674	190.60	361874	219.15
1.1875	1 3/16	3 1/8	6	361676	194.05	361876	223.15
1.2188	1 7/32	3 1/8	6	361678	203.75	361878	234.35
1.2500	1 1/4	3 1/8	6	361680	186.05	361880	214.00
-	-	-	-	-	-	-	-

CARBIDE TIPPED CNC SPOTTING/CENTERING DRILLS



TYPE 3677 - REGULAR LENGTH - 90° POINT

TYPE 3678 - REGULAR LENGTH - 120° POINT

TYPE 3679 - REGULAR LENGTH - 140° POINT

Carbide tip brazed to hardened tool steel bodies.

Cuts only to depth of point. Excellent for CNC spot facing, centering and chamfering. Tool diameter not cleared for drilling holes.

TYPE 3647 - SHORT LENGTH - 90° POINT

TYPE 3648 - SHORT LENGTH - 120° POINT

TYPE 3649 - SHORT LENGTH - 140° POINT

Same as Types 3677, 3678 & 3679 above, except shorter length.

REGULAR LENGTH

TOOL DIAMETER		LENGTH		90° POINT	120° POINT	140° POINT	ALL TYPES PRICE
DECIMAL	FRAC.	FLUTE	OVERALL	TYPE 3677 EDP NO.	TYPE 3678 EDP NO.	TYPE 3679 EDP NO.	
.2500	1/4	1	4	367716	367816	367916	\$82.60
.3750	3/8	1 1/8	5	367724	367824	367924	96.45
.5000	1/2	1 1/2	6	367732	367832	367932	129.70
.6250	5/8	1 5/8	7	367740	367840	367940	187.90
.7500	3/4	1 7/8	8	367748	367848	367948	217.90
1.0000	1	2 1/4	8	367764	367864	367964	288.85

SHORT LENGTH

TOOL DIAMETER		LENGTH		90° POINT	120° POINT	140° POINT	ALL TYPES PRICE
DECIMAL	FRAC.	FLUTE	OVERALL	TYPE 3647 EDP NO.	TYPE 3648 EDP NO.	TYPE 3649 EDP NO.	
.2500	1/4	1	2 1/2	364716	364816	364916	\$78.55
.3750	3/8	1 1/8	3 1/8	364724	364824	364924	91.60
.5000	1/2	1 1/2	3 3/4	364732	364832	364932	123.25
.6250	5/8	1 5/8	4 1/4	364740	364840	364940	178.45
.7500	3/4	1 7/8	5	364748	364848	364948	207.05
1.0000	1	2 1/4	6	364764	364864	364964	274.40

SINGLE POINT TOOLS WITH PREMIUM CARBIDE GRADE

TYPE 3980 - SILVER SHANK 883 / PREMIUM C2 CARBIDE GRADE

Carbide tip brazed to steel bodies. For machining non-ferrous materials and cast iron.



AR

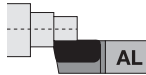
0° SIDE CUTTING EDGE ANGLE

For machining to a square shoulder.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
AR-4	398AR04	\$11.60	393AR04	\$8.55	1/4	1/4	2	12
AR-5	398AR05	10.30	393AR05	9.05	5/16	5/16	2 1/4	12
AR-6	398AR06	10.50	393AR06	9.25	3/8	3/8	2 1/2	12
AR-7	398AR07	11.25	393AR07	10.00	7/16	7/16	3	12
AR-8	398AR08	9.60	393AR08	9.60	1/2	1/2	3 1/2	12
AR-10	398AR10	23.60	393AR10	13.30	5/8	5/8	4	12
AR-12	398AR12	29.80	393AR12	16.50	3/4	3/4	4 1/2	12
AR-16	398AR16	CALL	393AR16	32.90	1	1	7	6
AR-20	398AR20	CALL	393AR20	CALL	1 1/4	1 1/4	8	1
AR-44	398AR44	CALL	393AR44	CALL	1/2	1	7	12



For turning to a square shoulder



TYPE 3930 - GOLD SHANK 370 / PREMIUM C5-C6 CARBIDE GRADE

Carbide tip brazed to steel bodies. For machining most steels.



