

LEXINGTON



CUTTER, INC.

**ISO 9001 Registered
Quality Carbide and Carbide Tipped Cutting Tools**

2011



Proudly Made in the United States

LEXINGTON CUTTER TOOL INDEX

	Tool Type	Fractional Page	Metric Page	Non-Ferrous Soft	Non-Ferrous Hard	Cast Iron	Low Carbon Steel	Med Strength Steels	High Strength Steels	High Temp Alloys	CT	Cleveland	Fullerton	IMCO	Mercut	Morpe	RTW (Greenfield)	Union
COUNTERBORES				TOOL SELECTOR							CROSS REFERENCE							
3-4 Spiral Flutes - Straight Shank - Non-Ferrous & Cast Iron	3514	34	35								-	779	-	-	-	5779	SSC	5470
3-4 Spiral Flutes - Straight Shank - Steel	3510	38	39								-	-	-	-	-	-	FAC	-
3-4 Spiral Flutes - Taper Shank - Non-Ferrous & Cast Iron	3516	36	37								-	778	-	-	-	5780	TSC	5471
3-4 Spiral Flutes - Taper Shank - Steel	3511	38	39								-	-	-	-	-	-	TAC	-
4 Spiral Flutes - Straight Shank - Non-Ferrous & Cast Iron	3512	34	35								-	-	-	-	-	-	-	-
4 Spiral Flutes - Taper Shank - Non-Ferrous & Cast Iron	3518	36	37								-	-	-	-	-	-	-	-
Aircraft - Reduced Shank - 3 Flutes	3522	40									-	-	-	-	-	-	-	-
Capscrew	3513,15	33	33								-	-	-	-	-	-	-	-
Pilots - Interchangeable	3500	41									-	Yes	-	-	410	776	Yes	4704
Pin Drive - Non-Ferrous & Cast Iron	3573	42									-	-	-	-	200	-	-	-
Pin Drive - Steel	3574	42									-	-	-	-	-	-	-	-
Stub Taper Shank - Non-Ferrous & Cast Iron	3575	43									-	-	-	-	210	-	-	-
Stub Taper Shank - Steel	3576	43									-	-	-	-	-	-	-	-
REAMERS				TOOL SELECTOR							CROSS REFERENCE							
CNC Stub / Screw Machine - Straight or Left Spiral Flutes	3430,40	86	87								-	4701	50SML	8250	-	5669	SML	-
Coolant - Left Spiral Flutes - Through Hole - Cast Iron	3428	106									-	-	-	-	-	-	-	-
Coolant - Left Spiral Flutes - Through Hole - Non-Ferrous	3427	106									-	-	-	-	-	-	-	-
Coolant - Left Spiral Flutes - Through Hole - Steel	3429	106									-	-	-	-	-	-	-	-
Coolant - Right Spiral Flutes - Blind Hole - Cast Iron	3413	105									453	-	-	-	-	-	-	-
Coolant - Right Spiral Flutes - Blind Hole - Non-Ferrous	3411	105									453	-	-	-	-	-	-	-
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Coolant - Right Spiral Flutes - Through Hole - Non-Ferrous	3417	104									453A	-	-	-	-	-	-	-
Coolant - Right Spiral Flutes - Through Hole - Steel	3419	104									453A	-	-	-	-	-	-	-
Coolant - Straight Flutes - Blind Hole - Cast Iron	3424	102	103								452	-	-	-	-	-	-	-
Coolant - Straight Flutes - Blind Hole - Non-Ferrous	3414	102	103								452	-	-	-	-	-	-	-
Coolant - Straight Flutes - Blind Hole - Steel	3434	102	103								452	-	-	-	-	-	-	-
Coolant - Straight Flutes - Through Hole - Cast Iron	3426	100	101								452A	-	-	-	-	-	-	-
Coolant - Straight Flutes - Through Hole - Non-Ferrous	3416	100	101								452A	-	-	-	-	-	-	-
Coolant - Straight Flutes - Through Hole - Steel	3435	100	101								452A	-	-	-	-	-	-	-
Dowel Pin Size - Regular & Jobbers Drill Length	3476,77	57									450	-	-	8003	-	-	-	-
Dowel Pin Size - Straight Flute Long Carbide - Straight Shank - Steel	3486	75									-	-	-	-	-	-	-	-
Expansion - Straight Flute Long Carbide - Straight Shank	3465	82	83								490	-	50ES	8500	-	5733	ESR	5531
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NAS 897 - Expansion - Straight Shank - Non-Ferrous	3464	98									-	704	-	-	-	-	-	-
NAS 897 - Expansion - Straight Shank - Steel	3468	98									-	704	-	-	-	-	-	-
NAS 897 - Expansion - Taper Shank - Cast Iron	3462	99									-	716	-	-	-	-	-	-
NAS 897 - Expansion - Taper Shank - Non-Ferrous	3461	99									-	716	-	-	-	-	-	-
NAS 897 - Expansion - Taper Shank - Steel	3463	99									-	716	-	-	-	-	-	-
NAS 897 - Left Spiral Flute Long Carbide - Straight Shank - Cast Iron	3483	95									-	-	-	-	-	-	-	-
NAS 897 - Left Spiral Flute Long Carbide - Straight Shank - Non-Ferrous	3482	95									-	-	-	-	-	-	-	-
NAS 897 - Left Spiral Flute Long Carbide - Straight Shank - Steel	3484	95									-	-	-	-	-	-	-	-
NAS 897 - Left Spiral Flutes - Straight Shank - Cast Iron	3437	97									-	4709	-	-	-	-	-	-
NAS 897 - Left Spiral Flutes - Straight Shank - Non-Ferrous	3433	97									-	4709	-	-	-	-	-	-
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NAS 897 - Right Spiral Flute Long Carbide - Straight Shank - Non-Ferrous	3442	94									-	-	-	-	-	-	-	-
NAS 897 - Right Spiral Flute Long Carbide - Straight Shank - Steel	3444	94									-	-	-	-	-	-	-	-
NAS 897 - Right Spiral Flutes - Straight Shank - Cast Iron	3436	96									-	4711	-	-	-	-	-	-
NAS 897 - Right Spiral Flutes - Straight Shank - Non-Ferrous	3432	96									-	4711	-	-	-	-	-	-
NAS 897 - Right Spiral Flutes - Straight Shank - Steel	3438	96									-	4711	-	-	-	-	-	-
NAS 897 - Straight Flute Long Carbide - Straight Shank - Cast Iron	3458	90	91								-	-	-	-	-	-	-	-
NAS 897 - Straight Flute Long Carbide - Straight Shank - Non-Ferrous	3457	90	91								-	-	-	-	-	-	-	-
NAS 897 - Straight Flute Long Carbide - Straight Shank - Steel	3459	90	91								-	-	-	-	-	-	-	-
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NAS 897 - Straight Flutes - Straight Shank - Cast Iron	3408	88	89								-	4703	-	-	-	-	-	-
NAS 897 - Straight Flutes - Straight Shank - Non-Ferrous	3407	88	89								-	4703	-	-	-	-	-	-
NAS 897 - Straight Flutes - Straight Shank - Steel	3409	88	89								-	4703	-	-	-	-	-	-
NAS 897 - Straight Flutes - Taper Shank - Cast Iron	3473	92									-	4715	-	-	-	-	-	-
NAS 897 - Straight Flutes - Taper Shank - Non-Ferrous	3472	92									-	4715	-	-	-	-	-	-
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Pipe Tap - Straight Flutes	3446,47	108									-	-	-	-	-	-	-	-
Semi-Finished	ALL	65									-	-	Yes	-	Yes	Yes	Yes	-
Shell Reamer - Straight Flutes	3431	109									-	-	-	-	5625	-	-	5910
Solid Carbide - Left Spiral Flutes	3822,23	47									-	-	1410L	-	-	-	-	-
Solid Carbide - Right Spiral Flutes	3812,13	47									-	1711	1410R	-	-	-	1200R	-
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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 Temp Alloys	CT	Cleveland	Fullerton	IMCO	Metcut	Morse	RTW (Green/Red)	Union	
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Solid Carbide - Coolant - Straight Flutes - Blind Hole	3806,07	48																	
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Solid Carbide Head - Left Spiral Flutes - Cast Iron & Steel	3820	45																	
Solid Carbide Head - Left Spiral Flutes - Non-Ferrous	3821	45																	
Solid Carbide Head - Right Spiral Flutes - Cast Iron & Steel	3810	45																	
Solid Carbide Head - Right Spiral Flutes - Non-Ferrous	3811	45																	
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Straight Flute Long Carbide - Straight Shank - .0005 Increments	3450	70-72																	
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Variable Length - Left Spiral Flute Long Carbide	All	115																	
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Jobbers Length Twist - 135° Split Point - Reduced Shank	3601	138																	
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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

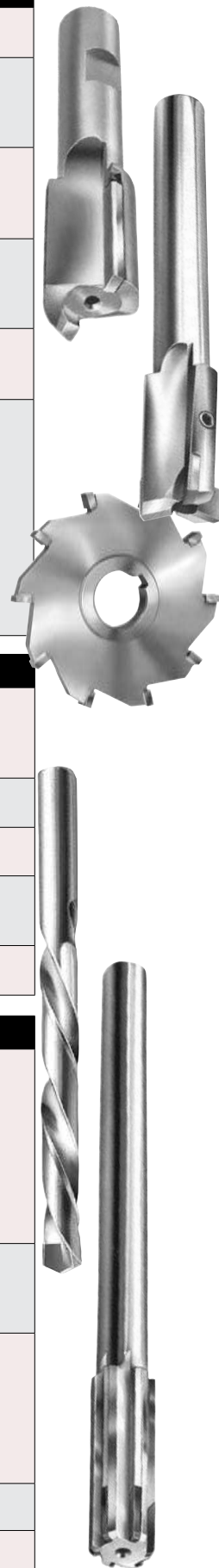
Lexington's tool selection is based on materials most common to condition. Special heat treatments or processing may change the material's machining characteristics. This guide is a suggested starting point for tool selection.

CARBIDE TIPPED TOOL PROBLEM SOLVING GUIDE

DRILLING 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.

MILLING 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 HIGH PERFORMANCE KEYSEAT CUTTERS FOR ALUMINUM



TYPE 3704 - HIGH PERFORMANCE - FOR ALUMINUM

Carbide tips brazed to hardened alloy steel bodies.

Designed specifically for the aluminum industry. Tools have a high volume flute capacity for higher speeds and feeds and better finishes. The tool geometry includes clearance for cutting on all three surfaces. Used for milling, slotting, grooving, snap rings, and O-rings. Also used in circular interpolation of spot facing, back spot facing, and counterboring. Starting point for aluminum slotting: 1K - 4K SFPM, .002 - .008 IPT. Reduce SFPM and IPT by 25% for widths under .0938.

Up to 1 1/2" diameter: 1/2" shank.
 1 3/4" diameter thru 2 1/2": 3/4" shank.
 Face width tolerance: +.0005"/-.0005".
 Tool diameter tolerance: +.020"/+.015".

AMERICAN STANDARD NO.	TOOL DIAM.	WIDTH	NO. OF TEETH	NECK DIAM.	OAL	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE
-	5/8	1/16	2	.160	2 1/16	37042002	\$141.45	.0575 - .0787
305	5/8	3/32	2	.191	2 3/32	37040305	141.45	.0788 - .1099
405	5/8	1/8	2	.223	2 1/8	37040405	141.45	.1100 - .1400
505	5/8	5/32	2	.252	2 5/32	37040505	141.45	.1401 - .1713
605	5/8	3/16	2	.279	2 3/16	37040605	141.45	.1714 - .2025
-	5/8	7/32	2	.342	2 7/32	37042007	141.45	.2026 - .2339
-	5/8	1/4	2	.342	2 1/4	37042008	141.45	.2340 - .2650
-	3/4	1/16	2	.160	2 1/16	37042402	148.55	.0575 - .0787
-	3/4	3/32	2	.191	2 3/32	37042403	148.55	.0788 - .1099
406	3/4	1/8	2	.217	2 1/8	37040406	148.55	.1100 - .1400
506	3/4	5/32	2	.246	2 5/32	37040506	148.55	.1401 - .1713
606	3/4	3/16	2	.279	2 3/16	37040606	148.55	.1714 - .2025
-	3/4	7/32	2	.342	2 7/32	37042407	148.55	.2026 - .2339
806	3/4	1/4	2	.342	2 1/4	37040806	148.55	.2340 - .2650
-	7/8	1/16	2	.160	2 1/16	37042802	159.20	.0575 - .0787
-	7/8	3/32	2	.191	2 3/32	37042803	159.20	.0788 - .1099
-	7/8	1/8	2	.217	2 1/8	37042804	159.20	.1100 - .1400
507	7/8	5/32	2	.246	2 5/32	37040507	159.20	.1401 - .1713
607	7/8	3/16	2	.279	2 3/16	37040607	159.20	.1714 - .2025
707	7/8	7/32	2	.312	2 7/32	37040707	159.20	.2026 - .2339
807	7/8	1/4	2	.342	2 1/4	37040807	159.20	.2340 - .2650
-	1	3/32	2	.191	2 3/32	37043203	168.00	.0788 - .1088
-	1	1/8	2	.217	2 1/8	37043204	168.00	.1089 - .1400
-	1	5/32	2	.246	2 5/32	37043205	168.00	.1401 - .1713
608	1	3/16	2	.279	2 3/16	37040608	168.00	.1714 - .2025
708	1	7/32	2	.312	2 7/32	37040708	168.00	.2026 - .2339
808	1	1/4	2	.342	2 1/4	37040808	168.00	.2340 - .2650
-	1	9/32	2	.401	2 9/32	37043209	168.00	.2651 - .2968
1008	1	5/16	2	.401	2 5/16	37041008	168.00	.2969 - .3281
-	1	11/32	2	.467	2 11/32	37043211	168.00	.3282 - .3593
1208	1	3/8	2	.467	2 3/8	37041208	168.00	.3594 - .3900
-	1 1/8	3/32	2	.217	2 3/32	37043603	168.00	.0788 - .1088
-	1 1/8	1/8	2	.246	2 1/8	37043604	168.00	.1089 - .1400
-	1 1/8	5/32	2	.279	2 5/32	37043605	168.00	.1401 - .1713
609	1 1/8	3/16	2	.312	2 3/16	37040609	168.00	.1714 - .2025
709	1 1/8	7/32	2	.342	2 7/32	37040709	168.00	.2026 - .2339
809	1 1/8	1/4	2	.374	2 1/4	37040809	168.00	.2340 - .2650
-	1 1/8	9/32	2	.435	2 9/32	37043609	168.00	.2651 - .2968
1009	1 1/8	5/16	2	.435	2 5/16	37041009	168.00	.2969 - .3281
-	1 1/8	11/32	2	.467	2 11/32	37043611	168.00	.3282 - .3593
-	1 1/8	3/8	2	.467	2 3/8	37043612	168.00	.3594 - .3900
-	1 1/4	3/32	3	.217	2 3/32	37044003	176.80	.0788 - .1088
-	1 1/4	1/8	3	.246	2 1/8	37044004	176.80	.1089 - .1400
-	1 1/4	5/32	3	.279	2 5/32	37044005	176.80	.1401 - .1713
610	1 1/4	3/16	3	.312	2 3/16	37040610	176.80	.1714 - .2025
710	1 1/4	7/32	3	.342	2 7/32	37040710	176.80	.2026 - .2339
810	1 1/4	1/4	3	.374	2 1/4	37040810	176.80	.2340 - .2650
-	1 1/4	9/32	3	.435	2 9/32	37044009	176.80	.2651 - .2968
1010	1 1/4	5/16	3	.435	2 5/16	37041010	176.80	.2969 - .3281
-	1 1/4	11/32	3	.467	2 11/32	37044011	176.80	.3282 - .3593
1210	1 1/4	3/8	3	.467	2 3/8	37041210	176.80	.3594 - .3900

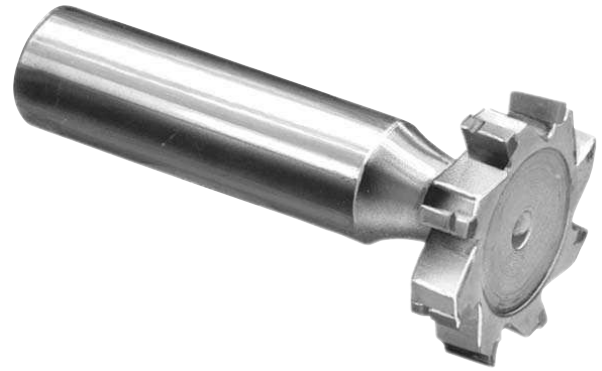
AMERICAN STANDARD NO.	TOOL DIAM.	WIDTH	NO. OF TEETH	NECK DIAM.	OAL	EDP NO.	PRICE EACH	DECIMAL SIZE RANGE
-	1 3/8	3/32	3	.312	2 3/32	37044403	\$194.45	.0788 - .1088
-	1 3/8	1/8	3	.342	2 1/8	37044404	194.45	.1089 - .1400
-	1 3/8	5/32	3	.374	2 5/32	37044405	194.45	.1401 - .1713
-	1 3/8	3/16	3	.401	2 3/16	37044406	194.45	.1714 - .2025
-	1 3/8	7/32	3	.401	2 7/32	37044407	194.45	.2026 - .2339
811	1 3/8	1/4	3	.401	2 1/4	37040811	194.45	.2340 - .2650
-	1 3/8	9/32	3	.467	2 9/32	37044409	194.45	.2651 - .2968
1011	1 3/8	5/16	3	.467	2 5/16	37041011	194.45	.2969 - .3281
-	1 3/8	11/32	3	.467	2 11/32	37044411	194.45	.3282 - .3593
1211	1 3/8	3/8	3	.467	2 3/8	37041211	194.45	.3594 - .3900
-	1 1/2	1/32	3	.435	2 1/32	37044803	221.05	.0788 - .1088
-	1 1/2	3/32	3	.435	2 3/32	37044804	221.05	.1089 - .1400
-	1 1/2	5/32	3	.435	2 5/32	37044805	221.05	.1401 - .1713
-	1 1/2	7/32	3	.435	2 7/32	37044806	221.05	.1714 - .2025
-	1 1/2	9/32	3	.435	2 9/32	37044807	221.05	.2026 - .2339
812	1 1/2	1/4	3	.435	2 1/4	37040812	221.05	.2340 - .2650
-	1 1/2	5/16	3	.467	2 5/16	37044809	221.05	.2651 - .2968
1012	1 1/2	3/16	3	.467	2 3/16	37041012	221.05	.2969 - .3281
-	1 1/2	11/32	3	.467	2 11/32	37044811	221.05	.3282 - .3593
1212	1 1/2	3/8	3	.467	2 3/8	37041212	265.25	.3594 - .3900
-	1 1/2	13/32	3	.467	2 13/32	37044813	265.25	.3901 - .4219
-	1 1/2	7/16	3	.467	2 7/16	37044814	265.25	.4220 - .4531
-	1 1/2	15/32	3	.467	2 15/32	37044815	265.25	.4532 - .4843
-	1 1/2	1/2	3	.467	2 1/2	37044816	265.25	.4844 - .5150
-	1 3/4	1/8	4	.718	3 1/8	37045604	244.00	.1089 - .1400
-	1 3/4	5/32	4	.718	3 5/32	37045605	244.00	.1401 - .1713
-	1 3/4	3/16	4	.718	3 3/16	37045606	244.00	.1714 - .2025
-	1 3/4	7/32	4	.718	3 7/32	37045607	244.00	.2026 - .2339
-	1 3/4	1/4	4	.718	3 1/4	37045608	244.00	.2340 - .2650
-	1 3/4	9/32	4	.718	3 9/32	37045609	244.00	.2651 - .2968
-	1 3/4	5/16	4	.718	3 5/16	37045610	244.00	.2969 - .3281
-	1 3/4	11/32	4	.718	3 11/32	37045611	244.00	.3282 - .3593
-	1 3/4	3/8	4	.718	3 3/8	37045612	286.50	.3594 - .3900
-	1 3/4	13/32	4	.718	3 13/32	37045613	286.50	.3901 - .4219
-	1 3/4	7/16	4	.718	3 7/16	37045614	286.50	.4220 - .4531
-	1 3/4	15/32	4	.718	3 15/32	37045615	286.50	.4532 - .4843
-	1 3/4	1/2	4	.718	3 1/2	37045616	286.50	.4844 - .5150
-	2	1/8	4	.718	3 1/8	37046404	282.85	.1089 - .1400
-	2	5/32	4	.718	3 5/32	37046405	282.85	.1401 - .1713
-	2	3/16	4	.718	3 3/16	37046406	282.85	.1714 - .2025
-	2	7/32	4	.718	3 7/32	37046407	282.85	.2026 - .2339
-	2	1/4	4	.718	3 1/4	37046408	282.85	.2340 - .2650
-	2	9/32	4	.718	3 9/32	37046409	282.85	.2651 - .2968
-	2	5/16	4	.718	3 5/16	37046410	282.85	.2969 - .3281
-	2	11/32	4	.718	3 11/32	37046411	282.85	.3282 - .3593
-	2	3/8	4	.718	3 3/8	37046412	327.20	.3594 - .3900
-	2	13/32	4	.718	3 13/32	37046413	327.20	.3901 - .4219
-	2	7/16	4	.718	3 7/16	37046414	327.20	.4220 - .4531
-	2	15/32	4	.718	3 15/32	37046415	327.20	.4532 - .4843
-	2	1/2	4	.718	3 1/2	37046416	327.20	.4844 - .5150

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 $\frac{5}{32}$ " and greater width. Decimal size cutters DO NOT have chip breakers.



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

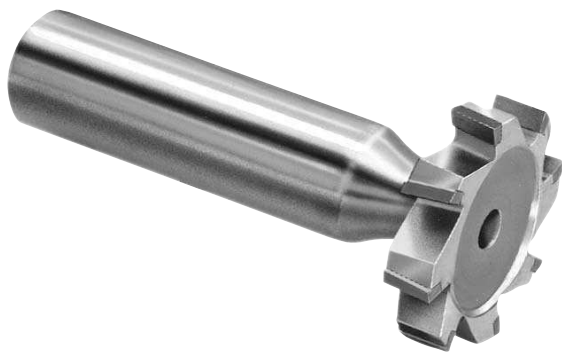
Face width tolerance: $+.0000"/-.0005"$.

Straight shank: $\frac{1}{2}$ " 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	$\frac{1}{2}$	6	$\frac{1}{16}$.130	2 $\frac{1}{16}$	37000204	\$121.15	.0575 - .0787	\$163.15	\$145.05	\$139.00	\$136.10	\$133.00	\$130.50
304	$\frac{1}{2}$	6	$\frac{3}{32}$.160	2 $\frac{3}{32}$	37000304	121.15	.0788 - .1088	163.15	145.05	139.00	136.10	133.00	130.50
404	$\frac{1}{2}$	6	$\frac{1}{8}$.191	2 $\frac{1}{8}$	37000404	121.15	.1089 - .1400	163.15	145.05	139.00	136.10	133.00	130.50
305	$\frac{5}{8}$	6	$\frac{3}{32}$.191	2 $\frac{3}{32}$	37000305	125.50	.0788 - .1088	167.70	149.60	143.50	140.55	137.50	135.05
405	$\frac{5}{8}$	6	$\frac{1}{8}$.223	2 $\frac{1}{8}$	37000405	125.50	.1089 - .1400	167.70	149.60	143.50	140.55	137.50	135.05
505	$\frac{5}{8}$	6	$\frac{5}{32}$.252	2 $\frac{5}{32}$	37000505	125.50	.1401 - .1713	167.70	149.60	143.50	140.55	137.50	135.05
605	$\frac{5}{8}$	6	$\frac{3}{16}$.279	2 $\frac{3}{16}$	37000605	125.50	.1714 - .2025	167.70	149.60	143.50	140.55	137.50	135.05
406	$\frac{3}{4}$	6	$\frac{1}{8}$.217	2 $\frac{1}{8}$	37000406	131.05	.1100 - .1400	173.45	155.40	149.25	146.35	143.30	140.75
506	$\frac{3}{4}$	6	$\frac{5}{32}$.246	2 $\frac{5}{32}$	37000506	131.05	.1401 - .1713	173.45	155.40	149.25	146.35	143.30	140.75
606	$\frac{3}{4}$	6	$\frac{3}{16}$.279	2 $\frac{3}{16}$	37000606	131.05	.1714 - .2025	173.45	155.40	149.25	146.35	143.30	140.75
-	$\frac{3}{4}$	6	$\frac{7}{32}$.342	2 $\frac{7}{32}$	37002407	143.50	.2026 - .2339	173.45	155.40	149.25	146.35	143.30	140.75
806	$\frac{3}{4}$	6	$\frac{1}{4}$.342	2 $\frac{1}{4}$	37000806	131.05	.2340 - .2650	173.45	155.40	149.25	146.35	143.30	140.75
507	$\frac{7}{8}$	6	$\frac{5}{32}$.246	2 $\frac{5}{32}$	37000507	137.20	.1401 - .1713	179.95	161.85	155.75	152.90	149.80	147.30
607	$\frac{7}{8}$	6	$\frac{3}{16}$.279	2 $\frac{3}{16}$	37000607	137.20	.1714 - .2025	179.95	161.85	155.75	152.90	149.80	147.30
707	$\frac{7}{8}$	6	$\frac{7}{32}$.312	2 $\frac{7}{32}$	37000707	137.20	.2026 - .2339	179.95	161.85	155.75	152.90	149.80	147.30
807	$\frac{7}{8}$	6	$\frac{1}{4}$.342	2 $\frac{1}{4}$	37000807	137.20	.2340 - .2650	179.95	161.85	155.75	152.90	149.80	147.30
608	1	8	$\frac{3}{16}$.279	2 $\frac{3}{16}$	37000608	154.75	.1714 - .2025	198.40	180.25	174.15	171.20	168.15	165.70
708	1	8	$\frac{7}{32}$.312	2 $\frac{7}{32}$	37000708	154.75	.2026 - .2339	198.40	180.25	174.15	171.20	168.15	165.70
808	1	8	$\frac{1}{4}$.342	2 $\frac{1}{4}$	37000808	154.75	.2340 - .2650	198.40	180.25	174.15	171.20	168.15	165.70
-	1	8	$\frac{9}{32}$.401	2 $\frac{9}{32}$	37003209	169.55	.2651 - .2968	198.40	180.25	174.15	171.20	168.15	165.70
1008	1	8	$\frac{5}{16}$.401	2 $\frac{5}{16}$	37001008	154.75	.2969 - .3281	198.40	180.25	174.15	171.20	168.15	165.70
-	1	8	$\frac{11}{32}$.467	2 $\frac{11}{32}$	37003211	169.55	.3282 - .3593	198.40	180.25	174.15	171.20	168.15	165.70
1208	1	8	$\frac{3}{8}$.467	2 $\frac{3}{8}$	37001208	154.75	.3594 - .3900	198.40	180.25	174.15	171.20	168.15	165.70
609	1 $\frac{1}{8}$	8	$\frac{3}{16}$.312	2 $\frac{3}{16}$	37000609	162.60	.1714 - .2025	206.50	188.45	182.35	179.40	176.35	173.90
709	1 $\frac{1}{8}$	8	$\frac{7}{32}$.342	2 $\frac{7}{32}$	37000709	162.60	.2026 - .2339	206.50	188.45	182.35	179.40	176.35	173.90
809	1 $\frac{1}{8}$	8	$\frac{1}{4}$.374	2 $\frac{1}{4}$	37000809	162.60	.2340 - .2650	206.50	188.45	182.35	179.40	176.35	173.90
-	1 $\frac{1}{8}$	8	$\frac{9}{32}$.435	2 $\frac{9}{32}$	37003609	178.10	.2651 - .2968	206.50	188.45	182.35	179.40	176.35	173.90
1009	1 $\frac{1}{8}$	8	$\frac{5}{16}$.435	2 $\frac{5}{16}$	37001009	162.60	.2969 - .3281	206.50	188.45	182.35	179.40	176.35	173.90
610	1 $\frac{1}{4}$	8	$\frac{3}{16}$.312	2 $\frac{3}{16}$	37000610	170.75	.1714 - .2025	215.05	197.00	190.80	187.95	184.85	182.35
710	1 $\frac{1}{4}$	8	$\frac{7}{32}$.342	2 $\frac{7}{32}$	37000710	170.75	.2026 - .2339	215.05	197.00	190.80	187.95	184.85	182.35
810	1 $\frac{1}{4}$	8	$\frac{1}{4}$.374	2 $\frac{1}{4}$	37000810	170.75	.2340 - .2650	215.05	197.00	190.80	187.95	184.85	182.35
-	1 $\frac{1}{4}$	8	$\frac{9}{32}$.435	2 $\frac{9}{32}$	37004009	186.95	.2651 - .2968	215.05	197.00	190.80	187.95	184.85	182.35
1010	1 $\frac{1}{4}$	8	$\frac{5}{16}$.435	2 $\frac{5}{16}$	37001010	170.75	.2969 - .3281	215.05	197.00	190.80	187.95	184.85	182.35
-	1 $\frac{1}{4}$	8	$\frac{11}{32}$.467	2 $\frac{11}{32}$	37004011	186.95	.3282 - .3593	215.05	197.00	190.80	187.95	184.85	182.35
1210	1 $\frac{1}{4}$	8	$\frac{3}{8}$.467	2 $\frac{3}{8}$	37001210	170.75	.3594 - .3900	215.05	197.00	190.80	187.95	184.85	182.35
811	1 $\frac{3}{8}$	8	$\frac{1}{4}$.401	2 $\frac{1}{4}$	37000811	179.35	.2340 - .2650	224.05	205.95	199.90	197.00	193.90	191.45
-	1 $\frac{3}{8}$	8	$\frac{5}{32}$.467	2 $\frac{5}{32}$	37004409	196.40	.2651 - .2968	224.05	205.95	199.90	197.00	193.90	191.45
1011	1 $\frac{3}{8}$	8	$\frac{3}{16}$.467	2 $\frac{3}{16}$	37001011	179.35	.2969 - .3281	224.05	205.95	199.90	197.00	193.90	191.45
-	1 $\frac{3}{8}$	8	$\frac{11}{32}$.467	2 $\frac{11}{32}$	37004411	196.40	.3282 - .3593	224.05	205.95	199.90	197.00	193.90	191.45
1211	1 $\frac{3}{8}$	8	$\frac{3}{8}$.467	2 $\frac{3}{8}$	37001211	179.35	.3594 - .3900	224.05	205.95	199.90	197.00	193.90	191.45
812	1 $\frac{1}{2}$	8	$\frac{1}{4}$.435	2 $\frac{1}{4}$	37000812	188.30	.2340 - .2650	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{9}{32}$.467	2 $\frac{9}{32}$	37004809	206.20	.2651 - .2968	233.45	215.40	209.30	206.35	203.30	200.85
1012	1 $\frac{1}{2}$	8	$\frac{5}{16}$.467	2 $\frac{5}{16}$	37001012	188.30	.2969 - .3281	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{11}{32}$.467	2 $\frac{11}{32}$	37004811	206.20	.3282 - .3593	233.45	215.40	209.30	206.35	203.30	200.85
1212	1 $\frac{1}{2}$	8	$\frac{3}{8}$.467	2 $\frac{3}{8}$	37001212	188.30	.3594 - .3900	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{13}{32}$.467	2 $\frac{13}{32}$	37004813	206.20	.3901 - .4219	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{7}{16}$.467	2 $\frac{7}{16}$	37004814	206.20	.4220 - .4531	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{15}{32}$.467	2 $\frac{15}{32}$	37004815	206.20	.4532 - .4843	233.45	215.40	209.30	206.35	203.30	200.85
-	1 $\frac{1}{2}$	8	$\frac{1}{2}$.467	2 $\frac{1}{2}$	37004816	206.20	.4844 - .5150	233.45	215.40	209.30	206.35	203.30	200.85

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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	\$167.45	\$161.35	\$158.50	\$155.40	\$152.90
304	1/2	6	3/32	.160	2 3/32	37010304	142.60	.0788 - .1088	185.55	167.45	161.35	158.50	155.40	152.90
404	1/2	6	1/8	.191	2 1/8	37010404	142.60	.1089 - .1400	185.55	167.45	161.35	158.50	155.40	152.90
305	5/8	6	3/32	.191	2 3/32	37010305	147.65	.0788 - .1088	190.90	172.85	166.75	163.80	160.70	158.20
405	5/8	6	1/8	.223	2 1/8	37010405	147.65	.1089 - .1400	190.90	172.85	166.75	163.80	160.70	158.20
505	5/8	6	5/32	.252	2 5/32	37010505	147.65	.1401 - .1713	190.90	172.85	166.75	163.80	160.70	158.20
605	5/8	6	3/16	.279	2 3/16	37010605	147.65	.1714 - .2025	190.90	172.85	166.75	163.80	160.70	158.20
406	3/4	6	1/8	.217	2 1/8	37010406	154.30	.1100 - .1400	197.80	179.75	173.60	170.75	167.65	165.20
506	3/4	6	5/32	.246	2 5/32	37010506	154.30	.1401 - .1713	197.80	179.75	173.60	170.75	167.65	165.20
606	3/4	6	3/16	.279	2 3/16	37010606	154.30	.1714 - .2025	197.80	179.75	173.60	170.75	167.65	165.20
-	3/4	6	7/32	.342	2 7/32	37012407	169.00	.2026 - .2339	197.80	179.75	173.60	170.75	167.65	165.20
806	3/4	6	1/4	.342	2 1/4	37010806	154.30	.2340 - .2650	197.80	179.75	173.60	170.75	167.65	165.20
507	7/8	6	5/32	.246	2 5/32	37010507	161.35	.1401 - .1713	205.25	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	205.25	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	205.25	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	205.25	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	208.80	202.70	199.80	196.70	194.25
708	1	8	7/32	.312	2 7/32	37010708	182.05	.2026 - .2339	226.95	208.80	202.70	199.80	196.70	194.25
808	1	8	1/4	.342	2 1/4	37010808	182.05	.2340 - .2650	226.95	208.80	202.70	199.80	196.70	194.25
-	1	8	9/32	.401	2 9/32	37013209	199.45	.2651 - .2968	226.95	208.80	202.70	199.80	196.70	194.25
1008	1	8	5/16	.401	2 5/16	37011008	182.05	.2969 - .3281	226.95	208.80	202.70	199.80	196.70	194.25
-	1	8	11/32	.467	2 11/32	37013211	199.45	.3282 - .3593	226.95	208.80	202.70	199.80	196.70	194.25
1208	1	8	3/8	.467	2 3/8	37011208	182.05	.3594 - .3900	226.95	208.80	202.70	199.80	196.70	194.25
609	1 1/8	8	3/16	.312	2 3/16	37010609	191.10	.1714 - .2025	236.40	218.25	212.15	209.30	206.20	203.70
709	1 1/8	8	7/32	.342	2 7/32	37010709	191.10	.2026 - .2339	236.40	218.25	212.15	209.30	206.20	203.70
809	1 1/8	8	1/4	.374	2 1/4	37010809	191.10	.2340 - .2650	236.40	218.25	212.15	209.30	206.20	203.70
-	1 1/8	8	9/32	.435	2 9/32	37013609	209.30	.2651 - .2968	236.40	218.25	212.15	209.30	206.20	203.70
1009	1 1/8	8	5/16	.435	2 5/16	37011009	191.10	.2969 - .3281	236.40	218.25	212.15	209.30	206.20	203.70
610	1 1/4	8	3/16	.312	2 3/16	37010610	200.75	.1714 - .2025	246.45	228.35	222.25	219.30	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	219.30	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	219.30	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	219.30	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	219.30	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	219.30	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	219.30	216.25	213.80
811	1 3/8	8	1/4	.401	2 1/4	37010811	210.85	.2340 - .2650	257.10	239.05	232.95	230.00	226.95	224.40
-	1 3/8	8	9/32	.467	2 9/32	37014409	230.95	.2651 - .2968	257.10	239.05	232.95	230.00	226.95	224.40
1011	1 3/8	8	5/16	.467	2 5/16	37011011	210.85	.2969 - .3281	257.10	239.05	232.95	230.00	226.95	224.40
-	1 3/8	8	11/32	.467	2 11/32	37014411	230.95	.3282 - .3593	257.10	239.05	232.95	230.00	226.95	224.40
1211	1 3/8	8	3/8	.467	2 3/8	37011211	210.85	.3594 - .3900	257.10	239.05	232.95	230.00	226.95	224.40
812	1 1/2	8	1/4	.435	2 1/4	37010812	221.50	.2340 - .2650	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	9/32	.467	2 9/32	37014809	242.55	.2651 - .2968	268.15	250.10	243.95	241.10	238.00	235.50
1012	1 1/2	8	5/16	.467	2 5/16	37011012	221.50	.2969 - .3281	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	11/32	.467	2 11/32	37014811	242.55	.3282 - .3593	268.15	250.10	243.95	241.10	238.00	235.50
1212	1 1/2	8	3/8	.467	2 3/8	37011212	221.50	.3594 - .3900	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	13/32	.467	2 13/32	37014813	242.55	.3901 - .4219	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	7/16	.467	2 7/16	37014814	242.55	.4220 - .4531	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	15/32	.467	2 15/32	37014815	242.55	.4532 - .4843	268.15	250.10	243.95	241.10	238.00	235.50
-	1 1/2	8	1/2	.467	2 1/2	37014816	242.55	.4844 - .5150	268.15	250.10	243.95	241.10	238.00	235.50

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

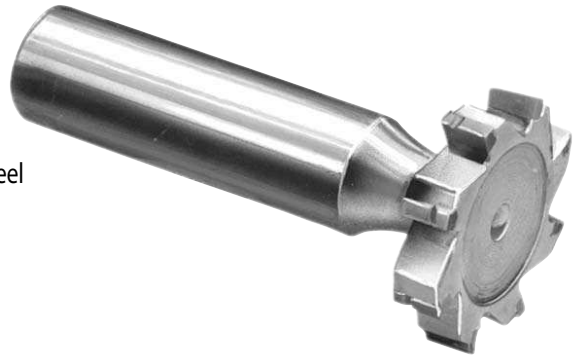
Made in U.S.A.

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.

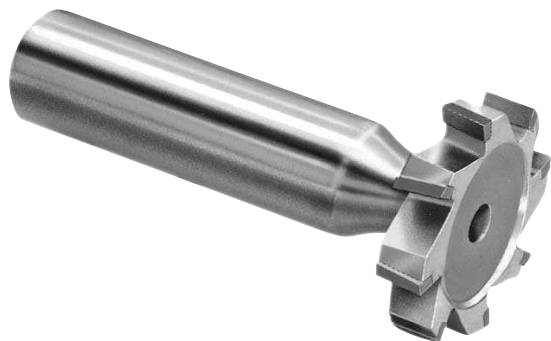


Tool diameter tolerance: +.020"/+.015".
Face width tolerance: +.0000"/-.0005".
Straight shank: 1/2" diameter, 2" long.

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	\$148.75	\$145.65	\$143.20
304	1/2	6	3/32	.160	2 3/32	37020304	133.35	.0788 -.1088	175.90	157.80	151.70	148.75	145.65	143.20
404	1/2	6	1/8	.191	2 1/8	37020404	133.35	.1089 -.1400	175.90	157.80	151.70	148.75	145.65	143.20
305	5/8	6	3/32	.191	2 3/32	37020305	138.10	.0788 -.1088	180.80	162.75	156.65	153.70	150.65	148.20
405	5/8	6	1/8	.223	2 1/8	37020405	138.10	.1089 -.1400	180.80	162.75	156.65	153.70	150.65	148.20
505	5/8	6	5/32	.252	2 5/32	37020505	138.10	.1401 -.1713	180.80	162.75	156.65	153.70	150.65	148.20
605	5/8	6	3/16	.279	2 3/16	37020605	138.10	.1714 -.2025	180.80	162.75	156.65	153.70	150.65	148.20
406	3/4	6	1/8	.217	2 1/8	37020406	144.15	.1100 -.1400	187.25	169.10	163.05	160.10	157.00	154.55
506	3/4	6	5/32	.246	2 5/32	37020506	144.15	.1401 -.1713	187.25	169.10	163.05	160.10	157.00	154.55
606	3/4	6	3/16	.279	2 3/16	37020606	144.15	.1714 -.2025	187.25	169.10	163.05	160.10	157.00	154.55
-	3/4	6	1/32	.342	2 7/32	37022407	157.85	.2026 -.2339	187.25	169.10	163.05	160.10	157.00	154.55
806	3/4	6	1/4	.342	2 1/4	37020806	144.15	.2340 -.2650	187.25	169.10	163.05	160.10	157.00	154.55
507	7/8	6	5/32	.246	2 5/32	37020507	151.00	.1401 -.1713	194.30	176.20	170.10	167.25	164.15	161.65
607	7/8	6	3/16	.279	2 3/16	37020607	151.00	.1714 -.2025	194.30	176.20	170.10	167.25	164.15	161.65
707	7/8	6	7/32	.312	2 7/32	37020707	151.00	.2026 -.2339	194.30	176.20	170.10	167.25	164.15	161.65
807	7/8	6	1/4	.342	2 1/4	37020807	151.00	.2340 -.2650	194.30	176.20	170.10	167.25	164.15	161.65
608	1	8	3/16	.279	2 3/16	37020608	170.30	.1714 -.2025	214.55	196.50	190.35	187.45	184.40	181.85
708	1	8	7/32	.312	2 7/32	37020708	170.30	.2026 -.2339	214.55	196.50	190.35	187.45	184.40	181.85
808	1	8	1/4	.342	2 1/4	37020808	170.30	.2340 -.2650	214.55	196.50	190.35	187.45	184.40	181.85
-	1	8	9/32	.401	2 9/32	37023209	186.55	.2651 -.2968	214.55	196.50	190.35	187.45	184.40	181.85
1008	1	8	5/16	.401	2 5/16	37021008	170.30	.2969 -.3281	214.55	196.50	190.35	187.45	184.40	181.85
-	1	8	11/32	.467	2 11/32	37023211	186.55	.3282 -.3593	214.55	196.50	190.35	187.45	184.40	181.85
1208	1	8	3/8	.467	2 3/8	37021208	170.30	.3594 -.3900	214.55	196.50	190.35	187.45	184.40	181.85
609	1 1/8	8	3/16	.312	2 3/16	37020609	178.85	.1714 -.2025	223.60	205.45	199.35	196.50	193.40	190.90
709	1 1/8	8	7/32	.342	2 7/32	37020709	178.85	.2026 -.2339	223.60	205.45	199.35	196.50	193.40	190.90
809	1 1/8	8	1/4	.374	2 1/4	37020809	178.85	.2340 -.2650	223.60	205.45	199.35	196.50	193.40	190.90
-	1 1/8	8	9/32	.435	2 9/32	37023609	195.85	.2651 -.2968	223.60	205.45	199.35	196.50	193.40	190.90
1009	1 1/8	8	5/16	.435	2 5/16	37021009	178.85	.2969 -.3281	223.60	205.45	199.35	196.50	193.40	190.90
610	1 1/4	8	3/16	.312	2 3/16	37020610	187.80	.1714 -.2025	232.95	214.85	208.75	205.80	202.70	200.25
710	1 1/4	8	7/32	.342	2 7/32	37020710	187.80	.2026 -.2339	232.95	214.85	208.75	205.80	202.70	200.25
810	1 1/4	8	1/4	.374	2 1/4	37020810	187.80	.2340 -.2650	232.95	214.85	208.75	205.80	202.70	200.25
-	1 1/4	8	9/32	.435	2 9/32	37024009	205.65	.2651 -.2968	232.95	214.85	208.75	205.80	202.70	200.25
1010	1 1/4	8	5/16	.435	2 5/16	37021010	187.80	.2969 -.3281	232.95	214.85	208.75	205.80	202.70	200.25
-	1 1/4	8	11/32	.467	2 11/32	37024011	205.65	.3282 -.3593	232.95	214.85	208.75	205.80	202.70	200.25
1210	1 1/4	8	3/8	.467	2 3/8	37021210	187.80	.3594 -.3900	232.95	214.85	208.75	205.80	202.70	200.25
811	1 3/8	8	1/4	.401	2 1/4	37020811	197.25	.2340 -.2650	242.90	224.75	218.70	215.75	212.65	210.20
-	1 3/8	8	9/32	.467	2 9/32	37024409	216.10	.2651 -.2968	242.90	224.75	218.70	215.75	212.65	210.20
1011	1 3/8	8	5/16	.467	2 5/16	37021011	197.25	.2969 -.3281	242.90	224.75	218.70	215.75	212.65	210.20
-	1 3/8	8	11/32	.467	2 11/32	37024411	216.10	.3282 -.3593	242.90	224.75	218.70	215.75	212.65	210.20
1211	1 3/8	8	3/8	.467	2 3/8	37021211	197.25	.3594 -.3900	242.90	224.75	218.70	215.75	212.65	210.20
812	1 1/2	8	1/4	.435	2 1/4	37020812	207.15	.2340 -.2650	253.20	235.15	229.05	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	229.05	226.10	223.00	220.55
1012	1 1/2	8	5/16	.467	2 5/16	37021012	207.15	.2969 -.3281	253.20	235.15	229.05	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	229.05	226.10	223.00	220.55
1212	1 1/2	8	3/8	.467	2 3/8	37021212	207.15	.3594 -.3900	253.20	235.15	229.05	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	229.05	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	229.05	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	229.05	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	229.05	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	\$200.55	\$182.40	\$176.35	\$173.40	\$170.30	\$167.85
304	1/2	6	3/32	.160	2 3/32	37030304	156.85	.0788 - .1088	200.55	182.40	176.35	173.40	170.30	167.85
404	1/2	6	1/8	.191	2 1/8	37030404	156.85	.1089 - .1400	200.55	182.40	176.35	173.40	170.30	167.85
305	5/8	6	3/32	.191	2 3/32	37030305	162.40	.0788 - .1088	206.35	188.30	182.20	179.25	176.20	173.75
405	5/8	6	1/8	.223	2 1/8	37030405	162.40	.1089 - .1400	206.35	188.30	182.20	179.25	176.20	173.75
505	5/8	6	5/32	.252	2 5/32	37030505	162.40	.1401 - .1713	206.35	188.30	182.20	179.25	176.20	173.75
605	5/8	6	3/16	.279	2 3/16	37030605	162.40	.1714 - .2025	206.35	188.30	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	195.95	189.85	186.90	183.80	181.30
506	3/4	6	5/32	.246	2 5/32	37030506	169.70	.1401 - .1713	214.00	195.95	189.85	186.90	183.80	181.30
606	3/4	6	3/16	.279	2 3/16	37030606	169.70	.1714 - .2025	214.00	195.95	189.85	186.90	183.80	181.30
-	3/4	6	7/32	.342	2 7/32	37032407	185.85	.2026 - .2339	214.00	195.95	189.85	186.90	183.80	181.30
806	3/4	6	1/4	.342	2 1/4	37030806	169.70	.2340 - .2650	214.00	195.95	189.85	186.90	183.80	181.30
507	7/8	6	5/32	.246	2 5/32	37030507	177.50	.1401 - .1713	222.10	204.00	197.95	194.95	191.85	189.50
607	7/8	6	3/16	.279	2 3/16	37030607	177.50	.1714 - .2025	222.10	204.00	197.95	194.95	191.85	189.50
707	7/8	6	7/32	.312	2 7/32	37030707	177.50	.2026 - .2339	222.10	204.00	197.95	194.95	191.85	189.50
807	7/8	6	1/4	.342	2 1/4	37030807	177.50	.2340 - .2650	222.10	204.00	197.95	194.95	191.85	189.50
608	1	8	3/16	.279	2 3/16	37030608	200.25	.1714 - .2025	246.00	227.90	221.85	218.90	215.80	213.35
708	1	8	7/32	.312	2 7/32	37030708	200.25	.2026 - .2339	246.00	227.90	221.85	218.90	215.80	213.35
808	1	8	1/4	.342	2 1/4	37030808	200.25	.2340 - .2650	246.00	227.90	221.85	218.90	215.80	213.35
-	1	8	9/32	.401	2 9/32	37033209	219.40	.2651 - .2968	246.00	227.90	221.85	218.90	215.80	213.35
1008	1	8	5/16	.401	2 5/16	37031008	200.25	.2969 - .3281	246.00	227.90	221.85	218.90	215.80	213.35
-	1	8	11/32	.467	2 11/32	37033211	219.40	.3282 - .3593	246.00	227.90	221.85	218.90	215.80	213.35
1208	1	8	3/8	.467	2 3/8	37031208	200.25	.3594 - .3900	246.00	227.90	221.85	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	226.25	223.70
709	1 1/8	8	7/32	.342	2 7/32	37030709	210.20	.2026 - .2339	256.40	238.30	232.20	229.30	226.25	223.70
809	1 1/8	8	1/4	.374	2 1/4	37030809	210.20	.2340 - .2650	256.40	238.30	232.20	229.30	226.25	223.70
-	1 1/8	8	9/32	.435	2 9/32	37033609	230.25	.2651 - .2968	256.40	238.30	232.20	229.30	226.25	223.70
1009	1 1/8	8	5/16	.435	2 5/16	37031009	210.20	.2969 - .3281	256.40	238.30	232.20	229.30	226.25	223.70
610	1 1/4	8	3/16	.312	2 3/16	37030610	220.80	.1714 - .2025	267.45	249.35	243.30	240.40	237.30	234.85
710	1 1/4	8	7/32	.342	2 7/32	37030710	220.80	.2026 - .2339	267.45	249.35	243.30	240.40	237.30	234.85
810	1 1/4	8	1/4	.374	2 1/4	37030810	220.80	.2340 - .2650	267.45	249.35	243.30	240.40	237.30	234.85
-	1 1/4	8	9/32	.435	2 9/32	37034009	241.85	.2651 - .2968	267.45	249.35	243.30	240.40	237.30	234.85
1010	1 1/4	8	5/16	.435	2 5/16	37031010	220.80	.2969 - .3281	267.45	249.35	243.30	240.40	237.30	234.85
-	1 1/4	8	11/32	.467	2 11/32	37034011	241.85	.3282 - .3593	267.45	249.35	243.30	240.40	237.30	234.85
1210	1 1/4	8	3/8	.467	2 3/8	37031210	220.80	.3594 - .3900	267.45	249.35	243.30	240.40	237.30	234.85
811	1 3/8	8	1/4	.401	2 1/4	37030811	232.00	.2340 - .2650	279.25	261.15	255.00	252.15	249.05	246.55
-	1 3/8	8	9/32	.467	2 9/32	37034409	254.05	.2651 - .2968	279.25	261.15	255.00	252.15	249.05	246.55
1011	1 3/8	8	5/16	.467	2 5/16	37031011	232.00	.2969 - .3281	279.25	261.15	255.00	252.15	249.05	246.55
-	1 3/8	8	11/32	.467	2 11/32	37034411	254.05	.3282 - .3593	279.25	261.15	255.00	252.15	249.05	246.55
1211	1 3/8	8	3/8	.467	2 3/8	37031211	232.00	.3594 - .3900	279.25	261.15	255.00	252.15	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	264.25	261.15	258.70
-	1 1/2	8	9/32	.467	2 9/32	37034809	266.75	.2651 - .2968	291.40	273.30	267.20	264.25	261.15	258.70
1012	1 1/2	8	5/16	.467	2 5/16	37031012	243.60	.2969 - .3281	291.40	273.30	267.20	264.25	261.15	258.70
-	1 1/2	8	11/32	.467	2 11/32	37034811	266.75	.3282 - .3593	291.40	273.30	267.20	264.25	261.15	258.70
1212	1 1/2	8	3/8	.467	2 3/8	37031212	243.60	.3594 - .3900	291.40	273.30	267.20	264.25	261.15	258.70
-	1 1/2	8	13/32	.467	2 13/32	37034813	266.75	.3901 - .4219	291.40	273.30	267.20	264.25	261.15	258.70
-	1 1/2	8	7/16	.467	2 7/16	37034814	266.75	.4220 - .4531	291.40	273.30	267.20	264.25	261.15	258.70
-	1 1/2	8	15/32	.467	2 15/32	37034815	266.75	.4532 - .4843	291.40	273.30	267.20	264.25	261.15	258.70
-	1 1/2	8	1/2	.467	2 1/2	37034816	266.75	.4844 - .5150	291.40	273.30	267.20	264.25	261.15	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

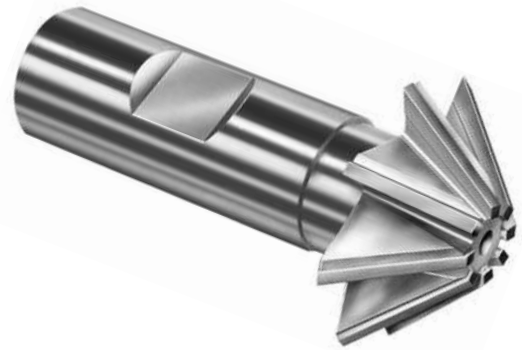
TYPE 3732 - 60° - FOR NON-FERROUS & CAST IRON

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	\$187.00	373116	\$205.60	7/32	373216	\$187.00	373316	\$205.60
3/4	3/8	6	2 1/8	3/16	373024	201.60	373124	221.70	5/16	373224	201.60	373324	221.70
1	1/2	6	2 1/2	5/16	373032	236.50	373132	260.05	7/16	373232	236.50	373332	260.05
1 1/2	3/4	8	2 3/4	1/2	373048	299.70	373148	329.75	3/8	373248	299.70	373348	329.75

DOUBLE ANGLE CUTTERS

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

TYPE 3747 - 60° - FOR STEEL

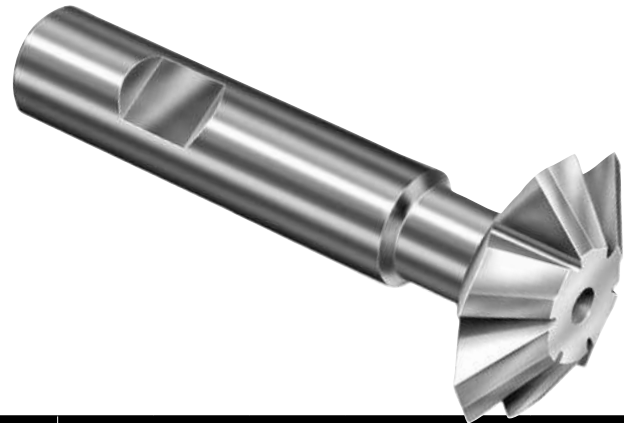
TYPE 3748 - 90° - FOR NON-FERROUS & CAST IRON

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".