AL

0° SIDE CUTTING EDGE ANGLE

For machining to a square shoulder.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
AL-4	398AL04	\$11.60	393AL04	\$8.55	1/4	1/4	2	12
AL-5	398AL05	10.30	393AL05	9.05	5/16	5/16	2 1/4	12
AL-6	398AL06	10.50	393AL06	9.25	3/8	3/8	2 1/2	12
AL-7	398AL07	11.25	393AL07	10.00	7/16	7/16	3	12
AL-8	398AL08	9.60	393AL08	9.60	1/2	1/2	3 1/2	12
AL-10	398AL10	13.65	393AL10	13.30	5/8	5/8	4	12
AL-12	398AL12	17.55	393AL12	17.45	3/4	3/4	4 1/2	12
AL-16	398AL16	34.25	393AL16	34.25	1	1	7	6
AL-20	-	-	393AL20	CALL	1 1/4	1 1/4	8	1
AL-44	398AL44	CALL	393AL44	CALL	1/2	1	7	12



BR

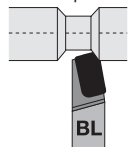
15° SIDE CUTTING EDGE ANGLE

For interrupted or irregular cuts.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
BR-4	398BR04	\$11.60	393BR04	\$8.55	1/4	1/4	2	12
BR-5	398BR05	10.30	393BR05	9.05	5/16	5/16	2 1/4	12
BR-6	398BR06	10.50	393BR06	9.25	3/8	3/8	2 1/2	12
BR-7	398BR07	11.25	393BR07	10.00	7/16	7/16	3	12
BR-8	398BR08	9.60	393BR08	9.60	1/2	1/2	3 1/2	12
BR-10	398BR10	23.60	393BR10	13.30	5/8	5/8	4	12
BR-12	398BR12	29.80	393BR12	16.50	3/4	3/4	4 1/2	12
BR-16	398BR16	CALL	393BR16	32.90	1	1	7	6
BR-20	398BR20	CALL	393BR20	CALL	1 1/4	1 1/4	8	1
BR-44	398BR44	CALL	393BR44	CALL	1/2	1	7	12



For turning where square shoulder is not required



BL

15° SIDE CUTTING EDGE ANGLE

For interrupted or irregular cuts.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
BL-4	398BL04	\$11.60	393BL04	\$8.55	1/4	1/4	2	12
BL-5	398BL05	10.30	393BL05	9.05	5/16	5/16	2 1/4	12
BL-6	398BL06	10.50	393BL06	9.25	3/8	3/8	2 1/2	12
BL-7	398BL07	11.25	393BL07	10.00	7/16	7/16	3	12
BL-8	398BL08	9.60	393BL08	9.60	1/2	1/2	3 1/2	12
BL-10	398BL10	13.65	393BL10	13.30	5/8	5/8	4	12
BL-12	398BL12	17.55	393BL12	17.45	3/4	3/4	4 1/2	12
BL-16	398BL16	34.25	393BL16	34.25	1	1	7	6
BL-20	398BL20	CALL	393BL20	CALL	1 1/4	1 1/4	8	1
BL-44	398BL44	CALL	393BL44	CALL	1/2	1	7	12



C

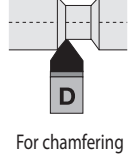
0° SQUARE NOSE

No nose radius.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
C-4	398C04	CALL	393C04	\$7.65	1/4	1/4	2	12
C-5	398C05	\$8.45	393C05	8.20	5/16	5/16	2 1/4	12
C-6	398C06	10.90	393C06	9.05	3/8	3/8	2 1/2	12
C-7	398C07	8.35	393C07	11.55	7/16	7/16	3	12
C-8	398C08	13.45	393C08	12.45	1/2	1/2	3 1/2	12
C-10	398C10	15.10	393C10	16.50	5/8	5/8	4	12
C-12	398C12	20.85	393C12	23.65	3/4	3/4	4 1/2	12
C-16	398C16	CALL	393C16	41.65	1	1	7	6
C-20	398C20	CALL	393C20	CALL	1 1/4	1 1/4	8	1
C-44	398C44	CALL	393C44	CALL	1/2	1	7	12



For undercutting and chamfering



D

40° SIDE CUTTING EDGE ANGLE

80° pointed nose.