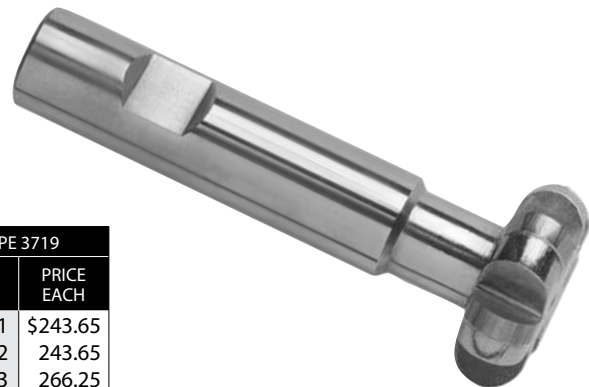
TOOL DIAMETER	SHANK DIAMETER	NO. OF TEETH	60° DOUBLE ANGLE						90° DOUBLE ANGLE					
			OVERALL LENGTH	CUTTER WIDTH	TYPE 3746 EDP NO.	PRICE EACH	TYPE 3747 EDP NO.	PRICE EACH	OVERALL LENGTH	CUTTER WIDTH	TYPE 3748 EDP NO.	PRICE EACH	TYPE 3749 EDP NO.	PRICE EACH
3/4	3/8	6	2 3/8	3/16	374624	\$166.65	374724	\$183.40	2 3/8	1/4	374824	\$166.65	374924	\$183.40
1	1/2	6	2 27/32	5/16	374632	196.85	374732	216.60	2 29/32	3/8	374832	196.85	374932	216.60
1 3/8	5/8	6	3 7/32	7/16	374644	228.10	374744	250.95	3 9/32	1/2	374844	228.10	374944	250.95
1 1/2	5/8	6	3 3/8	1/2	374648	239.50	374748	263.50	3 7/16	9/16	374848	239.50	374948	263.50
1 7/8	3/4	6	3 25/32	5/8	374660	363.75	374760	400.10	3 25/32	5/8	374860	363.75	374960	400.10
2 1/4	7/8	6	4 5/32	3/4	374672	492.30	374772	541.50	4 5/32	3/4	374872	492.30	374972	541.50

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.

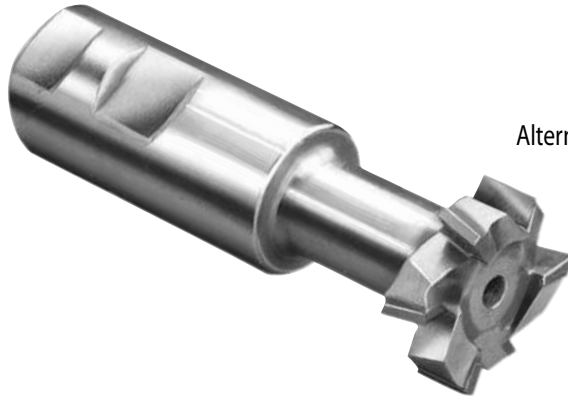


CUTTER RADIUS	TOOL DIAM.	SHANK DIAM.	NO. OF TEETH	CUTTER WIDTH	OVERALL LENGTH	TYPE 3718		TYPE 3719	
						EDP NO.	PRICE EACH	EDP NO.	PRICE EACH
1/32	3/4	1/2	6	1/16	3	371801	\$221.50	371901	\$243.65
1/16	3/4	1/2	6	1/8	3	371802	221.50	371902	243.65
3/32	7/8	1/2	6	3/16	3	371803	242.10	371903	266.25
1/8	1 1/4	3/4	6	1/4	3 1/2	371804	263.50	371904	289.90
5/32	1 5/16	3/4	6	5/16	3 1/2	371805	303.20	371905	333.55
3/16	1 3/8	3/4	6	3/8	3 1/2	371806	320.90	371906	352.95
1/4	1 1/2	3/4	6	1/2	4	371808	332.10	371908	365.45

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	\$165.05
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	472.50
1 1/4	2 7/32	1 1/4	1 3/32	1 7/32	1 31/32	8	5 3/8	372040	552.10	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	639.30	372148	690.55

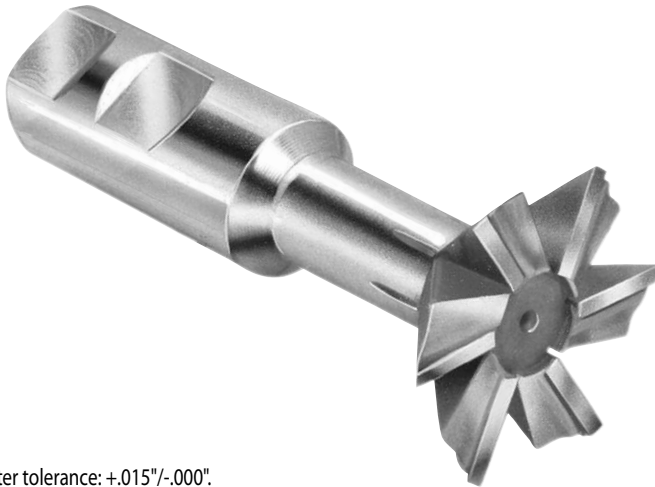
CARBIDE TIPPED DOVETAIL CUTTERS

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	\$143.75	373516	\$155.30	7/32	373616	\$143.75	373716	\$155.30
3/4	3/8	1/4	3	2 1/4	1/4	373424	155.10	373524	167.40	1/4	373624	155.10	373724	167.40
1	1/2	3/8	4	2 1/2	5/16	373432	165.90	373532	179.20	3/8	373632	165.90	373732	179.20
1 1/4	5/8	1/2	4	2 3/4	3/8	373440	188.55	373540	203.70	1/2	373640	188.55	373740	203.70
1 1/2	3/4	1/2	4	3 1/4	1/2	373448	220.35	373548	238.05	5/8	373648	220.35	373748	238.05
2	1	3/4	6	4 1/4	5/8	373464	353.95	373564	382.30	3/4	373664	353.95	373764	382.30
2 1/2	1 1/4	1	6	4 3/8	3/4	373480	478.70	373580	517.00	7/8	373680	478.70	373780	517.00
3	1 1/4	1	6	4 1/2	1	373496	564.55	373596	609.70	1 1/8	373696	564.55	373796	609.70

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.

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

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



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.

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

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

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

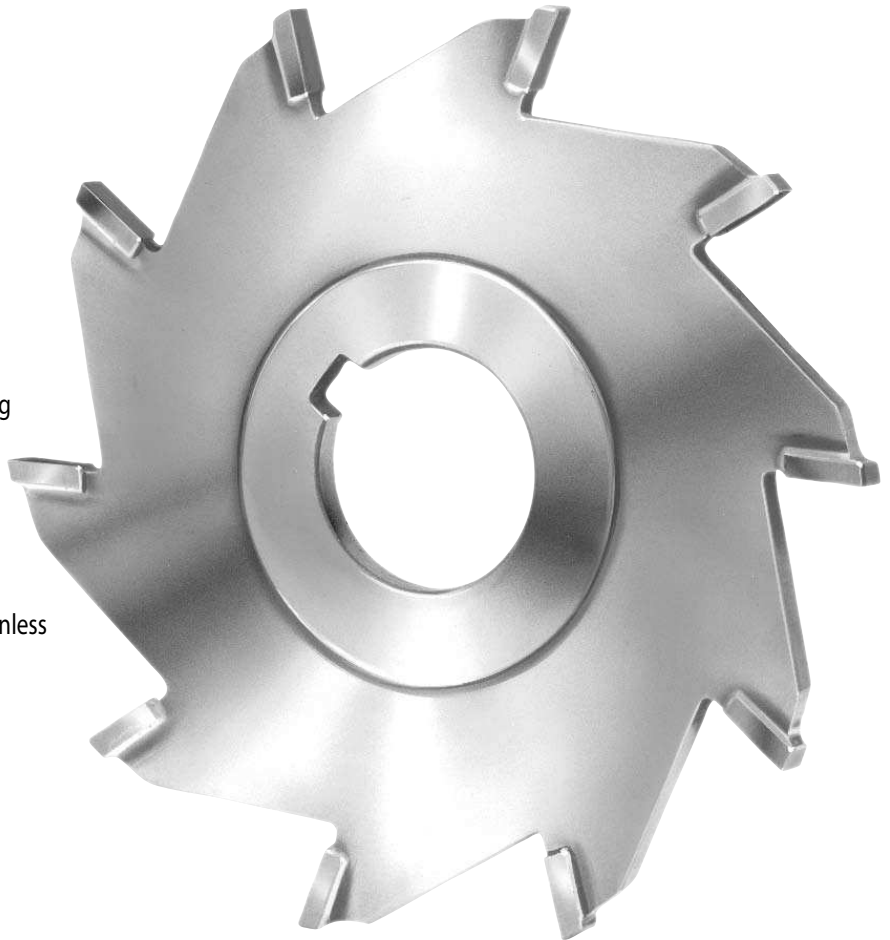
Carbide tips brazed to alloy steel bodies.

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	\$171.25	6	355232	\$197.10	8	355432	\$195.30	8	355832	\$183.00
3	$\frac{1}{8}$.1250	1	6	355034	176.30	6	355234	208.65	8	355434	218.60	8	355834	189.95
3	$\frac{3}{16}$.1875	1	6	355036	183.35	6	355236	220.65	8	355436	220.65	8	355836	197.30
3	$\frac{1}{4}$.2500	1	6	355037	124.65	6	355237	180.95	8	355437	180.95	8	355837	217.20
3	$\frac{5}{16}$.3125	1	6	355031	130.90	6	355231	180.95	8	355431	180.95	8	355831	217.20
3	$\frac{3}{8}$.3750	1	6	355038	133.55	6	355238	183.85	8	355438	183.85	8	355838	220.65
4	$\frac{3}{32}$.0938	1	6	355042	210.20	8	355242	252.75	8	355442	252.75	10	355842	263.35
4	$\frac{1}{8}$.1250	1	6	355044	216.35	8	355244	256.00	8	355444	256.00	10	355844	266.65
4	$\frac{3}{16}$.1875	1	6	355046	219.65	8	355246	275.90	8	355446	275.90	10	355846	270.30
4	$\frac{1}{4}$.2500	1	6	355047	160.25	8	355247	234.30	8	355447	234.30	10	355847	281.30
4	$\frac{5}{16}$.3125	1	6	355041	164.70	8	355241	243.30	8	355441	243.30	10	355841	291.90
4	$\frac{3}{8}$.3750	1	6	355048	169.10	8	355248	252.20	8	355448	252.20	10	355848	302.60
4	$\frac{3}{8}$.3750	1 1/4	6	355049	169.10	8	355249	252.20	8	355449	252.20	10	355849	302.60
5	$\frac{3}{32}$.0938	1	8	355052	227.40	10	355252	339.25	10	355452	339.25	12	355852	358.00
5	$\frac{1}{8}$.1250	1	-	-	-	10	355254	364.75	10	355454	364.75	12	355854	365.45
5	$\frac{3}{16}$.1875	1	-	-	-	10	355256	410.70	10	355456	410.70	12	355856	380.05
6	$\frac{1}{8}$.1250	1 1/4	8	355063	309.70	12	355263	445.20	12	355463	445.20	14	355863	427.45
6	$\frac{3}{16}$.1875	1 1/4	8	355065	408.10	12	355265	459.90	12	355465	459.90	14	355865	438.45
6	$\frac{1}{4}$.2500	1 1/4	8	355067	422.70	12	355267	469.45	12	355467	469.45	14	355867	445.70
8	$\frac{1}{8}$.1250	1 1/4	10	355083	395.85	-	-	-	-	-	-	-	-	-
8	$\frac{3}{16}$.1875	1 1/4	-	-	-	16	355285	632.85	16	355485	632.85	-	-	-
8	$\frac{1}{4}$.2500	1 1/4	-	-	-	16	355287	657.10	16	355487	657.10	-	-	-

CARBIDE TIPPED SLITTING SAWS - STANDARD TOOTH



TYPE 3551 - FOR NON-FERROUS

Similar to our Type 3550
Except designed with more
teeth for better finishes.

TYPE 3553 - FOR CAST IRON

Similar to our Type 3552
Except designed with more
teeth for better finishes.

TYPE 3556 - FOR STEEL

Similar to our Type 3554
Except designed with more
teeth for better finishes.

TYPE 3559 - FOR STAINLESS STEEL

Similar to our Type 3558
Except designed with more
teeth for better finishes.

For tolerances, see page 14.

TOOL DIAM.	WIDTH		TYPE 3551 FOR NON-FERROUS				TYPE 3553 FOR CAST IRON				TYPE 3556 FOR STEEL				TYPE 3559 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	1/16	.0625	12	355198	-	\$269.70	12	355398	-	\$269.70	16	355698	-	\$322.55	12	355998	-	\$303.40
3	3/64	.0781	12	355100	-	319.00	12	355300	-	319.00	16	355600	-	390.00	12	355900	-	339.85
3	3/32	.0938	12	355102	-	269.70	12	355302	-	269.70	16	355602	-	322.55	12	355902	-	303.40
3	7/64	.1094	12	355104	-	268.75	12	355304	-	268.75	16	355604	-	297.55	12	355904	-	289.60
3	1/8	.1250	12	355106	355107	216.90	12	355306	355307	216.90	16	355606	-	269.65	12	355906	355907	276.55
3	5/32	.1562	12	355108	-	258.35	12	355308	-	258.35	16	355608	-	283.30	12	355908	-	283.30
3	3/16	.1875	12	355109	-	231.15	12	355309	-	231.15	16	355609	-	296.95	12	355909	-	290.05
3	7/32	.2188	12	355110	-	267.40	12	355310	-	267.40	16	355610	-	310.55	12	355910	-	299.25
3	1/4	.2500	12	355111	-	281.15	12	355311	-	281.15	16	355611	-	324.25	12	355911	-	308.30
3	5/16	.3125	12	355112	-	308.30	12	355312	-	308.30	16	355612	-	355.50	12	355912	-	337.70
3	3/8	.3750	12	355113	-	335.45	12	355313	-	335.45	16	355613	-	386.90	12	355913	-	369.35
4	1/16	.0625	14	355116	355117	314.10	14	355316	-	314.10	20	355616	-	390.00	14	355916	355917	345.05
4	3/64	.0781	14	355118	355119	371.00	14	355318	355319	371.00	20	355618	355619	426.70	14	355918	355919	395.35
4	3/32	.0938	14	355120	355121	314.10	14	355320	355321	314.10	20	355620	355621	390.00	14	355920	355921	345.05
4	7/64	.1094	14	355122	355123	320.75	14	355322	355323	320.75	20	355622	355623	368.85	14	355922	355923	409.15
4	1/8	.1250	14	355124	355125	283.30	14	355324	355325	283.30	20	355624	355625	344.50	14	355924	355925	344.50
4	5/32	.1562	14	355126	355127	321.75	14	355326	355327	321.75	20	355626	355627	370.20	14	355926	355927	353.55
4	3/16	.1875	14	355128	355129	301.55	14	355328	355329	301.55	20	355628	355629	371.65	14	355928	355929	364.85
4	7/32	.2188	14	355130	355131	342.30	14	355330	355331	342.30	20	355630	355631	393.65	14	355930	355931	376.35
4	1/4	.2500	14	355132	355133	348.90	14	355332	355333	348.90	20	355632	355633	398.75	14	355932	355933	385.30
4	5/16	.3125	14	355134	355135	376.35	14	355334	355335	376.35	20	355634	355635	432.65	14	355934	355935	412.50
4	3/8	.3750	14	355136	355137	403.50	14	355336	355337	403.50	20	355636	355637	463.95	14	355936	355937	444.15
5	3/64	.0781	16	355142	355143	459.50	16	355342	355343	459.50	24	355642	355643	528.45	16	355942	355943	487.10
5	3/32	.0938	16	355144	355145	379.15	16	355344	355345	379.15	24	355644	355645	532.15	16	355944	355945	417.80
5	7/64	.1094	16	355146	355147	431.70	16	355346	355347	431.70	24	355646	355647	496.45	16	355946	355947	459.50
5	1/8	.1250	16	355148	355149	350.30	16	355348	355349	350.30	24	355648	355649	430.50	16	355948	355949	405.75
5	5/32	.1562	16	355150	355151	382.95	16	355350	355351	382.95	24	355650	355651	440.45	16	355950	355951	419.15
5	3/16	.1875	16	355152	355153	392.30	16	355352	355353	392.30	24	355652	355653	471.40	16	355952	355953	441.95
5	7/32	.2188	16	355154	355155	421.55	16	355354	355355	421.55	24	355654	355655	484.80	16	355954	355955	464.65
5	1/4	.2500	16	355156	355157	439.70	16	355356	355357	439.70	24	355656	355657	505.65	16	355956	355957	487.20
5	5/16	.3125	16	355158	355159	478.05	16	355358	355359	478.05	24	355658	355659	549.90	16	355958	355959	525.70
5	3/8	.3750	16	355160	355161	516.75	16	355360	355361	516.75	24	355660	355661	594.20	16	355960	355961	566.60
6	3/64	.0781	18	355166	355167	516.65	18	355366	355367	516.65	28	355666	355667	594.10	18	355966	355967	547.80
6	3/32	.0938	18	355168	355169	460.10	18	355368	355369	460.10	28	355668	355669	544.25	18	355968	355969	504.50
6	7/64	.1094	18	355170	355171	518.45	18	355370	355371	518.45	28	355670	355671	596.10	18	355970	355971	549.65
6	1/8	.1250	18	355172	355173	438.50	18	355372	355373	438.50	28	355672	355673	571.05	18	355972	355973	518.90
6	5/32	.1562	18	355174	355175	496.25	18	355374	355375	496.25	28	355674	355675	570.75	18	355974	355975	541.60
6	3/16	.1875	18	355176	355177	480.45	18	355376	355377	480.45	28	355676	355677	612.35	18	355976	355977	564.20
6	7/32	.2188	18	355178	355179	541.60	18	355378	355379	541.60	28	355678	355679	622.85	18	355978	355979	586.90
6	1/4	.2500	18	355180	355181	564.30	18	355380	355381	564.30	28	355680	355681	665.80	18	355980	355981	618.25
6	5/16	.3125	18	355182	355183	587.05	18	355382	355383	587.05	28	355682	355683	675.05	18	355982	355983	645.90
6	3/8	.3750	18	355184	355185	609.65	18	355384	355385	609.65	28	355684	355685	700.95	18	355984	355985	670.75
8	1/8	.1250	24	-	355186	728.10	24	-	355386	728.10	24	-	355686	769.70	24	-	355986	769.70
8	5/32	.1562	24	-	355187	736.80	24	-	355387	736.80	24	-	355687	778.45	24	-	355987	778.45
8	3/16	.1875	24	-	355188	745.50	24	-	355388	745.50	24	-	355688	787.10	24	-	355988	787.10
8	1/4	.2500	24	-	355189	790.45	24	-	355389	790.45	24	-	355689	832.15	24	-	355989	832.15

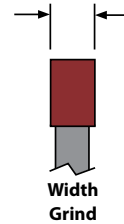
3" CARBIDE TIPPED MILLING CUTTERS

TYPE 3559 - GENERAL PURPOSE



Width grinds between .0600" and .5312"

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH - FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
3	.0600-.0703	.0555	355998D	\$373.00	\$346.05	\$341.40	\$338.95	\$337.45	\$303.40
3	.0704-.0859	.0711	355900D	409.50	382.60	377.85	375.40	373.90	339.85
3	.0860-.1015	.0867	355902D	373.00	346.05	341.40	338.95	337.45	303.40
3	.1016-.1171	.1024	355904D	359.20	332.35	327.60	325.15	323.65	289.60
3	.1172-.1406	.1180	355906D	346.20	319.30	314.55	312.10	310.60	276.55
3	.1407-.1718	.1562	355908D	352.90	326.05	321.30	318.85	317.35	283.30
3	.1719-.2031	.1875	355909D	359.65	332.70	328.05	325.60	324.10	290.05
3	.2032-.2343	.2188	355910D	368.85	342.00	337.25	334.80	333.30	299.25
3	.2344-.2812	.2500	355911D	377.95	351.05	346.30	343.85	342.35	308.30
3	.2813-.3437	.3125	355912D	407.35	380.40	375.75	373.30	371.80	337.70
3	.3438-.4062	.3750	355913D	438.95	412.10	407.35	404.90	403.45	369.35
3	.4063-.4687	.4375	355914D	470.95	444.00	439.35	436.90	435.40	401.35
3	.4688-.5312	.5000	355915D	502.95	476.00	471.25	468.85	467.40	433.25



Cutter Notes (All cutters on page)

- 12 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39RC)

Corner Radius or Chamfer on ONE Side

Radius Notes

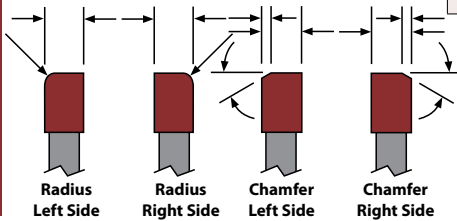
- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/3 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED WITH RADIUS OR CHAMFER					
				1 PC	2 PC	3 PC	4 PC	5 PC	6 PC
3	.0600-.0703	.0555	355998R1	\$391.25	\$351.40	\$346.05	\$343.40	\$341.75	\$340.85
3	.0704-.0859	.0711	355900R1	427.70	387.85	382.60	379.85	378.20	377.30
3	.0860-.1015	.0867	355902R1	391.25	351.40	346.05	343.40	341.75	340.85
3	.1016-.1171	.1024	355904R1	377.45	337.60	332.35	329.60	327.95	327.05
3	.1172-.1406	.1180	355906R1	364.40	324.55	319.30	316.55	314.90	314.00
3	.1407-.1718	.1562	355908R1	371.15	331.30	326.05	323.30	321.65	320.75
3	.1719-.2031	.1875	355909R1	377.90	338.05	332.70	330.05	328.40	327.50
3	.2032-.2343	.2188	355910R1	387.10	347.25	342.00	339.25	337.60	336.70
3	.2344-.2812	.2500	355911R1	396.15	356.30	351.05	348.30	346.65	345.75
3	.2813-.3437	.3125	355912R1	425.60	385.75	380.40	377.75	376.10	375.15
3	.3438-.4062	.3750	355913R1	457.20	417.40	412.10	409.35	407.75	406.85
3	.4063-.4687	.4375	355914R1	489.20	449.35	444.00	441.35	439.70	438.80
3	.4688-.5312	.5000	355915R1	521.20	481.25	476.00	473.30	471.60	470.70

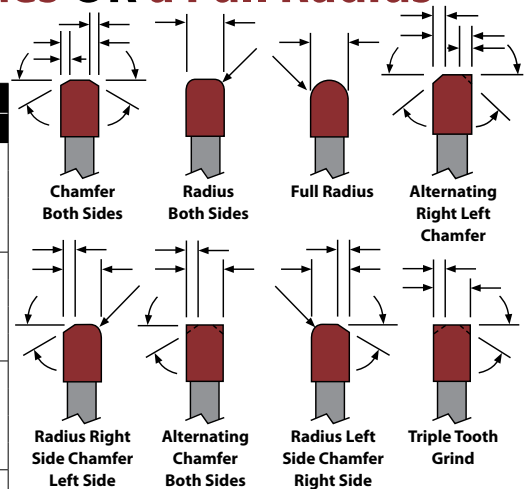
Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED WITH RADI, CHAMFERS, OR COMBINATION					
				1 PC	2 PC	3 PC	4 PC	5 PC	6 PC
3	.0600-.0703	.0555	355998R2	\$401.00	\$356.75	\$350.90	\$347.85	\$346.00	\$345.05
3	.0704-.0859	.0711	355900R2	437.50	393.20	387.30	384.30	382.45	381.45
3	.0860-.1015	.0867	355902R2	401.00	356.75	350.90	347.85	346.00	345.05
3	.1016-.1171	.1024	355904R2	387.25	342.95	337.10	334.05	332.20	331.25
3	.1172-.1406	.1180	355906R2	374.20	329.90	324.05	321.00	319.15	318.25
3	.1407-.1718	.1562	355908R2	380.95	336.65	330.80	327.75	325.90	324.90
3	.1719-.2031	.1875	355909R2	387.60	343.40	337.55	334.50	332.65	331.65
3	.2032-.2343	.2188	355910R2	396.90	352.60	346.75	343.70	341.85	340.85
3	.2344-.2812	.2500	355911R2	405.95	361.65	355.80	352.75	350.90	349.95
3	.2813-.3437	.3125	355912R2	435.35	391.10	385.15	382.20	380.35	379.40
3	.3438-.4062	.3750	355913R2	467.00	422.70	416.85	413.80	411.95	411.00
3	.4063-.4687	.4375	355914R2	498.90	454.70	448.85	445.80	443.95	442.95
3	.4688-.5312	.5000	355915R2	530.90	486.70	480.75	477.75	475.90	474.95





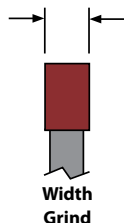
4" CARBIDE TIPPED MILLING CUTTERS

TYPE 3559 - GENERAL PURPOSE

Width grinds between .0600" and .5312"

Cutter Notes (All cutters on page)

- 14 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)



TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
4	.0600-.0703	.0545	355916D	\$427.10	\$396.15	\$390.50	\$387.60	\$385.85	\$345.10
4	.0704-.0859	.0701	355918D	477.40	446.40	440.75	437.85	436.05	395.35
4	.0860-.1015	.0858	355920D	427.10	396.15	390.50	387.60	385.85	345.10
4	.1016-.1171	.1014	355922D	491.20	460.25	454.55	451.75	449.95	409.15
4	.1172-.1406	.1170	355924D	426.60	395.55	389.90	387.05	385.25	344.50
4	.1407-.1718	.1562	355926D	435.65	404.70	398.95	396.15	394.30	353.55
4	.1719-.2031	.1875	355928D	446.90	415.95	410.25	407.45	405.60	364.85
4	.2032-.2343	.2188	355930D	458.35	427.40	421.75	418.85	417.10	376.25
4	.2344-.2812	.2500	355932D	467.40	436.35	430.75	427.85	426.05	385.30
4	.2813-.3437	.3125	355934D	494.45	463.55	457.90	455.00	453.20	412.50
4	.3438-.4062	.3750	355936D	526.25	495.30	489.65	486.75	484.95	444.15
4	.4063-.4687	.4375	355938D	558.20	527.25	521.55	518.75	516.90	476.15
4	.4688-.5312	.5000	355940D	590.20	559.15	553.55	550.65	548.85	508.10

Corner Radius or Chamfer on ONE Side

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
4	.0600-.0703	.0545	355916R1	\$446.85	\$401.95	\$395.70	\$392.45	\$390.50	\$389.50
4	.0704-.0859	.0701	355918R1	497.05	452.15	445.95	442.70	440.75	439.70
4	.0860-.1015	.0858	355920R1	446.85	401.95	395.70	392.45	390.50	389.50
4	.1016-.1171	.1014	355922R1	510.95	466.05	459.75	456.55	454.55	453.50
4	.1172-.1406	.1170	355924R1	446.25	401.35	395.10	391.85	389.90	388.90
4	.1407-.1718	.1562	355926R1	455.30	410.40	404.15	401.00	398.95	397.95
4	.1719-.2031	.1875	355928R1	466.65	421.75	415.45	412.25	410.25	409.20
4	.2032-.2343	.2188	355930R1	478.05	433.20	426.95	423.70	421.75	420.65
4	.2344-.2812	.2500	355932R1	487.05	442.15	435.90	432.65	430.75	429.70
4	.2813-.3437	.3125	355934R1	514.20	469.30	463.10	459.80	457.90	456.80
4	.3438-.4062	.3750	355936R1	545.95	501.05	494.85	491.60	489.65	488.55
4	.4063-.4687	.4375	355938R1	577.95	533.05	526.75	523.55	521.55	520.50
4	.4688-.5312	.5000	355940R1	609.85	564.95	558.75	555.45	553.55	552.50

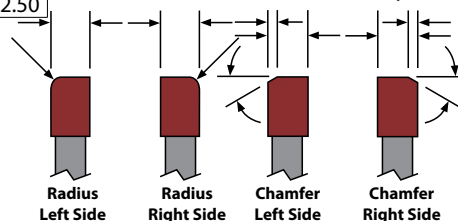
Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

Chamfer Notes

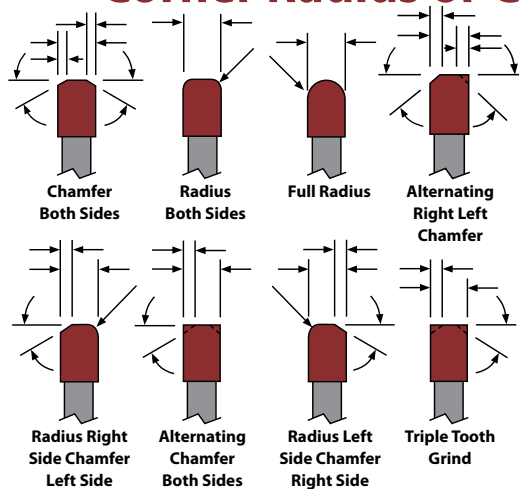
- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/2 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%



TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
4	.0600-.0703	.0545	355916R2	\$457.20	\$407.80	\$400.85	\$397.25	\$395.10	\$393.95
4	.0704-.0859	.0701	355918R2	507.45	458.05	451.05	447.50	445.35	444.15
4	.0860-.1015	.0858	355920R2	457.20	407.80	400.85	397.25	395.10	393.95
4	.1016-.1171	.1014	355922R2	521.35	471.85	464.95	461.40	459.20	458.05
4	.1172-.1406	.1170	355924R2	456.65	407.20	400.25	396.65	394.50	393.35
4	.1407-.1718	.1562	355926R2	465.70	416.25	409.30	405.80	403.55	402.45
4	.1719-.2031	.1875	355928R2	477.05	427.55	420.65	417.10	414.85	413.75
4	.2032-.2343	.2188	355930R2	488.45	438.95	432.05	428.50	426.35	425.15
4	.2344-.2812	.2500	355932R2	497.45	448.00	441.05	437.50	435.35	434.15
4	.2813-.3437	.3125	355934R2	524.60	475.20	468.20	464.65	462.50	461.30
4	.3438-.4062	.3750	355936R2	556.35	506.85	499.95	496.40	494.25	493.05
4	.4063-.4687	.4375	355938R2	588.35	538.85	531.95	528.40	526.15	525.05
4	.4688-.5312	.5000	355940R2	620.25	570.80	563.85	560.30	558.15	556.95

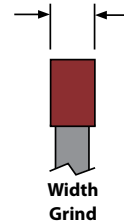
5" CARBIDE TIPPED MILLING CUTTERS

TYPE 3559 - GENERAL PURPOSE



Width grinds between .0600" and .5312"

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
5	.0704-.0859	.0691	355942D	\$571.05	\$539.35	\$533.55	\$530.60	\$528.80	\$487.10
5	.0860-.1015	.0848	355944D	501.75	470.05	464.35	461.40	459.60	417.80
5	.1016-.1171	.1004	355946D	543.45	511.70	505.95	503.00	501.20	459.50
5	.1094-.1406	.1160	355948D	489.65	457.90	452.15	449.20	447.45	405.75
5	.1407-.1718	.1562	355950D	503.10	471.40	465.70	462.70	460.85	419.15
5	.1719-.2031	.1875	355952D	525.85	494.15	488.45	485.50	483.70	441.95
5	.2032-.2343	.2188	355954D	548.55	516.90	511.15	508.20	506.35	464.65
5	.2188-.2812	.2500	355956D	571.10	539.45	533.70	530.75	528.95	487.20
5	.2813-.3437	.3125	355958D	609.65	577.95	572.15	569.20	567.40	525.70
5	.3438-.4062	.3750	355960D	650.45	618.75	613.05	610.05	608.30	566.60
5	.4063-.4687	.4375	355962D	682.40	650.75	645.00	642.05	640.25	598.50
5	.4688-.5312	.5000	355964D	714.40	682.70	677.00	674.05	672.20	630.50



Cutter Notes (All cutters on page)

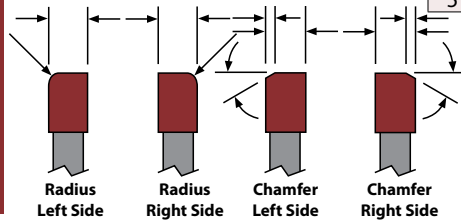
- 16 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39RC)

Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/3 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted



Corner Radius or Chamfer on ONE Side

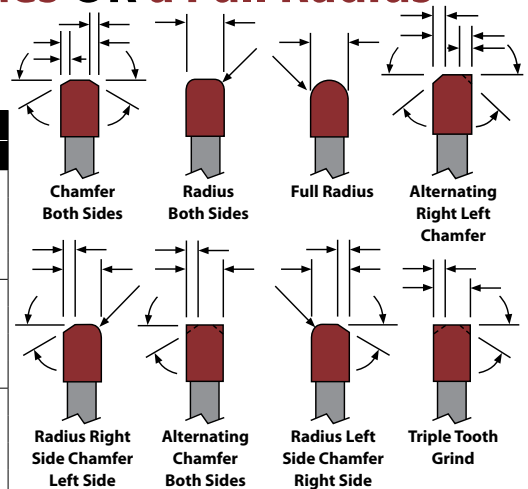
TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
5	.0704-.0859	.0691	355942R1	\$590.95	\$545.15	\$538.75	\$535.45	\$533.40	\$532.40
5	.0860-.1015	.0848	355944R1	521.70	475.90	469.45	466.20	464.20	463.10
5	.1016-.1171	.1004	355946R1	563.35	517.55	511.15	507.80	505.80	504.80
5	.1094-.1406	.1160	355948R1	509.55	463.75	457.35	454.05	452.05	451.00
5	.1407-.1718	.1562	355950R1	523.05	477.20	470.80	467.55	465.55	464.40
5	.1719-.2031	.1875	355952R1	545.80	500.05	493.60	490.30	488.30	487.20
5	.2032-.2343	.2188	355954R1	568.45	522.65	516.30	513.00	510.95	509.90
5	.2188-.2812	.2500	355956R1	591.10	545.30	538.85	535.60	533.55	532.45
5	.2813-.3437	.3125	355958R1	629.50	583.75	577.35	574.00	572.00	570.95
5	.3438-.4062	.3750	355960R1	670.40	624.60	618.15	614.90	612.90	611.85
5	.4063-.4687	.4375	355962R1	702.40	656.60	650.15	646.90	644.85	643.75
5	.4688-.5312	.5000	355964R1	734.30	688.50	682.10	678.85	676.80	675.75

Specify side for radius or chamfer

Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
5	.0704-.0859	.0691	355942R2	\$611.70	\$556.80	\$549.10	\$545.05	\$542.70	\$541.45
5	.0860-.1015	.0848	355944R2	542.50	487.50	479.80	475.85	473.45	472.20
5	.1016-.1171	.1004	355946R2	584.10	529.10	521.50	517.45	515.10	513.85
5	.1094-.1406	.1160	355948R2	530.30	475.35	467.70	463.70	461.30	460.05
5	.1407-.1718	.1562	355950R2	543.80	488.85	481.10	477.20	474.80	473.45
5	.1719-.2031	.1875	355952R2	566.60	511.60	503.90	499.95	497.60	496.30
5	.2032-.2343	.2188	355954R2	589.20	534.30	526.60	522.65	520.20	518.95
5	.2188-.2812	.2500	355956R2	611.85	556.85	549.15	545.20	542.85	541.60
5	.2813-.3437	.3125	355958R2	650.30	595.40	587.65	583.65	581.30	580.00
5	.3438-.4062	.3750	355960R2	691.15	636.20	628.55	624.55	622.15	620.90
5	.4063-.4687	.4375	355962R2	723.15	668.15	660.45	656.50	654.15	652.90
5	.4688-.5312	.5000	355964R2	755.05	700.15	692.45	688.50	686.05	684.80





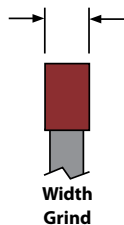
6" CARBIDE TIPPED MILLING CUTTERS

TYPE 3559 - GENERAL PURPOSE

Width grinds between .0704" and .5312"

Cutter Notes (All cutters on page)

- 18 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)



TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
6	.0704 - .0859	.0681	355966D	635.45	602.35	596.35	593.25	591.35	547.80
6	.0860 - .1015	.0838	355968D	592.05	559.00	553.00	549.90	548.05	504.50
6	.1016 - .1171	.0994	355970D	637.30	604.20	598.20	595.10	593.25	549.65
6	.1094 - .1406	.1150	355972D	606.50	573.40	567.40	564.30	562.45	518.90
6	.1407 - .1718	.1562	355974D	629.15	596.10	590.10	587.00	585.15	541.60
6	.1719 - .2031	.1875	355976D	651.85	618.75	612.80	609.65	607.75	564.20
6	.2032 - .2343	.2188	355978D	674.55	641.45	635.45	632.35	630.50	586.90
6	.2188 - .2812	.2500	355980D	705.85	672.75	666.75	663.65	661.80	618.25
6	.2813 - .3437	.3125	355982D	733.55	700.45	694.45	691.30	689.45	645.90
6	.3438 - .4062	.3750	355984D	758.30	725.25	719.30	716.10	714.25	670.70
6	.4063 - .4687	.4375	355992D	790.30	757.20	751.20	748.10	746.25	702.65
6	.4688 - .5312	.5000	355990D	822.20	789.20	783.20	780.05	778.20	734.65

Corner Radius or Chamfer on ONE Side

TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
6	.0704 - .0859	.0681	355966R1	\$655.80	\$608.15	\$601.45	\$598.05	\$595.95	\$594.85
6	.0860 - .1015	.0838	355968R1	612.45	564.80	558.15	554.70	552.65	551.55
6	.1016 - .1171	.0994	355970R1	657.65	610.00	603.30	599.90	597.85	596.70
6	.1094 - .1406	.1150	355972R1	626.85	579.20	572.55	569.10	567.05	565.90
6	.1407 - .1718	.1562	355974R1	649.55	601.90	595.25	591.80	589.75	588.65
6	.1719 - .2031	.1875	355976R1	672.20	624.60	617.95	614.45	612.45	611.35
6	.2032 - .2343	.2188	355978R1	694.90	647.30	640.65	637.15	635.10	633.95
6	.2188 - .2812	.2500	355980R1	726.20	678.65	671.95	668.45	666.40	665.30
6	.2813 - .3437	.3125	355982R1	753.85	706.30	699.65	696.15	694.05	692.95
6	.3438 - .4062	.3750	355984R1	778.65	731.10	724.40	720.95	718.90	717.80
6	.4063 - .4687	.4375	355992R1	810.65	763.05	756.40	752.90	750.85	749.70
6	.4688 - .5312	.5000	355990R1	842.60	795.00	788.30	784.90	782.80	781.70

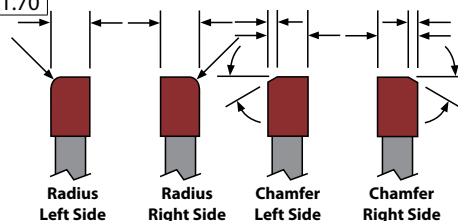
Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

Chamfer Notes

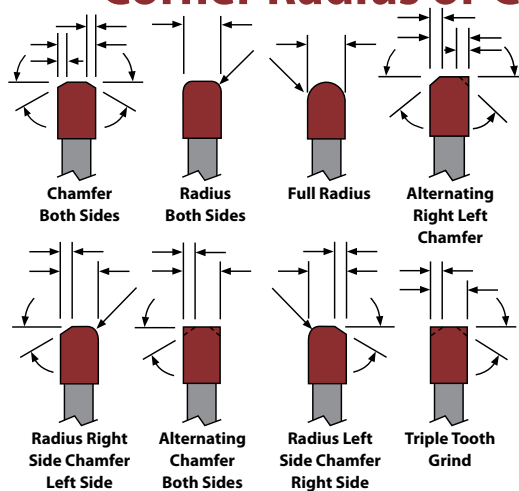
- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/2 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%



TOOL DIAM.	DECIMAL SIZE WIDTH RANGE	HUB WIDTH	1"ARBOR EDP NO.	PRICE EACH FINISHED TO DECIMAL WIDTH					
				1 PC	2 PC	3 PC	4 PC	5PC	6PC
6	.0704-.0859	.0681	355966R2	\$676.55	\$619.80	\$611.85	\$607.75	\$605.25	\$603.90
6	.0860-.1015	.0838	355968R2	633.20	576.45	568.45	564.35	561.90	560.60
6	.1016-.1171	.0994	355970R2	678.40	621.65	613.70	609.65	607.10	605.75
6	.1094-.1406	.1150	355972R2	647.60	590.85	582.90	578.85	576.30	575.00
6	.1407-.1718	.1562	355974R2	670.30	613.55	605.55	601.45	599.00	597.70
6	.1719-.2031	.1875	355976R2	692.95	636.20	628.25	624.15	621.70	620.40
6	.2032-.2343	.2188	355978R2	715.65	658.90	650.95	646.90	644.35	643.00
6	.2188-.2812	.2500	355980R2	746.95	690.20	682.25	678.20	675.65	674.40
6	.2813-.3437	.3125	355982R2	774.65	717.90	709.95	705.85	703.35	702.00
6	.3438-.4062	.3750	355984R2	799.45	742.65	734.75	730.65	728.20	726.85
6	.4063-.4687	.4375	355992R2	831.40	774.65	766.70	762.65	760.10	758.75
6	.4688-.5312	.5000	355990R2	863.40	806.65	798.70	794.60	792.10	790.75

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	-	\$136.55	6	354130	-	\$170.75	6	354230	-	\$168.60	8	354330	-	\$214.35
3	5/16	.3125	4	354031	-	143.35	6	354131	-	171.50	6	354231	-	170.90	8	354331	-	224.60
3	3/8	.3750	4	354032	-	148.55	6	354132	-	174.95	6	354232	-	173.05	8	354332	-	227.65
3	7/16	.4375	4	354033	-	154.65	6	354133	-	189.20	6	354233	-	193.00	-	-	-	-
3	1/2	.5000	4	354034	-	162.15	6	354134	-	197.00	6	354234	-	195.60	8	354334	-	254.45
4	1/4	.2500	4	354040	-	177.95	8	354140	-	220.60	8	354240	-	222.00	10	354340	-	268.00
4	5/16	.3125	4	354041	-	183.00	8	354141	-	228.00	8	354241	-	235.75	10	354341	-	281.50
4	3/8	.3750	4	354042	354043	187.75	8	354142	354143	239.60	8	354242	354243	235.75	10	354342	354343	287.80
4	7/16	.4375	4	354074	-	188.60	8	354174	-	244.40	8	354274	-	242.80	10	354374	-	312.55
4	1/2	.5000	4	354044	354045	188.60	8	354144	354145	252.50	8	354244	354245	251.25	10	354344	354345	314.90
4	9/16	.5625	4	354094	-	205.10	8	354194	-	259.50	8	354294	-	263.65	-	-	-	-
4	5/8	.6250	4	354046	354047	220.10	8	354146	354147	281.30	8	354246	354247	308.25	10	354346	354347	331.65
4	3/4	.7500	4	354048	354049	246.55	8	354148	354149	281.30	8	354248	354249	312.15	10	354348	354349	341.60
5	1/4	.2500	6	354050	-	248.55	10	354150	-	292.15	10	354250	-	292.35	-	-	-	-
5	5/16	.3125	-	-	-	-	10	354151	-	292.15	10	354251	-	292.35	-	-	-	-
5	3/8	.3750	-	-	-	-	10	-	354153	299.25	10	-	354253	306.90	-	-	-	-
5	7/16	.4375	6	-	354075	258.60	10	-	354175	300.65	10	-	354275	316.75	-	-	-	-
5	1/2	.5000	6	354054	354055	261.65	10	354154	354155	319.20	10	354254	354255	316.85	12	354354	354355	361.70
5	9/16	.5625	6	-	354095	270.10	10	-	354195	324.60	10	-	354295	330.80	-	-	-	-
5	5/8	.6250	6	-	354057	284.10	10	-	354157	345.55	10	-	354257	388.30	12	-	354357	395.10
5	3/4	.7500	6	354058	354059	302.90	10	354158	354159	391.35	10	354258	354259	429.70	12	354358	354359	443.10
5	1	1.0000	6	-	354015	303.40	10	-	354115	425.75	10	-	354215	453.20	-	-	-	-
6	3/8	.3750	6	354062	-	266.65	12	-	354163	367.60	12	-	354263	388.35	-	-	-	-
6	1/2	.5000	6	354064	354065	292.15	12	354164	354165	390.35	12	354264	354265	400.00	14	354364	354365	465.45
6	5/8	.6250	6	-	354067	320.15	12	-	354167	426.60	12	-	354267	435.10	14	-	354367	469.15
6	3/4	.7500	6	354068	354069	368.20	12	354168	354169	478.60	12	354268	354269	495.60	14	354368	354369	506.25
6	1	1.0000	6	-	354016	422.05	12	-	354116	483.70	12	-	354216	505.65	-	-	-	-
				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	479.05	12	354188	354189	502.35	12	354288	354289	521.10	14	354388	-	542.75
8	1	1.0000	8	354080	354081	519.75	12	354180	354181	523.55	12	354280	354281	542.35	-	-	-	-

CARBIDE TIPPED ANGLE CUTTERS

SINGLE ANGLE CUTTERS

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

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

(Left hand shown)

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	\$415.40
4	1/2	1 1/4	10	371416	371616	372416	372616	514.10
4	3/4	1 1/4	10	371424	371624	372424	372624	557.70

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	\$346.40
3	1/2	1	8	375008	375208	375408	432.00
4	1/2	1 1/4	10	375016	375216	375416	534.75
4	3/4	1 1/4	10	375024	375224	375424	580.00
4	1	1 1/4	10	-	375232	375432	678.90

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	\$215.90	4	353124	\$215.90	4	353224	\$224.55
1 1/2	1/2	1/2	1 1/8	1/4	5/32	4	353026	224.75	4	353126	224.75	4	353226	233.75
1 3/4	3/4	1/2	1 1/4	5/16	3/16	4	353028	280.15	4	353128	280.15	4	353228	291.30
2	3/4	5/8	1 3/8	5/16	3/16	4	353032	288.60	4	353132	312.95	4	353232	325.40
2 1/4	1	5/8	1 1/2	3/8	7/32	6	353036	304.90	6	353136	338.80	6	353236	352.35
2 1/2	1	5/8	1 5/8	3/8	7/32	6	353040	321.10	6	353140	369.30	6	353240	369.30
2 3/4	1	5/8	1 5/8	3/8	7/32	6	353044	338.80	6	353144	387.40	6	353244	387.40
3	1 1/4	3/4	1 3/4	1/2	9/32	6	353048	371.45	6	353148	421.40	6	353248	421.40
3 1/2	1 1/4	3/4	1 7/8	1/2	9/32	6	353056	454.60	8	353156	495.55	6	353256	523.90
4	1 1/2	3/4	2 1/4	5/8	3/8	6	353064	571.25	8	353164	613.05	6	353264	650.65

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	\$197.45	4	353724	\$197.45	4	353824	\$203.25
2	3/4	3/4	1/2	1/4	2 7/8	4	353632	241.45	4	353732	241.45	4	353832	247.00
2 1/2	3/4	3/4	1/2	1/4	2 7/8	6	353640	271.80	6	353740	271.80	6	353840	279.05
3 1/2	1 1/4	1 1/8	5/8	5/16	4	6	353656	469.10	6	353756	469.10	8	353856	485.20
3 1/2	1 1/2	1 1/8	5/8	5/16	4	6	353657	492.55	6	353757	492.55	8	353857	509.40
4	1 1/2	1 1/2	3/4	3/8	5	8	353664	527.10	8	353764	527.10	8	353864	527.65

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	\$61.50
3/8	1/4	5/64	356112	358112	359112	358412	61.50
1/2	3/8	3/32	356116	358116	359116	358416	73.00
3/4	1/2	1/8	356124	358124	359124	358424	91.30
1	1/2	1/8	356132	358132	359132	358432	119.25
1 1/4	1/2	5/32	356140	358140	359140	358440	151.75
1 1/2	1/2	3/16	356148	358148	359148	358448	170.15

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	\$67.60
3/8	1/4	7/64	356312	358312	359012	358512	67.60
1/2	3/8	9/64	356316	358316	359016	358516	80.40
3/4	1/2	1/8	356320	358320	359020	358520	84.45
1	1/2	3/16	356324	358324	359024	358524	101.55
1 1/4	1/2	5/32	356328	358328	359028	358528	116.40
1 1/2	1/2	3/16	356332	358332	359032	358532	126.95
1 1/2	1/2	5/32	356340	358340	359040	358540	158.00
1 1/2	1/2	3/8	356348	358348	359048	358548	184.25

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	\$140.30	374102	\$151.60
3/32	1/2	3/8	17/64	13/32	2 3/4	374003	140.30	374103	151.60
1/8	5/8	1/2	19/64	13/32	3	374004	145.20	374104	156.70
5/32	3/4	1/2	23/64	13/32	3	374005	153.95	374105	166.30
3/16	7/8	3/4	13/32	13/32	3 1/4	374006	162.95	374106	175.95
1/4	1	3/4	13/32	15/32	3 1/4	374008	185.70	374108	200.55
5/16	1 1/8	7/8	13/32	19/32	3 1/2	374010	190.75	374110	206.05
3/8	1 1/4	7/8	13/32	25/32	3 3/4	374012	198.20	374112	214.05
7/16	1 3/8	1	13/32	7/8	4	374014	220.65	374114	238.35
1/2	1 1/2	1	13/32	1	4	374016	245.60	374116	265.25
5/8	2	1 1/4	21/32	1 7/32	4 1/4	374020	302.30	374120	326.50

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	\$167.25
.6250	5/8	5/8	2	1 1/4	3 3/8	331820	186.95
.7500	3/4	3/4	2	1 1/4	3 3/8	331824	198.10
.8750	7/8	7/8	2	1 1/2	3 3/4	331828	217.90
1.0000	1	1	2	1 1/2	4	331832	250.40
1.2500	1 1/4	1 1/4	2	1 3/4	4 1/4	331840	340.35
1.5000	1 1/2	1 1/2	2	2	4 3/4	331848	397.15

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	\$100.00	331212	\$103.95
.4375	7/16	3/8	3	3/4	2 1/2	331414	102.25	331214	106.25
.5000	1/2	1/2	3	3/4	3	331416	104.95	331216	108.90
.5625	9/16	1/2	3	3/4	3	331418	108.95	331218	113.20
.6250	5/8	5/8	3	3/4	3 1/4	331420	127.60	331220	132.35
.7500	3/4	5/8	3	3/4	3 3/8	331424	133.45	331224	138.60
.8750	7/8	7/8	3	3/4	3 3/4	331428	155.75	331228	161.85
1.0000	1	7/8	3	3/4	3 3/4	331432	171.15	331232	177.70
1.1250	1 1/8	1	3	3/4	4	331436	183.35	331236	190.35
1.2500	1 1/4	1	3	3/4	4	331440	212.45	331240	220.70
1.5000	1 1/2	1 1/4	3	3/4	4	331448	252.55	331248	262.25

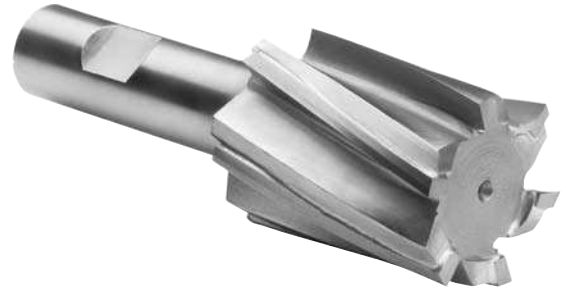
CARBIDE TIPPED BRIDGEPORT/REDUCED SHANK END MILLS

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	\$132.20
.8750	$\frac{7}{8}$	$\frac{3}{4}$	1 $\frac{1}{2}$	3 $\frac{3}{4}$	4	332328	335328	151.40
1.0000	1	$\frac{3}{4}$	1 $\frac{1}{2}$	4	6	332332	335332	212.30
1.1250	1 $\frac{1}{8}$	$\frac{3}{4}$	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332336	335336	249.80
1.2500	1 $\frac{1}{4}$	$\frac{3}{4}$	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332340	335340	286.35
1.5000	1 $\frac{1}{2}$	$\frac{3}{4}$	2	4 $\frac{1}{2}$	6	332348	335348	329.50

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	\$117.15
.6250	$\frac{5}{8}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	4	332220	335520	135.35
.7500	$\frac{3}{4}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	4	332224	335524	150.70
1.0000	1	1	1 $\frac{1}{2}$	4	6	332232	335532	242.00
1.1250	1 $\frac{1}{8}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332236	335536	284.75
1.2500	1 $\frac{1}{4}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	6	332240	335540	326.50
1.5000	1 $\frac{1}{2}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	6	332248	335548	375.60
1.7500	1 $\frac{3}{4}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	8	332256	335556	472.45
2.0000	2	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	8	332264	335564	533.75

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.

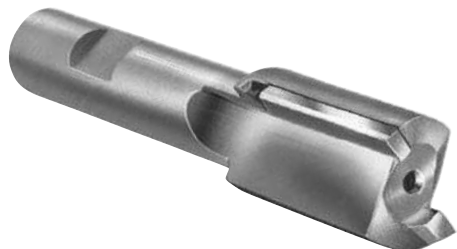


TOOL DIAMETER		SHANK DIAM.	CARBIDE TIP LENGTH	OVER ALL LENGTH	NO. OF FLUTES	NON-FERR. TYPE 3337 EDP NO.	PRICE EACH
DECIMAL	FRACTION						
.5000	$\frac{1}{2}$	$\frac{1}{2}$	1	3	2	333716	\$117.15
.6250	$\frac{5}{8}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	2	333720	135.35
.7500	$\frac{3}{4}$	$\frac{5}{8}$	1 $\frac{1}{4}$	3 $\frac{3}{8}$	2	333724	150.70
1.0000	1	1	1 $\frac{1}{2}$	4	2	333732	199.30
1.2500	1 $\frac{1}{4}$	1	1 $\frac{3}{4}$	4 $\frac{1}{4}$	3	333740	289.45
1.5000	1 $\frac{1}{2}$	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	3	333748	350.65
2.0000	2	1 $\frac{1}{4}$	2	4 $\frac{1}{2}$	3	333764	512.15

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.	FRAC.				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	\$64.55	2	330808	331008	\$66.50
.3125	5/16	3/8	5/8	2 1/2	2	330010	67.30	2	330810	331010	71.70
.3750	3/8	3/8	5/8	2 1/2	2	330012	71.85	2	330812	331012	76.05
.4375	7/16	3/8	1	2 1/16	2	330014	71.85	2	330814	331014	76.05
.5000	1/2	1/2	1	3 1/4	2	330016	73.55	4	330816	331016	81.90
.5625	9/16	1/2	1	3 3/8	2	330018	81.45	4	330818	331018	88.00
.6250	5/8	1/2	1	3 3/8	2	330020	81.45	4	330820	331020	108.55
.7500	3/4	5/8	1	3 3/8	2	330024	91.50	4	330824	331024	121.05
.8750	7/8	5/8	1 1/4	4	2	330028	108.10	4	330828	331028	145.75
1.0000	1	7/8	1 1/4	4	2	330032	119.50	6	330832	331032	167.55
1.1250	1 1/8	1	1 1/4	4 1/4	2	330036	122.35	6	330836	331036	177.70
1.2500	1 1/4	1	1 1/4	4 1/4	2	330040	136.45	6	330840	331040	214.85
1.5000	1 1/2	1 1/4	1 1/2	4 1/2	2	330048	175.70	6	330848	331048	261.35
1.7500	1 3/4	1 1/4	1 1/2	4 1/2	2	330056	197.10	8	330856	331056	314.55
2.0000	2	1 1/4	1 1/2	4 1/2	2	330064	235.30	8	330864	331064	351.25

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 27 for descriptions.

Also available in 3/4" shank diameter, see pg. 24.

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3350 - 15° RIGHT SPIRAL		
DECIMAL	FRAC.				NO. OF FLTS.	EDP NO.	PRICE EACH
.5000	1/2	3/8	1	3	4	335016	\$102.75
.5000	1/2	1/2	1	3	4	335017	102.75
.5625	9/16	1/2	1	3	4	335018	110.40
.6250	5/8	1/2	1 1/4	3 1/4	4	335020	118.80
.6250	5/8	5/8	1 1/4	3 3/8	4	335021	118.80
.6875	11/16	1/2	1 1/4	3 1/4	4	335022	123.85
.6875	11/16	5/8	1 1/4	3 3/8	4	335023	123.85
.7500	3/4	1/2	1 1/4	3 1/4	4	335024	132.20
.7500	3/4	5/8	1 1/4	3 3/8	4	335025	132.20
.8125	13/16	5/8	1 1/2	3 5/8	4	335026	142.60
.8750	7/8	5/8	1 1/2	3 5/8	4	335028	151.40
.8750	7/8	7/8	1 1/2	3 3/4	4	335029	151.40

TOOL DIAMETER		SHANK DIAM.	CARB. TIP LEN.	OVER ALL LEN.	TYPE 3350 - 15° RIGHT SPIRAL		
DECIMAL	FRAC.				NO. OF FLTS.	EDP NO.	PRICE EACH
.9375	15/16	5/8	1 1/2	3 3/4	4	335030	\$224.20
.9375	15/16	7/8	1 1/2	3 3/4	4	335031	224.20
1.0000	1	7/8	1 1/2	3 3/4	6	335032	212.30
1.0000	1	1	1 1/2	4	6	335033	212.30
1.1250	1 1/8	1	1 3/4	4 1/4	6	335036	249.85
1.2500	1 1/4	1	1 3/4	4 1/4	6	335040	286.45
1.3750	1 3/8	1	1 3/4	4 1/4	6	335044	334.55
1.5000	1 1/2	1 1/4	2	4 1/2	6	335048	329.55
1.6250	1 5/8	1 1/4	2	4 1/2	8	335052	439.35
1.7500	1 3/4	1 1/4	2	4 1/2	8	335056	468.55
1.8750	1 7/8	1 1/4	2	4 1/2	8	335060	501.10
2.0000	2	1 1/4	2	4 1/2	8	335064	529.30

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 27.

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	\$56.25	4	330408	\$56.70	4	330508	\$56.70	2	330608	\$58.55	2	330708	\$60.90
.3125	5/16	3/8	5/8	2 1/2	2	330210	58.40	4	330410	60.55	-	-	-	2	330610	60.70	-	-	-
.3750	3/8	3/8	5/8	2 1/2	2	330212	62.50	4	330412	63.80	-	-	-	2	330612	64.90	-	-	-
.4375	7/16	3/8	1	2 1/16	2	330214	62.50	4	330414	63.80	4	330514	61.45	2	330614	64.90	2	330714	67.50
.5000	1/2	1/2	1	3 1/4	2	330216	64.10	4	330416	65.35	4	330516	65.20	2	330616	66.65	2	330716	69.25
.5625	9/16	1/2	1	3 3/4	2	330218	70.95	4	330418	73.45	4	330518	73.25	2	330618	73.75	2	330718	76.55
.6250	5/8	1/2	1	3 3/8	2	330220	70.95	4	330420	76.85	4	330520	76.70	4	330620	76.65	4	330720	79.60
.6875	11/16	5/8	1	3 3/8	2	330222	76.70	4	330422	84.65	4	330522	84.45	-	-	-	-	-	-
.7500	3/4	5/8	1	3 5/8	2	330224	79.60	4	330424	79.10	4	330524	87.65	4	330624	87.55	4	330724	90.95
.8125	13/16	5/8	1	3 5/8	2	330226	96.25	4	330426	93.50	4	330526	100.40	-	-	-	-	-	-
.8750	7/8	5/8	1 1/4	4	2	330228	96.85	4	330428	93.50	4	330528	103.65	4	330628	117.05	4	330728	121.75
.9375	15/16	7/8	1 1/4	4	2	330230	103.65	4	330430	103.70	4	330530	110.40	-	-	-	-	-	-
1.0000	1	7/8	1 1/4	4	2	330232	104.05	4	330432	108.05	4	330532	119.75	4	330632	135.20	4	330732	140.50
1.1250	1 1/8	1	1 1/4	4 1/4	2	330236	106.70	4	330436	122.50	4	330536	135.65	4	330636	153.40	-	-	-
1.2500	1 1/4	1	1 1/4	4 1/4	2	330240	128.65	4	330440	137.70	4	330540	152.55	4	330640	172.40	4	330740	178.95
1.5000	1 1/2	1 1/4	1 1/2	4 1/2	2	330248	159.40	4	330448	177.50	4	330548	188.95	4	330648	213.50	4	330748	213.60
1.7500	1 3/4	1 1/4	1 1/2	4 1/2	2	330256	188.95	6	330456	228.85	-	-	-	6	330656	275.50	-	-	-
2.0000	2	1 1/4	1 1/2	4 1/2	2	330264	210.75	6	330464	263.65	-	-	-	6	330664	317.25	6	330764	317.30

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. 24.



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	FRAC.				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	\$96.45	2	-	332516	\$102.75
.5000	1/2	1/2	1	3	4	332017	\$102.75	2	337517	96.45	2	-	332517	102.75
.5625	9/16	1/2	1	3	-	-	-	2	337518	103.75	2	-	332518	110.40
.6250	5/8	1/2	1 1/4	3 1/4	-	-	-	2	337520	111.50	2	-	332520	118.80
.6250	5/8	5/8	1 1/4	3 3/8	4	332021	118.80	2	337521	111.50	2	332721	332521	118.80
.6875	11/16	1/2	1 1/4	3 1/4	-	-	-	2	337522	116.25	2	-	332522	123.85
.6875	11/16	5/8	1 1/4	3 3/8	4	332023	123.85	2	337523	116.25	2	-	332523	123.85
.7500	3/4	1/2	1 1/4	3 1/4	-	-	-	2	337524	124.10	2	332724	332524	132.20
.7500	3/4	5/8	1 1/4	3 3/8	4	332025	132.20	2	337525	124.10	2	332725	332525	132.20
.8125	13/16	5/8	1 1/2	3 5/8	4	332026	142.60	2	337526	133.90	2	332726	332526	142.60
.8750	7/8	5/8	1 1/2	3 5/8	-	-	-	2	337528	142.20	2	-	332528	151.40
.8750	7/8	7/8	1 1/2	3 3/4	4	332029	151.40	2	337529	142.20	2	-	332529	151.40
.9375	15/16	5/8	1 1/2	3 3/4	-	-	-	3	337530	210.60	2	-	332530	171.25
.9375	15/16	7/8	1 1/2	3 3/4	-	-	-	3	337531	210.60	2	-	332531	171.25
1.0000	1	7/8	1 1/2	3 3/4	-	-	-	3	337532	199.35	2	332732	332532	174.80
1.0000	1	1	1 1/2	4	6	332033	212.30	3	337533	199.35	2	332733	332533	174.80
1.1250	1 1/8	1	1 3/4	4 1/4	6	332036	249.85	3	337536	234.70	2	-	332536	191.35
1.2500	1 1/4	1	1 3/4	4 1/4	6	332040	286.45	4	337540	269.05	3	332740	332540	253.85
1.3750	1 3/8	1	1 3/4	4 1/4	6	332044	334.55	4	337544	314.15	3	332744	332544	275.30
1.5000	1 1/2	1 1/4	2	4 1/2	6	332048	329.55	4	337548	309.55	3	332748	332548	307.45
1.6250	1 5/8	1 1/4	2	4 1/2	-	-	-	4	337552	378.55	3	-	332552	363.80
1.7500	1 3/4	1 1/4	2	4 1/2	8	332056	414.50	4	337556	403.70	3	-	332556	390.40
1.8750	1 7/8	1 1/4	2	4 1/2	-	-	-	4	337560	431.75	3	-	332560	420.25
2.0000	2	1 1/4	2	4 1/2	8	332064	468.25	4	337564	456.05	3	332764	332564	449.30

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 29.



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	\$399.55
M 10X1	.3560	.7870	.5000	3	12°	2	.4530	1 1/4	3 1/4	3786100	3787100	399.55
M 12X1.5	.4150	.9060	.5000	3	15°	2	.5510	1 1/4	3 1/4	3786120	3787120	418.50
M 14X1.5	.4930	.9840	.5000	3	15°	2	.5510	1 1/4	3 1/4	3786140	3787140	418.50
M 16X1.5	.5720	1.1020	.5000	3	15°	2	.6100	1 1/4	3 1/4	3786160	3787160	460.80
M 18X1.5	.6510	1.1810	.7500	3	15°	2	.6690	1 3/8	3 3/8	3786180	3787180	460.80
M 20X1.5	.7300	1.2600	.7500	3	15°	2	.6890	1 3/8	3 3/8	3786200	3787200	478.60
M 22X1.5	.8080	1.3390	.7500	3	15°	2	.7090	1 3/8	3 3/8	3786220	3787220	496.40
M 27X2	.9850	1.5750	.7500	3	15°	2 1/4	.8660	1 7/8	4 1/8	3786270	3787270	536.45
M 33X2	1.2210	1.9290	.7500	3	15°	2 1/4	.8660	1 7/8	4 1/8	3786330	3787330	587.65
M 42X2	1.5760	2.3620	1.0000	3	15°	2 1/4	.8860	1 7/8	4 1/8	3786420	3787420	642.20
M 48X2	1.8120	2.5890	1.0000	4	15°	2 1/4	.9840	2	4 1/4	3786480	3787480	678.95
M 60X2	2.2840	2.9920	1.0000	4	15°	2 1/4	1.0830	2	4 1/4	3786600	3787600	701.20

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.

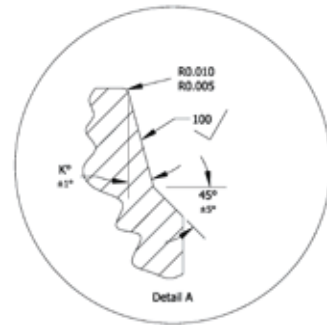
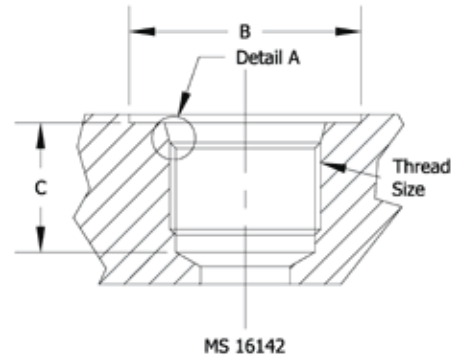
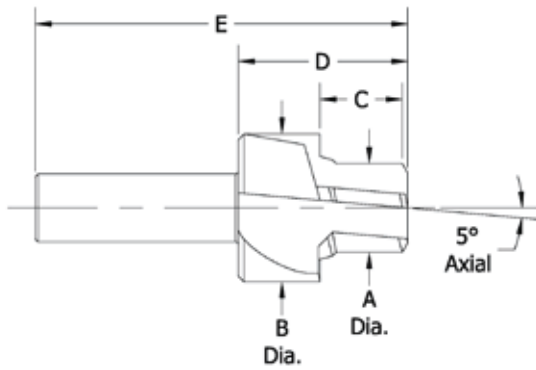
Full form relieved cutting edges without O.D. lands provide true form and size for the tool life. Tools can be resharpened with a simple face grind. All tolerances are within military specifications. All are manufactured with negative radial rake and 5° axial rake. In a single operation, a port contour cutter can produce the form and finish required on internal straight thread o-ring ports. For special ordering see page 29.



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	\$353.95
3	3/16	3/8-24	.3350	.7600	.5000	12°	2	.4730	1 1/4	3 1/4	378003	378103	353.95
4	1/4	7/16-20	.3890	.8380	.5000	12°	2	.5520	1 1/4	3 1/4	378004	378104	353.95
5	5/16	1/2-20	.4520	.9160	.5000	12°	2	.5520	1 1/4	3 1/4	378005	378105	365.05
6	3/8	9/16-18	.5090	.9790	.5000	12°	2	.6140	1 1/4	3 1/4	378006	378106	365.05
8	1/2	3/4-16	.6890	1.1980	.7500	15°	2	.6930	1 3/8	3 3/8	378008	378108	399.55
10	5/8	7/8-14	.8060	1.3540	.7500	15°	2	.7860	1 5/8	3 5/8	378010	378110	451.90
12	3/4	1 1/16-12	.9810	1.6350	.7500	15°	2 1/4	.9110	1 7/8	4 1/8	378012	378112	487.50
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	495.30
16	1	1 5/16-12	1.2310	1.9200	.7500	15°	2 1/4	.9110	1 7/8	4 1/8	378016	378116	533.15
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	570.95
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	722.35
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	917.10

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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 _____

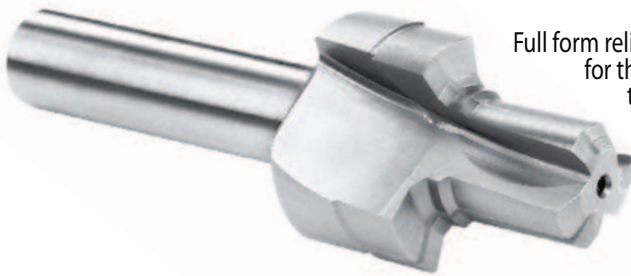
MS 33649 - INTEGRAL REAMER PILOT

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	\$434.05
2	1/8	5/16-24	.2750	.7420	.5000	2	.5820	1 1/8	3 3/8	379202	379302	434.05
3	3/16	3/8-24	.3390	.8050	.5000	2	.5880	1 1/4	3 1/4	379203	379303	411.80
4	1/4	7/16-20	.3930	.8880	.5000	2	.6610	1 1/4	3 1/4	379204	379304	422.95
5	5/16	1/2-20	.4550	.9500	.5000	2	.6610	1 1/4	3 1/4	379205	379305	434.05
6	3/8	9/16-18	.5120	1.0120	.5000	2	.7140	1 1/2	3 1/2	379206	379306	456.35
7	7/16	5/8-18	.5750	1.1050	.5000	2	.7300	1 1/2	3 1/2	379207	379307	467.45
8	1/2	3/4-16	.6930	1.2400	.7500	2	.8390	1 5/8	3 5/8	379208	379308	478.60
9	9/16	13/16-16	.7560	1.3020	.7500	2	.8550	1 5/8	3 5/8	379209	379309	489.70
10	5/8	7/8-14	.8100	1.4150	.7500	2 1/4	.9350	1 7/8	4 1/8	379210	379310	500.85
11	1 1/16	1-12	.9250	1.6020	.7500	2 1/4	1.0690	2 1/8	4 3/8	379211	379311	545.35
12	3/4	1 1/16-12	.9870	1.6650	.7500	2 1/4	1.0690	2 1/8	4 3/8	379212	379312	578.75
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	612.15
16	1	1 5/16-12	1.2370	1.9650	.7500	2 1/4	1.0690	2 1/8	4 3/8	379216	379316	645.55
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	695.60
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	745.70
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	868.15
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	1306.50
32	2	2 1/2-12	2.4250	3.5200	1.0000	2 1/2	1.3730	2 1/2	5	379232	379332	1486.10

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 29.

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	\$432.75
2	1/8	5/16-24	.2710	.7420	.5000	2	.6090	1 1/8	3 1/8	379402	379502	432.75
3	3/16	3/8-24	.3330	.8050	.5000	2	.6090	1 1/4	3 1/4	379403	379503	451.90
4	1/4	7/16-20	.3860	.8880	.5000	2	.6870	1 1/4	3 1/4	379404	379504	451.90
5	5/16	1/2-20	.4490	.9500	.5000	2	.6870	1 1/4	3 1/4	379405	379505	470.80
6	3/8	9/16-18	.5060	1.0120	.5000	2	.7340	1 1/2	3 1/2	379406	379506	478.95
8	1/2	3/4-16	.6870	1.2400	.7500	2	.8590	1 5/8	3 5/8	379408	379508	509.00
10	5/8	7/8-14	.8020	1.4150	.7500	2 1/4	.9530	1 7/8	4 1/8	379410	379510	547.00
12	3/4	1 1/16-12	.9760	1.6650	.7500	2 1/4	1.0930	2 1/8	4 3/8	379412	379512	604.15
16	1	1 5/16-12	1.2260	1.9650	.7500	2 1/4	1.0930	2 1/8	4 3/8	379416	379516	813.85
20	1 1/4	1 7/8-12	1.5380	2.3100	1.0000	2 1/4	1.1400	2 1/4	4 1/2	379420	379520	1034.35
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	1189.45
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	1306.50
32	2	2 1/2-12	2.4140	3.5200	1.0000	2 1/2	1.3900	2 1/2	5	379432	379532	1486.15

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 29.



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	\$400.10
M 10X1	.3560	.7870	2	12°	.5510	1 3/4	4 7/8	3790100	3791100	417.15
M 12X1.5	.4150	.8660	2	15°	.6610	1 3/4	4 7/8	3790120	3791120	432.75
M 14X1.5	.4930	.9840	2	15°	.7200	1 3/4	4 7/8	3790140	3791140	449.05
M 16X1.5	.5720	1.0630	2	15°	.7200	1 3/4	4 7/8	3790160	3791160	475.60
M 18X1.5	.6510	1.1420	3	15°	.8110	1 7/8	5 3/4	3790180	3791180	491.20
M 20X1.5	.7300	1.2600	3	15°	.6890	2	5 7/8	3790200	3791200	509.00
M 22X1.5	.8080	1.3390	3	15°	.9370	2	5 7/8	3790220	3791220	532.75
M 27X2	.9850	1.5750	3	15°	1.0940	2 1/8	6	3790270	3791270	572.95
M 33X2	1.2210	1.8110	3	15°	1.0940	2 1/8	6	3790330	3791330	660.00
M 42X2	1.5760	2.2050	3	15°	1.0940	2 1/8	6	3790420	3791420	711.75
M 48X2	1.8120	2.5980	4	15°	1.0940	2 1/8	7	3790480	3791480	773.00
M 60X2	2.2840	2.9920	4	15°	1.0940	2 1/8	7	3790600	3791600	909.10

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

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 29.

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	\$353.95
3	3/16	3/8-24	.3350	.7600	2	12°	.4730	1 5/8	4 3/4	378203	378303	353.95
4	1/4	7/16-20	.3890	.8380	2	12°	.5520	1 5/8	4 3/4	378204	378304	353.95
5	5/16	1/2-20	.4520	.9160	2	12°	.5520	1 5/8	4 3/4	378205	378305	365.05
6	3/8	9/16-18	.5090	.9790	2	12°	.6140	1 5/8	4 3/4	378206	378306	365.05
8	1/2	3/4-16	.6890	1.1980	3	15°	.6930	1 3/4	5 5/8	378208	378308	399.55
10	5/8	7/8-14	.8060	1.3540	3	15°	.7860	1 7/8	5 3/4	378210	378310	451.90
12	3/4	1 1/16-12	.9810	1.6350	3	15°	.9110	2	5 7/8	378212	378312	487.50
14	7/8	1 3/16-12	1.1060	1.7750	3	15°	.9110	2	5 7/8	378214	378314	495.30
16	1	1 5/16-12	1.2310	1.9200	3	15°	.9110	2	5 7/8	378216	378316	533.15
20	1 1/4	1 5/8-12	1.5440	2.2800	4	15°	.9110	2 1/4	7 1/8	378220	378320	570.95
24	1 1/2	1 7/8-12	1.7940	2.5700	4	15°	.9110	2 1/4	7 1/8	378224	378324	722.35
32	2	2 1/2-12	2.4190	3.4900	4	15°	.9110	2 1/4	7 1/8	378232	378332	917.10

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



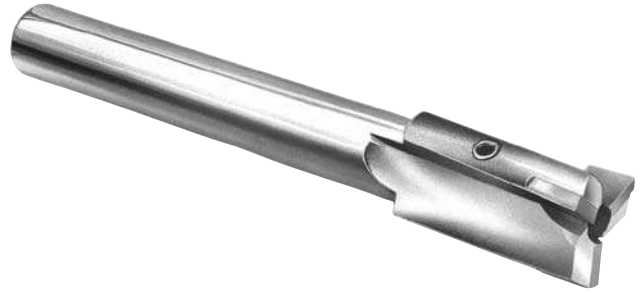
Carbide tips brazed to one piece heat treated steel bodies.

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 29.

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	\$372.85
3	3/16	3/8-24	.3350	.7600	2	12°	.5800	1 3/4	4 7/8	378403	378503	372.85
4	1/4	7/16-20	.3890	.8380	2	12°	.6900	1 3/4	4 7/8	378404	378504	372.85
5	5/16	1/2-20	.4520	.9160	2	12°	.6900	1 3/4	4 7/8	378405	378505	381.75
6	3/8	9/16-18	.5090	.9790	2	12°	.7500	1 3/4	4 7/8	378406	378506	381.75
8	1/2	3/4-16	.6890	1.1980	3	15°	.8400	2	5 7/8	378408	378508	419.60
10	5/8	7/8-14	.8060	1.3540	3	15°	.9700	2	5 7/8	378410	378510	475.25
12	3/4	1 1/16-12	.9810	1.6350	3	15°	1.1250	2 1/4	6 1/8	378412	378512	509.75
14	7/8	1 3/16-12	1.1060	1.7750	3	15°	1.1250	2 1/4	6 1/8	378414	378514	522.00
16	1	1 5/16-12	1.2310	1.9200	3	15°	1.1250	2 1/4	6 1/8	378416	378516	559.85
20	1 1/4	1 5/8-12	1.5440	2.2800	4	15°	1.1250	2 1/2	7 3/8	378420	378520	601.00
24	1 1/2	1 7/8-12	1.7940	2.5700	4	15°	1.1250	2 1/2	7 3/8	378424	378524	860.15
32	2	2 1/2-12	2.4190	3.4900	4	15°	1.1250	2 1/2	7 3/8	378432	378532	1080.50

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	\$93.70	3	35152500	\$103.10
.3980	1/4	.2650	.3125	5/16	5 5/8	3	35132650	104.20	3	35152650	114.60
.4140	1/4	.2810	.3125	5/16	5 5/8	3	35132810	104.20	3	35152810	114.60
.4750	5/16	.3125	.3750	3/8	6 1/8	3	35133125	104.85	3	35153125	115.40
.4910	5/16	.3280	.3750	3/8	6 1/8	3	35133280	104.85	3	35153280	115.40
.5070	5/16	.3430	.3750	3/8	6 1/8	3	35133430	104.85	3	35153430	115.40
.5720	3/8	.3750	.5000	1/2	6 1/2	3	35133750	118.25	3	35153750	130.15
.5880	3/8	.3900	.5000	1/2	6 1/2	3	35133900	118.25	3	35153900	130.15
.6040	3/8	.4060	.5000	1/2	6 1/2	3	35134060	118.25	3	35154060	130.15
.6630	7/16	.4375	.5000	1/2	7	3	35134375	114.25	3	35154375	125.65
.6790	7/16	.4530	.5000	1/2	7	3	35134530	114.25	3	35154530	125.65
.6950	7/16	.4680	.5000	1/2	7	3	35134680	114.25	3	35154680	125.65
.7570	1/2	.5000	.5000	1/2	7 1/2	3	35135000	129.50	3	35155000	142.55
.7730	1/2	.5150	.5000	1/2	7 1/2	3	35135150	129.50	3	35155150	142.55
.7890	1/2	.5310	.5000	1/2	7 1/2	3	35135310	129.50	3	35155310	142.55
.8510	9/16	.5625	.5625	5/8	7 5/8	3	35135625	125.20	3	35155625	137.75
.8670	9/16	.5780	.5625	5/8	7 5/8	3	35135780	125.20	3	35155780	137.75
.8830	9/16	.5930	.5625	5/8	7 5/8	3	35135930	125.20	3	35155930	137.75
.9450	5/8	.6250	.6250	5/8	7 5/8	3	35136250	142.75	3	35156250	157.00
.9610	5/8	.6400	.6250	5/8	7 5/8	3	35136400	142.75	3	35156400	157.00
.9770	5/8	.6560	.6250	5/8	7 5/8	3	35136560	142.75	3	35156560	157.00
1.1330	3/4	.7500	.7500	3/4	7 3/4	3	35137500	140.70	3	35157500	154.75
1.1490	3/4	.7650	.7500	3/4	7 3/4	3	35137650	140.70	3	35157650	154.75
1.1650	3/4	.7810	.7500	3/4	7 3/4	3	35137810	140.70	3	35157810	154.75
1.3220	7/8	.8750	.8750	7/8	8 1/8	4	35138750	156.45	4	35158750	172.15
1.3380	7/8	.8910	.8750	7/8	8 1/8	4	35138910	156.45	4	35158910	172.15
1.3540	7/8	.9060	.8750	7/8	8 1/8	4	35139060	156.45	4	35159060	172.15
1.5100	1	1.0000	1.0000	1	8 1/2	4	35130000	179.10	4	35150000	197.05
1.5260	1	1.0150	1.0000	1	8 1/2	4	35130156	179.10	4	35150156	197.05
1.5420	1	1.0310	1.0000	1	8 1/2	4	35130313	179.10	4	35150313	197.05

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	5/32	5/16	5 5/8	3	3513055	\$103.85	3	3515055	\$114.25
6	.4134	6.5	5/16	5/16	5 5/8	3	3513065	109.65	3	3515065	120.60
8	.5315	8.5	3/8	1/2	6 1/2	3	3513085	130.30	3	3515085	143.20
10	.6496	10.5	1/2	1/2	7	3	3513105	141.60	3	3515105	155.85
12	.7283	12.5	1/2	1/2	7 1/2	3	3513125	132.90	3	3515125	146.15
14	.8465	14.5	5/16	5/8	7 5/8	3	3513145	155.00	3	3515145	170.50
16	.9646	16.5	3/8	5/8	7 5/8	3	3513165	161.95	3	3515165	178.20
20	1.0039	20.5	3/4	7/8	8	3	3513205	150.15	3	3515205	165.15

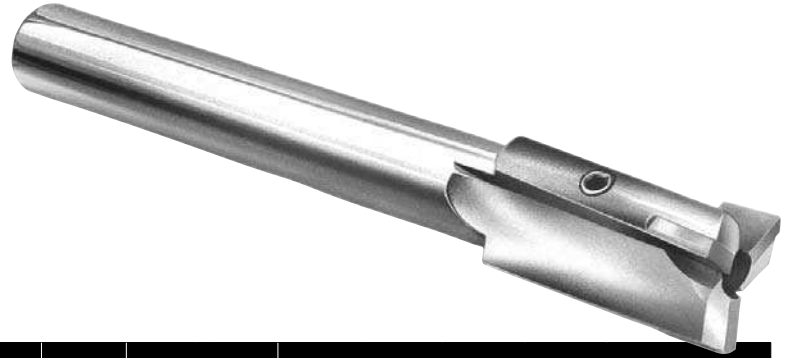
CARBIDE TIPPED COUNTERBORES FOR NON-FERROUS & CAST IRON

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.

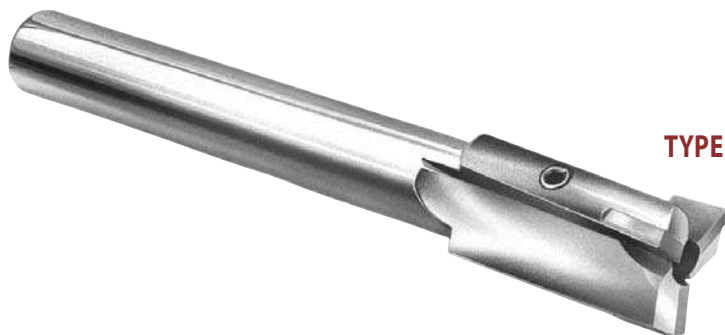


Tool diameter tolerance: +.001"/-.000".
Shank diameter tolerance: +.0000"/-.0005".

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	\$77.25	.2381 - .2530	\$120.70	\$99.00	\$91.70	\$88.15	\$84.45	\$81.45
.2812	9/32	.114	3/32	17/64	3 13/16	-	-	3	351409	94.40	.2531 - .2840	137.85	116.10	108.85	105.30	101.65	98.60
.3125	5/16	.114	3/32	19/64	3 13/16	-	-	3	351410	85.80	.2841 - .3150	129.25	107.50	100.25	96.70	93.05	90.00
.3438	11/32	.114	3/32	5/16	3 13/16	-	-	3	351411	108.50	.3151 - .3470	151.95	130.20	122.95	119.40	115.70	112.70
.3750	3/8	.182	5/32	5/16	4 1/16	-	-	3	351412	90.90	.3471 - .3780	131.05	111.00	104.35	101.00	97.55	94.85
.4062	13/32	.182	5/32	3/8	4 1/16	-	-	3	351413	102.55	.3781 - .4090	142.70	122.65	115.90	112.65	109.20	106.50
.4375	7/16	.182	5/32	3/8	4 1/16	-	-	3	351414	93.25	.4091 - .4410	133.40	113.30	106.65	103.35	99.95	97.20
.4688	15/32	.228	3/16	7/16	4 5/16	-	-	3	351415	113.90	.4411 - .4720	153.95	133.95	127.25	124.00	120.60	117.85
.5000	1/2	.228	3/16	7/16	4 5/16	4	351216	3	351416	103.50	.4721 - .5030	143.65	123.55	116.85	113.60	110.20	107.45
.5312	17/32	.228	3/16	1/2	4 5/16	4	351217	3	351417	117.15	.5031 - .5340	157.30	137.25	130.60	127.25	123.90	121.10
.5625	9/16	.228	3/16	1/2	4 5/16	4	351218	3	351418	106.55	.5341 - .5660	146.70	126.65	119.90	116.65	113.25	110.50
.5938	19/32	.228	3/16	1/2	5 1/8	4	351219	3	351419	118.35	.5661 - .5970	158.50	138.45	131.80	128.45	125.05	122.30
.6250	5/8	.228	3/16	1/2	5 1/8	4	351220	3	351420	107.60	.5971 - .6280	147.75	127.60	120.95	117.70	114.25	111.50
.6562	21/32	.228	3/16	1/2	5 1/8	4	351221	3	351421	125.30	.6281 - .6590	165.40	145.35	138.70	135.35	132.00	129.25
.6875	11/16	.228	3/16	1/2	5 1/8	4	351222	3	351422	113.95	.6591 - .6910	154.10	134.00	127.35	124.05	120.65	117.90
.7188	23/32	.290	1/4	1/2	5 3/8	4	351223	3	351423	128.30	.6911 - .7220	168.35	148.35	141.65	138.40	134.95	132.20
.7500	3/4	.290	1/4	1/2	5 3/8	4	351224	3	351424	116.55	.7221 - .7530	156.70	136.60	129.90	126.65	123.25	120.50
.7812	25/32	.290	1/4	5/8	5 3/8	4	351225	3	351425	130.95	.7531 - .7840	171.10	151.00	144.30	141.05	137.65	134.90
.8125	13/16	.290	1/4	5/8	5 3/8	4	351226	3	351426	119.00	.7841 - .8160	159.10	139.05	132.35	129.05	125.70	122.95
.8438	27/32	.290	1/4	3/4	5 3/8	4	351227	3	351427	138.75	.8161 - .8470	178.80	158.80	152.10	148.85	145.45	142.70
.8750	7/8	.290	1/4	3/4	5 3/8	4	351228	3	351428	126.15	.8471 - .8780	166.30	146.25	139.50	136.25	132.80	130.05
.9062	29/32	.290	1/4	3/4	6 1/8	4	351229	3	351429	141.55	.8781 - .9090	181.70	161.60	154.95	151.65	148.25	145.50
.9375	15/16	.290	1/4	3/4	6 1/8	4	351230	3	351430	128.75	.9091 - .9410	168.90	148.85	142.10	138.85	135.40	132.65
.9688	31/32	.353	5/16	3/4	6 3/8	4	351231	3	351431	145.65	.9411 - .9720	185.80	165.70	159.00	155.75	152.35	149.60
1.0000	1	.353	5/16	3/4	6 3/8	4	351232	3	351432	132.45	.9721 - 1.0030	172.60	152.50	145.80	142.55	139.10	136.40
1.0625	1 1/16	.353	5/16	3/4	6 3/8	4	351234	3	351434	133.85	1.0031 - 1.0660	174.00	153.90	147.20	143.95	140.55	137.80
1.1250	1 1/8	.353	5/16	1	6 3/8	4	351236	3	351436	137.25	1.0661 - 1.1280	177.35	157.30	150.65	147.30	143.95	141.20
1.1875	1 3/16	.353	5/16	1	6 3/8	4	351238	3	351438	143.35	1.1281 - 1.1905	183.50	163.45	156.80	153.45	150.05	147.30
1.2500	1 1/4	.426	3/8	1	6 3/8	-	-	4	351440	159.70	1.1906 - 1.2530	203.15	181.40	174.15	170.60	166.90	163.90
1.3125	1 5/16	.426	3/8	1	6 3/8	-	-	4	351442	172.35	1.2531 - 1.3155	215.90	194.10	186.85	183.25	179.65	176.60
1.3750	1 3/8	.426	3/8	1	6 3/8	-	-	4	351444	181.25	1.3156 - 1.3780	224.75	203.00	195.75	192.20	188.45	185.50
1.4375	1 7/16	.426	3/8	1 1/4	7 7/8	-	-	4	351446	198.70	1.3781 - 1.4405	245.95	222.30	214.45	210.60	206.55	203.30
1.5000	1 1/2	.426	3/8	1 1/4	7 7/8	-	-	4	351448	221.40	1.4406 - 1.5030	268.70	245.00	237.15	233.30	229.30	226.00
1.5625	1 5/8	.489	7/16	1 1/4	8 1/8	-	-	4	351450	227.85	1.5031 - 1.5660	275.20	251.55	243.65	239.75	235.80	232.55
1.6250	1 3/4	.489	7/16	1 1/4	8 1/8	-	-	4	351452	232.70	1.5661 - 1.6280	280.05	256.35	248.50	244.55	240.55	237.35
1.6875	1 11/16	.489	7/16	1 1/4	8 1/8	-	-	4	351454	278.40	1.6281 - 1.6910	329.45	303.90	295.40	291.15	286.85	283.35
1.7500	1 3/4	.489	7/16	1 1/4	8 1/8	-	-	4	351456	278.40	1.6911 - 1.7530	329.45	303.90	295.40	291.15	286.85	283.35
1.8125	1 13/16	.489	7/16	1 1/2	8 1/8	-	-	4	351458	329.60	1.7531 - 1.8160	380.65	355.10	346.60	342.35	338.05	334.55
1.8750	1 7/8	.489	7/16	1 1/2	8 1/8	-	-	4	351460	329.60	1.8161 - 1.8780	380.65	355.10	346.60	342.35	338.05	334.55
1.9375	1 15/16	.489	7/16	1 1/2	8 1/8	-	-	4	351462	360.25	1.8781 - 1.9410	411.30	385.75	377.25	373.00	368.70	365.20
2.0000	2	.551	1/2	1 1/2	8 3/8	-	-	4	351464	360.25	1.9411 - 2.0030	411.30	385.75	377.25	373.00	368.70	365.20

CARBIDE TIPPED COUNTERBORES FOR NON-FERROUS & CAST IRON

METRIC



TYPE 3512 - STRAIGHT SHANK - FOUR FLUTES
TYPE 3514 - STRAIGHT SHANK - THREE/FOUR FLUTES

Detailed description, tolerances, and fractional sizes on page 34. Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAM.		MIN. CUT DIAM.	PILOT HOLE DIAM.	SHANK DIAM.	OVER ALL LEN.	TYPE 3512		TYPE 3514		BOTH TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH					NO. OF FLTS.	EDP NO.	NO. OF FLTS.	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
6.0	.2362	.114	3/32	15/64	3 13/16	-	-	3	3514060	\$91.70	6.000 - 6.426	\$124.20	\$102.45	\$95.20	\$91.70	\$88.10	\$85.10	\$80.80
6.5	.2559	.114	3/32	17/64	3 13/16	-	-	3	3514065	108.85	6.427 - 7.214	141.45	119.60	112.40	108.85	105.20	102.25	97.95
7.0	.2756	.114	3/32	17/64	3 13/16	-	-	3	3514070	108.85	-	-	-	-	-	-	-	-
7.5	.2953	.114	3/32	19/64	3 13/16	-	-	3	3514075	100.25	7.215 - 8.001	132.75	111.00	103.75	100.25	96.60	93.65	89.35
8.0	.3150	.114	3/32	19/64	3 13/16	-	-	3	3514080	100.25	-	-	-	-	-	-	-	-
8.5	.3346	.114	3/32	5/16	3 13/16	-	-	3	3514085	122.95	8.002 - 8.814	155.45	133.70	126.45	122.95	119.30	116.25	112.05
9.0	.3543	.182	5/32	5/16	4 1/16	-	-	3	3514090	104.35	8.815 - 9.601	134.25	114.20	107.50	104.35	100.90	98.15	94.25
9.5	.3740	.182	5/32	5/16	4 1/16	-	-	3	3514095	104.35	-	-	-	-	-	-	-	-
10.0	.3937	.182	5/32	3/8	4 1/16	-	-	3	3514100	115.90	9.602 - 10.389	145.90	125.85	119.15	115.90	112.55	109.80	105.90
10.5	.4134	.182	5/32	3/8	4 1/16	-	-	3	3514105	106.65	10.390 - 11.201	136.60	116.55	109.90	106.65	103.30	100.55	96.60
11.0	.4331	.182	5/32	3/8	4 1/16	-	-	3	3514110	106.65	-	-	-	-	-	-	-	-
11.5	.4528	.228	3/16	7/16	4 5/16	-	-	3	3514115	127.25	11.202 - 11.989	157.25	137.20	130.50	127.25	123.90	121.10	117.15
12.0	.4724	.228	3/16	7/16	4 5/16	4	3512120	3	3514120	116.85	11.990 - 12.776	146.85	126.80	120.15	116.85	113.55	110.70	106.75
12.5	.4921	.228	3/16	7/16	4 5/16	4	3512125	3	3514125	116.85	-	-	-	-	-	-	-	-
13.0	.5118	.228	3/16	1/2	4 5/16	4	3512130	3	3514130	130.60	12.777 - 13.564	160.50	140.45	133.80	130.60	127.20	124.45	120.50
13.5	.5315	.228	3/16	1/2	4 5/16	4	3512135	3	3514135	130.60	-	-	-	-	-	-	-	-
14.0	.5512	.228	3/16	1/2	4 5/16	4	3512140	3	3514140	119.90	13.565 - 14.376	149.90	129.85	123.15	119.90	116.55	113.80	109.90
14.5	.5709	.228	3/16	1/2	5 1/8	4	3512145	3	3514145	131.80	14.377 - 15.164	161.70	141.65	134.95	131.80	128.35	125.60	121.70
15.0	.5906	.228	3/16	1/2	5 1/8	4	3512150	3	3514150	131.80	-	-	-	-	-	-	-	-
15.5	.6102	.228	3/16	1/2	5 1/8	4	3512155	3	3514155	120.95	15.165 - 15.951	150.90	130.90	124.20	120.95	117.60	114.85	110.95
16.0	.6299	.228	3/16	1/2	5 1/8	4	3512160	3	3514160	138.70	15.952 - 16.739	168.65	148.55	141.85	138.70	135.25	132.50	128.60
16.5	.6496	.228	3/16	1/2	5 1/8	4	3512165	3	3514165	138.70	-	-	-	-	-	-	-	-
17.0	.6693	.228	3/16	1/2	5 1/8	4	3512170	3	3514170	127.35	16.740 - 17.551	157.30	137.25	130.60	127.35	124.00	121.15	117.25
17.5	.6890	.228	3/16	1/2	5 1/8	4	3512175	3	3514175	127.35	-	-	-	-	-	-	-	-
18.0	.7087	.290	1/4	1/2	5 3/8	4	3512180	3	3514180	141.65	17.552 - 18.339	171.60	151.60	144.90	141.65	138.25	135.50	131.55
18.5	.7283	.290	1/4	1/2	5 3/8	4	3512185	3	3514185	129.90	18.340 - 19.126	159.90	139.85	133.20	129.90	126.60	123.75	119.85
19.0	.7480	.290	1/4	1/2	5 3/8	4	3512190	3	3514190	129.90	-	-	-	-	-	-	-	-
19.5	.7677	.290	1/4	5/8	5 3/8	4	3512195	3	3514195	144.30	19.127 - 19.914	174.30	154.25	147.60	144.30	141.00	138.15	134.25
20.0	.7874	.290	1/4	5/8	5 3/8	4	3512200	3	3514200	132.35	19.915 - 20.726	162.35	142.30	135.55	132.35	128.95	126.20	122.30
20.5	.8071	.290	1/4	5/8	5 3/8	4	3512205	3	3514205	132.35	-	-	-	-	-	-	-	-
21.0	.8268	.290	1/4	3/4	5 3/8	4	3512210	3	3514210	152.10	20.727 - 21.514	182.10	162.05	155.35	152.10	148.70	145.95	142.00
21.5	.8465	.290	1/4	3/4	5 3/8	4	3512215	3	3514215	152.10	-	-	-	-	-	-	-	-
22.0	.8661	.290	1/4	3/4	5 3/8	4	3512220	3	3514220	139.50	21.515 - 22.301	169.45	149.45	142.75	139.50	136.15	133.40	129.50
22.5	.8858	.290	1/4	3/4	6 1/8	4	3512225	3	3514225	154.95	22.302 - 23.089	184.90	164.85	158.20	154.95	151.60	148.85	144.90
23.0	.9055	.290	1/4	3/4	6 1/8	4	3512230	3	3514230	154.95	-	-	-	-	-	-	-	-
23.5	.9252	.290	1/4	3/4	6 1/8	4	3512235	3	3514235	142.10	23.090 - 23.901	172.05	152.05	145.35	142.10	138.75	136.00	132.10
24.0	.9449	.353	5/16	3/4	6 3/8	4	3512240	3	3514240	159.00	23.902 - 24.689	189.00	168.95	162.30	159.00	155.65	152.95	149.00
24.5	.9646	.353	5/16	3/4	6 3/8	4	3512245	3	3514245	159.00	-	-	-	-	-	-	-	-
25.0	.9843	.353	5/16	3/4	6 3/8	4	3512250	3	3514250	145.80	24.690 - 25.476	175.80	155.75	149.05	145.80	142.45	139.70	135.80
25.5	1.0039	.353	5/16	3/4	6 3/8	4	3512255	3	3514255	147.20	25.477 - 27.076	177.20	157.15	150.50	147.20	143.85	141.15	137.20
26.0	1.0236	.353	5/16	3/4	6 3/8	4	3512260	3	3514260	147.20	-	-	-	-	-	-	-	-
27.0	1.0630	.353	5/16	3/4	6 3/8	4	3512270	3	3514270	147.20	-	-	-	-	-	-	-	-
28.0	1.1024	.353	5/16	1	6 3/8	4	3512280	3	3514280	150.65	27.077 - 28.651	180.60	160.50	153.80	150.65	147.20	144.45	140.55
29.0	1.1417	.353	5/16	1	6 3/8	4	3512290	3	3514290	156.80	28.652 - 30.239	186.70	166.65	160.00	156.80	153.35	150.65	146.70
30.0	1.1811	.353	5/16	1	6 3/8	4	3512300	3	3514300	156.80	-	-	-	-	-	-	-	-
31.0	1.2205	.426	3/8	1	6 5/8	-	-	4	3514310	174.15	30.240 - 31.826	206.65	184.90	177.65	174.15	170.50	167.45	163.25
32.0	1.2598	.426	3/8	1	6 5/8	-	-	4	3514320	186.85	31.827 - 33.414	219.40	197.60	190.40	186.85	183.20	180.25	175.95
33.0	1.2992	.426	3/8	1	6 5/8	-	-	4	3514330	186.85	-	-	-	-	-	-	-	-
34.0	1.3386	.426	3/8	1	6 5/8	-	-	4	3514340	195.75	33.415 - 35.001	228.25	206.50	199.25	195.75	192.10	189.05	184.85
35.0	1.3780	.426	3/8	1	6 5/8	-	-	4	3514350	195.75	-	-	-	-	-	-	-	-
36.0	1.4173	.426	3/8	1 1/4	7 7/8	-	-	4	3514360	214.45	35.002 - 36.589	249.75	226.15	218.20	214.45	210.45	207.15	202.55
37.0	1.4567	.426	3/8	1 1/4	7 7/8	-	-	4	3514370	237.15	36.590 - 38.176	272.45	248.85	241.00	237.15	233.15	229.95	225.25
38.0	1.4961	.426	3/8	1 1/4	7 7/8	-	-	4	3514380	237.15	-	-	-	-	-	-	-	-

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Diameters up to 50mm - call us for pricing & availability.