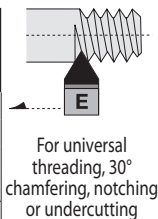
TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
D-4	398D04	\$7.15	393D04	\$7.15	1/4	1/4	2	12
D-5	398D05	8.25	393D05	8.55	5/16	5/16	2 1/4	12
D-6	398D06	8.45	393D06	9.10	3/8	3/8	2 1/2	12
D-7	398D07	11.55	393D07	14.00	7/16	7/16	3	12
D-8	398D08	11.05	393D08	11.75	1/2	1/2	3 1/2	12
D-10	398D10	15.55	393D10	17.15	5/8	5/8	4	12
D-12	398D12	22.20	393D12	39.55	3/4	3/4	4 1/2	12
D-16	398D16	32.95	393D16	33.95	1	1	7	6

SINGLE POINT TOOLS WITH PREMIUM CARBIDE GRADE

TYPE 3980 - SILVER SHANK 883 / PREMIUM C2 CARBIDE GRADE

Carbide tip brazed to steel bodies. For machining non-ferrous materials and cast iron.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
E-4	398E04	\$7.15	393E04	\$7.15	¼	¼	2	12
E-5	398E05	7.75	393E05	7.75	⅝	⅝	2 ¼	12
E-6	398E06	8.10	393E06	7.90	⅜	⅜	2 ½	12
E-7	398E07	13.80	393E07	15.05	⅞	⅞	3	12
E-8	398E08	18.55	393E08	9.95	½	½	3 ½	12
E-10	398E10	15.40	393E10	13.95	⅝	⅝	4	12
E-12	398E12	19.20	393E12	19.40	¾	¾	4 ½	12
E-16	398E16	52.70	393E16	54.30	1	1	7	6

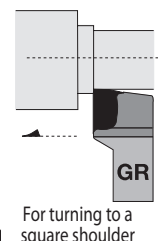


60° INCLUDED ANGLE
30° SIDE CUTTING EDGE ANGLE
For threading, chamfering, notching, or undercutting.



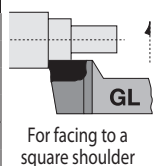
0° SIDE CUTTING EDGE ANGLE
Offset for facing or turning to a square shoulder or close to chuck jaws.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
GR-8	398GR08	\$13.45	393GR08	\$12.75	½	½	3 ½	12
GR-10	398GR10	29.25	393GR10	18.40	⅝	⅝	4	12
GR-12	398GR12	37.10	393GR12	22.90	¾	¾	4 ½	6
GR-16	398GR16	CALL	393GR16	54.95	1	1	7	4
GR-20	398GR20	CALL	393GR20	CALL	1 ¼	1 ¼	8	1
GR-44	398GR44	CALL	393GR44	CALL	½	1	6	6



0° SIDE CUTTING EDGE ANGLE
Offset for facing or turning to a square shoulder or close to chuck jaws.

TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
GL-8	398GL08	\$13.35	393GL08	\$13.15	½	½	3 ½	12
GL-10	398GL10	19.30	393GL10	18.40	⅝	⅝	4	12
GL-12	398GL12	24.90	393GL12	24.70	¾	¾	4 ½	6
GL-16	398GL16	52.90	393GL16	54.95	1	1	7	4
GL-20	398GL20	CALL	393GL20	CALL	1 ¼	1 ¼	8	1
GL-44	398GL44	CALL	393GL44	CALL	½	1	6	6



Carbide tip brazed to steel bodies. For machining non-ferrous materials and cast iron.



STANDARD CUTOFF TOOLS

For stock cut off and grooving solid bars.

Standard package quantity is 6.

TOOL TYPE & SIZE NO.	CUTOFF WIDTH	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION		
		EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L
CT-111	⅝	398CT01	\$17.20	393CT01	\$17.90	½	1	5
CT-122	⅜	398CT02	17.80	393CT02	18.35	½	1	5
CT-121	¼	398CT03	18.40	393CT03	18.95	½	1	5
CT-120	⅝	398CT04	18.35	393CT04	18.95	½	1	5
CT-130	⅜	398CT13	22.20	393CT13	23.60	⅝	1 ¼	5
CT-140	⅜	398CT14	24.65	393CT14	25.50	¾	1 ½	6

Carbide tip brazed to steel bodies. For machining most steels.



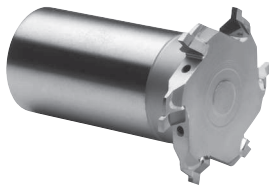
STANDARD CUTOFF TOOLS

For stock cut off and grooving solid bars.

Standard package quantity is 6.

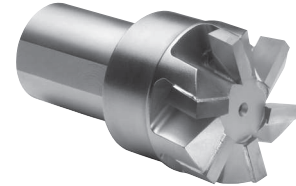
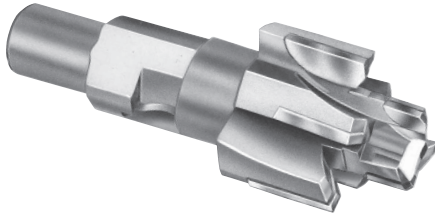
TOOL TYPE & SIZE NO.	CUTOFF WIDTH	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION		
		EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L
CTL-111	⅝	398CL01	\$17.20	393CL01	\$17.90	½	1	5
CTL-122	⅜	398CL02	17.80	393CL02	18.35	½	1	5
CTL-121	¼	398CL03	18.40	393CL03	18.95	½	1	5
CTL-120	⅝	398CL04	18.35	393CL04	18.95	½	1	5
CTL-130	⅜	398CL13	22.20	393CL13	23.60	⅝	1 ¼	5
CTL-140	⅜	398CL14	24.65	393CL14	25.50	¾	1 ½	6

DESIGN AND MANUFACTURING OF SPECIAL CUTTING TOOLS



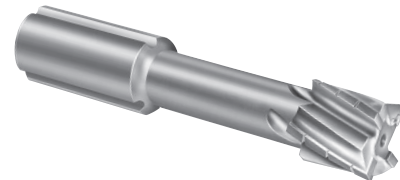
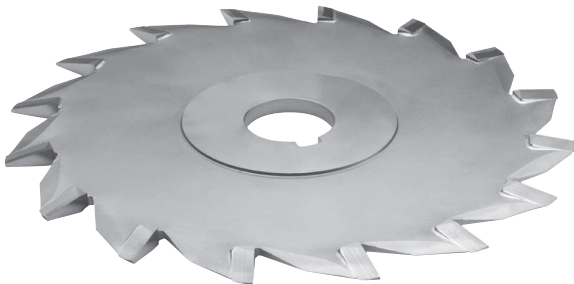
QUOTE FROM PRINT

Lexington Cutter will provide you with expedited quotes for specials from your tooling prints. Whether a complex blueprint or a simple sketch our staff will analyze your drawing and provide your quote typically within 1-2 business days.



QUOTE FROM DESCRIPTION

Many quotes for specials are supplied by description alone. These are normally standard tools with one or more non-standard features. Cutting diameter or width, shank diameter or length, chamfer or radii, arbor hole or locator pin, are just a few examples that can be accurately quoted by description.



QUOTE THROUGH DESIGN AND BUILD

Lexington Cutter's qualified staff can provide you with application support to recommend, design, and manufacture the right tool for your new or existing application. Provide us with a concept drawing of your new or existing application and we can work with you to develop or improve your current process. Often combination or step tools can be designed to eliminate steps and increase productivity. Our commitment to application specific tooling will place you a cut ahead of the competition.



ISO 9001:2008 REGISTERED FOR DESIGN AND DEVELOPMENT OF CUTTING TOOLS

Lexington Cutter is committed to continuous improvement in order to provide the necessary tools, equipment, and working environment to deliver high quality products that meet or exceed the expectations of our customers. Our factory houses over 100 machines tooled for the production of standard and specialty tooling. Lexington combines many well known manufacturing techniques such as Setup Reduction, Total Quality Management, Lean Production, Poka-Yoke, and Cellular Manufacturing into a production environment that thrives on high quality and continuous improvement.