Made in U.S.A.

CARBIDE TIPPED COUNTERBORES FOR NON-FERROUS & CAST IRON

TYPE 3518 - TAPER SHANK - FOUR FLUTES

TYPE 3516 - TAPER 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.



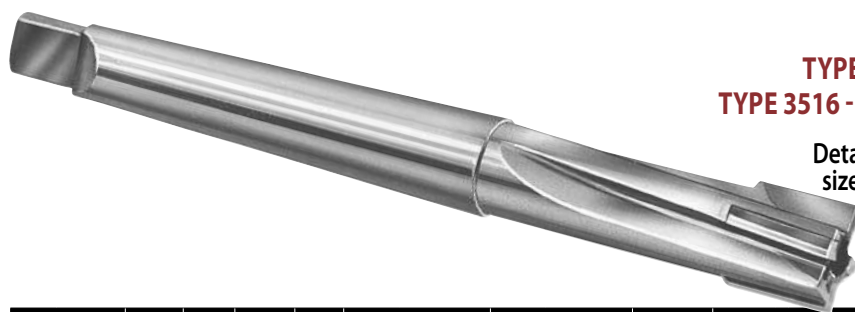
Tool diameter tolerance: +.001"/-.000".
Shank diameter tolerance: +.0000"/-.0005".

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	MORSE TAPER	OVER ALL LEN.	TYPE 3518		TYPE 3516		BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTIONAL					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	1	3 13/16	-	-	3	351608	\$90.30	.2381 - .2530	\$133.80	\$112.05	\$104.75	\$101.20	\$97.50	\$94.55
.2812	9/32	.114	3/32	1	3 13/16	-	-	3	351609	108.55	.2531 - .2840	152.05	130.30	123.00	119.45	115.85	112.80
.3125	5/16	.114	3/32	1	3 13/16	-	-	3	351610	98.75	.2841 - .3150	142.25	120.50	113.25	109.65	105.95	103.00
.3438	11/32	.114	3/32	1	3 13/16	-	-	3	351611	121.70	.3151 - .3470	165.15	143.45	136.15	132.60	128.95	125.90
.3750	3/8	.182	5/32	1	4 1/16	-	-	3	351612	101.95	.3471 - .3780	142.00	122.00	115.30	111.95	108.65	105.90
.4062	13/32	.182	5/32	1	4 1/16	-	-	3	351613	115.15	.3781 - .4090	155.25	135.20	128.50	125.25	121.85	119.10
.4375	7/16	.182	5/32	1	4 1/16	-	-	3	351614	104.70	.4091 - .4410	144.75	124.75	118.05	114.80	111.35	108.65
.4688	15/32	.228	3/16	1	4 5/16	-	-	3	351615	127.10	.4411 - .4720	167.25	147.15	140.45	137.20	133.80	131.05
.5000	1/2	.228	3/16	1	4 5/16	4	351816	3	351616	115.60	.4721 - .5030	155.75	135.65	128.95	125.70	122.30	119.55
.5312	17/32	.228	3/16	1	4 5/16	4	351817	3	351617	129.50	.5031 - .5340	169.55	149.50	142.85	139.50	136.15	133.40
.5625	9/16	.228	3/16	1	4 5/16	4	351818	3	351618	117.75	.5341 - .5660	157.80	137.80	131.10	127.75	124.45	121.70
.5938	19/32	.228	3/16	2	5 1/8	4	351819	3	351619	132.95	.5661 - .5970	173.10	153.05	146.40	143.05	139.70	136.90
.6250	5/8	.228	3/16	2	5 1/8	4	351820	3	351620	120.85	.5971 - .6280	161.00	141.00	134.25	130.95	127.55	124.80
.6562	21/32	.228	3/16	2	5 1/8	4	351821	3	351621	140.40	.6281 - .6590	180.55	160.40	153.75	150.50	147.05	144.30
.6875	11/16	.228	3/16	2	5 1/8	4	351822	3	351622	127.55	.6591 - .6910	167.70	147.65	141.00	137.65	134.25	131.50
.7188	23/32	.290	1/4	2	5 3/8	4	351823	3	351623	142.75	.6911 - .7220	182.85	162.80	156.10	152.85	149.45	146.70
.7500	3/4	.290	1/4	2	5 3/8	4	351824	3	351624	129.70	.7221 - .7530	169.85	149.75	143.05	139.80	136.40	133.65
.7812	25/32	.290	1/4	2	5 3/8	4	351825	3	351625	145.15	.7531 - .7840	185.20	165.15	158.50	155.15	151.80	149.05
.8125	13/16	.290	1/4	2	5 3/8	4	351826	3	351626	132.00	.7841 - .8160	172.05	152.05	145.35	142.00	138.70	135.95
.8438	27/32	.290	1/4	2	5 3/8	4	351827	3	351627	152.65	.8161 - .8470	192.75	172.75	166.05	162.70	159.40	156.55
.8750	7/8	.290	1/4	2	5 3/8	4	351828	3	351628	138.75	.8471 - .8780	178.80	158.80	152.10	148.85	145.45	142.70
.9062	29/32	.290	1/4	3	6 1/8	4	351829	3	351629	156.80	.8781 - .9090	196.85	176.80	170.15	166.80	163.45	160.70
.9375	15/16	.290	1/4	3	6 1/8	4	351830	3	351630	142.55	.9091 - .9410	182.60	162.55	155.90	152.55	149.20	146.45
.9688	31/32	.353	5/16	3	6 3/8	4	351831	3	351631	160.35	.9411 - .9720	200.50	180.45	173.80	170.45	167.00	164.30
1.0000	1	.353	5/16	3	6 3/8	4	351832	3	351632	151.30	.9721 - 1.0030	192.95	172.15	165.15	161.80	158.25	155.40
1.0625	1 1/16	.353	5/16	3	6 3/8	4	351834	3	351634	153.30	1.0031 - 1.0660	194.90	174.10	167.15	163.70	160.25	157.40
1.1250	1 1/8	.353	5/16	3	6 3/8	4	351836	3	351636	158.15	1.0661 - 1.1280	199.80	179.00	172.00	168.65	165.10	162.25
1.1875	1 3/16	.353	5/16	3	6 3/8	4	351838	3	351638	163.55	1.1281 - 1.1905	205.20	184.40	177.40	174.00	170.50	167.65
1.2500	1 1/4	.426	3/8	3	6 5/8	-	-	4	351640	181.80	1.1906 - 1.2530	226.90	204.35	196.80	193.10	189.35	186.20
1.3125	1 5/16	.426	3/8	3	6 5/8	-	-	4	351642	194.90	1.2531 - 1.3155	240.10	217.45	210.00	206.20	202.45	199.35
1.3750	1 3/8	.426	3/8	3	6 5/8	-	-	4	351644	204.20	1.3156 - 1.3780	249.35	226.75	219.20	215.50	211.75	208.60
1.4375	1 7/16	.426	3/8	4	7 7/8	-	-	4	351646	227.15	1.3781 - 1.4405	276.30	251.70	243.45	239.45	235.30	231.90
1.5000	1 1/2	.426	3/8	4	7 7/8	-	-	4	351648	251.85	1.4406 - 1.5030	301.00	276.45	268.25	264.20	260.10	256.70
1.5625	1 9/16	.489	7/16	4	8 1/8	-	-	4	351650	258.35	1.5031 - 1.5660	307.40	282.90	274.75	270.65	266.50	263.20
1.6250	1 5/8	.489	7/16	4	8 1/8	-	-	4	351652	262.95	1.5661 - 1.6280	312.00	287.50	279.35	275.30	271.10	267.80
1.6875	1 11/16	.489	7/16	4	8 1/8	-	-	4	351654	314.60	1.6281 - 1.6910	367.70	341.20	332.35	327.95	323.50	319.85
1.7500	1 3/4	.489	7/16	4	8 1/8	-	-	4	351656	314.60	1.6911 - 1.7530	367.70	341.20	332.35	327.95	323.50	319.85
1.8125	1 13/16	.489	7/16	4	8 1/8	-	-	4	351658	372.35	1.7531 - 1.8160	425.35	398.85	390.00	385.60	381.15	377.55
1.8750	1 7/8	.489	7/16	4	8 1/8	-	-	4	351660	372.35	1.8161 - 1.8780	425.35	398.85	390.00	385.60	381.15	377.55
1.9375	1 15/16	.489	7/16	4	8 1/8	-	-	4	351662	406.85	1.8781 - 1.9410	459.85	433.35	424.50	420.20	415.70	412.05
2.0000	2	.551	1/2	4	8 3/8	-	-	4	351664	406.85	1.9411 - 2.0030	459.85	433.35	424.50	420.20	415.70	412.05

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CARBIDE TIPPED COUNTERBORES FOR NON-FERROUS & CAST IRON

METRIC



TYPE 3518 - TAPER SHANK - FOUR FLUTES
TYPE 3516 - TAPER SHANK - THREE/FOUR FLUTES

Detailed description, tolerances, and fractional sizes on page 36. Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAM.		MIN. CUT DIAM.	PILOT HOLE DIAM.	MORSE TAPER	OVER ALL LEN.	TYPE 3518		TYPE 3516		BOTH TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH					NO. OF FLTS.	EDP NO.	NO. OF FLTS.	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
6.0	.2362	.114	3/32	1	3 13/16	-	-	3	3516060	\$104.75	6.000 - 6.426	\$137.25	\$115.55	\$108.25	\$104.75	\$101.15	\$98.10	\$93.85
6.5	.2559	.114	3/32	1	3 13/16	-	-	3	3516065	123.00	6.427 - 7.214	155.50	133.80	126.50	123.00	119.40	116.40	112.10
7.0	.2756	.114	3/32	1	3 13/16	-	-	3	3516070	123.00	-	-	-	-	-	-	-	-
7.5	.2953	.114	3/32	1	3 13/16	-	-	3	3516075	113.25	7.215 - 8.001	145.75	124.00	116.70	113.25	109.60	106.55	102.30
8.0	.3150	.114	3/32	1	3 13/16	-	-	3	3516080	113.25	-	-	-	-	-	-	-	-
8.5	.3346	.114	3/32	1	3 13/16	-	-	3	3516085	136.15	8.002 - 8.814	168.75	146.90	139.70	136.15	132.50	129.55	125.25
9.0	.3543	.182	5/32	1	4 1/16	-	-	3	3516090	115.30	8.815 - 9.601	145.30	125.25	118.50	115.30	111.90	109.15	105.20
9.5	.3740	.182	5/32	1	4 1/16	-	-	3	3516095	115.30	-	-	-	-	-	-	-	-
10.0	.3937	.182	5/32	1	4 1/16	-	-	3	3516100	128.50	9.602 - 10.389	158.50	138.45	131.80	128.50	125.10	122.35	118.40
10.5	.4134	.182	5/32	1	4 1/16	-	-	3	3516105	118.05	10.390 - 11.201	148.05	128.00	121.30	118.05	114.65	111.90	107.95
11.0	.4331	.182	5/32	1	4 1/16	-	-	3	3516110	118.05	-	-	-	-	-	-	-	-
11.5	.4528	.228	3/16	1	4 3/16	-	-	3	3516115	140.45	11.202 - 11.989	170.45	150.40	143.75	140.45	137.10	134.30	130.35
12.0	.4724	.228	3/16	1	4 3/16	4	3518120	3	3516120	128.95	11.990 - 12.776	158.95	138.90	132.20	128.95	125.60	122.90	118.95
12.5	.4921	.228	3/16	1	4 3/16	4	3518125	3	3516125	128.95	-	-	-	-	-	-	-	-
13.0	.5118	.228	3/16	1	4 3/16	4	3518130	3	3516130	142.85	12.777 - 13.564	172.80	152.80	146.05	142.85	139.40	136.70	132.75
13.5	.5315	.228	3/16	1	4 3/16	4	3518135	3	3516135	142.85	-	-	-	-	-	-	-	-
14.0	.5512	.228	3/16	1	4 3/16	4	3518140	3	3516140	131.10	13.565 - 14.376	161.10	141.05	134.30	131.10	127.70	124.95	121.00
14.5	.5709	.228	3/16	2	5 1/8	4	3518145	3	3516145	146.40	14.377 - 15.164	176.35	156.25	149.60	146.40	143.00	140.25	136.30
15.0	.5906	.228	3/16	2	5 1/8	4	3518150	3	3516150	146.40	-	-	-	-	-	-	-	-
15.5	.6102	.228	3/16	2	5 1/8	4	3518155	3	3516155	134.25	15.165 - 15.951	164.20	144.15	137.50	134.25	130.90	128.15	124.20
16.0	.6299	.228	3/16	2	5 1/8	4	3518160	3	3516160	153.75	15.952 - 16.739	183.70	163.70	157.00	153.75	150.40	147.65	143.75
16.5	.6496	.228	3/16	2	5 1/8	4	3518165	3	3516165	153.75	-	-	-	-	-	-	-	-
17.0	.6693	.228	3/16	2	5 1/8	4	3518170	3	3516170	141.00	16.740 - 17.551	170.90	150.85	144.15	141.00	137.55	134.80	130.90
17.5	.6890	.228	3/16	2	5 1/8	4	3518175	3	3516175	141.00	-	-	-	-	-	-	-	-
18.0	.7087	.290	1/4	2	5 3/8	4	3518180	3	3516180	156.10	17.552 - 18.339	186.10	166.05	159.40	156.10	152.80	149.95	146.05
18.5	.7283	.290	1/4	2	5 3/8	4	3518185	3	3516185	143.05	18.340 - 19.126	173.05	153.00	146.30	143.05	139.70	136.90	132.95
19.0	.7480	.290	1/4	2	5 3/8	4	3518190	3	3516190	143.05	-	-	-	-	-	-	-	-
19.5	.7677	.290	1/4	2	5 3/8	4	3518195	3	3516195	158.50	19.127 - 19.914	188.45	168.35	161.70	158.50	155.10	152.35	148.40
20.0	.7874	.290	1/4	2	5 3/8	4	3518200	3	3516200	145.35	19.915 - 20.726	175.35	155.25	148.55	145.35	141.95	139.20	135.25
20.5	.8071	.290	1/4	2	5 3/8	4	3518205	3	3516205	145.35	-	-	-	-	-	-	-	-
21.0	.8268	.290	1/4	2	5 3/8	4	3518210	3	3516210	166.05	20.727 - 21.514	196.05	175.95	169.25	166.05	162.65	159.90	155.95
21.5	.8465	.290	1/4	2	5 3/8	4	3518215	3	3516215	166.05	-	-	-	-	-	-	-	-
22.0	.8661	.290	1/4	2	5 3/8	4	3518220	3	3516220	152.10	21.515 - 22.301	182.10	162.05	155.35	152.10	148.70	145.95	142.00
22.5	.8858	.290	1/4	3	6 1/8	4	3518225	3	3516225	170.15	22.302 - 23.089	200.10	180.00	173.35	170.15	166.75	164.00	160.05
23.0	.9055	.290	1/4	3	6 1/8	4	3518230	3	3516230	170.15	-	-	-	-	-	-	-	-
23.5	.9252	.290	1/4	3	6 1/8	4	3518235	3	3516235	155.90	23.090 - 23.901	185.85	165.75	159.10	155.90	152.50	149.75	145.80
24.0	.9449	.353	5/16	3	6 3/8	4	3518240	3	3516240	173.80	23.902 - 24.689	203.70	183.65	176.95	173.80	170.35	167.60	163.70
24.5	.9646	.353	5/16	3	6 3/8	4	3518245	3	3516245	173.80	-	-	-	-	-	-	-	-
25.0	.9843	.353	5/16	3	6 3/8	4	3518250	3	3516250	159.15	24.690 - 25.476	189.15	169.10	162.40	159.15	155.80	153.05	149.15
25.5	1.0039	.353	5/16	3	6 3/8	4	3518255	3	3516255	167.15	25.477 - 27.076	198.30	177.40	170.50	167.15	163.60	160.80	156.70
26.0	1.0236	.353	5/16	3	6 3/8	4	3518260	3	3516260	167.15	-	-	-	-	-	-	-	-
27.0	1.0630	.353	5/16	3	6 3/8	4	3518270	3	3516270	167.15	-	-	-	-	-	-	-	-
28.0	1.1024	.353	5/16	3	6 3/8	4	3518280	3	3516280	172.00	27.077 - 28.651	203.15	182.35	175.40	172.00	168.55	165.70	161.60
29.0	1.1417	.353	5/16	3	6 3/8	4	3518290	3	3516290	177.40	28.652 - 30.239	208.50	187.75	180.80	177.40	173.95	171.10	167.00
30.0	1.1811	.353	5/16	3	6 3/8	4	3518300	3	3516300	177.40	-	-	-	-	-	-	-	-
31.0	1.2205	.426	3/8	3	6 5/8	-	-	4	3516310	196.80	30.240 - 31.826	230.60	208.00	200.50	196.80	193.05	189.95	185.50
32.0	1.2598	.426	3/8	3	6 5/8	-	-	4	3516320	210.00	31.827 - 33.414	243.70	221.15	213.60	210.00	206.15	203.05	198.60
33.0	1.2992	.426	3/8	3	6 5/8	-	-	4	3516330	210.00	-	-	-	-	-	-	-	-
34.0	1.3386	.426	3/8	3	6 5/8	-	-	4	3516340	219.20	33.415 - 35.001	253.00	230.40	222.90	219.20	215.45	212.35	207.90
35.0	1.3780	.426	3/8	3	6 5/8	-	-	4	3516350	219.20	-	-	-	-	-	-	-	-
36.0	1.4173	.426	3/8	4	7 7/8	-	-	4	3516360	243.45	35.002 - 36.589	280.20	255.65	247.50	243.45	239.40	236.00	231.15
37.0	1.4567	.426	3/8	4	7 7/8	-	-	4	3516370	268.25	36.590 - 38.176	304.90	280.35	272.20	268.25	264.10	260.70	255.95
38.0	1.4961	.426	3/8	4	7 7/8	-	-	4	3516380	268.25	-	-	-	-	-	-	-	-

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Diameters up to 50mm - call us for pricing & availability.

Made in U.S.A.

CARBIDE TIPPED COUNTERBORES FOR STEEL

TYPE 3510 - STRAIGHT SHANK - THREE/FOUR FLUTES

TYPE 3511 - TAPER 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 steel and steel alloys.



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

Shank diameter tolerance: +.0000"/-.0005".

TOOL DIAMETER		MIN. CUT DIAM.	PILOT HOLE DIAM.	NO. OF FLUTES	OVER ALL LEN.	STRAIGHT SHANK TYPE 3510		TAPER SHANK TYPE 3511		BOTH TYPES PRICE	DECIMAL SIZE RANGE	PRICE EACH - FINISHED TO DECIMAL SIZE					
DECIMAL	FRACTION					SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.2500	1/4	.114	3/32	3	3 13/16	15/64	351008	1	351108	\$90.30	.2381 - .2530	\$133.80	\$112.05	\$104.75	\$101.20	\$97.50	\$94.55
.2812	9/32	.114	3/32	3	3 13/16	17/64	351009	1	351109	108.55	.2531 - .2840	152.05	130.30	123.00	119.45	115.85	112.80
.3125	5/16	.114	3/32	3	3 13/16	19/64	351010	1	351110	98.75	.2841 - .3150	142.25	120.50	113.25	109.65	105.95	103.00
.3438	11/32	.114	3/32	3	3 13/16	5/16	351011	1	351111	121.70	.3151 - .3470	165.15	143.45	136.15	132.60	128.95	125.90
.3750	3/8	.182	5/32	3	4 1/16	5/16	351012	1	351112	101.95	.3471 - .3780	142.00	122.00	115.30	111.95	108.65	105.90
.4062	13/32	.182	5/32	3	4 1/16	3/8	351013	1	351113	115.15	.3781 - .4090	155.25	135.20	128.50	125.25	121.85	119.10
.4375	7/16	.182	5/32	3	4 1/16	3/8	351014	1	351114	104.70	.4091 - .4410	144.75	124.75	118.05	114.80	111.35	108.65
.4688	15/32	.228	3/16	3	4 5/16	7/16	351015	1	351115	127.10	.4411 - .4720	167.25	147.15	140.45	137.20	133.80	131.05
.5000	1/2	.228	3/16	3	4 5/16	7/16	351016	1	351116	115.60	.4721 - .5030	155.75	135.65	128.95	125.70	122.30	119.55
.5312	17/32	.228	3/16	3	4 5/16	1/2	351017	1	351117	129.50	.5031 - .5340	169.55	149.50	142.85	139.50	136.15	133.40
.5625	9/16	.228	3/16	3	4 5/16	1/2	351018	1	351118	117.75	.5341 - .5660	157.80	137.80	131.10	127.75	124.45	121.70
.5938	19/32	.228	3/16	3	5 1/8	1/2	351019	2	351119	132.95	.5661 - .5970	173.10	153.05	146.40	143.05	139.70	136.90
.6250	5/8	.228	3/16	3	5 1/8	1/2	351020	2	351120	120.85	.5971 - .6280	161.00	141.00	134.25	130.95	127.55	124.80
.6562	21/32	.228	3/16	3	5 1/8	1/2	351021	2	351121	140.40	.6281 - .6590	180.55	160.40	153.75	150.50	147.05	144.30
.6875	11/16	.228	3/16	3	5 1/8	1/2	351022	2	351122	127.55	.6591 - .6910	167.70	147.65	141.00	137.65	134.25	131.50
.7188	23/32	.290	1/4	3	5 3/8	1/2	351023	2	351123	142.75	.6911 - .7220	182.85	162.80	156.10	152.85	149.45	146.70
.7500	3/4	.290	1/4	3	5 3/8	1/2	351024	2	351124	129.70	.7221 - .7530	169.85	149.75	143.05	139.80	136.40	133.65
.7812	25/32	.290	1/4	3	5 3/8	5/8	351025	2	351125	145.15	.7531 - .7840	185.20	165.15	158.50	155.15	151.80	149.05
.8125	13/16	.290	1/4	3	5 3/8	5/8	351026	2	351126	132.00	.7841 - .8160	172.05	152.05	145.35	142.00	138.70	135.95
.8438	27/32	.290	1/4	3	5 3/8	3/4	351027	2	351127	152.65	.8161 - .8470	192.75	172.75	166.05	162.70	159.40	156.55
.8750	7/8	.290	1/4	3	5 3/8	3/4	351028	2	351128	138.75	.8471 - .8780	178.80	158.80	152.10	148.85	145.45	142.70
.9062	29/32	.290	1/4	3	6 1/8	3/4	351029	3	351129	156.80	.8781 - .9090	196.85	176.80	170.15	166.80	163.45	160.70
.9375	19/16	.290	1/4	3	6 1/8	3/4	351030	3	351130	142.55	.9091 - .9410	182.60	162.55	155.90	152.55	149.20	146.45
.9688	31/32	.353	5/16	3	6 3/8	3/4	351031	3	351131	160.35	.9411 - .9720	200.50	180.45	173.80	170.45	167.00	164.30
1.0000	1	.353	5/16	3	6 3/8	3/4	351032	3	351132	151.30	.9721 - 1.0030	192.95	172.15	165.15	161.80	158.25	155.40
1.0625	1 1/16	.353	5/16	3	6 3/8	3/4	351034	3	351134	153.30	1.0031 - 1.0660	194.90	174.10	167.15	163.70	160.25	157.40
1.1250	1 1/8	.353	5/16	3	6 3/8	1	351036	3	351136	158.15	1.0661 - 1.1280	199.80	179.00	172.00	168.65	165.10	162.25
1.1875	1 3/16	.353	5/16	3	6 3/8	1	351038	3	351138	163.55	1.1281 - 1.1905	205.20	184.40	177.40	174.00	170.50	167.65
1.2500	1 1/4	.426	3/8	4	6 5/8	1	351040	3	351140	181.80	1.1906 - 1.2530	226.90	204.35	196.80	193.10	189.35	186.20
1.3125	1 5/16	.426	3/8	4	6 5/8	1	351042	3	351142	194.90	1.2531 - 1.3155	240.10	217.45	210.00	206.20	202.45	199.35
1.3750	1 3/8	.426	3/8	4	6 5/8	1	351044	3	351144	204.20	1.3156 - 1.3780	249.35	226.75	219.20	215.50	211.75	208.60
1.4375	1 7/16	.426	3/8	4	7 7/8	1 1/4	351046	4	351146	227.15	1.3781 - 1.4405	276.30	251.70	243.45	239.45	235.30	231.90
1.5000	1 1/2	.426	3/8	4	7 7/8	1 1/4	351048	4	351148	251.85	1.4406 - 1.5030	301.00	276.45	268.25	264.20	260.10	256.70
1.5625	1 9/16	.489	7/16	4	8 1/8	1 1/4	351050	4	351150	258.35	1.5031 - 1.5660	307.40	282.90	274.75	270.65	266.50	263.20
1.6250	1 5/8	.489	7/16	4	8 1/8	1 1/4	351052	4	351152	262.95	1.5661 - 1.6280	312.00	287.50	279.35	275.30	271.10	267.80
1.6875	1 11/16	.489	7/16	4	8 1/8	1 1/4	351054	4	351154	314.60	1.6281 - 1.6910	367.70	341.20	332.35	327.95	323.50	319.85
1.7500	1 3/4	.489	7/16	4	8 1/8	1 1/4	351056	4	351156	314.60	1.6911 - 1.7530	367.70	341.20	332.35	327.95	323.50	319.85
1.8125	1 13/16	.489	7/16	4	8 1/8	1 1/2	351058	4	351158	372.35	1.7531 - 1.8160	425.35	398.85	390.00	385.60	381.15	377.55
1.8750	1 7/8	.489	7/16	4	8 1/8	1 1/2	351060	4	351160	372.35	1.8161 - 1.8780	425.35	398.85	390.00	385.60	381.15	377.55
1.9375	1 15/16	.489	7/16	4	8 1/8	1 1/2	351062	4	351162	406.85	1.8781 - 1.9410	459.85	433.35	424.50	420.20	415.70	412.05
2.0000	2	.551	1/2	4	8 3/8	1 1/2	351064	4	351164	406.85	1.9411 - 2.0030	459.85	433.35	424.50	420.20	415.70	412.05

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CARBIDE TIPPED COUNTERBORES FOR STEEL

METRIC



TYPE 3510 - STRAIGHT SHANK - THREE/FOUR FLUTES
TYPE 3511 - TAPER SHANK - THREE/FOUR FLUTES

Detailed description, tolerances, and fractional sizes on page 38. Tool diameter in millimeters with all other dimensions in inches.

TOOL DIAM.		MIN. CUT DIAM.	PILOT HOLE DIAM.	NO. OF FLTS.	OVER ALL LEN.	STRAIGHT SHANK TYPE 3510		TAPER SHANK TYPE 3511		BOTH TYPES PRICE	METRIC SIZE RANGE	PRICE EACH - FINISHED TO METRIC SIZE						
mm	INCH					SHANK DIAM.	EDP NO.	MORSE TAPER	EDP NO.			PRICE	1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14
6.0	.2362	.114	3/32	3	3 13/16	15/64	3510060	1	3511060	\$104.75	6.000 - 6.426	\$137.25	\$115.55	\$108.25	\$104.75	\$101.15	\$98.10	\$93.85
6.5	.2559	.114	3/32	3	3 13/16	17/64	3510065	1	3511065	123.00	6.427 - 7.214	155.50	133.80	126.50	123.00	119.40	116.40	112.10
7.0	.2756	.114	3/32	3	3 13/16	17/64	3510070	1	3511070	123.00	-	-	-	-	-	-	-	-
7.5	.2953	.114	3/32	3	3 13/16	19/64	3510075	1	3511075	113.25	7.215 - 8.001	145.75	124.00	116.70	113.25	109.60	106.55	102.30
8.0	.3150	.114	3/32	3	3 13/16	19/64	3510080	1	3511080	113.25	-	-	-	-	-	-	-	-
8.5	.3346	.114	3/32	3	3 13/16	5/16	3510085	1	3511085	136.15	8.002 - 8.814	168.75	146.90	139.70	136.15	132.50	129.55	125.25
9.0	.3543	.182	5/32	3	4 1/16	5/16	3510090	1	3511090	115.30	8.815 - 9.601	145.30	125.25	118.50	115.30	111.90	109.15	105.20
9.5	.3740	.182	5/32	3	4 1/16	5/16	3510095	1	3511095	115.30	-	-	-	-	-	-	-	-
10.0	.3937	.182	5/32	3	4 1/16	3/8	3510100	1	3511100	128.50	9.602 - 10.389	158.50	138.45	131.80	128.50	125.10	122.35	118.40
10.5	.4134	.182	5/32	3	4 1/16	3/8	3510105	1	3511105	118.05	10.390 - 11.201	148.05	128.00	121.30	118.05	114.65	111.90	107.95
11.0	.4331	.182	5/32	3	4 1/16	3/8	3510110	1	3511110	118.05	-	-	-	-	-	-	-	-
11.5	.4528	.228	3/16	3	4 5/16	7/16	3510115	1	3511115	140.45	11.202 - 11.989	170.45	150.40	143.75	140.45	137.10	134.30	130.35
12.0	.4724	.228	3/16	3	4 5/16	7/16	3510120	1	3511120	128.95	11.990 - 12.776	158.95	138.90	132.20	128.95	125.60	122.90	118.95
12.5	.4921	.228	3/16	3	4 5/16	7/16	3510125	1	3511125	128.95	-	-	-	-	-	-	-	-
13.0	.5118	.228	3/16	3	4 5/16	1/2	3510130	1	3511130	142.85	12.777 - 13.564	172.80	152.80	146.05	142.85	139.40	136.70	132.75
13.5	.5315	.228	3/16	3	4 5/16	1/2	3510135	1	3511135	142.85	-	-	-	-	-	-	-	-
14.0	.5512	.228	3/16	3	4 5/16	1/2	3510140	1	3511140	131.10	13.565 - 14.376	161.10	141.05	134.30	131.10	127.70	124.95	121.00
14.5	.5709	.228	3/16	3	5 1/8	1/2	3510145	2	3511145	146.40	14.377 - 15.164	176.35	156.25	149.60	146.40	143.00	140.25	136.30
15.0	.5906	.228	3/16	3	5 1/8	1/2	3510150	2	3511150	146.40	-	-	-	-	-	-	-	-
15.5	.6102	.228	3/16	3	5 1/8	1/2	3510155	2	3511155	134.25	15.165 - 15.951	164.20	144.15	137.50	134.25	130.90	128.15	124.20
16.0	.6299	.228	3/16	3	5 1/8	1/2	3510160	2	3511160	134.25	15.952 - 16.739	164.20	144.15	137.50	134.25	130.90	128.15	124.20
16.5	.6496	.228	3/16	3	5 1/8	1/2	3510165	2	3511165	153.75	-	-	-	-	-	-	-	-
17.0	.6693	.228	3/16	3	5 1/8	1/2	3510170	2	3511170	141.00	16.740 - 17.551	170.90	150.85	144.15	141.00	137.55	134.80	130.90
17.5	.6890	.228	3/16	3	5 1/8	1/2	3510175	2	3511175	141.00	-	-	-	-	-	-	-	-
18.0	.7087	.290	1/4	3	5 3/8	1/2	3510180	2	3511180	156.10	17.552 - 18.339	186.10	166.05	159.40	156.10	152.80	149.95	146.05
18.5	.7283	.290	1/4	3	5 3/8	1/2	3510185	2	3511185	143.05	18.340 - 19.126	173.05	153.00	146.30	143.05	139.70	136.90	132.95
19.0	.7480	.290	1/4	3	5 3/8	1/2	3510190	2	3511190	143.05	-	-	-	-	-	-	-	-
19.5	.7677	.290	1/4	3	5 3/8	1/2	3510195	2	3511195	158.50	19.127 - 19.914	188.45	168.35	161.70	158.50	155.10	152.35	148.40
20.0	.7874	.290	1/4	3	5 3/8	5/8	3510200	2	3511200	145.35	19.915 - 20.726	175.35	155.25	148.55	145.35	141.95	139.20	135.25
20.5	.8071	.290	1/4	3	5 3/8	5/8	3510205	2	3511205	145.35	-	-	-	-	-	-	-	-
21.0	.8268	.290	1/4	3	5 3/8	3/4	3510210	2	3511210	166.05	20.727 - 21.514	196.05	175.95	169.25	166.05	162.65	159.90	155.95
21.5	.8465	.290	1/4	3	5 3/8	3/4	3510215	2	3511215	166.05	-	-	-	-	-	-	-	-
22.0	.8661	.290	1/4	3	5 3/8	3/4	3510220	2	3511220	152.10	21.515 - 22.301	182.10	162.05	155.35	152.10	148.70	145.95	142.00
22.5	.8858	.290	1/4	3	6 1/8	3/4	3510225	3	3511225	170.15	22.302 - 23.089	200.10	180.00	173.35	170.15	166.75	164.00	160.05
23.0	.9055	.290	1/4	3	6 1/8	3/4	3510230	3	3511230	170.15	-	-	-	-	-	-	-	-
23.5	.9252	.290	1/4	3	6 1/8	3/4	3510235	3	3511235	155.90	23.090 - 23.901	185.85	165.75	159.10	155.90	152.50	149.75	145.80
24.0	.9449	.353	5/16	3	6 3/8	3/4	3510240	3	3511240	173.80	23.902 - 24.689	203.70	183.65	176.95	173.80	170.35	167.60	163.70
24.5	.9646	.353	5/16	3	6 3/8	3/4	3510245	3	3511245	173.80	-	-	-	-	-	-	-	-
25.0	.9843	.353	5/16	3	6 3/8	3/4	3510250	3	3511250	159.15	24.690 - 25.476	189.15	169.10	162.40	159.15	155.80	153.05	149.15
25.5	1.0039	.353	5/16	3	6 3/8	3/4	3510255	3	3511255	167.15	25.477 - 27.076	198.30	177.40	170.50	167.15	163.60	160.80	156.70
26.0	1.0236	.353	5/16	3	6 3/8	3/4	3510260	3	3511260	167.15	-	-	-	-	-	-	-	-
27.0	1.0630	.353	5/16	3	6 3/8	3/4	3510270	3	3511270	167.15	-	-	-	-	-	-	-	-
28.0	1.1024	.353	5/16	3	6 3/8	1	3510280	3	3511280	172.00	27.077 - 28.651	203.15	182.35	175.40	172.00	168.55	165.70	161.60
29.0	1.1417	.353	5/16	3	6 3/8	1	3510290	3	3511290	177.40	28.652 - 30.239	208.50	187.75	180.80	177.40	173.95	171.10	167.00
30.0	1.1811	.353	5/16	3	6 3/8	1	3510300	3	3511300	177.40	-	-	-	-	-	-	-	-
31.0	1.2205	.426	3/8	4	6 5/8	1	3510310	3	3511310	196.80	30.240 - 31.826	230.60	208.00	200.50	196.80	193.05	189.95	185.50
32.0	1.2598	.426	3/8	4	6 5/8	1	3510320	3	3511320	210.00	31.827 - 33.414	243.70	221.15	213.60	210.00	206.15	203.05	198.60
33.0	1.2992	.426	3/8	4	6 5/8	1	3510330	3	3511330	210.00	-	-	-	-	-	-	-	-
34.0	1.3386	.426	3/8	4	6 5/8	1	3510340	3	3511340	219.20	33.415 - 35.001	253.00	230.40	222.90	219.20	215.45	212.35	207.90
35.0	1.3780	.426	3/8	4	6 5/8	1	3510350	3	3511350	219.20	-	-	-	-	-	-	-	-
36.0	1.4173	.426	3/8	4	7 7/8	1 1/4	3510360	4	3511360	243.45	35.002 - 36.589	280.20	255.65	247.50	243.45	239.40	236.00	231.15
37.0	1.4567	.426	3/8	4	7 7/8	1 1/4	3510370	4	3511370	268.25	36.590 - 38.176	304.90	280.35	272.20	268.25	264.10	260.70	255.95
38.0	1.4961	.426	3/8	4	7 7/8	1 1/4	3510380	4	3511380	268.25	-	-	-	-	-	-	-	-

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Diameters up to 50mm - call us for price & availability.

Made in U.S.A.

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: +.001"/-.000".
Shank diameter tolerance: +.0000"/-.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	FRACTIONAL									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	\$58.40	.2381 - .2530	\$99.30	\$78.85	\$72.05	\$68.70	\$65.20	\$62.40
.2812	9/32	.125	3/32	3	1/4	2 3/8	352209	58.45	.2531 - .2840	99.35	78.95	72.10	68.80	65.30	62.50
.3125	5/16	.125	3/32	3	1/4	2 3/8	352210	59.95	.2841 - .3150	100.85	80.35	73.55	70.20	66.80	63.95
.3438	11/32	.125	3/32	3	1/4	2 3/8	352211	61.15	.3151 - .3470	102.00	81.55	74.80	71.40	67.95	65.15
.3750	3/8	.125	3/32	3	1/4	2 3/8	352212	61.30	.3471 - .3780	102.15	81.75	74.95	71.55	68.10	65.30
.4062	13/32	.156	1/8	3	1/4	2 3/4	352213	69.75	.3781 - .4090	110.55	90.15	83.35	80.00	76.50	73.75
.4375	7/16	.156	1/8	3	1/4	2 3/4	352214	75.15	.4091 - .4410	116.05	95.55	88.80	85.40	82.00	79.15
.4688	15/32	.156	1/8	3	1/4	2 3/4	352215	76.45	.4411 - .4720	117.30	96.90	90.10	86.75	83.25	80.45
.5000	1/2	.156	1/8	3	1/4	2 3/4	352216	77.30	.4721 - .5030	118.20	97.80	90.95	87.55	84.15	81.30
.5312	17/32	.156	1/8	3	1/4	2 3/4	352217	77.75	.5031 - .5340	118.55	98.15	91.35	88.00	84.50	81.75
.5625	9/16	.156	1/8	3	1/4	2 3/4	352218	78.05	.5341 - .5660	118.95	98.45	91.70	88.30	84.90	82.05
.5938	19/32	.156	1/8	3	1/4	2 3/4	352219	78.50	.5661 - .5970	119.40	99.00	92.15	88.80	85.35	82.50
.6250	5/8	.156	1/8	3	1/4	2 3/4	352220	79.40	.5971 - .6280	120.30	99.85	93.05	89.70	86.20	83.40
.6562	21/32	.219	3/16	3	1/4	2 3/4	352221	88.20	.6281 - .6590	129.10	108.65	101.90	98.45	95.05	92.25
.6875	11/16	.219	3/16	3	1/4	2 3/4	352222	92.60	.6591 - .6910	133.50	113.10	106.25	102.90	99.45	96.60
.7188	23/32	.219	3/16	3	1/4	2 3/4	352223	95.80	.6911 - .7220	136.60	116.20	109.35	106.05	102.55	99.80
.7500	3/4	.219	3/16	3	1/4	2 3/4	352224	97.00	.7221 - .7530	137.85	117.40	110.55	107.20	103.80	101.00
.7812	25/32	.219	3/16	3	1/4	2 3/4	352225	97.35	.7531 - .7840	138.25	117.85	111.00	107.60	104.20	101.35
.8125	13/16	.219	3/16	3	1/4	2 3/4	352226	98.25	.7841 - .8160	139.10	118.65	111.90	108.50	105.05	102.25
.8438	27/32	.219	3/16	3	1/4	2 3/4	352227	98.90	.8161 - .8470	139.80	119.30	112.50	109.15	105.75	102.90
.8750	7/8	.219	3/16	3	1/4	2 3/4	352228	99.85	.8471 - .8780	140.70	120.30	113.45	110.10	106.65	103.90
.9062	29/32	.219	3/16	3	1/4	2 3/4	352229	100.55	.8781 - .9090	141.45	121.00	114.20	110.85	107.35	104.55
.9375	15/16	.219	3/16	3	1/4	2 3/4	352230	101.50	.9091 - .9410	142.40	122.00	115.15	111.80	108.35	105.50
.9688	31/32	.219	3/16	3	1/4	2 3/4	352231	102.15	.9411 - .9720	143.05	122.60	115.85	112.40	109.00	106.20
1.0000	1	.219	3/16	3	1/4	2 3/4	352232	102.45	.9721 - 1.0030	143.35	122.95	116.10	112.80	109.30	106.50
1.0625	1 1/16	.219	3/16	3	3/8	2 3/4	352234	130.80	1.0031 - 1.0660	171.60	151.20	144.40	141.05	137.55	134.80
1.1250	1 1/8	.219	3/16	3	3/8	2 3/4	352236	139.55	1.0661 - 1.1280	180.45	160.05	153.20	149.90	146.40	143.60
1.1875	1 3/16	.219	3/16	3	3/8	2 3/4	352238	141.35	1.1281 - 1.1905	182.25	161.85	155.00	151.60	148.20	145.35
1.2500	1 1/4	.281	1/4	3	3/8	2 3/4	352240	144.00	1.1906 - 1.2530	184.90	164.45	157.60	154.25	150.85	148.05
1.3125	1 5/16	.281	1/4	3	3/8	2 3/4	352242	146.60	1.2531 - 1.3155	187.50	167.10	160.25	156.95	153.45	150.65
1.3750	1 3/8	.281	1/4	3	3/8	2 3/4	352244	148.40	1.3156 - 1.3780	189.30	168.90	162.05	158.65	155.25	152.40
1.4375	1 7/16	.281	1/4	3	3/8	2 3/4	352246	150.20	1.3781 - 1.4405	191.05	170.60	163.85	160.40	157.00	154.20
1.5000	1 1/2	.281	1/4	3	3/8	2 3/4	352248	158.05	1.4406 - 1.5030	200.40	179.25	172.20	168.75	165.10	162.20
1.5625	1 9/16	.343	5/16	3	1/2	3 1/16	352250	175.85	1.5031 - 1.5660	218.20	197.10	189.95	186.45	182.90	180.00
1.6250	1 5/8	.343	5/16	3	1/2	3 1/16	352252	178.15	1.5661 - 1.6280	220.50	199.40	192.35	188.85	185.20	182.30
1.6875	1 11/16	.343	5/16	3	1/2	3 1/16	352254	180.55	1.6281 - 1.6910	222.90	201.70	194.65	191.15	187.60	184.70
1.7500	1 3/4	.343	5/16	3	1/2	3 1/16	352256	183.25	1.6911 - 1.7530	225.65	204.40	197.35	193.90	190.30	187.45
1.8125	1 13/16	.343	5/16	3	1/2	3 1/16	352258	185.45	1.7531 - 1.8160	227.40	206.30	199.25	195.75	192.10	189.20
1.8750	1 7/8	.343	5/16	3	1/2	3 1/16	352260	186.85	1.8161 - 1.8780	229.20	208.00	200.95	197.45	193.90	191.00
1.9375	1 15/16	.343	5/16	3	1/2	3 1/16	352262	206.15	1.8781 - 1.9410	248.50	227.25	220.25	216.75	213.20	210.30
2.0000	2	.343	5/16	3	1/2	3 1/16	352264	256.50	1.9411 - 2.0030	298.95	277.75	270.70	267.20	263.65	260.65

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INTERCHANGEABLE COUNTERBORE PILOTS

TYPE 3500 - CARBON STEEL - SHORT SHANK

For use with our carbide tipped counterbores (pages 34 thru 40 & 42, 43).

The shank diameter must be the same as the pilot hole diameter in the counterbore. The pilot head diameter is always larger than the shank diameter and is determined by part to be machined.



PILOT HEAD DIAMETER		TOLERANCE
1/8" THRU	1/4"	-.001"/-.002"
OVER 1/4" THRU	7/8"	-.003"/-.004"
OVER 7/8" THRU	1 1/4"	-.005"/-.006"
OVER 1 1/4"		-.006"/-.007"

Shank diameter tolerance: +.0000"/-.0005"

PILOT HEAD DIAMETER		SHANK DIAMETER									ALL TYPES PRICE	PRICE EACH - PILOT HEAD DIAMETER FINISHED TO DECIMAL SIZE					
		3/32 .0938 EDP NO.	1/8 .1250 EDP NO.	5/32 .1562 EDP NO.	3/16 .1875 EDP NO.	1/4 .2500 EDP NO.	5/16 .3125 EDP NO.	3/8 .3750 EDP NO.	7/16 .4375 EDP NO.	1/2 .5000 EDP NO.		1 PC.	2 PC.	3 PC.	4 PC.	5-7	8+
.1250	1/8	350104	-	-	-	-	-	-	-	-	\$22.35	\$88.75	\$55.55	\$44.50	\$39.05	\$33.40	\$28.85
.1562	5/32	350105	350205	-	-	-	-	-	-	-	18.10	84.50	51.30	40.25	34.70	29.20	24.65
.1875	3/16	350106	350206	350306	-	-	-	-	-	-	18.45	84.85	51.65	40.60	35.15	29.50	24.95
.2188	7/32	350107	350207	350307	350407	-	-	-	-	-	20.95	87.35	54.15	43.05	37.65	32.00	27.45
.2500	1/4	350108	350208	350308	350408	-	-	-	-	-	20.95	87.35	54.15	43.05	37.65	32.00	27.45
.2812	9/32	350109	350209	350309	350409	350509	-	-	-	-	22.35	88.75	55.55	44.50	39.05	33.40	28.85
.3125	5/16	350110	350210	350310	350410	350510	-	-	-	-	22.35	88.75	55.55	44.50	39.05	33.40	28.85
.3438	11/32	350111	350211	350311	350411	350511	350611	-	-	-	22.35	88.75	55.55	44.50	39.05	33.40	28.85
.3750	3/8	350112	350212	350312	350412	350512	350612	-	-	-	24.65	91.05	57.85	46.75	41.25	35.70	31.15
.4062	13/32	-	350213	350313	350413	350513	350613	-	-	-	24.65	91.05	57.85	46.75	41.25	35.70	31.15
.4375	7/16	-	350214	350314	350414	350514	350614	350714	-	-	25.15	91.55	58.35	47.30	41.75	36.25	31.70
.4688	15/32	-	350215	-	350415	350515	350615	-	-	-	25.15	91.55	58.35	47.30	41.75	36.25	31.70
.5000	1/2	-	350216	-	350416	350516	350616	350716	350816	-	28.85	95.25	62.05	51.00	45.55	39.95	35.35
.5312	17/32	-	350217	-	350417	350517	350617	-	350817	-	33.65	100.05	66.85	55.75	50.25	44.70	40.15
.5625	9/16	-	350218	-	350418	350518	350618	350718	350818	350918	37.75	104.15	70.95	59.90	54.45	48.80	44.25
.5938	19/32	-	350219	-	-	350519	350619	-	350819	350919	41.45	107.85	74.65	63.60	58.05	52.50	47.95
.6250	5/8	-	350220	-	350420	350520	350620	350720	350820	350920	41.45	107.85	74.65	63.60	58.05	52.50	47.95
.6562	21/32	-	-	-	350421	350521	350621	-	350821	-	42.40	108.85	75.60	64.55	59.15	53.50	48.95
.6875	11/16	-	-	-	350422	350522	350622	350722	350822	350922	42.40	108.85	75.60	64.55	59.15	53.50	48.95
.7188	23/32	-	-	-	-	350523	350623	-	350823	350923	48.05	114.45	81.25	70.20	64.65	59.15	54.60
.7500	3/4	-	-	-	350424	350524	350624	350724	350824	350924	48.05	114.45	81.25	70.20	64.65	59.15	54.60
.7812	25/32	-	-	-	-	350525	350625	-	350825	350925	54.05	120.45	87.25	76.15	70.75	65.10	60.55
.8125	13/16	-	-	-	350426	350526	350626	350726	350826	350926	54.05	120.45	87.25	76.15	70.75	65.10	60.55
.8438	27/32	-	-	-	-	350527	-	-	-	-	59.80	126.20	93.00	81.90	76.40	70.85	66.30
.8750	7/8	-	-	-	350428	350528	350628	350728	350828	350928	59.80	126.20	93.00	81.90	76.40	70.85	66.30
.9375	15/16	-	-	-	350430	350530	350630	350730	350830	350930	63.05	129.45	96.25	85.15	79.65	74.10	69.55
1.0000	1	-	-	-	350432	350532	350632	350732	350832	350932	65.20	131.60	98.40	87.35	81.90	76.30	71.70
1.0625	1 1/16	-	-	-	-	-	350634	350734	350834	350934	67.60	134.00	100.80	89.75	84.20	78.65	74.10
1.1250	1 1/8	-	-	-	-	-	350636	350736	350836	350936	81.50	147.90	114.70	103.60	98.20	92.55	88.00
1.1875	1 3/16	-	-	-	-	-	350638	350738	350838	350938	84.00	150.40	117.20	106.10	100.70	95.05	90.50
1.2500	1 1/4	-	-	-	-	-	350640	350740	350840	350940	88.55	154.95	121.75	110.65	105.25	99.60	95.05
1.3125	1 5/16	-	-	-	-	-	-	350742	350842	350942	93.20	159.60	126.40	115.35	109.90	104.25	99.70
1.3750	1 3/8	-	-	-	-	-	350644	350744	350844	350944	101.75	168.30	135.10	124.00	118.50	112.95	108.40
1.4375	1 7/16	-	-	-	-	-	-	350746	350846	350946	102.95	169.35	136.15	125.10	119.70	114.05	109.50
1.5000	1 1/2	-	-	-	-	-	-	-	350848	350948	104.25	170.80	137.60	126.50	121.00	115.45	110.90
1.5625	1 9/16	-	-	-	-	-	-	-	350850	350950	105.55	172.10	138.90	127.80	122.30	116.75	112.20
1.6250	1 5/8	-	-	-	-	-	-	-	-	350952	106.65	173.05	139.85	128.80	123.35	117.70	113.15
1.6875	1 11/16	-	-	-	-	-	-	-	-	350954	108.05	174.45	141.25	130.20	124.80	119.15	114.60
1.7500	1 3/4	-	-	-	-	-	-	-	350856	350956	109.80	176.10	142.90	131.85	126.40	120.75	116.20
1.8750	1 7/8	-	-	-	-	-	-	-	-	350960	132.25	198.75	165.55	154.50	148.95	143.45	138.90
2.0000	2	-	-	-	-	-	-	-	-	350964	132.25	198.75	165.55	154.50	148.95	143.45	138.90

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	5/16	3	2 7/8	357316	357416	\$153.35	.4721 - .5030	\$227.20	\$190.30	\$177.95	\$171.90	\$165.70	\$160.55
.5625	9/16	.2188	.1875	1	5/16	3	2 7/8	357318	357418	153.35	.5341 - .5660	227.20	190.30	177.95	171.90	165.70	160.55
.6250	5/8	.2188	.1875	1	5/16	3	2 7/8	357320	357420	153.35	.5971 - .6280	227.20	190.30	177.95	171.90	165.70	160.55
.6875	11/16	.2969	.2500	1	5/16	3	2 7/8	357322	357422	144.10	.6591 - .6910	217.95	181.05	168.75	162.65	156.50	151.35
.7500	3/4	.2969	.2500	1	5/16	3	2 7/8	357324	357424	144.10	.7221 - .7530	217.95	181.05	168.75	162.65	156.50	151.35
.8125	13/16	.2969	.2500	1	5/16	4	2 7/8	357326	357426	144.10	.7841 - .8160	217.95	181.05	168.75	162.65	156.50	151.35
.8750	7/8	.2969	.2500	1	5/16	4	2 7/8	357328	357428	144.10	.8471 - .8780	217.95	181.05	168.75	162.65	156.50	151.35
.9375	15/16	.2969	.2500	1	5/16	4	2 7/8	357330	357430	147.35	.9091 - .9410	221.20	184.30	172.00	165.90	159.75	154.65
1.0000	1	.2969	.2500	1	5/16	4	2 7/8	357332	357432	150.10	.9721 - 1.0030	223.85	187.05	174.65	168.60	162.40	157.30
1.0625	1 1/16	.2969	.2500	1	5/16	4	2 7/8	357334	357434	165.90	1.0031 - 1.0660	239.65	202.85	190.55	184.45	178.25	173.20
1.0625	1 1/16	.3594	.3125	2	7/8	4	3	357335	357435	175.25	1.0031 - 1.0660	249.10	212.20	199.90	193.80	187.60	182.55
1.1250	1 1/8	.2969	.2500	1	5/16	4	2 7/8	357336	357436	165.90	1.0661 - 1.1280	239.65	202.85	190.55	184.45	178.25	173.20
1.1250	1 1/8	.3594	.3125	2	7/8	4	3	357337	357437	175.25	1.0661 - 1.1280	249.10	212.20	199.90	193.80	187.60	182.55
1.1875	1 3/16	.3594	.3125	2	7/8	4	3	357338	357438	181.70	1.1281 - 1.1905	255.55	218.65	206.35	200.25	194.10	189.00
1.2500	1 1/4	.3594	.3125	2	7/8	4	3	357340	357440	181.70	1.1906 - 1.2530	255.55	218.65	206.35	200.25	194.10	189.00
1.3125	1 5/16	.3594	.3125	2	7/8	4	3	357342	357442	184.60	1.2531 - 1.3155	258.45	221.55	209.25	203.15	197.00	191.90
1.3750	1 3/8	.3594	.3125	2	7/8	4	3	357344	357444	184.60	1.3156 - 1.3780	258.45	221.55	209.25	203.15	197.00	191.90
1.4375	1 7/16	.3594	.3125	2	7/8	4	3	357346	357446	193.90	1.3781 - 1.4405	267.70	230.85	218.45	212.45	206.20	201.10
1.5000	1 1/2	.3594	.3125	2	7/8	4	3	357348	357448	203.45	1.4406 - 1.5030	277.20	240.40	228.00	221.95	215.75	210.65
1.5625	1 5/8	.3594	.3125	2	7/8	4	3	357350	357450	218.75	1.5031 - 1.5660	292.55	255.70	243.40	237.30	231.15	226.00
1.6250	1 3/4	.3594	.3125	2	7/8	4	3	357352	357452	228.30	1.5661 - 1.6280	302.15	265.25	252.95	246.85	240.70	235.60
1.6875	1 11/16	.3594	.3125	2	7/8	4	3	357354	357454	237.65	1.6281 - 1.6910	311.50	274.60	262.30	256.20	250.05	244.95
1.7500	1 3/4	.3594	.3125	2	7/8	4	3	357356	357456	250.35	1.6911 - 1.7530	324.10	287.25	274.90	268.85	262.65	257.55
1.7500	1 3/4	.4844	.4375	3	1 1/4	6	3 1/16	357357	357457	284.95	1.6911 - 1.7530	358.75	321.90	309.55	303.50	297.30	292.20
1.8750	1 7/8	.4844	.4375	3	1 1/4	6	3 1/16	357360	357460	284.95	1.8161 - 1.8780	358.75	321.90	309.55	303.50	297.30	292.20
2.0000	2	.4844	.4375	3	1 1/4	6	3 1/16	357364	357464	322.45	1.9411 - 2.0030	396.25	359.40	347.05	341.00	334.80	329.65
2.1250	2 1/8	.4844	.4375	3	1 1/4	6	3 1/16	357368	357468	331.45	2.0661 - 2.1280	405.20	368.40	356.00	349.95	343.75	338.65
2.2500	2 1/4	.4844	.4375	3	1 1/4	6	3 1/16	357372	357472	344.05	2.1906 - 2.2530	417.90	381.00	368.70	362.60	356.45	351.35
2.3750	2 3/8	.4844	.4375	3	1 1/4	6	3 1/16	357376	357476	386.10	2.3156 - 2.3780	462.70	424.40	411.65	405.35	398.85	393.60
2.5000	2 1/2	.5625	.5000	3	1 1/4	6	3 1/16	357380	357480	415.20	2.4406 - 2.5030	491.80	453.55	440.75	434.45	428.05	422.75
2.7500	2 3/4	.5625	.5000	3	1 1/4	6	3 1/16	357388	357488	460.85	2.6911 - 2.7530	537.45	499.20	486.40	480.10	473.70	468.40
3.0000	3	.5625	.5000	3	1 1/4	6	3 1/16	357396	357496	486.95	2.9411 - 3.0030	563.55	525.30	512.50	506.20	499.80	494.50

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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 41).



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

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

Body length = 1 ¼" thru 1.9410" tool diameter.

= 1 ½" 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	FRACTION										1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.5000	½	.2188	.1875	1	3	2 ⅞	357516	357616	186.40	.4721 - .5030	\$257.40	\$221.95	\$210.05	\$204.20	\$198.25	\$193.35
.5625	⅝	.2188	.1875	1	3	2 ⅞	357518	357618	186.40	.5341 - .5660	257.40	221.95	210.05	204.20	198.25	193.35
.6250	¾	.2188	.1875	1	3	2 ⅞	357520	357620	186.40	.5971 - .6280	257.40	221.95	210.05	204.20	198.25	193.35
.6875	⅞	.2188	.1875	1	3	2 ⅞	357522	357622	186.40	.6591 - .6910	257.40	221.95	210.05	204.20	198.25	193.35
.7500	¾	.2969	.2500	2	4	2 ⅞	357524	357624	174.75	.7221 - .7530	245.70	210.30	198.40	192.55	186.60	181.70
.8125	13/16	.2969	.2500	2	4	2 ⅞	357526	357626	174.75	.7841 - .8160	245.70	210.30	198.40	192.55	186.60	181.70
.8750	7/8	.2969	.2500	2	4	2 ⅞	357528	357628	174.75	.8471 - .8780	245.70	210.30	198.40	192.55	186.60	181.70
.9375	15/16	.2969	.2500	2	4	2 ⅞	357530	357630	168.50	.9091 - .9410	239.50	204.05	192.20	186.30	180.40	175.50
1.0000	1	.3594	.3125	2	4	2 ⅞	357532	357632	168.50	.9721 - 1.0030	239.50	204.05	192.20	186.30	180.40	175.50
1.0625	1 1/16	.3594	.3125	2	4	2 ⅞	357534	357634	168.50	1.0031 - 1.0660	239.50	204.05	192.20	186.30	180.40	175.50
1.1250	1 1/8	.3594	.3125	2	4	2 ⅞	357536	357636	168.50	1.0661 - 1.1280	239.50	204.05	192.20	186.30	180.40	175.50
1.1875	1 3/16	.3594	.3125	2	4	2 ⅞	357538	357638	174.75	1.1281 - 1.1905	245.70	210.30	198.40	192.55	186.60	181.70
1.2500	1 ¼	.3594	.3125	2	4	2 ⅞	357540	357640	174.75	1.1906 - 1.2530	245.70	210.30	198.40	192.55	186.60	181.70
1.3125	1 5/16	.3594	.3125	2	4	2 ⅞	357542	357642	177.50	1.2531 - 1.3155	248.50	213.05	201.15	195.30	189.35	184.45
1.3750	1 3/8	.3594	.3125	2	4	2 ⅞	357544	357644	195.60	1.3156 - 1.3780	266.55	231.15	219.25	213.40	207.45	202.55
1.4375	1 7/16	.3594	.3125	2	4	2 ⅞	357546	357646	213.60	1.3781 - 1.4405	284.55	249.15	237.30	231.45	225.50	220.50
1.5000	1 ½	.3594	.3125	2	4	2 ⅞	357548	357648	231.60	1.4406 - 1.5030	302.60	267.10	255.25	249.40	243.45	238.55
1.5625	1 5/8	.4844	.4375	3	6	3 3/16	357550	357650	246.65	1.5031 - 1.5660	317.60	282.10	270.25	264.45	258.50	253.60
1.6250	1 5/8	.4844	.4375	3	6	3 3/16	357552	357652	276.70	1.5661 - 1.6280	347.65	312.25	300.35	294.50	288.55	283.60
1.6875	1 11/16	.4844	.4375	3	6	3 3/16	357554	357654	300.65	1.6281 - 1.6910	371.65	336.20	324.35	318.45	312.55	307.65
1.7500	1 ¾	.4844	.4375	3	6	3 3/16	357556	357656	324.70	1.6911 - 1.7530	395.65	360.25	348.35	342.50	336.55	331.65
1.8125	1 13/16	.4844	.4375	3	6	3 3/16	357558	357658	342.90	1.7531 - 1.8160	413.90	378.40	366.55	360.70	354.75	349.85
1.8750	1 7/8	.4844	.4375	3	6	3 3/16	357560	357660	360.75	1.8161 - 1.8780	431.75	396.30	384.45	378.55	372.65	367.75
1.9375	1 15/16	.4844	.4375	3	6	3 3/16	357562	357662	379.00	1.8781 - 1.9410	449.95	414.50	402.60	396.80	390.90	385.90
2.0000	2	.5625	.5000	4	6	3 3/4	357564	357664	396.90	1.9411 - 2.0030	467.85	432.45	420.55	414.70	408.75	403.80
2.1250	2 1/8	.5625	.5000	4	6	3 3/4	357568	357668	408.90	2.0661 - 2.1280	479.95	444.45	432.60	426.70	420.80	415.90
2.2500	2 ¼	.5625	.5000	4	6	3 3/4	357572	357672	420.70	2.1906 - 2.2530	491.65	456.25	444.40	438.50	432.60	427.70
2.3750	2 3/8	.5625	.5000	4	6	3 3/4	357576	357676	452.45	2.3156 - 2.3780	526.05	489.35	477.00	470.95	464.75	459.70
2.5000	2 ½	.5625	.5000	4	6	3 3/4	357580	357680	468.25	2.4406 - 2.5030	541.95	505.10	492.80	486.70	480.55	475.50
2.7500	2 ¾	.5625	.5000	4	6	3 3/4	357588	357688	493.10	2.6911 - 2.7530	566.70	529.90	517.60	511.60	505.45	500.35
3.0000	3	.5625	.5000	4	6	3 3/4	357596	357696	517.90	2.9411 - 3.0030	591.50	554.80	542.45	536.40	530.20	525.15

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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 74) or Type 3459 (page 90) 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 56.

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	\$80.60	\$59.55	\$52.40	\$49.15	\$45.45	\$42.65
.0938	3/32*	.0880	4	3/4	3	-	380006	\$38.50	.0891 - .0970	80.60	59.55	52.40	49.15	45.45	42.65
.1094	7/64*	.0943	4	7/8	3 1/2	-	380007	38.50	.0971 - .1120	80.60	59.55	52.40	49.15	45.45	42.65
.1250	1/8*	.1099	4	7/8	3 1/2	380108	380008	38.50	.1121 - .1280	80.60	59.55	52.40	49.15	45.45	42.65
.1406	9/64*	.1255	4	7/8	3 1/2	380109	380009	44.05	.1281 - .1435	86.10	65.05	58.00	54.65	51.00	48.15
.1562	5/32*	.1411	4	1	4	380110	380010	45.30	.1436 - .1590	87.40	66.35	59.20	55.85	52.25	49.45
.1719	11/64*	.1567	4	1	4	380111	380011	51.10	.1591 - .1750	93.10	72.05	65.05	61.65	58.05	55.20
.1875	3/16*	.1724	4	1 1/8	4 1/2	380112	380012	52.15	.1751 - .1910	94.25	73.20	66.10	62.75	59.15	56.35
.2031	13/64	.1880	6	1 1/4	5	380113	380013	55.60	-	-	-	-	-	-	-
.2188	7/32	.1880	6	1 1/4	5	380114	380014	55.60	.1911 - .2210	97.70	76.65	69.55	66.20	62.55	59.80
.2344	15/64	.2193	6	1 1/2	6	380115	380015	59.15	-	-	-	-	-	-	-
.2500	1/4	.2193	6	1 1/2	6	380116	380016	59.15	.2211 - .2530	101.25	80.20	73.05	69.80	66.10	63.30
.2656	17/64	.2505	6	1 1/2	6	380117	380017	63.65	-	-	-	-	-	-	-
.2812	9/32	.2505	6	1 1/2	6	380118	380018	63.65	.2531 - .2840	105.65	84.60	77.55	74.20	70.60	67.75
.2969	19/64	.2817	6	1 5/8	6	380119	380019	66.20	-	-	-	-	-	-	-
.3125	5/16	.2817	6	1 5/8	6	380120	380020	66.20	.2841 - .3150	108.25	87.20	80.20	76.80	73.20	70.35
.3281	21/64	.3130	6	1 5/8	6	380121	380021	70.75	-	-	-	-	-	-	-
.3438	11/32	.3130	6	1 5/8	6	380122	380022	70.75	.3151 - .3470	112.85	91.75	84.70	81.35	77.70	74.95
.3594	23/64	.3443	6	1 3/4	7	380123	380023	76.15	-	-	-	-	-	-	-
.3750	3/8	.3443	6	1 3/4	7	380124	380024	76.15	.3471 - .3780	118.25	97.15	90.10	86.75	83.15	80.35
.3906	25/64	.3755	6	1 3/4	7	380125	380025	87.05	-	-	-	-	-	-	-
.4062	13/32	.3755	6	1 3/4	7	380126	380026	87.05	.3781 - .4090	129.05	108.05	101.00	97.60	94.00	91.15
.4219	27/64	.4067	6	1 3/4	7	380127	380027	92.45	-	-	-	-	-	-	-
.4375	7/16	.4067	6	1 3/4	7	380128	380028	92.45	.4091 - .4410	134.50	113.45	106.40	103.05	99.45	96.55
.4531	29/64	.4380	6	1 3/4	8	380129	380029	98.05	-	-	-	-	-	-	-
.4688	15/32	.4380	6	1 3/4	8	380130	380030	98.05	.4411 - .4720	140.05	119.00	111.95	108.60	105.00	102.15
.4844	31/64	.4693	6	1 3/4	8	380131	380031	105.25	-	-	-	-	-	-	-
.5000	1/2	.4693	6	1 3/4	8	380132	380032	105.25	.4721 - .5030	147.35	126.20	119.15	115.80	112.20	109.40
.5156	33/64	.5005	6	1 7/8	9	380133	380033	135.70	-	-	-	-	-	-	-
.5312	17/32	.5005	6	1 7/8	9	380134	380034	135.70	.5031 - .5340	177.70	156.65	149.65	146.25	142.65	139.80
.5469	35/64	.5005	6	1 7/8	9	380135	380035	160.20	-	-	-	-	-	-	-
.5625	9/16	.5005	6	1 7/8	9	380136	380036	160.20	.5341 - .5660	202.30	181.15	174.10	170.75	167.15	164.35
.5781	37/64	.5630	6	1 7/8	9	380137	380037	181.80	-	-	-	-	-	-	-
.5938	19/32	.5630	6	1 7/8	9	380138	380038	181.80	.5661 - .5970	223.85	202.80	195.75	192.40	188.80	185.90
.6094	39/64	.5630	6	1 7/8	9	380139	380039	183.85	-	-	-	-	-	-	-
.6250	5/8	.5630	6	1 7/8	9	380140	380040	183.85	.5971 - .6280	225.90	204.85	197.80	194.45	190.85	187.95

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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 56.

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	\$46.95	.1121 - .1280	\$89.05	\$68.00	\$60.85	\$57.50	\$53.90	\$51.10
.1406	9/64*	.1255	4	7/8	3 1/2	381109	381009	382109	382009	53.65	.1281 - .1435	95.75	74.60	67.55	64.20	60.60	57.80
.1562	5/32*	.1411	4	1	4	381110	381010	382110	382010	55.30	.1436 - .1590	97.40	76.25	69.20	65.85	62.25	59.45
.1719	11/64*	.1567	4	1	4	381111	381011	382111	382011	62.35	.1591 - .1750	104.40	83.30	76.25	72.90	69.30	66.50
.1875	3/16*	.1724	4	1 1/8	4 1/2	381112	381012	382112	382012	63.65	.1751 - .1910	105.65	84.60	77.55	74.20	70.60	67.75
.2031	13/64	.1880	6	1 1/4	5	381113	381013	382113	382013	67.75	-	-	-	-	-	-	-
.2188	7/32	.1880	6	1 1/4	5	381114	381014	382114	382014	67.75	.1911 - .2210	109.85	88.80	81.75	78.40	74.70	71.90
.2344	15/64	.2193	6	1 1/2	6	381115	381015	382115	382015	72.15	-	-	-	-	-	-	-
.2500	1/4	.2193	6	1 1/2	6	381116	381016	382116	382016	72.15	.2211 - .2530	114.15	93.10	86.10	82.70	79.10	76.25
.2656	17/64	.2505	6	1 1/2	6	381117	381017	382117	382017	77.55	-	-	-	-	-	-	-
.2812	9/32	.2505	6	1 1/2	6	381118	381018	382118	382018	77.55	.2531 - .2840	119.65	98.55	91.50	88.10	84.50	81.75
.2969	19/64	.2817	6	1 5/8	6	381119	381019	382119	382019	80.75	-	-	-	-	-	-	-
.3125	5/16	.2817	6	1 5/8	6	381120	381020	382120	382020	80.75	.2841 - .3150	122.75	101.70	94.70	91.30	87.70	84.85
.3281	21/64	.3130	6	1 5/8	6	381121	381021	382121	382021	86.25	-	-	-	-	-	-	-
.3438	11/32	.3130	6	1 5/8	6	381122	381022	382122	382022	86.25	.3151 - .3470	128.35	107.20	100.15	96.80	93.20	90.40
.3594	23/64	.3443	6	1 3/4	7	381123	381023	382123	382023	92.85	-	-	-	-	-	-	-
.3750	3/8	.3443	6	1 3/4	7	381124	381024	382124	382024	92.85	.3471 - .3780	134.90	113.85	106.80	103.45	99.85	96.95
.3906	25/64	.3755	6	1 3/4	7	381125	381025	382125	382025	106.15	-	-	-	-	-	-	-
.4062	13/32	.3755	6	1 3/4	7	381126	381026	382126	382026	106.15	.3781 - .4090	148.15	127.10	120.05	116.70	113.10	110.25
.4219	27/64	.4067	6	1 3/4	7	381127	381027	382127	382027	112.70	-	-	-	-	-	-	-
.4375	7/16	.4067	6	1 3/4	7	381128	381028	382128	382028	112.70	.4091 - .4410	154.70	133.65	126.60	123.25	119.65	116.80
.4531	29/64	.4380	6	1 3/4	8	381129	381029	382129	382029	119.55	-	-	-	-	-	-	-
.4688	15/32	.4380	6	1 3/4	8	381130	381030	382130	382030	119.55	.4411 - .4720	161.60	140.55	133.50	130.15	126.55	123.65
.4844	31/64	.4693	6	1 3/4	8	381131	381031	382131	382031	128.25	-	-	-	-	-	-	-
.5000	1/2	.4693	6	1 3/4	8	381132	381032	382132	382032	128.25	.4721 - .5030	170.25	149.20	142.20	138.80	135.20	132.35
.5156	33/64	.5005	6	1 7/8	9	381133	381033	382133	382033	165.35	-	-	-	-	-	-	-
.5312	17/32	.5005	6	1 7/8	9	381134	381034	382134	382034	165.35	.5031 - .5340	207.45	186.30	179.30	175.90	172.30	169.55
.5469	35/64	.5005	6	1 7/8	9	381135	381035	382135	382035	195.35	-	-	-	-	-	-	-
.5625	9/16	.5005	6	1 7/8	9	381136	381036	382136	382036	195.35	.5341 - .5660	237.35	216.30	209.25	205.90	202.30	199.45
.5781	37/64	.5630	6	1 7/8	9	381137	381037	382137	382037	221.60	-	-	-	-	-	-	-
.5938	19/32	.5630	6	1 7/8	9	381138	381038	382138	382038	221.60	.5661 - .5970	263.65	242.60	235.55	232.20	228.60	225.70
.6094	39/64	.5630	6	1 7/8	9	381139	381039	382139	382039	224.15	-	-	-	-	-	-	-
.6250	5/8	.5630	6	1 7/8	9	381140	381040	382140	382040	224.15	.5971 - .6280	266.25	245.20	238.10	234.75	231.10	228.35

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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 56.

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	\$80.60	\$59.55	\$52.40	\$49.15	\$45.45	\$42.65
.0938	3/32	.0880	4	3/4	3	-	380006	\$38.50	.0891 - .0970	80.60	59.55	52.40	49.15	45.45	42.65
.1094	7/64	.0943	4	7/8	3 1/2	-	380007	38.50	.0971 - .1120	80.60	59.55	52.40	49.15	45.45	42.65
.1250	1/8	.1099	4	7/8	3 1/2	380108	380008	38.50	.1121 - .1280	80.60	59.55	52.40	49.15	45.45	42.65
.1406	9/64	.1255	4	7/8	3 1/2	380109	380009	44.05	.1281 - .1435	86.10	65.05	58.00	54.65	51.00	48.15
.1562	5/32	.1411	4	1	4	380110	380010	45.30	.1436 - .1590	87.40	66.35	59.20	55.85	52.25	49.45
.1719	11/64	.1567	4	1	4	380111	380011	51.10	.1591 - .1750	93.10	72.05	65.05	61.65	58.05	55.20
.1875	3/16	.1724	4	1 1/8	4 1/2	380112	380012	52.15	.1751 - .1910	94.25	73.20	66.10	62.75	59.15	56.35

*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 sold 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 56.

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	\$83.85	\$52.15	\$41.60	\$36.60	\$31.20	\$26.95	\$20.70
.0661 - .0740	.0650	4	1/2	1 3/4	-	380245	84.10	52.40	41.85	36.85	31.45	27.20	20.95
.0741 - .0810	.0730	4	1/2	1 3/4	-	380205	84.20	52.60	41.95	37.00	31.55	27.25	21.05
.0811 - .0890	.0800	4	1/2	2	-	380255	84.75	53.15	42.60	37.60	32.20	27.85	21.70
.0891 - .0970	.0880	4	1/2	2	-	380206	85.25	53.55	43.00	38.00	32.60	28.25	22.10
.0971 - .1120	.0943	4	5/8	2 1/4	380307	380207	85.60	53.90	43.35	38.35	32.90	28.65	22.45
.1121 - .1280	.1099	4	5/8	2 1/4	380308	380208	87.05	55.35	44.80	39.80	34.40	30.15	23.90
.1281 - .1435	.1255	4	3/4	2 1/2	380309	380209	87.70	56.10	45.45	40.55	35.05	30.80	24.55
.1436 - .1590	.1411	4	3/4	2 1/2	380310	380210	89.20	57.50	46.95	41.95	36.55	32.25	26.05
.1591 - .1750	.1567	4	7/8	2 3/4	380311	380211	92.55	60.85	50.30	45.30	39.90	35.65	29.40
.1751 - .1910	.1724	4	7/8	2 3/4	380312	380212	94.75	63.15	52.60	47.60	42.10	37.85	31.60
.1911 - .2210	.1880	6	1	3	380314	380214	98.70	67.10	56.50	51.50	46.10	41.75	35.65
.2211 - .2530	.2193	6	1	3	380316	380216	105.40	73.80	63.25	58.25	52.85	48.50	42.35
.2531 - .2840	.2505	6	1 1/8	3 1/4	380318	380218	113.25	81.55	71.00	66.00	60.60	56.35	50.10
.2841 - .3150	.2817	6	1 1/8	3 1/4	380320	380220	121.85	90.15	79.60	74.60	69.20	64.95	58.70
.3151 - .3470	.3130	6	1 1/4	3 1/2	380322	380222	134.65	103.05	92.45	87.45	82.05	77.70	71.60
.3471 - .3780	.3443	6	1 1/4	3 1/2	380324	380224	136.35	104.75	94.20	89.20	83.80	79.45	73.30
.3781 - .4090	.3755	6	1 3/8	3 3/4	380326	380226	147.65	115.95	105.40	100.40	95.00	90.75	84.50
.4091 - .4410	.4067	6	1 3/8	3 3/4	380328	380228	148.90	117.20	106.65	101.65	96.25	91.90	85.75
.4411 - .4720	.4380	6	1 1/2	4	380330	380230	158.00	126.30	115.70	110.75	105.30	101.05	94.85
.4721 - .5150	.4693	6	1 1/2	4	380332	380232	166.75	135.15	124.50	119.55	114.10	109.85	103.60

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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 56.

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	\$46.95	.1121 - .1280	\$89.05	\$68.00	\$60.85	\$57.50	\$53.90	\$51.10
.1406	9/64	.1255	4	7/8	3 1/2	381109	381009	382109	382009	53.65	.1281 - .1435	95.75	74.60	67.55	64.20	60.60	57.80
.1562	5/32	.1411	4	1	4	381110	381010	382110	382010	55.30	.1436 - .1590	97.40	76.25	69.20	65.85	62.25	59.45
.1719	11/64	.1567	4	1	4	381111	381011	382111	382011	62.35	.1591 - .1750	104.40	83.30	76.25	72.90	69.30	66.50
.1875	3/16	.1724	4	1 1/8	4 1/2	381112	381012	382112	382012	63.65	.1751 - .1910	105.65	84.60	77.55	74.20	70.60	67.75

*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".

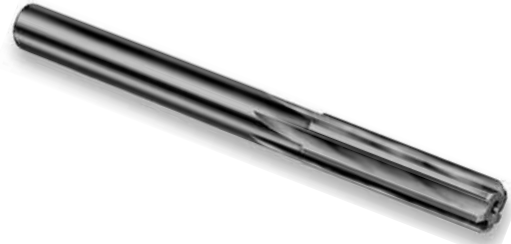
For closer tool diameter tolerance pricing, see page 56.

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	\$87.80	\$56.20	\$45.55	\$40.60	\$35.15	\$30.90	\$24.65
.1121 - .1280	.1099	4	5/8	2 1/4	381308	381208	382308	382208	89.45	57.80	47.15	42.25	36.75	32.50	26.30
.1281 - .1435	.1255	4	3/4	2 1/2	381309	381209	382309	382209	90.15	58.55	48.00	43.00	37.60	33.25	27.10
.1436 - .1590	.1411	4	3/4	2 1/2	381310	381210	382310	382210	91.80	60.20	49.65	44.65	39.25	34.90	28.75
.1591 - .1750	.1567	4	7/8	2 3/4	381311	381211	382311	382211	95.60	63.90	53.30	48.30	42.90	38.55	32.45
.1751 - .1910	.1724	4	7/8	2 3/4	381312	381212	382312	382212	97.95	66.35	55.70	50.80	45.30	41.05	34.80
.1911 - .2210	.1880	6	1	3	381314	381214	382314	382214	102.20	70.60	60.05	55.05	49.65	45.30	39.15
.2211 - .2530	.2193	6	1	3	381316	381216	382316	382216	109.75	78.05	67.50	62.50	57.10	52.85	46.60
.2531 - .2840	.2505	6	1 1/8	3 1/4	381318	381218	382318	382218	118.35	86.65	76.10	71.10	65.70	61.40	55.20
.2841 - .3150	.2817	6	1 1/8	3 1/4	381320	381220	382320	382220	127.70	96.05	85.50	80.50	75.10	70.75	64.60
.3151 - .3470	.3130	6	1 1/4	3 1/2	381322	381222	382322	382222	141.75	110.15	99.60	94.60	89.20	84.85	78.70
.3471 - .3780	.3443	6	1 1/4	3 1/2	381324	381224	382324	382224	143.75	112.05	101.45	96.50	91.05	86.75	80.60
.3781 - .4090	.3755	6	1 3/8	3 3/4	381326	381226	382326	382226	147.65	115.95	105.40	100.40	95.00	90.75	84.50
.4091 - .4410	.4067	6	1 3/8	3 3/4	381328	381228	382328	382228	148.90	117.20	106.65	101.65	96.25	91.90	85.75
.4411 - .4720	.4380	6	1 1/2	4	381330	381230	382330	382230	158.00	126.30	115.70	110.75	105.30	101.05	94.85
.4721 - .5150	.4693	6	1 1/2	4	381332	381232	382332	382232	166.75	135.15	124.50	119.55	114.10	109.85	103.60

SOLID CARBIDE COOLANT FED CHUCKING REAMERS

TYPE 3807 - STRAIGHT SHANK - STRAIGHT FLUTES - BLIND HOLES - FOR NON-FERROUS
TYPE 3806 - STRAIGHT SHANK - STRAIGHT FLUTES - BLIND HOLES - FOR CAST IRON & STEEL

Short length series solid carbide coolant fed chucking reamers.
 Center coolant feeding hole for flushing chips back towards shank.



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

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

For closer tool diameter tolerance pricing, see page 56.

CENTER FED COOLANT

DECIMAL SIZE RANGE	MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3807 EDP NO.	C.I./STEEL TYPE 3806 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
			FLUTE	OAL			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.1121 - .1280	.1099	4	5/8	2 1/4	380708	380608	\$149.70	\$129.65	\$123.00	\$119.75	\$116.30	\$113.60	\$109.65
.1281 - .1435	.1255	4	3/4	2 1/2	380709	380609	150.80	130.70	124.10	120.80	117.35	114.65	110.75
.1436 - .1590	.1411	4	3/4	2 1/2	380710	380610	151.45	131.35	124.75	121.45	118.00	115.30	111.40
.1591 - .1750	.1567	4	7/8	2 3/4	380711	380611	152.90	132.85	126.20	122.95	119.50	116.80	112.85
.1751 - .1910	.1724	4	7/8	2 3/4	380712	380612	158.95	138.90	132.25	129.00	125.55	122.85	118.90
.1911 - .2210	.1880	6	1	3	380714	380614	161.35	141.30	134.65	131.35	127.95	125.25	121.30
.2211 - .2530	.2193	6	1	3	380716	380616	164.20	144.15	137.50	134.25	130.80	128.10	124.15
.2531 - .2840	.2505	6	1 1/8	3 1/4	380718	380618	168.90	148.80	142.20	138.90	135.45	132.75	128.85
.2841 - .3150	.2817	6	1 1/8	3 1/4	380720	380620	172.80	152.75	146.10	142.85	139.40	136.70	132.75
.3151 - .3470	.3130	6	1 1/4	3 1/2	380722	380622	177.55	157.50	150.85	147.60	144.15	141.45	137.50
.3471 - .3780	.3443	6	1 1/4	3 1/2	380724	380624	182.95	162.90	156.25	153.00	149.55	146.85	142.90
.3781 - .4090	.3755	6	1 3/8	3 3/4	380726	380626	191.50	171.40	164.80	161.50	158.05	155.35	151.45

TYPE 3809 - STRAIGHT SHANK - STRAIGHT FLUTES - THROUGH HOLES - FOR NON-FERROUS
TYPE 3808 - STRAIGHT SHANK - STRAIGHT FLUTES - THROUGH HOLES - FOR CAST IRON & STEEL

Short length series solid carbide coolant fed chucking reamers.
 Coolant feeding hole in each flute for flushing chips forward through the hole being reamed.



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

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

For closer tool diameter tolerance pricing, see page 56.

FLUTE FED COOLANT

DECIMAL SIZE RANGE	MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3809 EDP NO.	C.I./STEEL TYPE 3808 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
			FLUTE	OAL			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.1121 - .1280	.1099	4	5/8	2 1/4	380908	380808	\$211.90	\$191.80	\$185.20	\$181.90	\$178.45	\$175.75	\$171.85
.1281 - .1435	.1255	4	3/4	2 1/2	380909	380809	201.25	181.15	174.55	171.25	167.80	165.10	161.20
.1436 - .1590	.1411	4	3/4	2 1/2	380910	380810	213.90	193.85	187.20	183.95	180.50	177.80	173.85
.1591 - .1750	.1567	4	7/8	2 3/4	380911	380811	215.80	195.75	189.10	185.85	182.40	179.70	175.75
.1751 - .1910	.1724	4	7/8	2 3/4	380912	380812	217.10	197.05	190.40	187.15	183.70	181.00	177.05
.1911 - .2210	.1880	6	1	3	380914	380814	260.95	240.85	234.25	230.95	227.50	224.80	220.90
.2211 - .2530	.2193	6	1	3	380916	380816	264.15	244.05	237.45	234.15	230.70	228.00	224.10
.2531 - .2840	.2505	6	1 1/8	3 1/4	380918	380818	269.80	249.70	243.10	239.80	236.35	233.65	229.75
.2841 - .3150	.2817	6	1 1/8	3 1/4	380920	380820	274.30	254.20	247.60	244.30	240.85	238.15	234.25
.3151 - .3470	.3130	6	1 1/4	3 1/2	380922	380822	291.75	271.65	265.05	261.75	258.30	255.60	251.70
.3471 - .3780	.3443	6	1 1/4	3 1/2	380924	380824	297.95	277.90	271.25	268.00	264.55	261.85	257.90
.3781 - .4090	.3755	6	1 3/8	3 3/4	380926	380826	308.10	288.05	281.40	278.15	274.70	272.00	268.05

SOLID CARBIDE COOLANT FED CHUCKING REAMERS

TYPE 3817 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR NON-FERROUS
TYPE 3816 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR CAST IRON & STEEL

Short length series solid carbide coolant fed chucking reamers.
 Center coolant feeding hole for flushing chips back towards shank.



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

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

For closer tool diameter tolerance pricing, see page 56.

CENTER FED COOLANT

DECIMAL SIZE RANGE	MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3817 EDP NO.	C.I./STEEL TYPE 3816 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
			FLUTE	OAL			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.1121 - .1280	.1099	4	5/8	2 1/4	381708	381608	\$153.50	\$133.40	\$126.80	\$123.50	\$120.05	\$117.35	\$113.45
.1281 - .1435	.1255	4	3/4	2 1/2	381709	381609	154.55	134.50	127.85	124.55	121.15	118.45	114.50
.1436 - .1590	.1411	4	3/4	2 1/2	381710	381610	155.20	135.15	128.50	125.25	121.80	119.10	115.15
.1591 - .1750	.1567	4	7/8	2 3/4	381711	381611	156.65	136.60	130.00	126.70	123.25	120.55	116.65
.1751 - .1910	.1724	4	7/8	2 3/4	381712	381612	162.75	142.65	136.05	132.75	129.30	126.60	122.70
.1911 - .2210	.1880	6	1	3	381714	381614	165.05	144.95	138.35	135.05	131.60	128.90	125.00
.2211 - .2530	.2193	6	1	3	381716	381616	167.90	147.85	141.20	137.90	134.50	131.80	127.85
.2531 - .2840	.2505	6	1 1/8	3 1/4	381718	381618	172.55	152.50	145.85	142.60	139.15	136.45	132.50
.2841 - .3150	.2817	6	1 1/8	3 1/4	381720	381620	176.50	156.45	149.80	146.50	143.10	140.40	136.45
.3151 - .3470	.3130	6	1 1/4	3 1/2	381722	381622	181.35	161.25	154.65	151.35	147.90	145.20	141.30
.3471 - .3780	.3443	6	1 1/4	3 1/2	381724	381624	187.80	167.75	161.10	157.80	154.40	151.70	147.75
.3781 - .4090	.3755	6	1 3/8	3 3/4	381726	381626	196.40	176.35	169.70	166.40	163.00	160.30	156.35

TYPE 3829 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - THROUGH HOLES - FOR NON-FERROUS
TYPE 3828 - STRAIGHT SHANK - LEFT SPIRAL FLUTES - THROUGH HOLES - FOR CAST IRON & STEEL

Short length series solid carbide coolant fed chucking reamers.
 Coolant feeding hole in each flute for flushing chips forward through the hole being reamed.



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

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

For closer tool diameter tolerance pricing, see page 56.

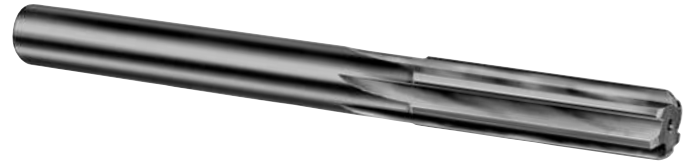
FLUTE FED COOLANT

DECIMAL SIZE RANGE	MAX. SHANK DIAM.	NO. OF FLTS.	LENGTH		NON-FERR. TYPE 3829 EDP NO.	C.I./STEEL TYPE 3828 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE						
			FLUTE	OAL			1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14	15+
.1121 - .1280	.1099	4	5/8	2 1/4	382908	382808	\$242.35	\$222.30	\$215.65	\$212.35	\$208.95	\$206.20	\$202.30
.1281 - .1435	.1255	4	3/4	2 1/2	382909	382809	243.65	223.60	216.95	213.70	210.25	207.55	203.60
.1436 - .1590	.1411	4	3/4	2 1/2	382910	382810	244.40	224.30	217.70	214.40	210.95	208.35	204.35
.1591 - .1750	.1567	4	7/8	2 3/4	382911	382811	246.10	226.05	219.40	216.15	212.70	210.00	206.05
.1751 - .1910	.1724	4	7/8	2 3/4	382912	382812	247.25	227.20	220.55	217.30	213.85	211.15	207.20
.1911 - .2210	.1880	6	1	3	382914	382814	319.75	299.65	293.05	289.75	286.30	283.60	279.70
.2211 - .2530	.2193	6	1	3	382916	382816	319.50	299.45	292.80	289.50	286.10	283.35	279.45
.2531 - .2840	.2505	6	1 1/8	3 1/4	382918	382818	325.05	305.00	298.35	295.10	291.65	288.95	285.00
.2841 - .3150	.2817	6	1 1/8	3 1/4	382920	382820	329.65	309.60	302.95	299.65	296.25	293.55	289.60
.3151 - .3470	.3130	6	1 1/4	3 1/2	382922	382822	347.00	326.95	320.30	317.05	313.60	310.90	306.95
.3471 - .3780	.3443	6	1 1/4	3 1/2	382924	382824	353.30	333.25	326.60	323.35	319.90	317.20	313.25
.3781 - .4090	.3755	6	1 3/8	3 3/4	382926	382826	363.65	343.55	336.95	333.65	330.20	327.50	323.60

SOLID CARBIDE CHUCKING REAMERS

TYPE 3804 - STRAIGHT SHANK STRAIGHT FLUTES - SHORT SERIES

For dimensional details for .0591" and above, see Types 3802/3803 on page 46.
For additional solid carbide reamer sizes (including wire #52-70), see page 51-54.
For reamer tolerances, see page 46. For closer tolerance pricing, see page 56.



TOOL DIAMETER					EDP NO.	PRICE EACH	TOOL DIAMETER					EDP NO.	PRICE EACH	TOOL DIAMETER					EDP NO.	PRICE EACH
DECIMAL	FRAC.	WIRE LETTER	mm	DECIMAL			FRAC.	WIRE LETTER	mm	DECIMAL	FRAC.			WIRE LETTER	mm	DECIMAL	FRAC.	WIRE LETTER		
.0312	*1/32			380402	\$25.05	.1457			3.7	3804037	\$33.60	.2480			6.3	3804063	\$57.65			
.0394			*1.0	3804010	23.90	.1470		26		38041470	34.15	.2500	1/4	E		380416	52.40			
.0433			*1.1	3804011	26.30	.1495		25		38041495	34.40	.2520			6.4	3804064	63.55			
.0469	*3/64			380403	26.55	.1496		3.8		3804038	36.10	.2559			6.5	3804065	63.45			
.0472			*1.2	3804012	26.55	.1520		24		38041520	34.40	.2570		F		38042570	63.45			
.0512			*1.3	3804013	26.55	.1535		3.9		3804039	35.85	.2598			6.6	3804066	66.60			
.0551			*1.4	3804014	26.55	.1540		23		38041540	35.85	.2610		G		38042610	63.45			
.0591			1.5	3804015	24.30	.1562	5/32			380410	33.90	.2638			6.7	3804067	66.60			
.0625	1/16			380404	25.05	.1570		22		38041570	37.00	.2656	17/64			380417	63.45			
.0630			1.6	3804016	27.20	.1575		4.0		3804040	33.90	.2660		H		38042660	63.45			
.0669			1.7	3804017	27.45	.1590		21		38041590	37.90	.2677			6.8	3804068	66.60			
.0670		51		38040670	27.45	.1610		20		38041610	38.50	.2717			6.9	3804069	66.60			
.0700		50		38040700	27.45	.1614		4.1		3804041	38.50	.2720		I		38042720	63.45			
.0709			1.8	3804018	27.45	.1654		4.2		3804042	38.65	.2756			7.0	3804070	58.00			
.0730		49		38040730	27.45	.1660		19		38041660	38.65	.2770		J		38042770	63.45			
.0748			1.9	3804019	27.45	.1693		4.3		3804043	39.15	.2795			7.1	3804071	72.30			
.0760		48		38040760	27.45	.1695		18		38041695	39.15	.2810		K		38042810	68.80			
.0781	3/64			380405	27.45	.1719	11/64			380411	39.80	.2812	9/32			380418	62.90			
.0785		47		38040785	27.50	.1730		17		38041730	39.80	.2835			7.2	3804072	78.15			
.0787			2.0	3804020	25.30	.1732		4.4		3804044	39.80	.2874			7.3	3804073	78.15			
.0810		46		38040810	27.50	.1770		16		38041770	40.80	.2900		L		38042900	74.45			
.0820		45		38040820	27.70	.1772		4.5		3804045	37.00	.2913			7.4	3804074	78.15			
.0827			2.1	3804021	27.70	.1800		15		38041800	41.05	.2950		M		38042950	74.45			
.0860		44		38040860	27.70	.1811		4.6		3804046	41.50	.2953			7.5	3804075	74.45			
.0866			2.2	3804022	27.70	.1820		14		38041820	41.60	.2969	19/64			380419	74.45			
.0890		43		38040890	28.15	.1850		13	4.7	3804047	41.85	.2992			7.6	3804076	81.50			
.0906			2.3	3804023	28.15	.1875	3/16			380412	40.20	.3020		N		38043020	77.65			
.0935		42		38040935	28.25	.1890		12	4.8	3804048	44.15	.3031			7.7	3804077	81.50			
.0938	3/32			380406	26.05	.1910		11		38041910	44.65	.3071			7.8	3804078	81.50			
.0945			2.4	3804024	28.25	.1929		4.9		3804049	44.65	.3110			7.9	3804079	81.50			
.0960		41		38040960	28.85	.1935		10		38041935	44.95	.3125	5/16			380420	70.95			
.0980		40		38040980	28.85	.1960		9		38041960	46.50	.3150			8.0	3804080	70.95			
.0984			2.5	3804025	26.30	.1969		5.0		3804050	42.50	.3160		O		38043160	81.50			
.0995		39		38040995	29.05	.1990		8		38041990	46.75	.3189			8.1	3804081	86.75			
.1015		38		38041015	29.05	.2008		5.1		3804051	48.25	.3228			8.2	3804082	86.75			
.1024			2.6	3804026	29.15	.2010		7		38042010	48.25	.3230		P		38043230	82.55			
.1040		37		38041040	30.90	.2031	13/64			380413	48.25	.3268			8.3	3804083	99.20			
.1063			2.7	3804027	29.30	.2040		6		38042040	48.25	.3281	21/64			380421	94.45			
.1065		36		38041065	29.30	.2047		5.2		3804052	48.25	.3307			8.4	3804084	99.20			
.1094	7/64			380407	30.30	.2055		5		38042055	48.25	.3320		Q		38043320	94.45			
.1100		35		38041100	30.30	.2087		5.3		3804053	48.25	.3346			8.5	3804085	94.45			
.1102			2.8	3804028	30.30	.2090		4		38042090	50.80	.3386			8.6	3804086	99.20			
.1110		34		38041110	30.70	.2126		5.4		3804054	48.25	.3390		R		38043390	94.45			
.1130		33		38041130	31.10	.2130		3		38042130	48.25	.3425			8.7	3804087	99.20			
.1142			2.9	3804029	31.10	.2165		5.5		3804055	44.15	.3438	11/32			380422	94.45			
.1160		32		38041160	31.10	.2188	7/32			380414	44.05	.3465			8.8	3804088	99.60			
.1181			3.0	3804030	28.85	.2205		5.6		3804056	53.80	.3480		S		38043480	94.85			
.1200		31		38041200	31.30	.2210		2		38042210	53.80	.3504			8.9	3804089	99.60			
.1220			3.1	3804031	31.30	.2244		5.7		3804057	55.85	.3543			9.0	3804090	87.15			
.1250	1/8			380408	28.85	.2280		1		38042280	56.60	.3580		T		38043580	95.25			
.1260			3.2	3804032	31.30	.2283		5.8		3804058	56.60	.3583			9.1	3804091	100.55			
.1285		30		38041285	31.35	.2323		5.9		3804059	56.60	.3594	23/64			380423	95.65			
.1299			3.3	3804033	31.35	.2340		A		38042340	56.60	.3622			9.2	3804092	101.80			
.1339			3.4	3804034	31.35	.2344	15/64			380415	56.60	.3661			9.3	3804093	101.80			
.1360		29		38041360	31.35	.2362		6.0		3804060	52.40	.3680		U		38043680	96.95			
.1378			3.5	3804035	29.15	.2380		B		38042380	57.65	.3701			9.4	3804094	102.40			
.1405		28		38041405	31.80	.2402		6.1		3804061	57.65	.3740			9.5	3804095	97.55			
.1406	9/64			380409	32.75	.2420		C		38042420	57.65	.3750	3/8			380424	89.25			
.1417			3.6	3804036	33.25	.2441		6.2		3804062	57.65	.3770		V		38043770	115.80			
.1440		27		38041440	33.25	.2460		D		38042460	57.65	.3780			9.6	3804096	121.70			

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SOLID CARBIDE DECIMAL SIZE CHUCKING REAMERS

**TYPE 3804 - SOLID CARBIDE - STRAIGHT FLUTES - SHORT LENGTH
STANDARD DECIMAL DIAMETER REAMERS (.0005" INCREMENTS)
THIS PAGE .0280" THRU .1475"**

Short length solid carbide head and shank. Tool geometry appropriate for material being machined. For fractional, wire and letter sizes, see page 50.



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

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

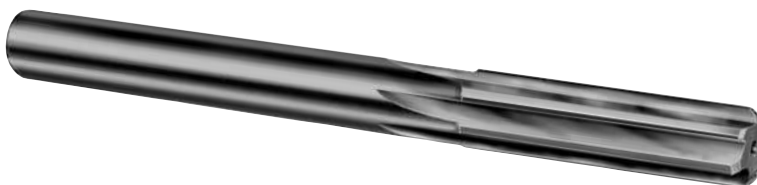
For closer tool diameter tolerance pricing, see page 56.

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
.0280	38040280	\$27.20	.0520	38040520	\$26.55	.0760	38040760	\$27.45	.1000	38041000	\$30.55	.1240	38041240	\$32.90
.0285	38040285	28.65	.0525	38040525	27.95	.0765	38040765	28.85	.1005	38041005	30.55	.1245	38041245	32.90
.0290	38040290	28.65	.0530	38040530	27.95	.0770	38040770	28.85	.1010	38041010	30.55	.1250	380408	28.85
.0295	38040295	27.20	.0535	38040535	27.95	.0775	38040775	28.85	.1015	38041015	29.05	.1255	38041255	32.90
.0300	38040300	28.65	.0540	38040540	27.95	.0780	38040780	28.85	.1020	38041020	30.70	.1260	3804032	31.30
.0305	38040305	28.65	.0545	38040545	27.95	.0785	38040785	27.50	.1025	38041025	30.90	.1265	38041265	33.00
.0310	38040310	27.20	.0550	38040550	26.55	.0790	38040790	28.90	.1030	38041030	30.90	.1270	38041270	33.00
.0315	3804008	27.20	.0555	38040555	27.95	.0795	38040795	28.90	.1035	38041035	30.90	.1275	38041275	33.00
.0320	38040320	27.20	.0560	38040560	27.95	.0800	38040800	28.90	.1040	38041040	30.90	.1280	38041280	31.35
.0325	38040325	28.65	.0565	38040565	27.95	.0805	38040805	28.90	.1045	38041045	30.90	.1285	38041285	31.35
.0330	38040330	27.20	.0570	38040570	27.95	.0810	38040810	27.50	.1050	38041050	30.90	.1290	38041290	33.00
.0335	38040335	27.20	.0575	38040575	27.95	.0815	38040815	29.05	.1055	38041055	30.90	.1295	38041295	33.00
.0340	38040340	27.70	.0580	38040580	27.95	.0820	38040820	27.70	.1060	38041060	30.90	.1300	38041300	33.00
.0345	38040345	27.70	.0585	38040585	27.95	.0825	38040825	29.05	.1065	38041065	29.30	.1305	38041305	33.00
.0350	38040350	26.30	.0590	38040590	24.30	.0830	38040830	29.05	.1070	38041070	31.35	.1310	38041310	33.00
.0355	38040355	27.70	.0595	38040595	26.55	.0835	38040835	29.05	.1075	38041075	31.35	.1315	38041315	33.00
.0360	38040360	26.30	.0600	38040600	28.65	.0840	38040840	29.05	.1080	38041080	31.35	.1320	38041320	33.00
.0365	38040365	27.70	.0605	38040605	28.65	.0845	38040845	29.05	.1085	38041085	31.80	.1325	38041325	33.00
.0370	38040370	26.30	.0610	38040610	27.20	.0850	38040850	29.05	.1090	38041090	31.80	.1330	38041330	33.00
.0375	38040375	27.70	.0615	38040615	28.65	.0855	38040855	29.05	.1095	38041095	31.80	.1335	38041335	33.00
.0380	38040380	26.30	.0620	38040620	28.65	.0860	38040860	27.70	.1100	38041100	30.30	.1340	38041340	33.00
.0385	38040385	27.70	.0625	380404	25.05	.0865	38040865	29.05	.1105	38041105	32.25	.1345	38041345	33.00
.0390	38040390	26.30	.0630	3804016	27.20	.0870	38040870	29.05	.1110	38041110	30.70	.1350	38041350	33.00
.0395	38040395	27.70	.0635	38040635	27.20	.0875	38040875	29.05	.1115	38041115	32.75	.1355	38041355	33.00
.0400	38040400	26.30	.0640	38040640	28.65	.0880	38040880	29.05	.1120	38041120	32.75	.1360	38041360	31.35
.0405	38040405	27.70	.0645	38040645	28.65	.0885	38040885	29.05	.1125	38041125	32.75	.1365	38041365	33.00
.0410	38040410	26.30	.0650	38040650	28.85	.0890	38040890	28.15	.1130	38041130	31.10	.1370	38041370	33.00
.0415	38040415	27.70	.0655	38040655	28.85	.0895	38040895	29.75	.1135	38041135	32.75	.1375	38041375	33.00
.0420	38040420	26.30	.0660	38040660	28.85	.0900	38040900	29.75	.1140	38041140	32.75	.1380	38041380	33.60
.0425	38040425	27.70	.0665	38040665	28.85	.0905	38040905	29.75	.1145	38041145	32.75	.1385	38041385	33.60
.0430	38040430	26.30	.0670	38040670	27.45	.0910	38040910	29.90	.1150	38041150	32.75	.1390	38041390	33.60
.0435	38040435	27.95	.0675	38040675	28.85	.0915	38040915	29.90	.1155	38041155	32.75	.1395	38041395	33.60
.0440	38040440	27.95	.0680	38040680	28.85	.0920	38040920	29.90	.1160	38041160	31.10	.1400	38041400	33.60
.0445	38040445	27.95	.0685	38040685	28.85	.0925	38040925	28.25	.1165	38041165	32.75	.1405	38041405	31.80
.0450	38040450	27.95	.0690	38040690	28.85	.0930	38040930	29.90	.1170	38041170	32.75	.1410	38041410	34.90
.0455	38040455	27.95	.0695	38040695	28.85	.0935	38040935	28.25	.1175	38041175	32.75	.1415	38041415	34.90
.0460	38040460	27.95	.0700	38040700	27.45	.0940	38040940	29.90	.1180	38041180	32.75	.1420	38041420	34.90
.0465	38040465	26.55	.0705	38040705	28.85	.0945	3804024	28.25	.1185	38041185	32.90	.1425	38041425	34.90
.0470	38040470	27.95	.0710	38040710	28.85	.0950	38040950	30.30	.1190	38041190	32.90	.1430	38041430	34.90
.0475	38040475	27.95	.0715	38040715	28.85	.0955	38040955	30.30	.1195	38041195	32.90	.1435	38041435	34.90
.0480	38040480	27.95	.0720	38040720	28.85	.0960	38040960	28.85	.1200	38041200	31.30	.1440	38041440	33.25
.0485	38040485	27.95	.0725	38040725	28.85	.0965	38040965	28.85	.1205	38041205	32.90	.1445	38041445	35.05
.0490	38040490	27.95	.0730	38040730	27.45	.0970	38040970	30.30	.1210	38041210	32.90	.1450	38041450	35.15
.0495	38040495	27.95	.0735	38040735	28.85	.0975	38040975	30.30	.1215	38041215	32.90	.1455	38041455	35.15
.0500	38040500	27.95	.0740	38040740	28.85	.0980	38040980	28.85	.1220	3804031	31.30	.1460	38041460	36.05
.0505	38040505	27.95	.0745	38040745	28.85	.0985	38040985	30.55	.1225	38041225	32.90	.1465	38041465	36.05
.0510	38040510	27.95	.0750	38040750	28.85	.0990	38040990	30.55	.1230	38041230	32.90	.1470	38041470	34.15
.0515	38040515	27.95	.0755	38040755	28.85	.0995	38040995	29.05	.1235	38041235	32.90	.1475	38041475	36.05

SOLID CARBIDE DECIMAL SIZE CHUCKING REAMERS

**TYPE 3804 - SOLID CARBIDE - STRAIGHT FLUTES - SHORT LENGTH
STANDARD DECIMAL DIAMETER REAMERS (.0005" INCREMENTS)
THIS PAGE .1480" THRU .2675"**

Short length solid carbide head and shank. Tool geometry appropriate for material being machined.
For fractional, wire and letter sizes, see page 50.