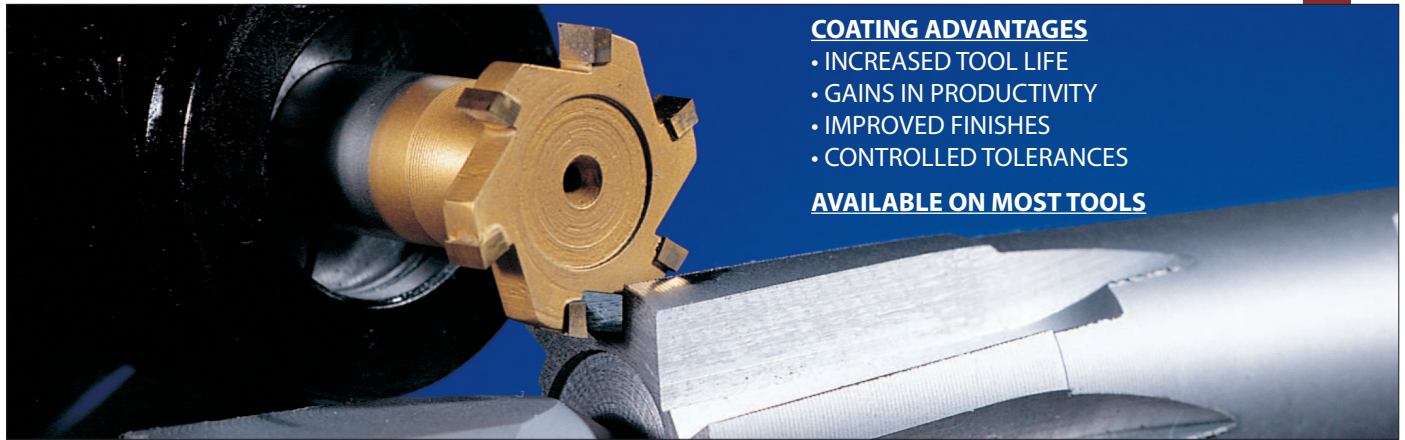
INDEX BY TOOL TYPE NUMBER

The first 4 digits of the EDP number represent the Type of the tool. The remaining digits represent the size of the tool. Within each Type of tool are different sizes that have the same basic function and design. If you know the Type of the tool you are looking for, this table will take you to the page where you can find it. Types in this chart that are bold are new products for our main catalog.