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

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

For closer tool diameter tolerance pricing, see page 56.

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
.1480	38041480	\$36.10	.1720	38041720	\$41.85	.1960	38041960	\$46.50	.2200	38042200	\$56.75	.2440	38042440	\$60.50
.1485	38041485	36.10	.1725	38041725	41.85	.1965	38041965	48.80	.2205	3804056	53.80	.2445	38042445	60.50
.1490	38041490	36.10	.1730	38041730	39.80	.1970	38041970	49.30	.2210	38042210	53.80	.2450	38042450	60.50
.1495	38041495	34.40	.1735	38041735	42.50	.1975	38041975	49.30	.2215	38042215	58.95	.2455	38042455	60.50
.1500	38041500	36.10	.1740	38041740	42.50	.1980	38041980	49.30	.2220	38042220	58.95	.2460	38042460	57.65
.1505	38041505	36.10	.1745	38041745	42.50	.1985	38041985	49.30	.2225	38042225	58.95	.2465	38042465	60.50
.1510	38041510	36.10	.1750	38041750	42.50	.1990	38041990	46.75	.2230	38042230	58.95	.2470	38042470	60.50
.1515	38041515	36.10	.1755	38041755	42.90	.1995	38041995	50.80	.2235	38042235	58.95	.2475	38042475	60.50
.1520	38041520	34.40	.1760	38041760	42.90	.2000	38042000	50.80	.2240	38042240	58.95	.2480	3804063	57.65
.1525	38041525	37.65	.1765	38041765	42.90	.2005	38042005	50.80	.2245	38042245	58.95	.2485	38042485	60.50
.1530	38041530	37.65	.1770	38041770	40.80	.2010	38042010	48.25	.2250	38042250	58.95	.2490	38042490	60.50
.1535	3804039	35.85	.1775	38041775	43.00	.2015	38042015	50.80	.2255	38042255	58.95	.2495	38042495	60.50
.1540	38041540	35.85	.1780	38041780	43.00	.2020	38042020	50.80	.2260	38042260	58.95	.2500	380416	52.40
.1545	38041545	37.65	.1785	38041785	43.00	.2025	38042025	50.80	.2265	38042265	59.55	.2505	38042505	60.50
.1550	38041550	37.65	.1790	38041790	43.00	.2030	38042030	50.80	.2270	38042270	59.55	.2510	38042510	60.50
.1555	38041555	35.85	.1795	38041795	43.00	.2035	38042035	50.80	.2275	38042275	59.55	.2515	38042515	60.50
.1560	38041560	37.65	.1800	38041800	41.05	.2040	38042040	48.25	.2280	38042280	56.60	.2520	3804064	63.55
.1565	38041565	39.05	.1805	38041805	43.35	.2045	38042045	50.80	.2285	38042285	59.55	.2525	38042525	63.55
.1570	38041570	37.00	.1810	38041810	43.40	.2050	38042050	50.80	.2290	38042290	59.55	.2530	38042530	60.50
.1575	3804040	33.90	.1815	38041815	43.65	.2055	38042055	48.25	.2295	38042295	59.55	.2535	38042535	66.90
.1580	38041580	39.80	.1820	38041820	41.60	.2060	38042060	50.80	.2300	38042300	59.55	.2540	38042540	66.90
.1585	38041585	39.80	.1825	38041825	43.90	.2065	38042065	50.80	.2305	38042305	59.55	.2545	38042545	66.90
.1590	38041590	37.90	.1830	38041830	43.90	.2070	38042070	50.80	.2310	38042310	59.55	.2550	38042550	66.90
.1595	38041595	40.55	.1835	38041835	44.05	.2075	38042075	50.80	.2315	38042315	59.55	.2555	38042555	66.90
.1600	38041600	40.55	.1840	38041840	44.05	.2080	38042080	50.80	.2320	38042320	59.55	.2560	38042560	66.90
.1605	38041605	40.55	.1845	38041845	44.05	.2085	38042085	50.80	.2325	38042325	59.55	.2565	38042565	66.90
.1610	38041610	38.50	.1850	3804047	41.85	.2090	38042090	50.80	.2330	38042330	59.55	.2570	38042570	63.45
.1615	38041615	40.55	.1855	38041855	46.35	.2095	38042095	50.80	.2335	38042335	59.55	.2575	38042575	66.90
.1620	38041620	40.55	.1860	38041860	46.35	.2100	38042100	50.80	.2340	38042340	56.60	.2580	38042580	66.90
.1625	38041625	40.55	.1865	38041865	46.35	.2105	38042105	50.80	.2345	38042345	59.55	.2585	38042585	66.90
.1630	38041630	40.55	.1870	38041870	44.15	.2110	38042110	50.80	.2350	38042350	59.55	.2590	38042590	66.90
.1635	38041635	40.70	.1875	380412	40.20	.2115	38042115	50.80	.2355	38042355	59.55	.2595	38042595	66.90
.1640	38041640	40.55	.1880	38041880	46.45	.2120	38042120	50.80	.2360	38042360	59.55	.2600	38042600	66.90
.1645	38041645	40.55	.1885	38041885	46.45	.2125	38042125	50.80	.2365	38042365	60.50	.2605	38042605	66.90
.1650	38041650	40.55	.1890	3804048	44.15	.2130	38042130	48.25	.2370	38042370	60.50	.2610	38042610	63.45
.1655	38041655	40.55	.1895	38041895	46.95	.2135	38042135	50.80	.2375	38042375	60.50	.2615	38042615	66.90
.1660	38041660	38.65	.1900	38041900	46.95	.2140	38042140	50.80	.2380	38042380	57.65	.2620	38042620	66.90
.1665	38041665	41.05	.1905	38041905	46.95	.2145	38042145	50.80	.2385	38042385	60.50	.2625	38042625	66.90
.1670	38041670	41.05	.1910	38041910	44.65	.2150	38042150	50.80	.2390	38042390	60.50	.2630	38042630	66.90
.1675	38041675	41.05	.1915	38041915	47.00	.2155	38042155	50.80	.2395	38042395	60.50	.2635	38042635	66.90
.1680	38041680	41.05	.1920	38041920	47.00	.2160	38042160	50.80	.2400	38042400	60.50	.2640	38042640	66.90
.1685	38041685	41.05	.1925	38041925	47.00	.2165	3804055	44.15	.2405	38042405	60.50	.2645	38042645	66.90
.1690	38041690	41.05	.1930	38041930	47.50	.2170	38042170	50.80	.2410	38042410	60.50	.2650	38042650	66.90
.1695	38041695	39.15	.1935	38041935	44.95	.2175	38042175	50.80	.2415	38042415	60.50	.2655	38042655	66.90
.1700	38041700	41.85	.1940	38041940	47.50	.2180	38042180	50.80	.2420	38042420	57.65	.2660	38042660	63.45
.1705	38041705	41.85	.1945	38041945	47.50	.2185	38042185	48.25	.2425	38042425	60.50	.2665	38042665	66.90
.1710	38041710	41.85	.1950	38041950	48.80	.2190	38042190	56.75	.2430	38042430	60.50	.2670	38042670	66.90
.1715	38041715	41.85	.1955	38041955	48.80	.2195	38042195	56.75	.2435	38042435	60.50	.2675	38042675	66.90

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 50.



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

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

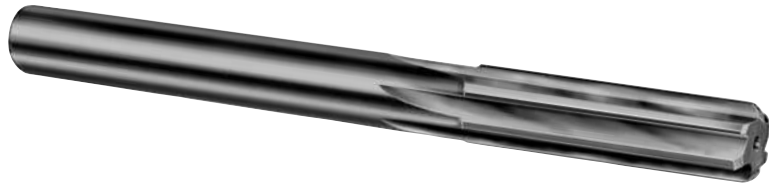
For closer tool diameter tolerance pricing, see page 56.

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	\$66.90	.2920	38042920	\$78.30	.3160	38043160	\$81.50	.3400	38043400	\$99.45	.3640	38043640	\$101.95
.2685	38042685	66.90	.2925	38042925	78.30	.3165	38043165	86.80	.3405	38043405	99.45	.3645	38043645	101.95
.2690	38042690	66.90	.2930	38042930	78.30	.3170	38043170	86.80	.3410	38043410	99.45	.3650	38043650	101.95
.2695	38042695	66.90	.2935	38042935	78.30	.3175	38043175	86.80	.3415	38043415	99.45	.3655	38043655	101.95
.2700	38042700	66.90	.2940	38042940	78.30	.3180	38043180	86.80	.3420	38043420	99.45	.3660	38043660	101.95
.2705	38042705	66.90	.2945	38042945	78.30	.3185	38043185	86.80	.3425	3804087	99.20	.3665	38043665	101.95
.2710	38042710	66.90	.2950	38042950	74.45	.3190	38043190	86.80	.3430	38043430	99.45	.3670	38043670	101.95
.2715	38042715	66.90	.2955	38042955	78.30	.3195	38043195	86.80	.3435	38043435	99.45	.3675	38043675	101.95
.2720	38042720	63.45	.2960	38042960	78.30	.3200	38043200	86.80	.3440	38043440	99.60	.3680	38043680	96.95
.2725	38042725	66.90	.2965	38042965	78.30	.3205	38043205	86.80	.3445	38043445	99.60	.3685	38043685	102.85
.2730	38042730	66.90	.2970	38042970	81.50	.3210	38043210	86.80	.3450	38043450	99.60	.3690	38043690	103.20
.2735	38042735	66.90	.2975	38042975	81.50	.3215	38043215	86.80	.3455	38043455	99.60	.3695	38043695	102.85
.2740	38042740	66.90	.2980	38042980	81.50	.3220	38043220	86.80	.3460	38043460	99.60	.3700	38043700	102.85
.2745	38042745	66.90	.2985	38042985	81.50	.3225	38043225	86.80	.3465	3804088	99.60	.3705	38043705	102.85
.2750	38042750	66.90	.2990	38042990	81.50	.3230	38043230	82.55	.3470	38043470	99.60	.3710	38043710	102.85
.2755	38042755	66.90	.2995	38042995	81.50	.3235	38043235	86.80	.3475	38043475	99.60	.3715	38043715	102.85
.2760	38042760	66.90	.3000	38043000	81.50	.3240	38043240	99.45	.3480	38043480	94.85	.3720	38043720	102.85
.2765	38042765	66.90	.3005	38043005	81.50	.3245	38043245	99.45	.3485	38043485	99.60	.3725	38043725	102.85
.2770	38042770	63.45	.3010	38043010	81.50	.3250	38043250	99.45	.3490	38043490	99.60	.3730	38043730	102.85
.2775	38042775	66.90	.3015	38043015	81.50	.3255	38043255	99.45	.3495	38043495	99.60	.3735	38043735	102.85
.2780	38042780	72.40	.3020	38043020	77.65	.3260	38043260	99.45	.3500	38043500	99.60	.3740	3804095	97.55
.2785	38042785	72.40	.3025	38043025	81.50	.3265	38043265	99.45	.3505	38043505	99.60	.3745	38043745	102.85
.2790	38042790	72.40	.3030	38043030	81.50	.3270	38043270	99.45	.3510	38043510	99.60	.3750	380424	89.25
.2795	3804071	72.30	.3035	38043035	81.50	.3275	38043275	99.45	.3515	38043515	99.60	.3755	38043755	121.95
.2800	38042800	72.40	.3040	38043040	81.50	.3280	38043280	99.45	.3520	38043520	99.60	.3760	38043760	122.10
.2805	38042805	72.40	.3045	38043045	81.50	.3285	38043285	99.45	.3525	38043525	99.60	.3765	38043765	121.95
.2810	38042810	68.80	.3050	38043050	81.50	.3290	38043290	99.45	.3530	38043530	99.60	.3770	38043770	115.80
.2815	38042815	72.40	.3055	38043055	81.50	.3295	38043295	99.45	.3535	38043535	99.60	.3775	38043775	121.95
.2820	38042820	78.30	.3060	38043060	81.50	.3300	38043300	99.45	.3540	38043540	99.60	.3780	3804096	121.70
.2825	38042825	78.30	.3065	38043065	81.50	.3305	38043305	99.45	.3545	38043545	99.60	.3785	38043785	121.95
.2830	38042830	78.30	.3070	38043070	81.50	.3310	38043310	96.00	.3550	38043550	100.10	.3790	38043790	121.95
.2835	3804072	78.15	.3075	38043075	81.50	.3315	38043315	99.45	.3555	38043555	100.10	.3795	38043795	121.95
.2840	38042840	78.30	.3080	38043080	81.50	.3320	38043320	94.45	.3560	38043560	100.10	.3800	38043800	121.95
.2845	38042845	78.30	.3085	38043085	81.50	.3325	38043325	99.45	.3565	38043565	100.10	.3805	38043805	121.95
.2850	38042850	78.30	.3090	38043090	81.50	.3330	38043330	99.45	.3570	38043570	100.10	.3810	38043810	121.95
.2855	38042855	78.30	.3095	38043095	81.50	.3335	38043335	99.45	.3575	38043575	100.10	.3815	38043815	121.95
.2860	38042860	78.30	.3100	38043100	81.50	.3340	38043340	99.45	.3580	38043580	95.25	.3820	38043820	121.95
.2865	38042865	78.30	.3105	38043105	81.50	.3345	38043345	99.45	.3585	38043585	100.10	.3825	38043825	121.95
.2870	38042870	78.30	.3110	3804079	81.50	.3350	38043350	99.45	.3590	38043590	100.80	.3830	38043830	121.95
.2875	38042875	78.30	.3115	38043115	81.50	.3355	38043355	99.45	.3595	38043595	101.95	.3835	38043835	121.95
.2880	38042880	78.30	.3120	38043120	81.50	.3360	38043360	99.45	.3600	38043600	101.95	.3840	38043840	121.95
.2885	38042885	78.30	.3125	380420	70.95	.3365	38043365	99.45	.3605	38043605	101.95	.3845	38043845	121.95
.2890	38042890	78.30	.3130	38043130	81.50	.3370	38043370	99.45	.3610	38043610	101.95	.3850	38043850	121.95
.2895	38042895	78.30	.3135	38043135	81.50	.3375	38043375	99.45	.3615	38043615	101.95	.3855	38043855	121.95
.2900	38042900	74.45	.3140	38043140	81.50	.3380	38043380	99.45	.3620	38043620	101.95	.3860	38043860	116.15
.2905	38042905	78.30	.3145	38043145	81.50	.3385	38043385	99.45	.3625	38043625	101.95	.3865	38043865	128.25
.2910	38042910	78.30	.3150	3804080	70.95	.3390	38043390	94.45	.3630	38043630	101.95	.3870	38043870	128.25
.2915	38042915	78.30	.3155	38043155	81.50	.3395	38043395	99.45	.3635	38043635	101.95	.3875	38043875	128.25

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 50.



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

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

For closer tool diameter tolerance pricing, see page 56.

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	\$128.25	.4135	38044135	\$131.70	.4390	38044390	\$144.25	.4645	38044645	\$144.25	.4910	38044910	\$156.85
.3885	38043885	128.25	.4140	38044140	131.70	.4395	38044395	144.25	.4650	38044650	144.25	.4915	38044915	156.85
.3890	38043890	128.25	.4145	38044145	131.70	.4400	38044400	144.25	.4655	38044655	144.25	.4920	38044920	156.85
.3895	38043895	128.25	.4150	38044150	131.70	.4405	38044405	144.25	.4660	38044660	144.25	.4925	38044925	156.85
.3900	38043900	128.25	.4155	38044155	131.70	.4410	38044410	144.25	.4665	38044665	144.25	.4930	38044930	156.85
.3905	38043905	128.25	.4160	38044160	131.70	.4415	38044415	144.25	.4670	38044670	144.25	.4935	38044935	156.85
.3910	38043910	128.25	.4165	38044165	131.70	.4420	38044420	144.25	.4675	38044675	144.25	.4940	38044940	156.85
.3915	38043915	128.25	.4170	38044170	131.70	.4425	38044425	144.25	.4680	38044680	144.25	.4945	38044945	156.85
.3920	38043920	128.25	.4175	38044175	131.70	.4430	38044430	144.25	.4685	3804119	144.25	.4950	38044950	156.85
.3925	38043925	128.25	.4180	38044180	131.70	.4435	38044435	144.25	.4690	38044690	144.25	.4955	38044955	156.85
.3930	38043930	128.25	.4185	38044185	131.70	.4440	38044440	144.25	.4695	38044695	144.25	.4960	38044960	156.85
.3935	38043935	128.25	.4190	38044190	131.70	.4445	38044445	144.25	.4700	38044700	144.25	.4965	38044965	156.85
.3940	38043940	128.25	.4195	38044195	131.70	.4450	38044450	144.25	.4705	38044705	144.25	.4970	38044970	156.85
.3945	38043945	128.25	.4200	38044200	131.70	.4455	38044455	144.25	.4710	38044710	144.25	.4975	38044975	156.85
.3950	38043950	128.25	.4205	38044205	131.70	.4460	38044460	144.25	.4715	38044715	144.25	.4980	38044980	156.85
.3955	38043955	128.25	.4210	38044210	131.70	.4465	38044465	144.25	.4720	38044720	144.25	.4985	38044985	156.85
.3960	38043960	128.25	.4215	38044215	131.70	.4470	38044470	144.25	.4725	38044725	156.85	.4990	38044990	156.85
.3965	38043965	128.25	.4220	38044220	131.70	.4475	38044475	144.25	.4730	38044730	156.85	.4995	38044995	148.40
.3970	38043970	122.10	.4225	38044225	131.70	.4480	38044480	144.25	.4735	38044735	156.85	.5000	380432	148.40
.3975	38043975	128.25	.4230	38044230	131.70	.4485	38044485	144.25	.4740	38044740	156.85	.5005	38045005	186.25
.3980	38043980	128.25	.4235	38044235	131.70	.4490	38044490	144.25	.4745	38044745	156.85	.5010	38045010	186.25
.3985	38043985	128.25	.4240	38044240	131.70	.4495	38044495	144.25	.4750	38044750	156.85	.5015	38045015	186.25
.3990	38043990	128.25	.4245	38044245	131.70	.4500	38044500	144.25	.4755	38044755	156.85	.5020	38045020	186.25
.3995	38043995	128.25	.4250	38044250	131.70	.4505	38044505	144.25	.4760	38044760	156.85	.5025	38045025	186.25
.4000	38044000	128.25	.4255	38044255	131.70	.4510	38044510	144.25	.4765	38044765	156.85	.5030	38045030	186.25
.4005	38044005	128.25	.4260	38044260	131.70	.4515	38044515	144.25	.4770	38044770	156.85	.5035	38045035	186.25
.4010	38044010	128.25	.4265	38044265	131.70	.4520	38044520	144.25	.4775	38044775	156.85	.5040	38045040	186.25
.4015	38044015	128.25	.4270	38044270	131.70	.4525	38044525	144.25	.4780	38044780	156.85	.5045	38045045	186.25
.4020	38044020	128.25	.4275	38044275	131.70	.4530	38044530	144.25	.4785	38044785	156.85	.5050	38045050	186.25
.4025	38044025	128.25	.4280	38044280	131.70	.4535	38044535	144.25	.4790	38044790	156.85	.5055	38045055	186.25
.4030	38044030	128.25	.4285	38044285	131.70	.4540	38044540	144.25	.4795	38044795	156.85	.5060	38045060	186.25
.4035	38044035	128.25	.4290	38044290	131.70	.4545	38044545	144.25	.4800	38044800	156.85	.5065	38045065	186.25
.4040	38044040	122.10	.4295	38044295	131.70	.4550	38044550	144.25	.4805	38044805	156.85	.5070	38045070	186.25
.4045	38044045	128.25	.4300	38044300	131.70	.4555	38044555	144.25	.4810	38044810	156.85	.5075	38045075	186.25
.4050	38044050	128.25	.4305	38044305	131.70	.4560	38044560	144.25	.4815	38044815	156.85	.5080	38045080	186.25
.4055	3804103	128.25	.4310	38044310	131.70	.4565	38044565	144.25	.4820	38044820	156.85	.5085	38045085	186.25
.4060	38044060	128.25	.4315	38044315	131.70	.4570	38044570	144.25	.4835	38044835	156.85	.5090	38045090	186.25
.4065	38044065	128.25	.4320	38044320	131.70	.4575	38044575	144.25	.4840	38044840	156.85	.5095	38045095	186.25
.4070	38044070	128.25	.4325	38044325	131.70	.4580	38044580	144.25	.4845	38044845	156.85	.5100	38045100	186.25
.4075	38044075	128.25	.4330	38044330	131.70	.4585	38044585	144.25	.4850	38044850	156.85	.5105	38045105	186.25
.4080	38044080	128.25	.4335	38044335	131.70	.4590	38044590	144.25	.4855	38044855	156.85	.5110	38045110	186.25
.4085	38044085	128.25	.4340	38044340	131.70	.4595	38044595	144.25	.4860	38044860	156.85	.5115	38045115	186.25
.4090	38044090	128.25	.4345	38044345	131.70	.4600	38044600	144.25	.4865	38044865	156.85	.5120	38045120	186.25
.4095	38044095	128.25	.4350	38044350	131.70	.4605	38044605	144.25	.4870	38044870	156.85	.5125	38045125	186.25
.4100	38044100	128.25	.4355	38044355	131.70	.4610	38044610	144.25	.4875	38044875	156.85	.5130	38045130	186.25
.4105	38044105	128.25	.4360	38044360	131.70	.4615	38044615	144.25	.4880	38044880	156.85	.5135	38045135	186.25
.4110	38044110	128.25	.4365	38044365	131.70	.4620	38044620	144.25	.4885	38044885	156.85	.5140	38045140	186.25
.4115	38044115	128.25	.4370	3804111	131.70	.4625	38044625	144.25	.4890	38044890	156.85	.5145	38045145	186.25
.4120	38044120	128.25	.4375	380428	125.30	.4630	38044630	144.25	.4895	38044895	156.85	.5150	38045150	186.25
.4125	38044125	128.25	.4380	38044380	144.25	.4635	38044635	144.25	.4900	38044900	156.85	-	-	-
.4130	38044130	122.10	.4385	38044385	144.25	.4640	38044640	144.25	.4905	38044905	156.85	-	-	-

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.



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

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	\$68.10	.1560 - .1769	\$108.80	\$88.45	\$81.60	\$78.35	\$74.85	\$72.10
.1719	1/16	.151	4	1	1/2	3 1/4	34011719	68.10	-	-	-	-	-	-	-
.1875	3/16	1/16	4	1 1/8	1/2	3 1/2	340106	65.90	.1770 - .2040	105.45	85.65	79.00	75.85	72.50	69.80
.2031	13/64	1/16	4	1 1/8	1/2	3 5/8	34012031	66.35	-	-	-	-	-	-	-
.2188	7/32	13/64	4	1 1/4	1/2	3 3/4	340107	65.90	.2041 - .2210	105.45	85.65	79.00	75.85	72.50	69.80
.2344	15/64	7/32	4	1 1/2	1/2	3 7/8	34012344	66.35	.2211 - .2380	105.90	86.05	79.40	76.30	72.85	70.20
.2500	1/4	15/64	4	1 1/2	1/2	4	340108	65.90	.2381 - .2530	105.45	85.65	79.00	75.85	72.50	69.80
.2656	17/64	15/64	4	1 1/2	1/2	4 1/8	34012656	67.25	-	-	-	-	-	-	-
.2812	9/32	15/64	4	1 1/2	1/2	4 1/4	340109	66.80	.2531 - .2840	106.35	86.50	79.90	76.70	73.40	70.70
.2969	19/64	9/32	4	1 1/2	1/2	4 3/8	34012969	67.25	-	-	-	-	-	-	-
.3125	5/16	9/32	4	1 1/2	1/2	4 1/2	340110	66.80	.2841 - .3150	106.35	86.50	79.90	76.70	73.40	70.70
.3281	21/64	9/32	4	1 1/2	5/8	4 5/8	34013281	69.25	-	-	-	-	-	-	-
.3438	11/32	9/32	4	1 1/2	5/8	4 3/4	340111	68.40	.3151 - .3470	107.95	88.15	81.55	78.35	74.95	72.25
.3594	23/64	5/16	4	1 3/4	5/8	4 7/8	34013594	69.25	-	-	-	-	-	-	-
.3750	3/8	5/16	4	1 3/4	5/8	5	340112	62.75	.3471 - .3780	99.05	80.90	74.80	71.90	68.80	66.35
.3906	25/64	5/16	4	1 3/4	5/8	5 1/8	34013906	71.85	-	-	-	-	-	-	-
.4062	13/32	5/16	4	1 3/4	5/8	5 1/4	340113	70.65	.3781 - .4090	110.20	90.40	83.70	80.60	77.15	74.50
.4219	27/64	3/8	4	1 3/4	5/8	5 3/8	34014219	71.85	-	-	-	-	-	-	-
.4375	7/16	3/8	4	1 3/4	5/8	5 1/2	340114	73.70	.4091 - .4410	113.25	93.40	86.80	83.60	80.20	77.55
.4531	29/64	3/8	4	1 3/4	5/8	5 5/8	34014531	76.55	-	-	-	-	-	-	-
.4688	15/32	3/8	4	1 3/4	5/8	5 3/4	340115	77.00	.4411 - .4720	116.55	96.75	90.10	86.95	83.55	80.90
.4844	31/64	7/16	6	2	5/8	5 7/8	34014844	81.60	-	-	-	-	-	-	-
.5000	1/2	7/16	6	2	5/8	6	340116	86.45	.4721 - .5030	130.00	108.20	100.90	97.40	93.65	90.75
.5156	33/64	7/16	6	2	5/8	6 5/8	34015156	91.85	-	-	-	-	-	-	-
.5312	17/32	7/16	6	2	5/8	6 5/8	340117	91.85	.5031 - .5340	135.40	113.60	106.35	102.85	99.15	96.15
.5469	35/64	7/16	6	2	5/8	6 5/8	34015469	91.85	-	-	-	-	-	-	-
.5625	9/16	7/16	6	2	5/8	6 5/8	340118	91.85	.5341 - .5660	135.40	113.60	106.35	102.85	99.15	96.15
.5781	37/64	7/16	6	2	5/8	6 5/8	34015781	94.45	-	-	-	-	-	-	-
.5938	19/32	7/16	6	2	5/8	7 1/8	340119	94.45	.5661 - .5970	138.00	116.20	108.95	105.45	101.65	98.75
.6094	39/64	9/16	6	2 1/4	5/8	7 1/8	34016094	94.45	-	-	-	-	-	-	-
.6250	5/8	9/16	6	2 1/4	5/8	7 1/8	340120	94.45	.5971 - .6280	138.00	116.20	108.95	105.45	101.65	98.75
.6406	41/64	9/16	6	2 1/4	5/8	7 1/8	34016406	95.65	-	-	-	-	-	-	-
.6562	21/32	9/16	6	2 1/4	5/8	7 1/8	340121	95.65	.6281 - .6590	139.20	117.40	110.05	106.55	102.85	99.85
.6719	43/64	9/16	6	2 1/4	5/8	7 5/8	34016719	95.65	-	-	-	-	-	-	-
.6875	11/16	9/16	6	2 1/4	5/8	7 5/8	340122	95.65	.6591 - .6910	139.20	117.40	110.05	106.55	102.85	99.85
.7031	45/64	9/16	6	2 1/4	5/8	7 5/8	34017031	98.90	-	-	-	-	-	-	-
.7188	23/32	9/16	6	2 1/4	5/8	7 5/8	340123	98.90	.6911 - .7220	142.45	120.65	113.40	109.90	106.10	103.20
.7344	47/64	5/8	6	2 1/2	3/4	7 5/8	34017344	98.90	-	-	-	-	-	-	-
.7500	3/4	5/8	6	2 1/2	3/4	8	340124	98.90	.7221 - .7530	142.45	120.65	113.40	109.90	106.10	103.20

*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. 58).

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	\$66.35
.1885	1/64	4	1 1/8	1/2	3 1/2	347919	66.35
.2490	15/64	4	1 1/2	1/2	4	347924	66.35
.2510	15/64	4	1 1/2	1/2	4	347925	66.35
.3115	9/32	4	1 1/2	1/2	4 1/2	347931	67.25
.3135	9/32	4	1 1/2	1/2	4 1/2	347932	67.25
.3740	5/16	4	1 3/4	5/8	5	347937	69.25
.3760	5/16	4	1 3/4	5/8	5	347938	69.25
.4365	3/8	4	1 3/4	5/8	5 1/2	347943	76.55
.4385	3/8	4	1 3/4	5/8	5 1/2	347944	76.55
.4990	7/16	6	2	5/8	6	347949	81.60
.5010	7/16	6	2	5/8	6	347950	81.60

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. 58).

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	\$53.30
.1885	1/64	4	1 1/8	1/2	4 1/2	347819	53.30
.2490	15/64	4	1 1/2	1/2	6	347824	53.30
.2510	15/64	4	1 1/2	1/2	6	347825	53.30
.3115	9/32	4	1 1/2	1/2	6	347831	54.45
.3135	9/32	4	1 1/2	1/2	6	347832	54.45
.3740	5/16	4	1 3/4	5/8	7	347837	56.45
.3760	5/16	4	1 3/4	5/8	7	347838	56.45
.4365	3/8	4	1 3/4	5/8	7	347843	63.15
.4385	3/8	4	1 3/4	5/8	7	347844	63.15
.4990	7/16	6	2	5/8	8	347849	69.25
.5010	7/16	6	2	5/8	8	347850	69.25
.6240	9/16	6	2 1/4	5/8	9	347862	82.95
.6260	9/16	6	2 1/4	5/8	9	347863	82.95
.7490	5/8	6	2 1/2	3/4	9 1/2	347874	87.40
.7510	5/8	6	2 1/2	3/4	9 1/2	347875	87.40
.8740	3/4	6	2 5/8	3/4	10	347886	92.90
.8760	3/4	6	2 5/8	3/4	10	347887	96.40
.9990	7/8	8	2 3/4	3/4	10 1/2	347898	114.50
1.0010	7/8	8	2 3/4	3/4	10 1/2	347899	109.70

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. 58).

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	\$66.35
.1870	1/64	4	1 1/8	1/2	3 1/2	347718	66.35
.2480	15/64	4	1 1/2	1/2	4	347723	66.35
.2495	15/64	4	1 1/2	1/2	4	347724	66.35
.3105	9/32	4	1 1/2	1/2	4 1/2	347730	67.25
.3120	9/32	4	1 1/2	1/2	4 1/2	347731	67.25
.3730	5/16	4	1 3/4	5/8	5	347736	69.25
.3745	5/16	4	1 3/4	5/8	5	347737	69.25
.4355	3/8	4	1 3/4	5/8	5 1/2	347742	76.55
.4370	3/8	4	1 3/4	5/8	5 1/2	347743	76.55
.4980	7/16	6	2	5/8	6	347748	81.60
.4995	7/16	6	2	5/8	6	347749	81.60

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. 58).

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	\$53.30
.1870	1/64	4	1 1/8	1/2	4 1/2	347618	53.30
.2480	15/64	4	1 1/2	1/2	6	347623	53.30
.2495	15/64	4	1 1/2	1/2	6	347624	53.30
.3105	9/32	4	1 1/2	1/2	6	347630	54.45
.3120	9/32	4	1 1/2	1/2	6	347631	54.45
.3730	5/16	4	1 3/4	5/8	7	347636	56.45
.3745	5/16	4	1 3/4	5/8	7	347637	56.45
.4355	3/8	4	1 3/4	5/8	7	347642	63.15
.4370	3/8	4	1 3/4	5/8	7	347643	63.15
.4980	7/16	6	2	5/8	8	347648	69.25
.4995	7/16	6	2	5/8	8	347649	69.25
CASED SET OF ABOVE 12 REAMERS						347600	664.75

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 60.

For reamer tolerances and closer tolerance pricing, see page 56.

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	\$46.15	.1560 - .1769	\$87.25	\$66.40	\$59.65	\$56.30	\$52.85	\$50.10
.1719	11/64	.151	4	1	1/2	4	34001719	46.15	-	-	-	-	-	-	-
.1875	3/16	11/64	4	1 1/8	1/2	4 1/2	340006	42.35	.1770 - .2040	81.90	62.10	55.50	52.30	48.90	46.25
.1875	3/16	11/64	4	1 1/4	1/2	5	340086	44.90	.1770 - .2040	84.45	64.65	58.10	54.85	51.40	48.75
.2031	13/64	11/64	4	1 1/8	1/2	4 1/2	34002031	44.90	-	-	-	-	-	-	-
.2188	7/32	13/64	4	1 1/4	1/2	5	340007	42.35	.2041 - .2210	81.90	62.10	55.50	52.30	48.90	46.25
.2344	15/64	7/32	4	1 1/2	1/2	6	34002344	44.90	.2211 - .2380	84.45	64.65	58.10	54.85	51.40	48.75
.2500	1/4	15/64	4	1 1/2	1/2	6	340008	42.35	.2381 - .2530	81.90	62.10	55.50	52.30	48.90	46.25
.2656	17/64	15/64	4	1 1/2	1/2	6	34002656	45.85	-	-	-	-	-	-	-
.2812	9/32	15/64	4	1 1/2	1/2	6	340009	43.25	.2531 - .2840	82.80	63.00	56.40	53.20	49.80	47.10
.2969	19/64	9/32	4	1 1/2	1/2	6	34002969	45.85	-	-	-	-	-	-	-
.3125	5/16	9/32	4	1 1/2	1/2	6	340010	43.25	.2841 - .3150	82.80	63.00	56.40	53.20	49.80	47.10
.3281	21/64	9/32	4	1 1/2	5/8	6	34003281	47.55	-	-	-	-	-	-	-
.3438	11/32	9/32	4	1 1/2	5/8	6	340011	44.80	.3151 - .3470	84.35	64.55	57.90	54.75	51.35	48.70
.3594	23/64	5/16	4	1 3/4	5/8	7	34003594	47.55	-	-	-	-	-	-	-
.3750	3/8	5/16	4	1 3/4	5/8	7	340012	41.10	.3471 - .3780	77.40	59.20	53.15	50.25	47.10	44.65
.3906	25/64	5/16	4	1 3/4	5/8	7	34003906	49.95	-	-	-	-	-	-	-
.4062	13/32	5/16	4	1 3/4	5/8	7	340013	46.95	.3781 - .4090	86.50	66.70	60.10	56.90	53.55	50.90
.4219	27/64	3/8	4	1 3/4	5/8	7	34004219	53.15	-	-	-	-	-	-	-
.4375	7/16	3/8	4	1 3/4	5/8	7	340014	50.15	.4091 - .4410	89.70	69.90	63.20	60.10	56.70	54.00
.4531	29/64	3/8	4	1 3/4	5/8	7	34004531	53.95	-	-	-	-	-	-	-
.4688	15/32	3/8	4	1 3/4	5/8	7	340015	50.90	.4411 - .4720	90.45	70.65	63.95	60.85	57.45	54.75
.4844	31/64	7/16	6	2	5/8	8	34004844	58.30	-	-	-	-	-	-	-
.5000	1/2	7/16	6	2	5/8	8	340016	60.55	.4721 - .5030	104.10	82.30	74.95	71.55	67.75	64.85
.5156	33/64	7/16	6	2	5/8	8	34005156	65.90	-	-	-	-	-	-	-
.5312	17/32	7/16	6	2	5/8	8	340017	65.90	.5031 - .5340	109.45	87.65	80.45	76.85	73.10	70.20
.5469	35/64	7/16	6	2	5/8	8	34005469	65.90	-	-	-	-	-	-	-
.5625	9/16	7/16	6	2	5/8	8	340018	65.90	.5341 - .5660	109.45	87.65	80.45	76.85	73.10	70.20
.5781	37/64	7/16	6	2	5/8	8	34005781	68.55	-	-	-	-	-	-	-
.5938	19/32	7/16	6	2	5/8	8	340019	68.55	.5661 - .5970	112.10	90.30	82.95	79.55	75.75	72.85
.6094	39/64	9/16	6	2 1/4	5/8	9	34006094	68.55	-	-	-	-	-	-	-
.6250	5/8	9/16	6	2 1/4	5/8	9	340020	68.55	.5971 - .6280	112.10	90.30	82.95	79.55	75.75	72.85
.6406	41/64	9/16	6	2 1/4	5/8	9	34006406	69.75	-	-	-	-	-	-	-
.6562	21/32	9/16	6	2 1/4	5/8	9	340021	69.75	.6281 - .6590	113.25	91.40	84.15	80.65	76.95	74.00
.6719	43/64	9/16	6	2 1/4	5/8	9	34006719	69.75	-	-	-	-	-	-	-
.6875	11/16	9/16	6	2 1/4	5/8	9	340022	69.75	.6591 - .6910	113.25	91.40	84.15	80.65	76.95	74.00
.7031	45/64	9/16	6	2 1/4	5/8	9	34007031	73.00	-	-	-	-	-	-	-
.7188	23/32	9/16	6	2 1/4	5/8	9	340023	73.00	.6911 - .7220	116.55	94.75	87.40	84.00	80.20	77.30
.7344	47/64	5/8	6	2 1/2	3/4	9 1/2	34007344	73.00	-	-	-	-	-	-	-
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	340024	73.00	.7221 - .7530	116.55	94.75	87.40	84.00	80.20	77.30

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 58		TYPE 3402 PAGE 66		TYPE 3410 PAGE 78		TYPE 3430 PAGE 86	TYPE 3440 PAGE 86	BOTH TYPES PRICE	TYPE 3450 PAGE 68		TYPE 3465 PAGE 82	
	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	\$36.05	-	-	341006SF	\$47.10	343006SF	344006SF	\$46.95	345006SF	\$43.10	-	-
.2041 - .2210	340007SF	36.05	-	-	341007SF	47.10	343007SF	344007SF	46.95	345007SF	43.10	-	-
.2211 - .2380	34002344SF	38.15	-	-	34102344SF	47.10	34302344SF	34402344SF	46.95	34502344SF	43.10	-	-
.2381 - .2530	340008SF	36.05	340208SF	\$41.55	341008SF	47.10	343008SF	344008SF	46.95	345008SF	43.10	-	-
.2531 - .2840	340009SF	36.75	340209SF	42.20	341009SF	47.25	343009SF	344009SF	46.95	345009SF	44.05	-	-
.2841 - .3150	340010SF	36.75	340210SF	42.20	341010SF	47.25	343010SF	344010SF	54.60	345010SF	44.05	346510SF	\$66.50
.3151 - .3470	340011SF	38.05	340211SF	43.85	341011SF	51.95	343011SF	344011SF	55.15	345011SF	45.65	346511SF	66.50
.3471 - .3780	340012SF	34.95	340212SF	40.20	341012SF	52.55	343012SF	344012SF	59.75	345012SF	45.65	346512SF	62.35
.3781 - .4090	340013SF	39.90	340213SF	45.95	341013SF	54.85	343013SF	344013SF	60.55	345013SF	47.85	346513SF	66.10
.4091 - .4410	340014SF	42.60	340214SF	48.90	341014SF	57.05	343014SF	344014SF	71.85	345014SF	51.80	346514SF	66.10
.4411 - .4720	340015SF	43.25	340215SF	50.30	341015SF	60.55	343015SF	344015SF	71.85	345015SF	56.00	346515SF	70.05
.4721 - .5030	340016SF	51.50	340216SF	59.20	341016SF	68.85	343016SF	344016SF	78.50	345016SF	60.05	346516SF	70.05
.5031 - .5340	340017SF	56.00	340217SF	63.95	341017SF	68.85	343017SF	344017SF	78.50	345017SF	61.60	346517SF	71.85
.5341 - .5660	340018SF	56.00	340218SF	63.95	341018SF	68.85	343018SF	344018SF	82.80	345018SF	61.60	346518SF	71.85
.5661 - .5970	340019SF	58.25	340219SF	66.95	341019SF	70.95	343019SF	344019SF	82.80	345019SF	64.05	346519SF	74.95
.5971 - .6280	340020SF	58.25	340220SF	66.95	341020SF	70.95	343020SF	344020SF	84.95	345020SF	64.05	346520SF	74.95
.6281 - .6590	340021SF	59.30	340221SF	68.20	341021SF	75.55	343021SF	344021SF	84.95	345021SF	65.15	346521SF	82.00
.6591 - .6910	340022SF	59.30	340222SF	68.20	341022SF	77.75	343022SF	344022SF	88.90	345022SF	65.15	346522SF	82.00
.6911 - .7220	340023SF	62.05	340223SF	71.30	341023SF	80.05	343023SF	344023SF	88.90	345023SF	68.20	346523SF	85.10
.7221 - .7530	340024SF	62.05	340224SF	71.30	341024SF	80.05	343024SF	344024SF	91.20	345024SF	68.20	346524SF	85.10
.7531 - .7840	340025SF	64.10	340225SF	73.55	341025SF	84.95	343025SF	344025SF	91.20	345025SF	70.50	346525SF	91.70
.7841 - .8160	340026SF	64.10	340226SF	73.55	341026SF	84.95	343026SF	344026SF	99.05	345026SF	70.50	346526SF	91.70
.8161 - .8470	340027SF	66.70	340227SF	76.65	341027SF	89.55	343027SF	344027SF	99.05	345027SF	73.40	346527SF	95.25
.8471 - .8780	340028SF	69.20	340228SF	79.55	341028SF	92.95	343028SF	344028SF	108.25	345028SF	76.15	346528SF	98.85
.8781 - .9090	340029SF	80.70	340229SF	93.30	341029SF	108.25	343029SF	344029SF	108.25	345029SF	88.65	346529SF	105.20
.9091 - .9410	340030SF	80.70	340230SF	93.30	341030SF	108.25	343030SF	344030SF	119.20	345030SF	88.65	346530SF	105.20
.9411 - .9720	340031SF	84.55	340231SF	97.15	341031SF	113.50	343031SF	344031SF	119.20	345031SF	92.85	346531SF	109.35
.9721 - 1.0030	340032SF	84.55	340232SF	97.15	341032SF	113.50	343032SF	344032SF	125.10	345032SF	92.85	346532SF	109.35
1.0031 - 1.0660	340034SF	87.40	340234SF	133.60	341034SF	121.90	343034SF	344034SF	125.10	345034SF	96.10	346534SF	119.80
1.0661 - 1.1280	340036SF	94.50	340236SF	142.20	341036SF	125.60	343036SF	344036SF	146.40	345036SF	103.95	346536SF	119.80
1.1281 - 1.1905	340038SF	99.25	340238SF	150.70	341038SF	132.00	343038SF	344038SF	152.70	345038SF	108.70	346538SF	130.75
1.1906 - 1.2530	340040SF	104.95	340240SF	167.50	341040SF	139.60	343040SF	344040SF	178.85	345040SF	126.95	346540SF	130.75
1.2531 - 1.3155	340042SF	110.40	340242SF	180.55	341042SF	154.55	343042SF	344042SF	178.85	345042SF	126.95	346542SF	145.00
1.3156 - 1.3780	340044SF	117.10	340244SF	187.90	341044SF	169.30	343044SF	344044SF	181.35	345044SF	128.80	346544SF	151.75
1.3781 - 1.4405	340046SF	130.60	340246SF	191.80	341046SF	179.40	343046SF	344046SF	211.45	345046SF	142.30	346546SF	179.25
1.4406 - 1.5030	340048SF	138.05	340248SF	201.35	341048SF	189.55	343048SF	344048SF	253.95	345048SF	170.95	346548SF	184.55

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 67.

For reamer tolerances and closer tolerance pricing, see page 56.

TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH			EDP NO.	PRICE EACH	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*
.2500	1/4	1	4	1 1/2	1/2	6	340208	\$48.80	.2381 - .2530	\$88.35	\$68.55	\$61.95	\$58.75	\$55.45	\$52.75
.2812	9/32	1	4	1 1/2	1/2	6	340209	49.70	.2531 - .2840	89.25	69.45	62.85	59.65	56.30	53.65
.3125	5/16	1	4	1 1/2	1/2	6	340210	49.70	.2841 - .3150	89.25	69.45	62.85	59.65	56.30	53.65
.3438	11/32	1	4	1 1/2	5/8	6	340211	51.55	.3151 - .3470	91.10	71.30	64.70	61.50	58.15	55.50
.3750	3/8	1	4	1 3/4	5/8	7	340212	47.35	.3471 - .3780	83.60	65.45	59.35	56.45	53.35	50.90
.4062	13/32	1	4	1 3/4	5/8	7	340213	54.10	.3781 - .4090	93.65	73.85	67.25	64.05	60.70	58.00
.4375	7/16	1	4	1 3/4	5/8	7	340214	57.60	.4091 - .4410	97.15	77.30	70.70	67.50	64.10	61.45
.4688	15/32	1	4	1 3/4	5/8	7	340215	59.15	.4411 - .4720	98.70	78.85	72.20	69.10	65.65	63.00
.5000	1/2	1	6	2	5/8	8	340216	69.60	.4721 - .5030	113.15	91.35	84.05	80.60	76.85	73.90
.5312	17/32	1	6	2	5/8	8	340217	75.15	.5031 - .5340	118.70	96.90	89.55	86.05	82.35	79.40
.5625	9/16	1	6	2	5/8	8	340218	75.15	.5341 - .5660	118.70	96.90	89.55	86.05	82.35	79.40
.5938	19/32	1	6	2	5/8	8	340219	78.80	.5661 - .5970	122.35	100.55	93.20	89.80	86.00	83.10
.6250	5/8	2	6	2 1/4	5/8	9	340220	78.80	.5971 - .6280	122.35	100.55	93.20	89.80	86.00	83.10
.6562	21/32	2	6	2 1/4	5/8	9	340221	80.20	.6281 - .6590	123.75	101.95	94.70	91.20	87.40	84.50
.6875	11/16	2	6	2 1/4	5/8	9	340222	80.20	.6591 - .6910	123.75	101.95	94.70	91.20	87.40	84.50
.7188	23/32	2	6	2 1/4	5/8	9	340223	83.85	.6911 - .7220	127.40	105.60	98.30	94.85	91.10	88.15
.7500	3/4	2	6	2 1/2	3/4	9 1/2	340224	83.85	.7221 - .7530	127.40	105.60	98.30	94.85	91.10	88.15
.7812	25/32	2	6	2 1/2	3/4	9 1/2	340225	86.45	.7531 - .7840	130.00	108.20	100.90	97.40	93.65	90.75
.8125	13/16	2	6	2 1/2	3/4	9 1/2	340226	86.45	.7841 - .8160	130.00	108.20	100.90	97.40	93.65	90.75
.8438	27/32	2	6	2 1/2	3/4	9 1/2	340227	90.25	.8161 - .8470	133.70	111.90	104.60	101.15	97.40	94.45
.8750	7/8	2	6	2 5/8	3/4	10	340228	93.65	.8471 - .8780	138.75	116.10	108.55	104.95	101.10	98.00
.9062	29/32	2	6	2 5/8	3/4	10	340229	109.80	.8781 - .9090	154.90	132.30	124.75	121.10	117.25	114.20
.9375	15/16	3	8	2 5/8	3/4	10	340230	109.80	.9091 - .9410	154.90	132.30	124.75	121.10	117.25	114.20
.9688	31/32	3	8	2 5/8	3/4	10	340231	114.40	.9411 - .9720	159.55	136.90	129.35	125.75	121.90	118.80
1.0000	1	3	8	2 3/4	3/4	10 1/2	340232	114.40	.9721 - 1.0030	159.55	136.90	129.35	125.75	121.90	118.80
1.0625	1 1/16	3	8	2 3/4	3/4	10 1/2	340234	157.15	1.0031 - 1.0660	200.50	178.80	171.55	168.10	164.30	161.40
1.1250	1 1/8	3	8	2 7/8	7/8	11	340236	167.40	1.0661 - 1.1280	210.65	188.95	181.70	178.25	174.55	171.65
1.1875	1 3/16	3	8	2 7/8	7/8	11	340238	177.25	1.1281 - 1.1905	220.60	198.90	191.65	188.20	184.40	181.55
1.2500	1 1/4	4	8	3	7/8	11 1/2	340240	197.05	1.1906 - 1.2530	240.30	218.60	211.35	207.90	204.20	201.30
1.3125	1 3/16	4	8	3	7/8	11 1/2	340242	212.45	1.2531 - 1.3155	255.70	234.00	226.75	223.30	219.60	216.70
1.3750	1 3/8	4	8	3 1/4	7/8	12	340244	221.00	1.3156 - 1.3780	264.35	242.65	235.40	231.90	228.25	225.30
1.4375	1 7/16	4	8	3 1/4	7/8	12	340246	225.60	1.3781 - 1.4405	268.95	247.25	239.95	236.55	232.75	229.85
1.5000	1 1/2	4	8	3 1/2	7/8	12 1/2	340248	236.85	1.4406 - 1.5030	280.20	258.50	251.25	247.80	244.00	241.10
1.5625	1 9/16	4	8	3 1/2	7/8	12 1/2	340250	255.65	1.5031 - 1.5660	298.90	277.30	269.95	266.55	262.80	259.90
1.6250	1 5/8	4	8	3 3/4	7/8	13	340252	264.50	1.5661 - 1.6280	307.75	286.15	278.80	275.35	271.65	268.75
1.6875	1 11/16	4	8	3 3/4	7/8	13	340254	297.45	1.6281 - 1.6910	340.70	319.00	311.75	308.30	304.60	301.70
1.7500	1 3/4	4	10	4	7/8	13 1/2	340256	297.45	1.6911 - 1.7530	340.70	319.00	311.75	308.30	304.60	301.70
1.8125	1 13/16	4	10	4	7/8	13 1/2	340258	297.45	1.7531 - 1.8160	340.70	319.00	311.75	308.30	304.60	301.70
1.8750	1 7/8	4	10	4 1/4	7/8	14	340260	311.60	1.8161 - 1.8780	354.90	333.20	325.95	322.50	318.80	315.85
1.9375	1 15/16	4	10	4 1/4	7/8	14	340262	311.60	1.8781 - 1.9410	354.90	333.20	325.95	322.50	318.80	315.85
2.0000	2	4	12	4 1/4	7/8	14	340264	311.60	1.9411 - 2.0030	354.90	333.20	325.95	322.50	318.80	315.85

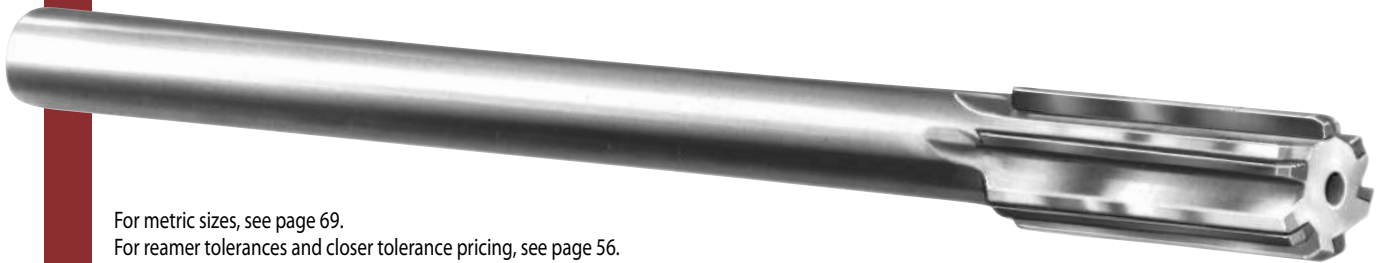
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CARBIDE TIPPED CHUCKING REAMERS

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 46 through 52.



For metric sizes, see page 69.

For reamer tolerances and closer tolerance pricing, see page 56.

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	11/64	4	1 1/2	6	345006	\$50.70	.1770 - .2040	\$91.35	\$70.95	\$64.25	\$60.90	\$57.45	\$54.70
.2188	7/32	13/64	4	1 1/2	6	345007	50.70	.2041 - .2210	91.35	70.95	64.25	60.90	57.45	54.70
.2344	15/64	7/32	4	1 1/2	6	34502344	50.70	.2211 - .2380	91.35	70.95	64.25	60.90	57.45	54.70
.2500	1/4	15/64	4	1 1/2	6	345008	50.70	.2381 - .2530	91.35	70.95	64.25	60.90	57.45	54.70
.2812	9/32	15/64	4	1 1/2	6	345009	51.80	.2531 - .2840	92.40	72.05	65.20	62.05	58.45	55.80
.3125	5/16	9/32	4	1 1/2	6	345010	51.80	.2841 - .3150	92.40	72.05	65.20	62.05	58.45	55.80
.3438	11/32	9/32	4	1 1/2	6	345011	53.70	.3151 - .3470	94.30	74.00	67.15	63.90	60.40	57.65
.3750	3/8	5/16	4	1 3/4	7	345012	53.70	.3471 - .3780	94.30	74.00	67.15	63.90	60.40	57.65
.4062	13/32	5/16	4	1 3/4	7	345013	56.30	.3781 - .4090	97.00	76.65	69.80	66.55	63.05	60.30
.4375	7/16	3/8	4	1 3/4	7	345014	60.90	.4091 - .4410	101.60	81.15	74.35	71.15	67.65	64.90
.4688	15/32	3/8	4	1 3/4	7	345015	65.80	.4411 - .4720	106.50	86.05	79.25	76.05	72.55	69.80
.5000	1/2	7/16	6	2	8	345016	70.50	.4721 - .5030	114.05	92.25	84.95	81.45	77.75	74.80
.5312	17/32	7/16	6	2	8	345017	72.50	.5031 - .5340	116.05	94.25	86.95	83.40	79.70	76.70
.5625	9/16	7/16	6	2	8	345018	72.50	.5341 - .5660	116.05	94.25	86.95	83.40	79.70	76.70
.5938	19/32	7/16	6	2	8	345019	75.30	.5661 - .5970	118.85	97.05	89.80	86.30	82.50	79.60
.6250	5/8	9/16	6	2	9	345020	75.30	.5971 - .6280	118.85	97.05	89.80	86.30	82.50	79.60
.6562	21/32	9/16	6	2	9	345021	76.65	.6281 - .6590	120.20	98.40	91.10	87.65	83.85	80.95
.6875	11/16	9/16	6	2	9	345022	76.65	.6591 - .6910	120.20	98.40	91.10	87.65	83.85	80.95
.7188	23/32	9/16	6	2	9	345023	80.20	.6911 - .7220	123.75	101.95	94.70	91.20	87.40	84.50
.7500	3/4	5/8	6	2	9 1/2	345024	80.20	.7221 - .7530	123.75	101.95	94.70	91.20	87.40	84.50
.7812	25/32	5/8	6	2	9 1/2	345025	82.95	.7531 - .7840	126.50	104.70	97.40	93.95	90.25	87.25
.8125	13/16	5/8	6	2	9 1/2	345026	82.95	.7841 - .8160	126.50	104.70	97.40	93.95	90.25	87.25
.8438	27/32	5/8	6	2	9 1/2	345027	86.30	.8161 - .8470	129.85	108.05	100.70	97.20	93.50	90.50
.8750	7/8	3/4	6	2 1/4	10	345028	89.55	.8471 - .8780	134.75	112.10	104.50	100.85	97.00	93.95
.9062	29/32	3/4	6	2 1/4	10	345029	104.25	.8781 - .9090	149.40	126.75	119.20	115.60	111.75	108.65
.9375	15/16	3/4	8	2 1/4	10	345030	104.25	.9091 - .9410	149.40	126.75	119.20	115.60	111.75	108.65
.9688	31/32	3/4	8	2 1/4	10	345031	109.20	.9411 - .9720	154.40	131.75	124.20	120.60	116.75	113.65
1.0000	1	7/8	8	2 1/4	10 1/2	345032	109.20	.9721 - 1.0030	154.40	131.75	124.20	120.60	116.75	113.65
1.0625	1 1/16	7/8	8	2 1/4	10 1/2	345034	112.95	1.0031 - 1.0660	156.30	134.60	127.35	123.90	120.20	117.25
1.1250	1 1/8	7/8	8	2 1/4	11	345036	122.30	1.0661 - 1.1280	165.55	143.90	136.60	133.20	129.45	126.50
1.1875	1 3/16	1	8	2 1/4	11	345038	127.95	1.1281 - 1.1905	171.25	149.55	142.30	138.85	135.15	132.20
1.2500	1 1/4	1	8	2 1/2	11 1/2	345040	149.40	1.1906 - 1.2530	192.65	171.00	163.70	160.30	156.55	153.60
1.3125	1 5/16	1	8	2 1/2	11 1/2	345042	149.40	1.2531 - 1.3155	192.65	171.00	163.70	160.30	156.55	153.60
1.3750	1 3/8	1	8	2 1/2	12	345044	151.60	1.3156 - 1.3780	194.90	173.15	165.95	162.45	158.75	155.85
1.4375	1 7/16	1 1/4	8	2 1/2	12	345046	167.50	1.3781 - 1.4405	210.75	189.05	181.80	178.35	174.65	171.70
1.5000	1 1/2	1 1/4	8	2 1/2	12 1/2	345048	200.95	1.4406 - 1.5030	244.30	222.60	215.35	211.90	208.20	205.30
1.5625	1 9/16	1 1/4	8	2 1/2	12 1/2	345050	265.25	1.5031 - 1.5660	308.60	286.90	279.65	276.20	272.50	269.60
1.6250	1 5/8	1 1/4	8	2 3/4	13	345052	274.45	1.5661 - 1.6280	317.70	296.00	288.75	285.30	281.60	278.65
1.6875	1 11/16	1 1/4	8	2 3/4	13	345054	301.30	1.6281 - 1.6910	344.65	322.95	315.70	312.25	308.55	305.60
1.7500	1 3/4	1 1/4	10	3	13 1/2	345056	301.30	1.6911 - 1.7530	344.65	322.95	315.70	312.25	308.55	305.60
1.8125	1 13/16	1 1/2	10	3	13 1/2	345058	308.30	1.7531 - 1.8160	351.65	329.95	322.70	319.25	315.45	312.60
1.8750	1 7/8	1 1/2	10	3 1/4	14	345060	323.30	1.8161 - 1.8780	366.60	344.90	337.65	334.20	330.50	327.55
1.9375	1 15/16	1 1/2	10	3 1/4	14	345062	342.80	1.8781 - 1.9410	386.10	364.35	357.15	353.65	349.95	347.05
2.0000	2	1 1/2	12	3 1/4	14	345064	342.80	1.9411 - 2.0030	386.10	364.35	357.15	353.65	349.95	347.05

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 56.

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	\$60.85	.1770 - .2040	\$101.50	\$81.10	\$74.25	\$71.10	\$67.60	\$64.85
.2031	13/64	.1805	4	1 1/8	4 1/2	34802031	60.85	-	-	-	-	-	-	-
.2188	7/32	.2075	4	1 1/4	5	348007	60.85	.2041 - .2210	101.50	81.10	74.25	71.10	67.60	64.85
.2344	15/64	.2265	4	1 1/2	6	34802344	60.85	.2211 - .2380	101.50	81.10	74.25	71.10	67.60	64.85
.2500	1/4	.2405	4	1 1/2	6	348008	60.85	.2381 - .2530	101.50	81.10	74.25	71.10	67.60	64.85
.2656	17/64	.2485	4	1 1/2	6	34802656	62.20	-	-	-	-	-	-	-
.2812	9/32	.2485	4	1 1/2	6	348009	62.20	.2531 - .2840	102.75	82.45	75.60	72.40	68.85	66.20
.2969	19/64	.2792	4	1 1/2	6	34802969	62.20	-	-	-	-	-	-	-
.3125	5/16	.2792	4	1 1/2	6	348010	62.20	.2841 - .3150	102.75	82.45	75.60	72.40	68.85	66.20
.3281	21/64	.2792	4	1 1/2	6	34803281	64.40	-	-	-	-	-	-	-
.3438	11/32	.2792	4	1 1/2	6	348011	64.40	.3151 - .3470	105.05	84.65	77.85	74.65	71.15	68.40
.3594	23/64	.3105	4	1 3/4	7	34803594	64.40	-	-	-	-	-	-	-
.3750	3/8	.3105	4	1 3/4	7	348012	64.40	.3471 - .3780	105.05	84.65	77.85	74.65	71.15	68.40
.3906	25/64	.3105	4	1 3/4	7	34803906	67.60	-	-	-	-	-	-	-
.4062	13/32	.3105	4	1 3/4	7	348013	67.60	.3781 - .4090	108.20	87.85	81.05	77.75	74.25	71.55
.4219	27/64	.3730	6	1 3/4	7	34804219	78.30	-	-	-	-	-	-	-
.4375	7/16	.3730	6	1 3/4	7	348014	78.30	.4091 - .4410	118.95	98.55	91.70	88.50	85.05	82.30
.4531	29/64	.3730	6	1 3/4	7	34804531	79.00	-	-	-	-	-	-	-
.4688	15/32	.3730	6	1 3/4	7	348015	79.00	.4411 - .4720	119.70	99.30	92.55	89.25	85.80	83.05
.4844	31/64	.4355	6	2	8	34804844	84.65	-	-	-	-	-	-	-
.5000	1/2	.4355	6	2	8	348016	84.65	.4721 - .5030	128.20	106.40	99.15	95.65	91.85	88.95
.5156	33/64	.4355	6	2	8	34805156	87.10	-	-	-	-	-	-	-
.5312	17/32	.4355	6	2	8	348017	87.10	.5031 - .5340	130.60	108.80	101.50	98.00	94.30	91.35
.5469	35/64	.4355	6	2	8	34805469	87.10	-	-	-	-	-	-	-
.5625	9/16	.4355	6	2	8	348018	87.10	.5341 - .5660	130.60	108.80	101.50	98.00	94.30	91.35
.5781	37/64	.4355	6	2	8	34805781	90.40	-	-	-	-	-	-	-
.5938	19/32	.4355	6	2	8	348019	90.40	.5661 - .5970	133.95	112.10	104.75	101.35	97.55	94.70
.6094	39/64	.5615	6	2 1/4	9	34806094	90.40	-	-	-	-	-	-	-
.6250	5/8	.5615	6	2 1/4	9	348020	90.40	.5971 - .6280	133.95	112.10	104.75	101.35	97.55	94.70
.6406	41/64	.5615	6	2 1/4	9	34806406	92.10	-	-	-	-	-	-	-
.6562	21/32	.5615	6	2 1/4	9	348021	92.10	.6281 - .6590	135.65	113.80	106.50	103.00	99.30	96.30
.6719	43/64	.5615	6	2 1/4	9	34806719	92.10	-	-	-	-	-	-	-

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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	\$92.10	.6591 - .6910	\$135.65	\$113.80	\$106.50	\$103.00	99.30	\$96.30
.7031	45/64	.5615	6	2 1/4	9	34807031	96.25	-	-	-	-	-	-	-
.7188	23/32	.5615	6	2 1/4	9	348023	96.25	.6911 - .7220	139.80	118.00	110.70	107.20	103.45	100.55
.7344	47/64	.6245	6	2 1/2	9 1/2	34807344	96.25	-	-	-	-	-	-	-
.7500	3/4	.6245	6	2 1/2	9 1/2	348024	96.25	.7221 - .7530	139.80	118.00	110.70	107.20	103.45	100.55
.7656	49/64	.6245	6	2 1/2	9 1/2	34807656	99.60	-	-	-	-	-	-	-
.7812	25/32	.6245	6	2 1/2	9 1/2	348025	99.60	.7531 - .7840	143.05	121.25	113.95	110.50	106.75	103.80
.7969	51/64	.6245	6	2 1/2	9 1/2	34807969	99.60	-	-	-	-	-	-	-
.8125	13/16	.6245	6	2 1/2	9 1/2	348026	99.60	.7841 - .8160	143.05	121.25	113.95	110.50	106.75	103.80
.8281	53/64	.6245	6	2 1/2	9 1/2	34808281	103.60	-	-	-	-	-	-	-
.8438	27/32	.6245	6	2 1/2	9 1/2	348027	103.60	.8161 - .8470	147.05	125.25	118.00	114.50	110.80	107.80
.8594	55/64	.7495	6	2 5/8	10	34808594	103.60	-	-	-	-	-	-	-
.8750	7/8	.7495	6	2 5/8	10	348028	107.50	.8471 - .8780	152.60	130.00	122.45	118.80	114.95	111.90
.8906	57/64	.7495	6	2 5/8	10	34808906	125.10	-	-	-	-	-	-	-
.9062	29/32	.7495	6	2 5/8	10	348029	125.10	.8781 - .9090	170.30	147.70	140.05	136.45	132.60	129.50
.9219	59/64	.7495	8	2 5/8	10	34809219	125.10	-	-	-	-	-	-	-
.9375	19/16	.7495	8	2 5/8	10	348030	125.10	.9091 - .9410	170.30	147.70	140.05	136.45	132.60	129.50
.9531	61/64	.7495	8	2 5/8	10	34809531	131.15	-	-	-	-	-	-	-
.9688	31/32	.7495	8	2 5/8	10	348031	131.15	.9411 - .9720	176.35	153.70	146.05	142.45	138.60	135.50
.9844	63/64	.8745	8	2 3/4	10 1/2	34809844	131.15	-	-	-	-	-	-	-
1.0000	1	.8745	8	2 3/4	10 1/2	348032	131.15	.9721 - 1.0030	176.35	153.70	146.05	142.45	138.60	135.50
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	348034	135.60	1.0031 - 1.0660	178.85	157.15	149.90	146.45	142.75	139.85
1.1250	1 1/8	.8745	8	2 7/8	11	348036	146.85	1.0661 - 1.1280	190.10	168.40	161.15	157.70	154.00	151.05
1.1875	1 3/16	.9995	8	2 7/8	11	348038	160.80	1.1281 - 1.1905	204.15	182.40	175.20	171.70	168.00	165.10
1.2500	1 1/4	.9995	8	3	11 1/2	348040	179.25	1.1906 - 1.2530	222.55	200.80	193.60	190.10	186.40	183.50
1.3125	1 5/16	.9995	8	3	11 1/2	348042	179.25	1.2531 - 1.3155	222.55	200.80	193.60	190.10	186.40	183.50
1.3750	1 3/8	.9995	8	3 1/4	12	348044	181.85	1.3156 - 1.3780	225.15	203.50	196.20	192.80	189.05	186.10
1.4375	1 7/16	.9995	8	3 1/4	12	348046	200.90	1.3781 - 1.4405	244.25	222.55	215.30	211.85	208.05	205.20
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	348048	241.30	1.4406 - 1.5030	284.60	262.90	255.65	252.20	248.50	245.55

*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	\$76.05
.1885	.1805	4	1 1/8	4 1/2	348819	76.05
.2490	.2405	4	1 1/2	6	348824	76.05
.2510	.2405	4	1 1/2	6	348825	76.05
.3115	.2792	4	1 1/2	6	348831	77.40
.3135	.2792	4	1 1/2	6	348832	77.40
.3740	.3105	4	1 3/4	7	348837	79.60
.3760	.3105	4	1 3/4	7	348838	79.60
.4365	.3730	6	1 3/4	7	348843	93.50
.4385	.3730	6	1 3/4	7	348844	93.50
.4990	.4355	6	2	8	348849	101.00
.5010	.4355	6	2	8	348850	101.00
CASED SET OF ABOVE 12 REAMERS					348800	956.80

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	\$76.05
.1870	.1805	4	1 1/8	4 1/2	348618	76.05
.2480	.2405	4	1 1/2	6	348623	76.05
.2495	.2405	4	1 1/2	6	348624	76.05
.3105	.2792	4	1 1/2	6	348630	77.40
.3120	.2792	4	1 1/2	6	348631	77.40
.3730	.3105	4	1 3/4	7	348636	79.60
.3745	.3105	4	1 3/4	7	348637	79.60
.4355	.3730	6	1 3/4	7	348642	93.50
.4370	.3730	6	1 3/4	7	348643	93.50
.4980	.4355	6	2	8	348648	101.00
.4995	.4355	6	2	8	348649	101.00
CASED SET OF ABOVE 12 REAMERS					348600	956.80

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 56.

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	\$58.30	.2381 - .2530	\$99.00	\$78.65	\$71.85	\$68.55	\$65.05	\$62.35
.2812	9/32	1	4	1 1/2	6	345209	59.15	.2531 - .2840	99.80	79.45	72.65	69.40	65.90	63.15
.3125	5/16	1	4	1 1/2	6	345210	59.15	.2841 - .3150	99.80	79.45	72.65	69.40	65.90	63.15
.3438	11/32	1	4	1 1/2	6	345211	60.45	.3151 - .3470	101.15	80.80	74.00	70.70	67.25	64.50
.3750	3/8	1	4	1 3/4	7	345212	61.15	.3471 - .3780	101.80	81.45	74.65	71.40	67.90	65.15
.4062	13/32	1	4	1 3/4	7	345213	64.40	.3781 - .4090	105.05	84.65	77.85	74.65	71.15	68.40
.4375	7/16	1	4	1 3/4	7	345214	68.65	.4091 - .4410	109.30	88.90	82.15	78.85	75.40	72.65
.4688	15/32	1	4	1 3/4	7	345215	70.05	.4411 - .4720	110.70	90.30	83.55	80.30	76.80	74.05
.5000	1/2	1	6	2	8	345216	75.55	.4721 - .5030	119.00	97.20	89.95	86.45	82.75	79.75
.5312	17/32	1	6	2	8	345217	82.75	.5031 - .5340	126.30	104.45	97.15	93.65	89.95	86.95
.5625	9/16	1	6	2	8	345218	82.75	.5341 - .5660	126.30	104.45	97.15	93.65	89.95	86.95
.5938	19/32	1	6	2	8	345219	86.50	.5661 - .5970	130.05	108.25	101.00	97.50	93.80	90.80
.6250	5/8	2	6	2	9	345220	86.50	.5971 - .6280	130.05	108.25	101.00	97.50	93.80	90.80
.6562	21/32	2	6	2	9	345221	88.15	.6281 - .6590	131.70	109.90	102.55	99.15	95.35	92.45
.6875	11/16	2	6	2	9	345222	88.15	.6591 - .6910	131.70	109.90	102.55	99.15	95.35	92.45
.7188	23/32	2	6	2	9	345223	89.40	.6911 - .7220	132.95	111.15	103.80	100.30	96.60	93.65
.7500	3/4	2	6	2	9 1/2	345224	92.25	.7221 - .7530	135.80	113.95	106.70	103.20	99.45	96.55
.7812	25/32	2	6	2	9 1/2	345225	92.95	.7531 - .7840	136.55	114.70	107.35	103.90	100.15	97.20
.8125	13/16	2	6	2	9 1/2	345226	95.10	.7841 - .8160	138.60	116.80	109.50	106.05	102.30	99.35
.8438	27/32	2	6	2	9 1/2	345227	99.30	.8161 - .8470	142.85	121.00	113.65	110.25	106.50	103.60
.8750	7/8	2	6	2 1/4	10	345228	103.05	.8471 - .8780	148.20	125.60	117.95	114.40	110.50	107.50
.9062	29/32	2	6	2 1/4	10	345229	116.05	.8781 - .9090	161.25	138.60	131.05	127.45	123.50	120.50
.9375	15/16	3	8	2 1/4	10	345230	120.65	.9091 - .9410	165.85	143.20	135.65	132.05	128.15	125.10
.9688	31/32	3	8	2 1/4	10	345231	125.65	.9411 - .9720	170.85	148.20	140.60	137.05	133.15	130.15
1.0000	1	3	8	2 1/4	10 1/2	345232	125.65	.9721 - 1.0030	170.85	148.20	140.60	137.05	133.15	130.15
1.0625	1 1/16	3	8	2 1/4	10 1/2	345234	172.25	1.0031 - 1.0660	215.50	193.80	186.55	183.10	179.40	176.50
1.1250	1 1/8	3	8	2 1/4	11	345236	185.50	1.0661 - 1.1280	228.85	207.15	199.90	196.45	192.65	189.75
1.1875	1 3/16	3	8	2 1/4	11	345238	199.35	1.1281 - 1.1905	242.65	220.90	213.70	210.20	206.50	203.60
1.2500	1 1/4	4	8	2 1/2	11 1/2	345240	211.85	1.1906 - 1.2530	255.10	233.40	226.15	222.70	219.00	216.05
1.3125	1 5/16	4	8	2 1/2	11 1/2	345242	239.15	1.2531 - 1.3155	282.45	260.80	253.50	250.10	246.30	243.40
1.3750	1 3/8	4	8	2 1/2	12	345244	273.25	1.3156 - 1.3780	316.55	294.90	287.60	284.15	280.45	277.50
1.4375	1 7/16	4	8	2 1/2	12	345246	285.20	1.3781 - 1.4405	328.50	306.85	299.55	296.15	292.35	289.45
1.5000	1 1/2	4	8	2 1/2	12 1/2	345248	297.15	1.4406 - 1.5030	340.50	318.80	311.55	308.10	304.40	301.45

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CARBIDE TIPPED CHUCKING REAMERS METRIC

TYPE 3452 - TAPER SHANK - STRAIGHT FLUTE LONG CARBIDE

Detailed description and fractional sizes on page 76. Tolerances on page 56.
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+
6.0	.2362	1	4	1 1/2	6	3452060	\$71.85	6.000 - 6.426	\$102.40	\$82.15	\$75.30	\$71.95	\$68.55	\$65.75	\$61.80
6.5	.2559	1	4	1 1/2	6	3452065	72.65	6.427 - 7.214	103.20	82.95	76.15	72.80	69.40	66.55	62.60
7.0	.2756	1	4	1 1/2	6	3452070	72.65	-	-	-	-	-	-	-	-
7.5	.2953	1	4	1 1/2	6	3452075	72.65	7.215 - 8.001	103.20	82.95	76.15	72.80	69.40	66.55	62.60
8.0	.3150	1	4	1 1/2	6	3452080	72.65	-	-	-	-	-	-	-	-
8.5	.3346	1	4	1 1/2	6	3452085	74.00	8.002 - 8.814	104.55	84.30	77.45	74.15	70.70	67.90	63.95
9.0	.3543	1	4	1 3/4	7	3452090	74.65	8.815 - 9.601	105.20	84.95	78.15	74.80	71.40	68.55	64.65
9.5	.3740	1	4	1 3/4	7	3452095	74.65	-	-	-	-	-	-	-	-
10.0	.3937	1	4	1 3/4	7	3452100	77.85	9.602 - 10.389	108.50	88.15	81.30	78.05	74.65	71.85	67.90
10.5	.4134	1	4	1 3/4	7	3452105	82.15	10.390 - 11.201	112.70	92.40	85.65	82.30	78.85	76.05	72.10
11.0	.4331	1	4	1 3/4	7	3452110	82.15	-	-	-	-	-	-	-	-
11.5	.4528	1	4	1 3/4	7	3452115	83.55	11.202 - 11.989	114.10	93.80	87.05	83.70	80.30	77.45	73.55
12.0	.4724	1	6	2	8	3452120	89.95	11.990 - 12.776	122.75	101.00	93.65	90.10	86.45	83.40	79.25
12.5	.4921	1	6	2	8	3452125	89.95	-	-	-	-	-	-	-	-
13.0	.5118	1	6	2	8	3452130	97.15	12.777 - 13.564	129.90	108.20	100.90	97.35	93.65	90.65	86.45
13.5	.5315	1	6	2	8	3452135	97.15	-	-	-	-	-	-	-	-
14.0	.5512	1	6	2	8	3452140	97.15	13.565 - 14.376	129.90	108.20	100.90	97.35	93.65	90.65	86.45
14.5	.5709	1	6	2	8	3452145	101.00	14.377 - 15.164	133.70	112.05	104.70	101.15	97.50	94.45	90.30
15.0	.5906	1	6	2	8	3452150	101.00	-	-	-	-	-	-	-	-
15.5	.6102	2	6	2	9	3452155	101.00	15.165 - 15.951	133.70	112.05	104.70	101.15	97.50	94.45	90.30
16.0	.6299	2	6	2	9	3452160	102.55	15.952 - 16.739	135.35	113.60	106.35	102.75	99.15	96.10	91.85
16.5	.6496	2	6	2	9	3452165	102.55	-	-	-	-	-	-	-	-
17.0	.6693	2	6	2	9	3452170	102.55	16.740 - 17.551	135.35	113.60	106.35	102.75	99.15	96.10	91.85
17.5	.6890	2	6	2	9	3452175	102.55	-	-	-	-	-	-	-	-
18.0	.7087	2	6	2	9	3452180	103.80	17.552 - 18.339	136.60	114.85	107.60	104.05	100.30	97.35	93.10
18.5	.7283	2	6	2	9 1/2	3452185	106.70	18.340 - 19.126	139.40	117.70	110.40	106.85	103.20	100.15	96.00
19.0	.7480	2	6	2	9 1/2	3452190	106.70	-	-	-	-	-	-	-	-
19.5	.7677	2	6	2	9 1/2	3452195	107.35	19.127 - 19.914	140.15	118.40	111.15	107.60	103.90	100.90	96.70
20.0	.7874	2	6	2	9 1/2	3452200	109.50	19.915 - 20.726	142.30	120.60	113.25	109.65	106.05	103.00	98.85
20.5	.8071	2	6	2	9 1/2	3452205	109.50	-	-	-	-	-	-	-	-
21.0	.8268	2	6	2	9 1/2	3452210	113.65	20.727 - 21.514	146.45	124.75	117.45	113.90	110.25	107.20	103.00
21.5	.8465	2	6	2	9 1/2	3452215	113.65	-	-	-	-	-	-	-	-
22.0	.8661	2	6	2 1/4	10	3452220	113.65	21.515 - 22.301	146.45	124.75	117.45	113.90	110.25	107.20	103.00
22.5	.8858	2	6	2 1/4	10	3452225	131.05	22.302 - 23.089	165.00	142.45	134.90	131.20	127.45	124.30	119.95
23.0	.9055	2	6	2 1/4	10	3452230	131.05	-	-	-	-	-	-	-	-
23.5	.9252	3	8	2 1/4	10	3452235	135.65	23.090 - 23.901	169.65	147.05	139.50	135.85	132.05	128.90	124.60
24.0	.9449	3	8	2 1/4	10	3452240	140.60	23.902 - 24.689	174.65	152.10	144.55	140.85	137.05	133.90	129.50
24.5	.9646	3	8	2 1/4	10	3452245	140.60	-	-	-	-	-	-	-	-
25.0	.9843	3	8	2 1/4	10 1/2	3452250	140.60	24.690 - 25.476	174.65	152.10	144.55	140.85	137.05	133.90	129.50
25.5	1.0039	3	8	2 1/4	10 1/2	3452255	186.55	25.477 - 27.076	219.15	197.60	190.25	186.70	183.10	180.10	175.95
26.0	1.0236	3	8	2 1/4	10 1/2	3452260	186.55	-	-	-	-	-	-	-	-
27.0	1.0630	3	8	2 1/4	10 1/2	3452270	186.55	-	-	-	-	-	-	-	-
28.0	1.1024	3	8	2 1/4	11	3452280	199.90	27.077 - 28.651	232.45	210.85	203.60	200.05	196.45	193.40	189.25
29.0	1.1417	3	8	2 1/4	11	3452290	213.70	28.652 - 30.239	246.25	224.70	217.35	213.85	210.20	207.20	203.05
30.0	1.1811	3	8	2 1/4	11	3452300	213.70	-	-	-	-	-	-	-	-
31.0	1.2205	4	8	2 1/2	11 1/2	3452310	226.15	30.240 - 31.826	258.70	237.15	229.85	226.30	222.70	219.70	215.50
32.0	1.2598	4	8	2 1/2	11 1/2	3452320	253.50	31.827 - 33.414	286.15	264.50	257.25	253.70	250.10	247.00	242.85
33.0	1.2992	4	8	2 1/2	11 1/2	3452330	253.50	-	-	-	-	-	-	-	-
34.0	1.3386	4	8	2 1/2	12	3452340	287.60	33.415 - 35.001	320.15	298.60	291.35	287.85	284.15	281.15	276.95
35.0	1.3780	4	8	2 1/2	12	3452350	287.60	-	-	-	-	-	-	-	-
36.0	1.4173	4	8	2 1/2	12	3452360	299.55	35.002 - 36.589	332.20	310.55	303.30	299.75	296.15	293.05	288.90
37.0	1.4567	4	8	2 1/2	12 1/2	3452370	311.55	36.590 - 38.176	344.10	322.50	315.25	311.70	308.10	305.05	300.90
38.0	1.4961	4	8	2 1/2	12 1/2	3452380	311.55	-	-	-	-	-	-	-	-

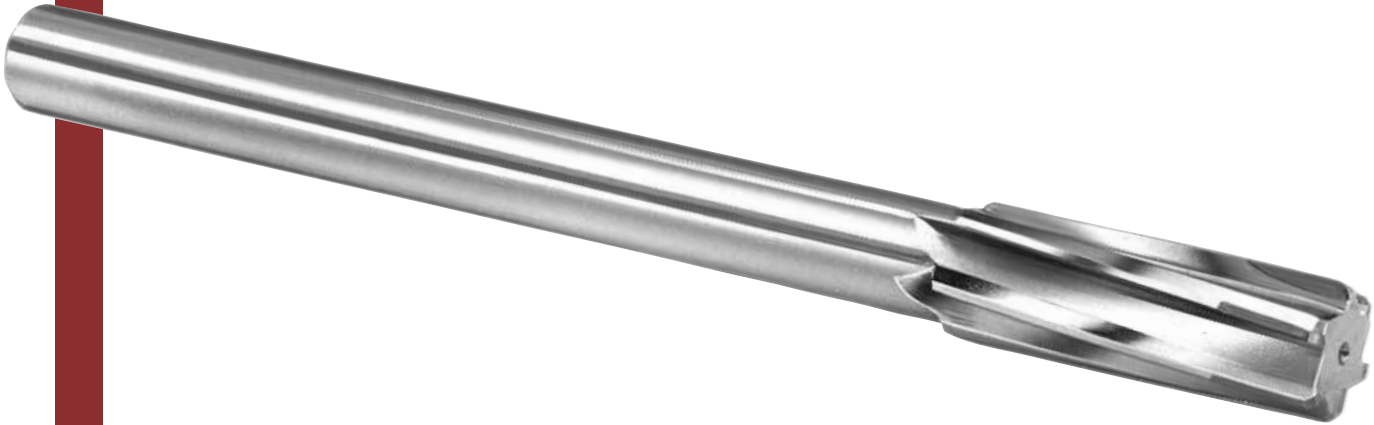
CARBIDE TIPPED RIGHT SPIRAL CHUCKING REAMERS

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 80.

For reamer tolerances and closer tolerance pricing, see page 56.

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	\$55.45	.1770 - .2040	\$93.50	\$74.40	\$68.05	\$65.00	\$61.75	\$59.15
.2188	7/32	13/64	4	1 1/4	1/2	5	341007	55.45	.2041 - .2210	93.50	74.40	68.05	65.00	61.75	59.15
.2344	15/64	7/32	4	1 1/2	1/2	6	34102344	55.45	.2211 - .2380	93.50	74.40	68.05	65.00	61.75	59.15
.2500	1/4	15/64	4	1 1/2	1/2	6	341008	55.45	.2381 - .2530	93.50	74.40	68.05	65.00	61.75	59.15
.2812	9/32	15/64	4	1 1/2	1/2	6	341009	55.60	.2531 - .2840	93.65	74.55	68.20	65.15	61.90	59.30
.3125	5/16	9/32	4	1 1/2	1/2	6	341010	55.60	.2841 - .3150	93.65	74.55	68.20	65.15	61.90	59.30
.3438	11/32	9/32	4	1 1/2	5/8	6	341011	61.15	.3151 - .3470	99.30	80.15	73.75	70.70	67.45	64.90
.3750	3/8	5/16	4	1 3/4	5/8	7	341012	61.75	.3471 - .3780	99.80	80.75	74.35	71.30	68.05	65.45
.4062	13/32	5/16	4	1 3/4	5/8	7	341013	64.50	.3781 - .4090	102.60	83.55	77.15	74.15	70.80	68.25
.4375	7/16	3/8	4	1 3/4	5/8	7	341014	67.10	.4091 - .4410	105.20	86.05	79.70	76.65	73.40	70.80
.4688	15/32	3/8	4	1 3/4	5/8	7	341015	71.25	.4411 - .4720	109.30	90.25	83.85	80.80	77.55	74.95
.5000	1/2	7/16	6	2	5/8	8	341016	81.10	.4721 - .5030	121.75	101.35	94.60	91.35	87.85	85.10
.5312	17/32	7/16	6	2	5/8	8	341017	81.10	.5031 - .5340	121.75	101.35	94.60	91.35	87.85	85.10
.5625	9/16	7/16	6	2	5/8	8	341018	81.10	.5341 - .5660	121.75	101.35	94.60	91.35	87.85	85.10
.5938	19/32	7/16	6	2	5/8	8	341019	83.55	.5661 - .5970	124.15	103.80	97.00	93.70	90.25	87.50
.6250	5/8	9/16	6	2 1/4	5/8	9	341020	83.55	.5971 - .6280	124.15	103.80	97.00	93.70	90.25	87.50
.6562	21/32	9/16	6	2 1/4	5/8	9	341021	88.80	.6281 - .6590	129.50	109.15	102.30	99.05	95.55	92.80
.6875	11/16	9/16	6	2 1/4	5/8	9	341022	91.50	.6591 - .6910	132.15	111.75	105.00	101.75	98.25	95.50
.7188	23/32	9/16	6	2 1/4	5/8	9	341023	94.15	.6911 - .7220	134.80	114.40	107.60	104.40	100.90	98.15
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	341024	94.15	.7221 - .7530	134.80	114.40	107.60	104.40	100.90	98.15
.7812	25/32	5/8	6	2 1/2	3/4	9 1/2	341025	99.85	.7531 - .7840	140.55	120.20	113.40	110.10	106.65	103.90
.8125	13/16	5/8	6	2 1/2	3/4	9 1/2	341026	99.85	.7841 - .8160	140.55	120.20	113.40	110.10	106.65	103.90
.8438	27/32	5/8	6	2 1/2	3/4	9 1/2	341027	105.35	.8161 - .8470	146.05	125.60	118.85	115.60	112.10	109.35
.8750	7/8	3/4	6	2 5/8	3/4	10	341028	109.35	.8471 - .8780	151.55	130.35	123.35	119.95	116.35	113.50
.9062	29/32	3/4	6	2 5/8	3/4	10	341029	127.35	.8781 - .9090	169.55	148.45	141.35	138.00	134.35	131.50
.9375	15/16	3/4	8	2 5/8	3/4	10	341030	127.35	.9091 - .9410	169.55	148.45	141.35	138.00	134.35	131.50
.9688	31/32	3/4	8	2 5/8	3/4	10	341031	133.60	.9411 - .9720	175.80	154.60	147.55	144.20	140.60	137.75
1.0000	1	7/8	8	2 3/4	3/4	10 1/2	341032	133.60	.9721 - 1.0030	175.80	154.60	147.55	144.20	140.60	137.75
1.0625	1 1/16	7/8	8	2 3/4	3/4	10 1/2	341034	143.30	1.0031 - 1.0660	185.50	164.40	157.30	153.90	150.30	147.45
1.1250	1 1/8	7/8	8	2 7/8	7/8	11	341036	147.75	1.0661 - 1.1280	189.90	168.80	161.70	158.30	154.70	151.85
1.1875	1 3/16	1	8	2 7/8	7/8	11	341038	155.25	1.1281 - 1.1905	197.45	176.25	169.15	165.85	162.25	159.40
1.2500	1 1/4	1	8	3	7/8	11 1/2	341040	164.30	1.1906 - 1.2530	206.45	185.35	178.25	174.85	171.25	168.40
1.3125	1 5/16	1	8	3	7/8	11 1/2	341042	181.80	1.2531 - 1.3155	224.00	202.80	195.75	192.40	188.80	185.95
1.3750	1 3/8	1	8	3 1/4	7/8	12	341044	199.20	1.3156 - 1.3780	241.40	220.20	213.20	209.80	206.20	203.35
1.4375	1 7/16	1 1/4	8	3 1/4	7/8	12	341046	211.05	1.3781 - 1.4405	253.20	232.10	225.00	221.60	218.00	215.15
1.5000	1 1/2	1 1/4	8	3 1/2	7/8	12 1/2	341048	222.90	1.4406 - 1.5030	265.10	243.95	236.95	233.55	229.90	227.05

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 80.

For reamer tolerances and closer tolerance pricing, see page 56.

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	\$62.60	.1770 - .2040	\$103.30	\$82.95	\$76.15	\$72.85	\$69.40	\$66.65
.2188	7/32	13/64	4	1 1/4	1/2	5	342007	62.60	.2041 - .2210	103.30	82.95	76.15	72.85	69.40	66.65
.2344	15/64	7/32	4	1 1/2	1/2	6	34202344	62.60	.2211 - .2380	103.30	82.95	76.15	72.85	69.40	66.65
.2500	1/4	15/64	4	1 1/2	1/2	6	342008	62.60	.2381 - .2530	103.30	82.95	76.15	72.85	69.40	66.65
.2812	9/32	15/64	4	1 1/2	1/2	6	342009	62.85	.2531 - .2840	103.45	83.10	76.30	73.00	69.55	66.80
.3125	5/16	9/32	4	1 1/2	1/2	6	342010	62.85	.2841 - .3150	103.45	83.10	76.30	73.00	69.55	66.80
.3438	11/32	9/32	4	1 1/2	5/8	6	342011	69.15	.3151 - .3470	109.80	89.40	82.60	79.40	75.90	73.15
.3750	3/8	5/16	4	1 3/4	5/8	7	342012	69.80	.3471 - .3780	110.40	90.10	83.25	80.05	76.55	73.85
.4062	13/32	5/16	4	1 3/4	5/8	7	342013	72.95	.3781 - .4090	113.60	93.25	86.45	83.20	79.70	76.95
.4375	7/16	3/8	4	1 3/4	5/8	7	342014	75.90	.4091 - .4410	116.50	96.15	89.35	86.05	82.60	79.85
.4688	15/32	3/8	4	1 3/4	5/8	7	342015	80.50	.4411 - .4720	121.15	100.85	94.00	90.75	87.25	84.50
.5000	1/2	7/16	6	2	5/8	8	342016	83.55	.4721 - .5030	125.25	104.35	97.35	94.00	90.45	87.65
.5312	17/32	7/16	6	2	5/8	8	342017	86.05	.5031 - .5340	127.85	106.90	99.95	96.60	93.05	90.25
.5625	9/16	7/16	6	2	5/8	8	342018	86.05	.5341 - .5660	127.85	106.90	99.95	96.60	93.05	90.25
.5938	19/32	7/16	6	2	5/8	8	342019	88.65	.5661 - .5970	130.35	109.45	102.45	99.15	95.55	92.75
.6250	5/8	9/16	6	2 1/4	5/8	9	342020	88.65	.5971 - .6280	130.35	109.45	102.45	99.15	95.55	92.75
.6562	21/32	9/16	6	2 1/4	5/8	9	342021	91.20	.6281 - .6590	132.95	112.05	105.05	101.75	98.10	95.35
.6875	11/16	9/16	6	2 1/4	5/8	9	342022	97.15	.6591 - .6910	138.85	117.90	110.95	107.60	104.05	101.20
.7188	23/32	9/16	6	2 1/4	5/8	9	342023	98.45	.6911 - .7220	140.15	119.30	112.25	109.00	105.35	102.55
.7500	3/4	5/8	6	2 1/2	3/4	9 1/2	342024	100.00	.7221 - .7530	141.70	120.80	113.80	110.50	106.90	104.10
.7812	25/32	5/8	6	2 1/2	3/4	9 1/2	342025	102.55	.7531 - .7840	144.30	123.40	116.40	113.10	109.45	106.70
.8125	13/16	5/8	6	2 1/2	3/4	9 1/2	342026	102.55	.7841 - .8160	144.30	123.40	116.40	113.10	109.45	106.70
.8438	27/32	5/8	6	2 1/2	3/4	9 1/2	342027	108.20	.8161 - .8470	149.95	129.05	122.00	118.70	115.10	112.25
.8750	7/8	3/4	6	2 5/8	3/4	10	342028	112.25	.8471 - .8780	155.60	133.90	126.60	123.20	119.45	116.50
.9062	29/32	3/4	6	2 5/8	3/4	10	342029	130.80	.8781 - .9090	174.10	152.40	145.15	141.70	138.00	135.05
.9375	15/16	3/4	8	2 5/8	3/4	10	342030	130.80	.9091 - .9410	174.10	152.40	145.15	141.70	138.00	135.05
.9688	31/32	3/4	8	2 5/8	3/4	10	342031	137.15	.9411 - .9720	180.50	158.75	151.55	148.05	144.30	141.45
1.0000	1	7/8	8	2 3/4	3/4	10 1/2	342032	137.15	.9721 - 1.0030	180.50	158.75	151.55	148.05	144.30	141.45
1.0625	1 1/16	7/8	8	2 3/4	3/4	10 1/2	342034	147.15	1.0031 - 1.0660	190.50	168.80	161.55	158.10	154.30	151.40
1.1250	1 1/8	7/8	8	2 7/8	7/8	11	342036	151.70	1.0661 - 1.1280	194.95	173.35	166.00	162.55	158.85	155.90
1.1875	1 3/16	1	8	2 7/8	7/8	11	342038	159.40	1.1281 - 1.1905	202.65	181.05	173.70	170.25	166.55	163.60
1.2500	1 1/4	1	8	3	7/8	11 1/2	342040	168.70	1.1906 - 1.2530	212.00	190.25	183.05	179.55	175.85	172.95
1.3125	1 5/16	1	8	3	7/8	11 1/2	342042	186.65	1.2531 - 1.3155	230.00	208.30	200.95	197.60	193.80	190.90
1.3750	1 3/8	1	8	3 1/4	7/8	12	342044	204.50	1.3156 - 1.3780	247.85	226.15	218.90	215.45	211.75	208.80
1.4375	1 7/16	1 1/4	8	3 1/4	7/8	12	342046	216.70	1.3781 - 1.4405	259.95	238.30	231.00	227.60	223.85	220.90
1.5000	1 1/2	1 1/4	8	3 1/2	7/8	12 1/2	342048	228.90	1.4406 - 1.5030	272.20	250.50	243.25	239.80	236.10	233.15

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 56.

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	\$62.55	.2381 - .2530	\$100.70	\$81.55	\$75.15	\$72.10	\$68.85	\$66.35
.2812	9/32	1	4	1 1/2	1/2	6	341209	342209	62.55	.2531 - .2840	100.70	81.55	75.15	72.10	68.85	66.35
.3125	5/16	1	4	1 1/2	1/2	6	341210	342210	63.95	.2841 - .3150	102.10	82.95	76.55	73.55	70.25	67.65
.3438	11/32	1	4	1 1/2	5/8	6	341211	342211	65.05	.3151 - .3470	103.15	84.05	77.70	74.65	71.40	68.80
.3750	3/8	1	4	1 3/4	5/8	7	341212	342212	66.05	.3471 - .3780	104.20	85.10	78.65	75.70	72.35	69.80
.4062	13/32	1	4	1 3/4	5/8	7	341213	342213	69.25	.3781 - .4090	107.35	88.30	81.90	78.85	75.55	73.00
.4375	7/16	1	4	1 3/4	5/8	7	341214	342214	72.20	.4091 - .4410	110.35	91.25	84.80	81.75	78.50	76.00
.4688	15/32	1	4	1 3/4	5/8	7	341215	342215	75.00	.4411 - .4720	113.15	94.00	87.65	84.60	81.30	78.80
.5000	1/2	1	6	2	5/8	8	341216	342216	86.45	.4721 - .5030	127.05	106.70	99.85	96.70	93.20	90.45
.5312	17/32	1	6	2	5/8	8	341217	342217	88.75	.5031 - .5340	129.40	109.00	102.25	99.00	95.50	92.75
.5625	9/16	1	6	2	5/8	8	341218	342218	88.75	.5341 - .5660	129.40	109.00	102.25	99.00	95.50	92.75
.5938	19/32	1	6	2	5/8	8	341219	342219	92.25	.5661 - .5970	132.90	112.50	105.75	102.45	99.00	96.25
.6250	5/8	2	6	2 1/4	5/8	9	341220	342220	92.25	.5971 - .6280	132.90	112.50	105.75	102.45	99.00	96.25
.6875	11/16	2	6	2 1/4	5/8	9	341222	342222	101.20	.6591 - .6910	141.85	121.45	114.70	111.45	107.95	105.20
.7500	3/4	2	6	2 1/2	3/4	9 1/2	341224	342224	107.05	.7221 - .7530	147.65	127.35	120.50	117.25	113.75	111.00
.8125	13/16	2	6	2 1/2	3/4	9 1/2	341226	342226	111.50	.7841 - .8160	152.20	131.80	124.95	121.75	118.25	115.55
.8750	7/8	2	6	2 5/8	3/4	10	341228	342228	120.05	.8471 - .8780	162.25	141.05	134.00	130.65	127.05	124.20
.9375	15/16	3	8	2 5/8	3/4	10	341230	342230	139.60	.9091 - .9410	181.80	160.70	153.60	150.25	146.60	143.75
1.0000	1	3	8	2 3/4	3/4	10 1/2	341232	342232	144.45	.9721 - 1.0030	186.65	165.45	158.40	155.10	151.45	148.60

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

CARBIDE TIPPED NAS 897 CHUCKING REAMERS

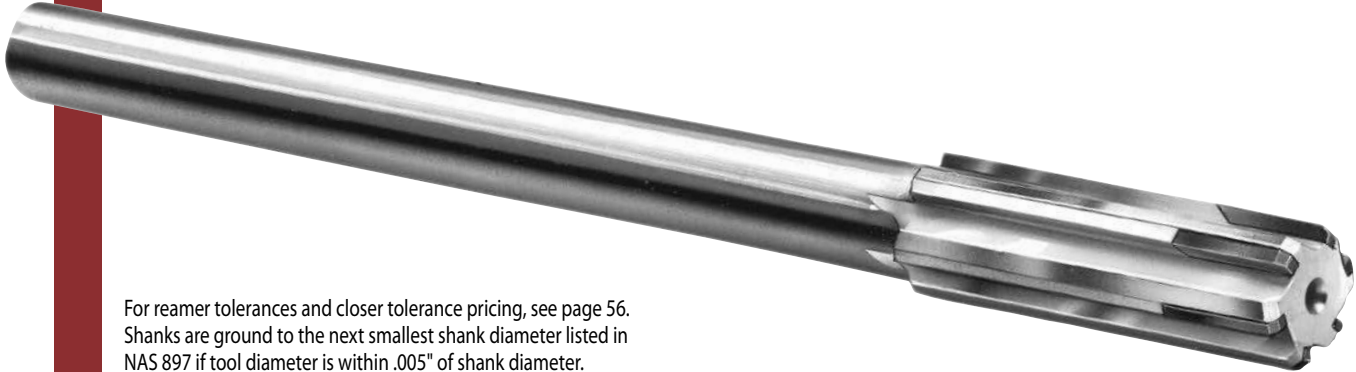
TYPE 3407 - STRAIGHT SHANK - STRAIGHT FLUTES - FOR NON-FERROUS

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 56.
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.	FRACTION			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	\$55.45	.1560 - .1769	\$96.10	\$75.70	\$68.85	\$65.65	\$62.20	\$59.45
.1875	3/16	.1805	4	1 1/8	1/2	4 1/2	340706	340806	340906	50.90	.1770 - .2040	90.45	70.65	63.95	60.85	57.45	54.75
.2188	7/32	.2075	4	1 1/4	1/2	5	340707	340807	340907	50.90	.2041 - .2210	90.45	70.65	63.95	60.85	57.45	54.75
.2344	15/64	.2265	4	1 1/2	1/2	6	34072344	34082344	34092344	53.95	.2211 - .2380	93.50	73.70	67.10	63.90	60.45	57.80
.2500	1/4	.2405	4	1 1/2	1/2	6	340708	340808	340908	51.20	.2381 - .2530	90.75	70.95	64.35	61.15	57.75	55.05
.2812	9/32	.2485	4	1 1/2	1/2	6	340709	340809	340909	52.25	.2531 - .2840	91.80	71.95	65.35	62.20	58.75	56.10
.3125	5/16	.2792	4	1 1/2	1/2	6	340710	340810	340910	52.25	.2841 - .3150	91.80	71.95	65.35	62.20	58.75	56.10
.3125	5/16	.2792	6	1 1/2	1/2	6	340790	340890	340990	57.45	.2841 - .3150	97.00	77.15	70.50	67.35	63.95	61.30
.3438	11/32	.2792	4	1 1/2	5/8	6	340711	340811	340911	54.15	.3151 - .3470	93.70	73.90	67.30	64.10	60.75	58.10
.3438	11/32	.2792	6	1 1/2	5/8	6	340791	340891	340991	59.50	.3151 - .3470	99.05	79.25	72.65	69.45	66.10	63.45
.3750	3/8	.3105	4	1 3/4	5/8	7	340712	340812	340912	49.70	.3471 - .3780	86.00	67.80	61.75	58.85	55.70	53.30
.3750	3/8	.3105	6	1 3/4	5/8	7	340792	340892	340992	54.60	.3471 - .3780	90.90	72.70	66.65	63.75	60.60	58.15
.4062	13/32	.3105	4	1 3/4	5/8	7	340713	340813	340913	56.75	.3781 - .4090	96.30	76.50	69.90	66.70	63.30	60.70
.4062	13/32	.3105	6	1 3/4	5/8	7	340793	340893	340993	60.55	.3781 - .4090	100.10	80.30	73.70	70.50	67.15	64.50
.4375	7/16	.3730	6	1 3/4	5/8	7	340714	340814	340914	60.55	.4091 - .4410	100.10	80.30	73.70	70.50	67.15	64.50
.4688	15/32	.3730	6	1 3/4	5/8	7	340715	340815	340915	61.45	.4411 - .4720	101.00	81.15	74.55	71.40	68.05	65.35
.5000	1/2	.4355	6	2	5/8	8	340716	340816	340916	72.65	.4721 - .5030	116.20	94.40	87.10	83.60	79.85	76.95
.5312	17/32	.4355	6	2	5/8	8	340717	340817	340917	79.10	.5031 - .5340	122.60	100.75	93.50	90.00	86.30	83.35
.5625	9/16	.4355	6	2	5/8	8	340718	340818	340918	79.10	.5341 - .5660	122.60	100.75	93.50	90.00	86.30	83.35
.5938	19/32	.4355	6	2	5/8	8	340719	340819	340919	82.30	.5661 - .5970	125.85	104.05	96.70	93.20	89.50	86.50
.6250	5/8	.5615	6	2 1/4	5/8	9	340720	340820	340920	82.30	.5971 - .6280	125.85	104.05	96.70	93.20	89.50	86.50
.6562	21/32	.5615	6	2 1/4	5/8	9	340721	340821	340921	83.70	.6281 - .6590	127.25	105.45	98.10	94.70	90.90	88.00
.6875	11/16	.5615	6	2 1/4	5/8	9	340722	340822	340922	83.70	.6591 - .6910	127.25	105.45	98.10	94.70	90.90	88.00
.7188	23/32	.5615	6	2 1/4	5/8	9	340723	340823	340923	87.65	.6911 - .7220	131.20	109.35	102.00	98.55	94.85	91.85
.7500	3/4	.6245	6	2 1/2	3/4	9 1/2	340724	340824	340924	87.65	.7221 - .7530	131.20	109.35	102.00	98.55	94.85	91.85
.7812	25/32	.6245	6	2 1/2	3/4	9 1/2	340725	340825	340925	90.45	.7531 - .7840	134.00	112.20	104.90	101.45	97.65	94.75
.8125	13/16	.6245	6	2 1/2	3/4	9 1/2	340726	340826	340926	90.45	.7841 - .8160	134.00	112.20	104.90	101.45	97.65	94.75
.8438	27/32	.6245	6	2 1/2	3/4	9 1/2	340727	340827	340927	94.10	.8161 - .8470	137.65	115.85	108.55	105.05	101.35	98.40
.8750	7/8	.7495	6	2 5/8	3/4	10	340728	340828	340928	97.65	.8471 - .8780	142.85	120.20	112.65	109.05	105.20	102.10
.9062	29/32	.7495	6	2 5/8	3/4	10	340729	340829	340929	113.75	.8781 - .9090	158.95	136.30	128.75	125.10	121.20	118.20
.9375	15/16	.7495	8	2 5/8	3/4	10	340730	340830	340930	113.75	.9091 - .9410	158.95	136.30	128.75	125.10	121.20	118.20
.9688	31/32	.7495	8	2 5/8	3/4	10	340731	340831	340931	119.10	.9411 - .9720	164.30	141.70	134.05	130.45	126.60	123.50
1.0000	1	.8745	8	2 3/4	3/4	10 1/2	340732	340832	340932	119.10	.9721 - 1.0030	164.30	141.70	134.05	130.45	126.60	123.50
1.0625	1 1/16	.8745	8	2 3/4	3/4	10 1/2	340734	340834	340934	123.35	1.0031 - 1.0660	166.65	145.00	137.70	134.20	130.50	127.60
1.1250	1 1/8	.8745	8	2 7/8	7/8	11	340736	340836	340936	133.35	1.0661 - 1.1280	176.65	154.90	147.70	144.20	140.50	137.60
1.1875	1 3/16	.9995	8	2 7/8	7/8	11	340738	340838	340938	140.15	1.1281 - 1.1905	183.50	161.80	154.55	151.05	147.40	144.45
1.2500	1 1/4	.9995	8	3	7/8	11 1/2	340740	340840	340940	148.15	1.1906 - 1.2530	191.40	169.80	162.45	159.00	155.30	152.40
1.3125	1 5/16	.9995	8	3	7/8	11 1/2	340742	340842	340942	155.90	1.2531 - 1.3155	199.30	177.55	170.25	166.85	163.10	160.15
1.3750	1 3/8	.9995	8	3 1/4	7/8	12	340744	340844	340944	165.40	1.3156 - 1.3780	208.75	187.05	179.70	176.35	172.55	169.65
1.4375	1 7/16	.9995	8	3 1/4	7/8	12	340746	340846	340946	184.35	1.3781 - 1.4405	227.70	206.00	198.75	195.25	191.50	188.65
1.5000	1 1/2	1.2495	8	3 1/2	7/8	12 1/2	340748	340848	340948	194.90	1.4406 - 1.5030	238.25	216.50	209.20	205.80	202.05	199.10

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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 110. For longer overall length reamers, see page 113.