TOOL TYPE	METRIC PAGE	FRAC. PAGE	TOOL TYPE	METRIC PAGE	FRAC. PAGE	TOOL TYPE	METRIC PAGE	FRAC. PAGE	TOOL TYPE	METRIC PAGE	FRAC. PAGE	TOOL TYPE	METRIC PAGE	FRAC. PAGE
END MILLS			REAMERS (CONT.)			REAMERS (CONT.)			DRILLS			60° ANGLE CUTTERS		
3300		21	3434	97	96	3484EL		109	3600	113	112, 134	3724		17
3302		22	3435	95	94	3486		69	3601	113	112, 134	3726		17
3304		22	3435EL		107	3488		69	3610		124	CHAMFER CUTTERS		
3305		22	3436		90	3490		101	3611		124	3730		10
3306		22	3437		91	Semi Finished		59	3616		135	3731		10
3307		22	3438		90	F & S Reamers		49	3618		135	3732		10
3308		21	3439		91	COUNTERBORES			3620	131	130	3733		10
3310		21	3440	81	80	3500		37	3621	133	132	DOVETAIL CUTTERS		
3312		19	3442		88	3510	35	34	3622	131	130	3734		11
3314		19	3442ST		105	3511	35	34	3623	133	132	3735		11
3318		19	3442EL		108	3512	31	30	3630	117	116	3736		11
3320		23	3443		88	3513	29	29	3631	117	116	3737		11
3322		20	3443ST		105	3514	31	30	3640	119	118, 134	CORNER ROUNDING		
3323		20	3443EL		108	3515	29	29	3641	119	118, 134	3740		19
3325		23	3444		88	3516	33	32	3647		135	3741		19
3327		23	3444ST		105	3518	33	32	3648		135	DOUBLE ANGLE CUTTERS		
3337		20	3444EL		108	3522		36	3649		135	3746		10
3350		21	3446		102	F & S Counterbore		28	3650	127	126	3747		10
3353		20	3447		102	SHELL MILLS			3652	127	126	3748		10
3355		20	3450	63	62-66	3530		17	3654	129	128	3749		10
3375		23	3452	71	70	3531		17	3655	129	128	3750		17
REAMERS			3453		87	3532		17	3656		128	3752		17
3400	54	52-58	3454		87	FACE MILLS			3657		128	3754		17
3401		50	3455		87	3536		18	3658		125	PORT CONTOUR CUTTERS		
3402	61	60	3457	85	84	3537		18	3660	121	120	3780		24
3403		102	3457ST		104	3538		18	3661	121	120	3781		24
3407	83	82	3457EL		107	MILLING CUTTERS			3664		125	3782		27
3408	83	82	3458	85	84	3540		16	3665		125	3783		27
3409	83	82	3458ST		104	3541		16	3668		120	3784		27
3410	74	72	3458EL		107	3542		16	3670	121	122, 134	3785		27
3411		99	3459	85	84	3543		16	3671		122	3786	24	
3411EL		108	3459ST		104	SLITTING SAWS			3672	121	122, 134	3787	24	
3412		75	3459EL		107	3550		14	3673		122	3790	26	
3413		99	3461		93	3551		15	3674		123	3791	26	
3413EL		108	3462		93	3552		14	3675		123	3792		25
3414	97	96	3463		93	3553		15	3677		135	3793		25
3415		99	3464		92	3554		14	3678		135	3794		26
3415EL		108	3465	77	76	3556		15	3679		135	3795		26
3416	95	94	3466		92	3558		14	3690	115	114	SOLID CARBIDE		
3416EL		107	3467	79	78	3559		15	3691	115	114	3800		40, 42
3417		98	3468		92	F & S Mills & Saws		13	F & S Drills			110	3801	40, 42
3418		98	3472		86	COUNTERSINKS			KEYSEAT CUTTERS			3802	42	
3419		98	3473		86	3561		18	3700		6	3803		42
3420	74	73	3474		86	3563		18	3701		7	3804	44	44-48
3422		75	3476		51	COUNTERBORES			3702		8	3810		41, 43
3424	97	96	3476 Set		51	3573		38	3703		9	3811		41, 43
3426	95	94	3477		51	3574		38	3704		5	3812		43
3426EL		107	3478		51	3575		39	F & S Keyseats			12	3813	43
3427		100	3479		51	3576		39	45° ANGLE CUTTERS			3820	41, 43	
3427EL		109	3480	67	68-69	COUNTERSINKS			3714		17	3821	41, 43	
3428		100	3482		89	3581		18	3716		17	3822		43
3428EL		109	3482ST		106	3583		18	RADIUS CUTTERS			3823	43	
3429		100	3482EL		109	3584		18	3718		10	3860		111
3429EL		109	3483		89	3585		18	3719		10	3893		123
3430	81	80	3483ST		106	3590		18	T-SLOT CUTTERS			SINGLE POINTS		
3431		103	3483EL		109	3591		18	3720		11	3930		136-137
3432		90	3484		89	Problem Solving Guide		4	3721		11	3980		136-137
3433		91	3484ST		106	Coating Guide		141				Specials Quote Form		138

COATINGS FOR LEXINGTON CARBIDE TIPPED TOOLS

TiN - TITANIUM NITRIDE	TiCN - TITANIUM CARBONITRIDE	AlTiN - ALUM. TITANIUM NITRIDE	ZrN - ZIRCONIUM NITRIDE
<p>TiN - Titanium Nitride coating is still the most popular coating and provides the highest adhesion and ductility characteristics of any coating we offer. Hard (81 Rc), smooth, and with high thermal stability (550° C) TiN is an excellent choice for general purpose drilling, reaming, counterboring and milling a wide variety of materials.</p>	<p>TiCN - Titanium Carbonitride has a higher hardness (87 Rc) than TiN and has greater lubricity. TiCN should be used in applications where tool temperature can be controlled due to the relatively low oxidation temperature (400° C). Excellent resistance to wear and edge build-up in drilling, reaming, and wet milling applications with non-ferrous materials and cast iron.</p>	<p>AlTiN - Aluminum Titanium Nitride is an excellent choice when machining abrasive and high temperature applications over 800° C. It creates a hard aluminum oxide layer during the cutting process. Recommended for use when counterboring, drilling, milling, and reaming in all of our material classifications except Non-Ferrous.</p>	<p>ZrN - Zirconium Nitride is an excellent choice when machining plastics and non-ferrous materials. Very reliable coating when moderate temperatures are generated at the cutting edge. This coating offers a higher service temperature than TiCN.</p>
<p>TECHNICAL DATA</p> <p>Hardness (Vickers): 2300 Max. Service Temperature: 525° C (975° F) Friction Coefficient: .50 Thickness: 2-4 microns Surface Roughness (R_a μM): .20</p>	<p>TECHNICAL DATA</p> <p>Hardness (Vickers): 3000 Max. Service Temperature: 400° C (750° F) Friction Coefficient: .40 Thickness: 2-4 microns Surface Roughness (R_a μM): .17</p>	<p>TECHNICAL DATA</p> <p>Hardness (Vickers): 3600 Max. Service Temperature: 750° C (1380° F) Friction Coefficient: .60 Thickness: 2-4 microns Surface Roughness (R_a μM): .30</p>	<p>TECHNICAL DATA</p> <p>Hardness (Vickers): 2500 Max. Service Temperature: 600° C (1110° F) Friction Coefficient: .50 Thickness: 2-4 microns Surface Roughness (R_a μM): .20</p>



COATING ADVANTAGES

- INCREASED TOOL LIFE
- GAINS IN PRODUCTIVITY
- IMPROVED FINISHES
- CONTROLLED TOLERANCES

AVAILABLE ON MOST TOOLS

WHY DO COATINGS WORK? COATINGS PROVIDE:

1. Thermal Insulation: - Coatings deflect heat back into the chip which reduces tool temperature & increases tool life.
2. Mechanical Strength - Coatings resist abrasion and protect the carbide tip from wear.
3. Chemical Resistance - Coatings protect and stabilize the carbide substrate under chemically reactive conditions.

MATERIAL CLASSIFICATION	DRILLING	REAMING	COUNTERBORING		MILLING	
	WET	WET	WET	DRY	WET	DRY
NON-FERROUS - SOFT	ZrN	TiCN/ZrN	ZrN	ZrN	ZrN	ZrN
NON-FERROUS - HARD	ZrN	TiCN/ZrN	ZrN	ZrN	ZrN	ZrN
CAST IRON	AlTiN	TiCN/AlTiN	AlTiN	AlTiN	AlTiN	AlTiN
LOW CARBON STEELS	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN
MEDIUM STRENGTH STEELS	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN
HIGH STRENGTH STEELS	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN	AlTiN
HIGH TEMPERATURE ALLOYS	AlTiN	AlTiN	AlTiN	*	AlTiN	*

The coatings in the table at left represent first choice recommendations. Only after a trial run can you be certain that a specific coating is best. Lexington Cutter, Inc. uses coating service companies that allow a low temperature Physical Vapor Deposition (PVD) process specially designed for carbide tipped tools. Tools that are coated by someone other than through Lexington Cutter, Inc. will not be warranted.

*High Temperature Alloys should not be machined dry.

LIMITED WARRANTY

Lexington Cutter, Inc. reserves the right to make any changes on the specifications, prices, or tolerances without notice.

WARNING - Because cutting tools may shatter or break, government regulations require the use of safety glasses and other safety equipment at all times in the vicinity of cutting tool use. Grinding of solid carbide or carbide tipped tools will produce carbide and braze dust that may be hazardous to your health. Use adequate ventilation and read the applicable "Material Safety Data Sheets."

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No Minimum Order
95% of Tools in Stock
Metrics Stocked
Specials Quoted

Sold Through Industrial Distributors

No Restocking Charge on Standards Within One Year
Same Day Shipping on Orders Received Before Noon EST

ISA Member

USCTI Member

ISO 9001 Registered

Value Added Partner

All Tools Manufactured in the USA

Four Time American Eagle Award Winner Including...

Value Added Manufacturer



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