For reamer tolerances and closer tolerance pricing, see page 56.
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.	FRACTIONAL			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	\$60.85	.1770 - .2040	\$101.50	\$81.10	\$74.25	\$71.10	\$67.60	\$64.85
.2188	7/32	.2075	4	1 1/4	5	345707	345807	345907	60.85	.2041 - .2210	101.50	81.10	74.25	71.10	67.60	64.85
.2344	15/64	.2265	4	1 1/2	6	34572344	34582344	34592344	60.85	.2211 - .2380	101.50	81.10	74.25	71.10	67.60	64.85
.2500	1/4	.2405	4	1 1/2	6	345708	345808	345908	60.85	.2381 - .2530	101.50	81.10	74.25	71.10	67.60	64.85
.2812	9/32	.2485	4	1 1/2	6	345709	345809	345909	62.20	.2531 - .2840	102.75	82.45	75.60	72.40	68.85	66.20
.3125	5/16	.2792	4	1 1/2	6	345710	345810	345910	62.20	.2841 - .3150	102.75	82.45	75.60	72.40	68.85	66.20
.3438	11/32	.2792	4	1 1/2	6	345711	345811	345911	64.40	.3151 - .3470	105.05	84.65	77.85	74.65	71.15	68.40
.3750	3/8	.3105	4	1 3/4	7	345712	345812	345912	64.40	.3471 - .3780	105.05	84.65	77.85	74.65	71.15	68.40
.4062	13/32	.3105	4	1 3/4	7	345713	345813	345913	67.60	.3781 - .4090	108.20	87.85	81.05	77.75	74.25	71.55
.4375	7/16	.3730	6	1 3/4	7	345714	345814	345914	73.15	.4091 - .4410	113.75	93.40	86.60	83.35	79.85	77.10
.4688	15/32	.3730	6	1 3/4	7	345715	345815	345915	79.00	.4411 - .4720	119.70	99.30	92.55	89.25	85.80	83.05
.5000	1/2	.4355	6	2	8	345716	345816	345916	84.65	.4721 - .5030	128.20	106.40	99.15	95.65	91.85	88.95
.5312	17/32	.4355	6	2	8	345717	345817	345917	87.10	.5031 - .5340	130.60	108.80	101.50	98.00	94.30	91.35
.5625	9/16	.4355	6	2	8	345718	345818	345918	87.10	.5341 - .5660	130.60	108.80	101.50	98.00	94.30	91.35
.5938	19/32	.4355	6	2	8	345719	345819	345919	90.40	.5661 - .5970	133.95	112.10	104.75	101.35	97.55	94.70
.6250	5/8	.5615	6	2 1/4	9	345720	345820	345920	90.40	.5971 - .6280	133.95	112.10	104.75	101.35	97.55	94.70
.6562	21/32	.5615	6	2 1/4	9	345721	345821	345921	92.10	.6281 - .6590	135.65	113.80	106.50	103.00	99.30	96.30
.6875	11/16	.5615	6	2 1/4	9	345722	345822	345922	92.10	.6591 - .6910	135.65	113.80	106.50	103.00	99.30	96.30
.7188	23/32	.5615	6	2 1/4	9	345723	345823	345923	96.25	.6911 - .7220	139.80	118.00	110.70	107.20	103.45	100.55
.7500	3/4	.6245	6	2 1/2	9 1/2	345724	345824	345924	96.25	.7221 - .7530	139.80	118.00	110.70	107.20	103.45	100.55
.7812	25/32	.6245	6	2 1/2	9 1/2	345725	345825	345925	99.60	.7531 - .7840	143.05	121.25	113.95	110.50	106.75	103.80
.8125	13/16	.6245	6	2 1/2	9 1/2	345726	345826	345926	99.60	.7841 - .8160	143.05	121.25	113.95	110.50	106.75	103.80
.8438	27/32	.6245	6	2 1/2	9 1/2	345727	345827	345927	103.60	.8161 - .8470	147.05	125.25	118.00	114.50	110.80	107.80
.8750	7/8	.7495	6	2 5/8	10	345728	345828	345928	107.50	.8471 - .8780	152.60	130.00	122.45	118.80	114.95	111.90
.9062	29/32	.7495	6	2 5/8	10	345729	345829	345929	125.10	.8781 - .9090	170.30	147.70	140.05	136.45	132.60	129.50
.9375	15/16	.7495	8	2 5/8	10	345730	345830	345930	125.10	.9091 - .9410	170.30	147.70	140.05	136.45	132.60	129.50
.9688	31/32	.7495	8	2 5/8	10	345731	345831	345931	131.15	.9411 - .9720	176.35	153.70	146.05	142.45	138.60	135.50
1.0000	1	.8745	8	2 3/4	10 1/2	345732	345832	345932	131.15	.9721 - 1.0030	176.35	153.70	146.05	142.45	138.60	135.50
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	345734	345834	345934	135.60	1.0031 - 1.0660	178.85	157.15	149.90	146.45	142.75	139.85
1.1250	1 1/8	.8745	8	2 7/8	11	345736	345836	345936	146.85	1.0661 - 1.1280	190.10	168.40	161.15	157.70	154.00	151.05
1.1875	1 3/16	.9995	8	2 7/8	11	345738	345838	345938	153.55	1.1281 - 1.1905	196.80	175.20	167.85	164.45	160.70	157.75
1.2500	1 1/4	.9995	8	3	11 1/2	345740	345840	345940	165.95	1.1906 - 1.2530	209.20	187.55	180.25	176.85	173.10	170.15
1.3125	1 5/16	.9995	8	3	11 1/2	345742	345842	345942	170.55	1.2531 - 1.3155	213.85	192.20	184.90	181.40	177.70	174.80
1.3750	1 3/8	.9995	8	3 1/4	12	345744	345844	345944	181.85	1.3156 - 1.3780	225.15	203.50	196.20	192.80	189.05	186.10
1.4375	1 7/16	.9995	8	3 1/4	12	345746	345846	345946	196.95	1.3781 - 1.4405	240.25	218.55	211.30	207.80	204.15	201.20
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	345748	345848	345948	202.65	1.4406 - 1.5030	246.00	224.30	217.05	213.60	209.90	207.00

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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 56.

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.	FRACTION			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	\$58.60	.2381 - .2530	\$98.15	\$78.35	\$71.75	\$68.55	\$65.20	\$62.55
.2812	9/32	1	4	1 1/2	1/2	6	347209	347309	347409	59.60	.2531 - .2840	99.15	79.30	72.70	69.55	66.20	63.50
.3125	5/16	1	4	1 1/2	1/2	6	347210	347310	347410	59.60	.2841 - .3150	99.15	79.30	72.70	69.55	66.20	63.50
.3438	11/32	1	4	1 1/2	5/8	6	347211	347311	347411	61.45	.3151 - .3470	101.00	81.15	74.55	71.40	68.05	65.35
.3750	3/8	1	4	1 3/4	5/8	7	347212	347312	347412	56.75	.3471 - .3780	93.05	74.85	68.80	65.90	62.75	60.30
.4062	13/32	1	4	1 3/4	5/8	7	347213	347313	347413	64.90	.3781 - .4090	104.45	84.65	78.05	74.85	71.55	68.85
.4375	7/16	1	6	1 3/4	5/8	7	347214	347314	347414	69.15	.4091 - .4410	108.70	88.90	82.30	79.10	75.70	73.00
.4688	15/32	1	6	1 3/4	5/8	7	347215	347315	347415	71.00	.4411 - .4720	110.55	90.75	84.15	80.95	77.55	74.85
.5000	1/2	1	6	2	5/8	8	347216	347316	347416	81.30	.4721 - .5030	124.80	103.00	95.70	92.25	88.50	85.55
.5312	17/32	1	6	2	5/8	8	347217	347317	347417	86.35	.5031 - .5340	129.90	108.10	100.75	97.35	93.55	90.65
.5625	9/16	1	6	2	5/8	8	347218	347318	347418	86.35	.5341 - .5660	129.90	108.10	100.75	97.35	93.55	90.65
.5938	19/32	1	6	2	5/8	8	347219	347319	347419	91.85	.5661 - .5970	135.40	113.60	106.35	102.85	99.15	96.15
.6250	5/8	2	6	2 1/4	5/8	9	347220	347320	347420	91.85	.5971 - .6280	135.40	113.60	106.35	102.85	99.15	96.15
.6562	21/32	2	6	2 1/4	5/8	9	347221	347321	347421	93.40	.6281 - .6590	136.95	115.15	107.80	104.35	100.60	97.65
.6875	11/16	2	6	2 1/4	5/8	9	347222	347322	347422	93.40	.6591 - .6910	136.95	115.15	107.80	104.35	100.60	97.65
.7188	23/32	2	6	2 1/4	5/8	9	347223	347323	347423	97.15	.6911 - .7220	140.70	118.85	111.60	108.10	104.35	101.45
.7500	3/4	2	6	2 1/2	3/4	9 1/2	347224	347324	347424	97.15	.7221 - .7530	140.70	118.85	111.60	108.10	104.35	101.45
.7812	25/32	2	6	2 1/2	3/4	9 1/2	347225	347325	347425	99.45	.7531 - .7840	143.00	121.15	113.90	110.40	106.70	103.75
.8125	13/16	2	6	2 1/2	3/4	9 1/2	347226	347326	347426	99.45	.7841 - .8160	143.00	121.15	113.90	110.40	106.70	103.75
.8438	27/32	2	6	2 1/2	3/4	9 1/2	347227	347327	347427	104.25	.8161 - .8470	147.80	126.00	118.70	115.25	111.45	108.55
.8750	7/8	2	6	2 5/8	3/4	10	347228	347328	347428	108.20	.8471 - .8780	153.40	130.75	123.20	119.60	115.65	112.65
.9062	29/32	2	6	2 5/8	3/4	10	347229	347329	347429	131.65	.8781 - .9090	176.85	154.25	146.60	143.05	139.15	136.15
.9375	15/16	3	8	2 5/8	3/4	10	347230	347330	347430	131.65	.9091 - .9410	176.85	154.25	146.60	143.05	139.15	136.15
.9688	31/32	3	8	2 5/8	3/4	10	347231	347331	347431	135.50	.9411 - .9720	180.70	158.10	150.55	146.90	143.05	140.00
1.0000	1	3	8	2 3/4	3/4	10 1/2	347232	347332	347432	135.50	.9721 - 1.0030	180.70	158.10	150.55	146.90	143.05	140.00
1.0625	1 1/16	3	8	2 3/4	3/4	10 1/2	347234	347334	347434	167.40	1.0031 - 1.0660	210.65	188.95	181.70	178.25	174.55	171.65
1.1250	1 1/8	3	8	2 7/8	7/8	11	347236	347336	347436	177.70	1.0661 - 1.1280	221.00	199.35	192.05	188.65	184.90	181.95
1.1875	1 3/16	3	8	2 7/8	7/8	11	347238	347338	347438	194.25	1.1281 - 1.1905	237.55	215.90	208.60	205.20	201.45	198.50
1.2500	1 1/4	4	8	3	7/8	11 1/2	347240	347340	347440	211.00	1.1906 - 1.2530	254.35	232.60	225.40	221.90	218.20	215.30
1.3125	1 5/16	4	8	3	7/8	11 1/2	347242	347342	347442	222.90	1.2531 - 1.3155	266.20	244.50	237.25	233.75	230.10	227.15
1.3750	1 3/8	4	8	3 1/4	7/8	12	347244	347344	347444	234.75	1.3156 - 1.3780	278.05	256.35	249.10	245.65	241.95	239.00
1.4375	1 7/16	4	8	3 1/4	7/8	12	347246	347346	347446	248.15	1.3781 - 1.4405	291.50	269.80	262.55	259.10	255.40	252.50
1.5000	1 1/2	4	8	3 1/2	7/8	12 1/2	347248	347348	347448	261.50	1.4406 - 1.5030	304.75	283.15	275.80	272.35	268.65	265.75
1.5625	1 9/16	4	8	3 1/2	7/8	12 1/2	347250	347350	347450	306.75	1.5031 - 1.5660	350.05	328.35	321.10	317.60	313.95	311.00
1.6250	1 5/8	4	8	3 3/4	7/8	13	347252	347352	347452	317.40	1.5661 - 1.6280	360.65	338.95	331.70	328.25	324.55	321.65
1.6875	1 11/16	4	8	3 3/4	7/8	13	347254	347354	347454	356.95	1.6281 - 1.6910	400.25	378.55	371.30	367.85	364.15	361.20
1.7500	1 3/4	4	10	4	7/8	13 1/2	347256	347356	347456	356.95	1.6911 - 1.7530	400.25	378.55	371.30	367.85	364.15	361.20
1.8125	1 13/16	4	10	4	7/8	13 1/2	347258	347358	347458	356.95	1.7531 - 1.8160	400.25	378.55	371.30	367.85	364.15	361.20
1.8750	1 7/8	4	10	4 1/4	7/8	14	347260	347360	347460	373.90	1.8161 - 1.8780	417.25	395.55	388.30	384.85	381.15	378.20
1.9375	1 15/16	4	10	4 1/4	7/8	14	347262	347362	347462	373.90	1.8781 - 1.9410	417.25	395.55	388.30	384.85	381.15	378.20
2.0000	2	4	12	4 1/4	7/8	14	347264	347364	347464	373.90	1.9411 - 2.0030	417.25	395.55	388.30	384.85	381.15	378.20

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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 56.

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.	FRAC.			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	\$69.95	.2381 - .2530	\$110.65	\$90.25	\$83.40	\$80.20	\$76.70	\$74.00
.2812	9/32	1	4	1 1/2	6	345309	345409	345509	71.10	.2531 - .2840	111.65	91.35	84.50	81.25	77.75	75.00
.3125	5/16	1	4	1 1/2	6	345310	345410	345510	71.10	.2841 - .3150	111.65	91.35	84.50	81.25	77.75	75.00
.3438	11/32	1	4	1 1/2	6	345311	345411	345511	72.65	.3151 - .3470	113.30	92.90	86.05	82.90	79.40	76.65
.3750	3/8	1	4	1 3/4	7	345312	345412	345512	73.45	.3471 - .3780	114.10	93.70	86.95	83.70	80.20	77.45
.4062	13/32	1	4	1 3/4	7	345313	345413	345513	77.30	.3781 - .4090	117.90	97.55	90.75	87.50	84.00	81.25
.4375	7/16	1	6	1 3/4	7	345314	345414	345514	82.35	.4091 - .4410	123.00	102.60	95.80	92.60	89.10	86.35
.4688	15/32	1	6	1 3/4	7	345315	345415	345515	84.05	.4411 - .4720	124.75	104.40	97.55	94.30	90.80	88.10
.5000	1/2	1	6	2	8	345316	345416	345516	90.50	.4721 - .5030	134.10	112.25	105.00	101.50	97.80	94.85
.5312	17/32	1	6	2	8	345317	345417	345517	99.30	.5031 - .5340	142.85	121.00	113.65	110.25	106.50	103.60
.5625	9/16	1	6	2	8	345318	345418	345518	99.30	.5341 - .5660	142.85	121.00	113.65	110.25	106.50	103.60
.5938	19/32	1	6	2	8	345319	345419	345519	103.90	.5661 - .5970	147.45	125.60	118.35	114.85	111.15	108.20
.6250	5/8	2	6	2 1/4	9	345320	345420	345520	103.90	.5971 - .6280	147.45	125.60	118.35	114.85	111.15	108.20
.6562	21/32	2	6	2 1/4	9	345321	345421	345521	105.80	.6281 - .6590	149.30	127.50	120.20	116.70	113.00	110.05
.6875	11/16	2	6	2 1/4	9	345322	345422	345522	105.80	.6591 - .6910	149.30	127.50	120.20	116.70	113.00	110.05
.7188	23/32	2	6	2 1/4	9	345323	345423	345523	107.20	.6911 - .7220	150.75	128.95	121.60	118.15	114.40	111.45
.7500	3/4	2	6	2 1/2	9 1/2	345324	345424	345524	110.70	.7221 - .7530	154.20	132.35	125.10	121.60	117.90	114.95
.7812	25/32	2	6	2 1/2	9 1/2	345325	345425	345525	111.60	.7531 - .7840	155.10	133.25	126.00	122.50	118.80	115.85
.8125	13/16	2	6	2 1/2	9 1/2	345326	345426	345526	114.05	.7841 - .8160	157.60	135.80	128.50	125.05	121.25	118.35
.8438	27/32	2	6	2 1/2	9 1/2	345327	345427	345527	119.00	.8161 - .8470	162.55	140.75	133.50	130.00	126.30	123.30
.8750	7/8	2	6	2 5/8	10	345328	345428	345528	123.50	.8471 - .8780	168.70	146.05	138.50	134.90	131.05	127.95
.9062	29/32	3	6	2 5/8	10	345329	345429	345529	145.05	.8781 - .9090	190.25	167.65	160.00	156.45	152.55	149.55
.9375	15/16	3	8	2 5/8	10	345330	345430	345530	145.05	.9091 - .9410	190.25	167.65	160.00	156.45	152.55	149.55
.9688	31/32	3	8	2 5/8	10	345331	345431	345531	150.90	.9411 - .9720	196.05	173.40	165.85	162.25	158.40	155.30
1.0000	1	3	8	2 3/4	10 1/2	345332	345432	345532	150.90	.9721 - 1.0030	196.05	173.40	165.85	162.25	158.40	155.30
1.0625	1 1/16	3	8	2 3/4	10 1/2	345334	345434	345534	192.40	1.0031 - 1.0660	235.70	214.05	206.75	203.30	199.60	196.65
1.1250	1 1/8	3	8	2 7/8	11	345336	345436	345536	204.45	1.0661 - 1.1280	247.80	226.05	218.85	215.35	211.60	208.75
1.1875	1 3/16	3	8	2 7/8	11	345338	345438	345538	223.55	1.1281 - 1.1905	266.80	245.10	237.85	234.40	230.70	227.75
1.2500	1 1/4	4	8	3	11 1/2	345340	345440	345540	242.55	1.1906 - 1.2530	285.80	264.10	256.85	253.40	249.70	246.80
1.3125	1 5/16	4	8	3	11 1/2	345342	345442	345542	256.25	1.2531 - 1.3155	299.55	277.90	270.60	267.20	263.40	260.50
1.3750	1 3/8	4	8	3 1/4	12	345344	345444	345544	271.05	1.3156 - 1.3780	314.30	292.70	285.35	281.95	278.20	275.30
1.4375	1 7/16	4	8	3 1/4	12	345346	345446	345546	285.30	1.3781 - 1.4405	328.65	306.90	299.70	296.20	292.45	289.50
1.5000	1 1/2	4	8	3 1/2	12 1/2	345348	345448	345548	300.70	1.4406 - 1.5030	344.05	322.30	315.10	311.60	307.90	305.00

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

Made in U.S.A.

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 111. For longer overall length reamers, see page 114.



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 56.

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	\$77.40	.2841 - .3150	\$115.45	\$96.40	\$90.00	\$86.95	\$83.70	\$81.10
.3438	11/32	.2792	4	1 1/2	6	344211	344311	344411	85.25	.3151 - .3470	123.30	104.25	97.85	94.85	91.55	88.95
.3750	3/8	.3105	4	1 3/4	7	344212	344312	344412	86.00	.3471 - .3780	124.15	105.00	98.60	95.55	92.30	89.80
.4062	13/32	.3105	4	1 3/4	7	344213	344313	344413	89.85	.3781 - .4090	127.90	108.85	102.45	99.45	96.15	93.55
.4375	7/16	.3730	6	1 3/4	7	344214	344314	344414	93.35	.4091 - .4410	131.40	112.35	105.95	102.90	99.65	97.05
.4688	15/32	.3730	6	1 3/4	7	344215	344315	344415	99.30	.4411 - .4720	137.35	118.25	111.90	108.85	105.60	103.00
.5000	1/2	.4355	6	2	8	344216	344316	344416	107.05	.4721 - .5030	147.65	127.35	120.50	117.25	113.75	111.00
.5312	17/32	.4355	6	2	8	344217	344317	344417	110.10	.5031 - .5340	150.75	130.35	123.55	120.35	116.85	114.10
.5625	9/16	.4355	6	2	8	344218	344318	344418	110.10	.5341 - .5660	150.75	130.35	123.55	120.35	116.85	114.10
.5938	19/32	.4355	6	2	8	344219	344319	344419	113.40	.5661 - .5970	153.95	133.65	126.80	123.55	120.05	117.30
.6250	5/8	.5615	6	2 1/4	9	344220	344320	344420	113.40	.5971 - .6280	153.95	133.65	126.80	123.55	120.05	117.30
.6562	21/32	.5615	6	2 1/4	9	344221	344321	344421	116.95	.6281 - .6590	157.60	137.20	130.35	127.20	123.70	120.95
.6875	11/16	.5615	6	2 1/4	9	344222	344322	344422	124.15	.6591 - .6910	164.80	144.45	137.65	134.40	130.90	128.15
.7188	23/32	.5615	6	2 1/4	9	344223	344323	344423	126.05	.6911 - .7220	166.75	146.30	139.50	136.30	132.80	130.05
.7500	3/4	.6245	6	2 1/2	9 1/2	344224	344324	344424	128.00	.7221 - .7530	168.60	148.25	141.45	138.25	134.75	132.00
.7812	25/32	.6245	6	2 1/2	9 1/2	344225	344325	344425	131.40	.7531 - .7840	172.00	151.65	144.85	141.55	138.10	135.35
.8125	13/16	.6245	6	2 1/2	9 1/2	344226	344326	344426	131.40	.7841 - .8160	172.00	151.65	144.85	141.55	138.10	135.35
.8438	27/32	.6245	6	2 1/2	9 1/2	344227	344327	344427	138.45	.8161 - .8470	179.10	158.70	151.90	148.70	145.20	142.45
.8750	7/8	.7495	6	2 5/8	10	344228	344328	344428	143.70	.8471 - .8780	185.90	164.70	157.60	154.30	150.70	147.85
.9062	29/32	.7495	6	2 5/8	10	344229	344329	344429	167.40	.8781 - .9090	209.60	188.40	181.35	178.00	174.40	171.55
.9375	15/16	.7495	8	2 5/8	10	344230	344330	344430	167.40	.9091 - .9410	209.60	188.40	181.35	178.00	174.40	171.55
.9688	31/32	.7495	8	2 5/8	10	344231	344331	344431	175.55	.9411 - .9720	217.75	196.65	189.55	186.20	182.55	179.70
1.0000	1	.8745	8	2 3/4	10 1/2	344232	344332	344432	175.55	.9721 - 1.0030	217.75	196.65	189.55	186.20	182.55	179.70
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	344234	344334	344434	206.35	1.0031 - 1.0660	248.55	227.40	220.35	217.00	213.35	210.50
1.1250	1 1/8	.8745	8	2 7/8	11	344236	344336	344436	212.75	1.0661 - 1.1280	254.95	233.75	226.70	223.40	219.75	216.90
1.1875	1 3/16	.9995	8	2 7/8	11	344238	344338	344438	223.60	1.1281 - 1.1905	265.80	244.65	237.60	234.25	230.60	227.75
1.2500	1 1/4	.9995	8	3	11 1/2	344240	344340	344440	236.60	1.1906 - 1.2530	278.80	257.70	250.65	247.25	243.65	240.80
1.3125	1 5/16	.9995	8	3	11 1/2	344242	344342	344442	261.80	1.2531 - 1.3155	304.00	282.90	275.80	272.45	268.80	265.95
1.3750	1 3/8	.9995	8	3 1/4	12	344244	344344	344444	286.80	1.3156 - 1.3780	329.00	307.85	300.85	297.45	293.85	291.00
1.4375	1 7/16	.9995	8	3 1/4	12	344246	344346	344446	303.90	1.3781 - 1.4405	346.10	324.95	317.85	314.55	310.95	308.10
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	344248	344348	344448	321.10	1.4406 - 1.5030	363.20	342.10	335.05	331.70	328.00	325.25

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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 112. For longer overall length reamers, see page 115.



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 56.

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	\$82.50	.2841 -.3150	\$123.15	\$102.75	\$96.00	\$92.75	\$89.25	\$86.50
.3438	11/32	.2792	4	1 1/2	6	348211	348311	348411	90.90	.3151 -.3470	131.55	111.25	104.40	101.15	97.65	94.90
.3750	3/8	.3105	4	1 3/4	7	348212	348312	348412	91.70	.3471 -.3780	132.35	112.05	105.20	101.95	98.45	95.70
.4062	13/32	.3105	4	1 3/4	7	348213	348313	348413	95.80	.3781 -.4090	136.45	116.10	109.30	106.05	102.55	99.80
.4375	7/16	.3730	6	1 3/4	7	348214	348314	348414	99.60	.4091 -.4410	140.15	119.85	113.00	109.80	106.25	103.60
.4688	15/32	.3730	6	1 3/4	7	348215	348315	348415	105.90	.4411 -.4720	146.55	126.15	119.30	116.10	112.65	109.90
.5000	1/2	.4355	6	2	8	348216	348316	348416	109.90	.4721 -.5030	151.65	130.75	123.75	120.45	116.80	113.95
.5312	17/32	.4355	6	2	8	348217	348317	348417	113.10	.5031 -.5340	154.80	133.85	126.90	123.55	120.00	117.15
.5625	9/16	.4355	6	2	8	348218	348318	348418	113.10	.5341 -.5660	154.80	133.85	126.90	123.55	120.00	117.15
.5938	19/32	.4355	6	2	8	348219	348319	348419	116.40	.5661 -.5970	158.10	137.20	130.20	126.90	123.30	120.50
.6250	5/8	.5615	6	2 1/4	9	348220	348320	348420	116.40	.5971 -.6280	158.10	137.20	130.20	126.90	123.30	120.50
.6562	21/32	.5615	6	2 1/4	9	348221	348321	348421	120.05	.6281 -.6590	161.75	140.90	133.85	130.60	126.95	124.15
.6875	11/16	.5615	6	2 1/4	9	348222	348322	348422	127.50	.6591 -.6910	169.20	148.35	141.30	138.00	134.40	131.55
.7188	23/32	.5615	6	2 1/4	9	348223	348323	348423	129.50	.6911 -.7220	171.20	150.25	143.30	139.95	136.40	133.55
.7500	3/4	.6245	6	2 1/2	9 1/2	348224	348324	348424	131.40	.7221 -.7530	173.10	152.25	145.20	141.85	138.30	135.50
.7812	25/32	.6245	6	2 1/2	9 1/2	348225	348325	348425	134.90	.7531 -.7840	176.60	155.75	148.70	145.45	141.80	139.00
.8125	13/16	.6245	6	2 1/2	9 1/2	348226	348326	348426	134.90	.7841 -.8160	176.60	155.75	148.70	145.45	141.80	139.00
.8438	27/32	.6245	6	2 1/2	9 1/2	348227	348327	348427	142.15	.8161 -.8470	183.85	162.95	155.95	152.65	149.05	146.25
.8750	7/8	.7495	6	2 5/8	10	348228	348328	348428	147.55	.8471 -.8780	190.80	169.10	161.85	158.40	154.70	151.75
.9062	29/32	.7495	6	2 5/8	10	348229	348329	348429	171.85	.8781 -.9090	215.15	193.50	186.20	182.80	179.00	176.10
.9375	15/16	.7495	8	2 5/8	10	348230	348330	348430	171.85	.9091 -.9410	215.15	193.50	186.20	182.80	179.00	176.10
.9688	31/32	.7495	8	2 5/8	10	348231	348331	348431	180.25	.9411 -.9720	223.60	201.90	194.65	191.20	187.50	184.55
1.0000	1	.8745	8	2 3/4	10 1/2	348232	348332	348432	180.25	.9721 -1.0030	223.60	201.90	194.65	191.20	187.50	184.55
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	348234	348334	348434	211.90	1.0031 -1.0660	255.20	233.55	226.25	222.75	219.05	216.15
1.1250	1 1/8	.8745	8	2 7/8	11	348236	348336	348436	218.45	1.0661 -1.1280	261.70	240.10	232.75	229.30	225.60	222.70
1.1875	1 3/16	.9995	8	2 7/8	11	348238	348338	348438	229.60	1.1281 -1.1905	272.90	251.25	243.95	240.45	236.80	233.85
1.2500	1 1/4	.9995	8	3	11 1/2	348240	348340	348440	243.00	1.1906 -1.2530	286.30	264.55	257.35	253.85	250.15	247.25
1.3125	1 5/16	.9995	8	3	11 1/2	348242	348342	348442	268.80	1.2531 -1.3155	312.15	290.45	283.20	279.75	276.05	273.10
1.3750	1 3/8	.9995	8	3 1/4	12	348244	348344	348444	294.50	1.3156 -1.3780	337.80	316.15	308.85	305.40	301.70	298.75
1.4375	1 7/16	.9995	8	3 1/4	12	348246	348346	348446	312.10	1.3781 -1.4405	355.35	333.65	326.40	322.95	319.25	316.30
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	348248	348348	348448	329.65	1.4406 -1.5030	373.00	351.25	344.05	340.55	336.90	333.95

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

CARBIDE TIPPED RIGHT SPIRAL COOLANT REAMERS

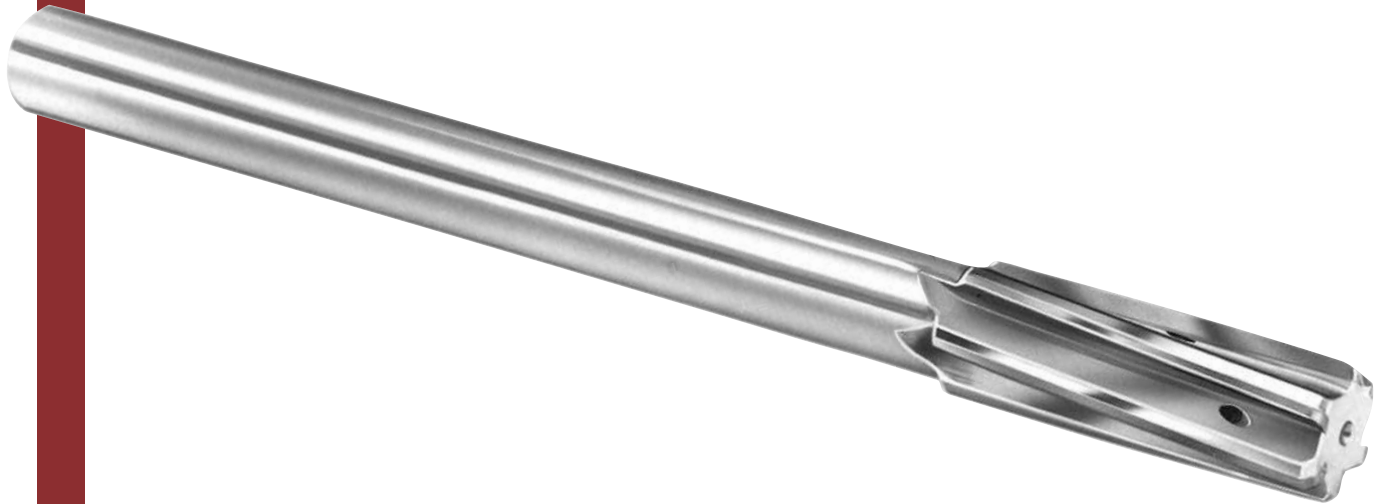
TYPE 3417 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - THROUGH HOLES - FOR NON-FERROUS

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 56.

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	\$153.30	.2381 - .2530	\$196.85	\$175.05	\$167.75	\$164.30	\$160.55	\$157.60
.2812	9/32	.2485	4	1 1/2*	6	341709	341809	341909	162.65	.2531 - .2840	206.20	184.40	177.10	173.65	169.90	166.95
.3125	5/16	.2792	4	1 1/2	6	341710	341810	341910	171.85	.2841 - .3150	215.40	193.60	186.25	182.85	179.05	176.15
.3438	11/32	.2792	4	1 1/2	6	341711	341811	341911	173.20	.3151 - .3470	216.75	194.90	187.60	184.15	180.40	177.50
.3750	3/8	.3105	4	1 3/4	7	341712	341812	341912	174.95	.3471 - .3780	218.50	196.70	189.35	185.95	182.15	179.25
.4062	13/32	.3105	4	1 3/4	7	341713	341813	341913	175.50	.3781 - .4090	219.05	197.20	189.95	186.45	182.70	179.80
.4375	7/16	.3730	6	1 3/4	7	341714	341814	341914	177.25	.4091 - .4410	220.80	199.00	191.75	188.25	184.45	181.55
.4688	15/32	.3730	6	1 3/4	7	341715	341815	341915	178.90	.4411 - .4720	222.45	200.65	193.30	189.80	186.10	183.15
.5000	1/2	.4355	6	2	8	341716	341816	341916	180.90	.4721 - .5030	224.45	202.65	195.35	191.90	188.15	185.20
.5312	17/32	.4355	6	2	8	341717	341817	341917	187.50	.5031 - .5340	231.05	209.25	201.95	198.50	194.70	191.80
.5625	9/16	.4355	6	2	8	341718	341818	341918	187.50	.5341 - .5660	231.05	209.25	201.95	198.50	194.70	191.80
.5938	19/32	.4355	6	2	8	341719	341819	341919	195.00	.5661 - .5970	238.55	216.75	209.40	206.00	202.20	199.30
.6250	5/8	.5615	6	2 1/4	9	341720	341820	341920	195.00	.5971 - .6280	238.55	216.75	209.40	206.00	202.20	199.30
.6562	21/32	.5615	6	2 1/4	9	341721	341821	341921	220.30	.6281 - .6590	263.85	242.05	234.70	231.20	227.50	224.55
.6875	11/16	.5615	6	2 1/4	9	341722	341822	341922	220.30	.6591 - .6910	263.85	242.05	234.70	231.20	227.50	224.55
.7188	23/32	.5615	6	2 1/4	9	341723	341823	341923	229.85	.6911 - .7220	273.45	251.60	244.35	240.85	237.15	234.20
.7500	3/4	.6245	6	2 1/2	9 1/2	341724	341824	341924	229.85	.7221 - .7530	273.45	251.60	244.35	240.85	237.15	234.20
.7812	25/32	.6245	6	2 1/2	9 1/2	341725	341825	341925	247.70	.7531 - .7840	291.25	269.40	262.15	258.65	254.95	252.00
.8125	13/16	.6245	6	2 1/2	9 1/2	341726	341826	341926	250.70	.7841 - .8160	294.30	272.45	265.20	261.70	257.90	255.05
.8438	27/32	.6245	6	2 1/2	9 1/2	341727	341827	341927	255.45	.8161 - .8470	299.05	277.20	269.85	266.40	262.65	259.70
.8750	7/8	.7495	6	2 5/8	10	341728	341828	341928	269.25	.8471 - .8780	314.45	291.85	284.20	280.60	276.75	273.65
.9062	29/32	.7495	6	2 5/8	10	341729	341829	341929	285.20	.8781 - .9090	330.40	307.75	300.20	296.60	292.75	289.65
.9375	15/16	.7495	8	2 5/8	10	341730	341830	341930	298.90	.9091 - .9410	344.10	321.50	313.85	310.30	306.40	303.40
.9688	31/32	.7495	8	2 5/8	10	341731	341831	341931	299.75	.9411 - .9720	344.95	322.30	314.70	311.10	307.25	304.15
1.0000	1	.8745	8	2 3/4	10 1/2	341732	341832	341932	300.20	.9721 - 1.0030	345.40	322.80	315.15	311.55	307.70	304.60
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341734	341834	341934	346.20	1.0031 - 1.0660	391.40	368.75	361.20	357.60	353.75	350.65
1.1250	1 1/8	.8745	8	2 7/8	11	341736	341836	341936	347.75	1.0661 - 1.1280	392.85	370.20	362.65	359.05	355.20	352.10
1.1875	1 3/16	.9995	8	2 7/8	11	341738	341838	341938	362.05	1.1281 - 1.1905	407.20	384.55	377.00	373.35	369.50	366.45
1.2500	1 1/4	.9995	8	3	11 1/2	341740	341840	341940	366.85	1.1906 - 1.2530	412.05	389.40	381.75	378.20	374.30	371.30
1.3125	1 5/16	.9995	8	3	11 1/2	341742	341842	341942	377.40	1.2531 - 1.3155	422.60	399.95	392.30	388.70	384.85	381.75
1.3750	1 3/8	.9995	8	3 1/4	12	341744	341844	341944	392.60	1.3156 - 1.3780	437.80	415.20	407.55	403.95	400.10	397.00
1.4375	1 7/16	.9995	8	3 1/4	12	341746	341846	341946	404.85	1.3781 - 1.4405	450.05	427.45	419.90	416.25	412.40	409.35
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341748	341848	341948	418.50	1.4406 - 1.5030	463.70	441.05	433.45	429.80	425.95	422.90

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CARBIDE TIPPED RIGHT SPIRAL COOLANT REAMERS

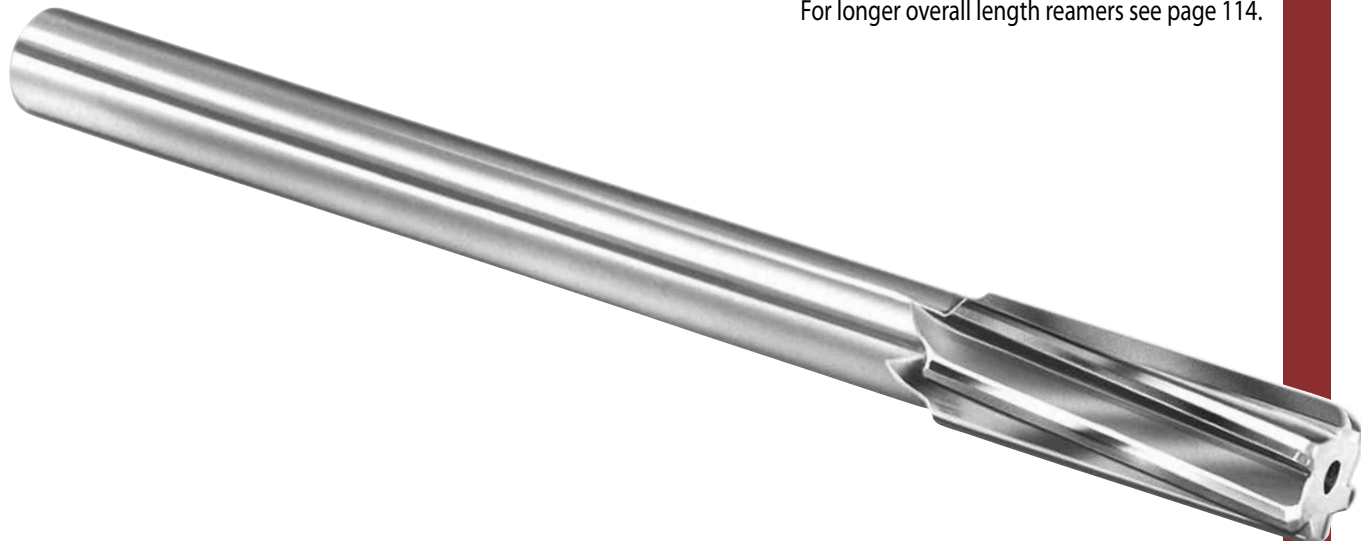
TYPE 3411 - STRAIGHT SHANK - RIGHT SPIRAL FLUTES - BLIND HOLES - FOR NON-FERROUS

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 114.



For reamer tolerances and closer tolerance pricing, see page 56.

TOOL DIAMETER		MAX. SHANK DIAM.	NO. OF FLTS.	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	\$143.15	.2381 - .2530	\$183.70	\$163.40	\$156.55	\$153.30	\$149.80	\$147.05
.2812	9/32	.2485	4	1 1/2*	6	341109	341309	341509	146.40	.2531 - .2840	185.55	166.00	159.40	156.25	152.95	150.25
.3125	5/16	.2792	4	1 1/2	6	341110	341310	341510	160.40	.2841 - .3150	201.00	180.70	173.85	170.60	167.10	164.35
.3438	11/32	.2792	4	1 1/2	6	341111	341311	341511	161.60	.3151 - .3470	202.25	181.95	175.10	171.85	168.35	165.60
.3750	3/8	.3105	4	1 3/4	7	341112	341312	341512	163.30	.3471 - .3780	203.90	183.55	176.75	173.55	170.05	167.30
.4062	13/32	.3105	4	1 3/4	7	341113	341313	341513	163.85	.3781 - .4090	204.40	184.10	177.25	174.00	170.50	167.75
.4375	7/16	.3730	6	1 3/4	7	341114	341314	341514	165.45	.4091 - .4410	206.15	185.70	178.90	175.70	172.20	169.45
.4688	15/32	.3730	6	1 3/4	7	341115	341315	341515	166.95	.4411 - .4720	207.60	187.20	180.45	177.20	173.70	170.95
.5000	1/2	.4355	6	2	8	341116	341316	341516	173.40	.4721 - .5030	215.10	194.20	187.20	183.85	180.30	177.50
.5312	17/32	.4355	6	2	8	341117	341317	341517	179.70	.5031 - .5340	221.40	200.50	193.50	190.15	186.60	183.80
.5625	9/16	.4355	6	2	8	341118	341318	341518	179.70	.5341 - .5660	221.40	200.50	193.50	190.15	186.60	183.80
.5938	19/32	.4355	6	2	8	341119	341319	341519	186.85	.5661 - .5970	228.60	207.70	200.70	197.35	193.80	191.00
.6250	5/8	.5615	6	2 1/4	9	341120	341320	341520	186.85	.5971 - .6280	228.60	207.70	200.70	197.35	193.80	191.00
.6562	21/32	.5615	6	2 1/4	9	341121	341321	341521	211.10	.6281 - .6590	252.80	231.95	224.90	221.65	218.00	215.20
.6875	11/16	.5615	6	2 1/4	9	341122	341322	341522	211.10	.6591 - .6910	252.80	231.95	224.90	221.65	218.00	215.20
.7188	23/32	.5615	6	2 1/4	9	341123	341323	341523	220.30	.6911 - .7220	262.05	241.15	234.20	230.85	227.20	224.40
.7500	3/4	.6245	6	2 1/2	9 1/2	341124	341324	341524	206.95	.7221 - .7530	246.10	226.45	219.95	216.75	213.40	210.75
.7812	25/32	.6245	6	2 1/2	9 1/2	341125	341325	341525	237.35	.7531 - .7840	279.15	258.20	251.25	247.90	244.25	241.45
.8125	13/16	.6245	6	2 1/2	9 1/2	341126	341326	341526	240.25	.7841 - .8160	282.05	261.10	254.15	250.80	247.25	244.40
.8438	27/32	.6245	6	2 1/2	9 1/2	341127	341327	341527	244.80	.8161 - .8470	286.55	265.65	258.65	255.30	251.70	248.95
.8750	7/8	.7495	6	2 5/8	10	341128	341328	341528	258.05	.8471 - .8780	301.30	279.65	272.35	268.95	265.20	262.25
.9062	29/32	.7495	6	2 5/8	10	341129	341329	341529	273.35	.8781 - .9090	316.60	295.00	287.65	284.30	280.50	277.60
.9375	15/16	.7495	8	2 5/8	10	341130	341330	341530	286.45	.9091 - .9410	329.80	308.10	300.85	297.35	293.60	290.70
.9688	31/32	.7495	8	2 5/8	10	341131	341331	341531	287.30	.9411 - .9720	330.55	308.85	301.60	298.15	294.45	291.50
1.0000	1	.8745	8	2 3/4	10 1/2	341132	341332	341532	287.65	.9721 - 1.0030	331.00	309.30	302.05	298.60	294.90	292.00
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	341134	341334	341534	295.75	1.0031 - 1.0660	339.05	317.40	310.10	306.60	302.90	300.00
1.1250	1 1/8	.8745	8	2 7/8	11	341136	341336	341536	306.00	1.0661 - 1.1280	349.35	327.65	320.40	316.95	313.25	310.30
1.1875	1 3/16	.9995	8	2 7/8	11	341138	341338	341538	327.80	1.1281 - 1.1905	371.15	349.45	342.20	338.70	334.95	332.00
1.2500	1 1/4	.9995	8	3	11 1/2	341140	341340	341540	332.00	1.1906 - 1.2530	375.40	353.65	346.40	342.95	339.25	336.35
1.3125	1 5/16	.9995	8	3	11 1/2	341142	341342	341542	341.65	1.2531 - 1.3155	384.90	363.20	355.95	352.50	348.80	345.90
1.3750	1 3/8	.9995	8	3 1/4	12	341144	341344	341544	355.50	1.3156 - 1.3780	398.85	377.15	369.90	366.45	362.65	359.75
1.4375	1 7/16	.9995	8	3 1/4	12	341146	341346	341546	366.60	1.3781 - 1.4405	409.85	388.25	380.90	377.45	373.75	370.85
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	341148	341348	341548	379.00	1.4406 - 1.5030	422.25	400.65	393.30	389.85	386.15	383.25

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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 115.



For reamer tolerances and closer tolerance pricing, see page 56.

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	\$177.25	.2381 - .2530	\$220.80	\$199.00	\$191.75	\$188.25	\$184.45	\$181.55
.2812	9/32	.2485	4	1 1/2*	6	342709	342809	342909	188.00	.2531 - .2840	231.60	209.75	202.50	199.00	195.30	192.35
.3125	5/16	.2792	4	1 1/2	6	342710	342810	342910	198.65	.2841 - .3150	242.20	220.35	213.10	209.60	205.85	202.95
.3438	11/32	.2792	4	1 1/2	6	342711	342811	342911	200.20	.3151 - .3470	243.65	221.85	214.60	211.10	207.40	204.40
.3750	3/8	.3105	4	1 3/4	7	342712	342812	342912	202.20	.3471 - .3780	245.75	223.95	216.65	213.20	209.40	206.50
.4062	13/32	.3105	4	1 3/4	7	342713	342813	342913	203.00	.3781 - .4090	246.55	224.75	217.40	214.00	210.20	207.30
.4375	7/16	.3730	6	1 3/4	7	342714	342814	342914	204.95	.4091 - .4410	248.50	226.70	219.40	215.90	212.20	209.25
.4688	15/32	.3730	6	1 3/4	7	342715	342815	342915	206.70	.4411 - .4720	250.30	228.45	221.20	217.70	214.00	211.00
.5000	1/2	.4355	6	2	8	342716	342816	342916	209.40	.4721 - .5030	252.95	231.15	223.85	220.35	216.65	213.70
.5312	17/32	.4355	6	2	8	342717	342817	342917	213.75	.5031 - .5340	257.35	235.50	228.25	224.75	220.95	218.05
.5625	3/4	.4355	6	2	8	342718	342818	342918	216.90	.5341 - .5660	260.45	238.65	231.35	227.85	224.10	221.20
.5938	19/32	.4355	6	2	8	342719	342819	342919	221.40	.5661 - .5970	264.95	243.15	235.90	232.40	228.70	225.70
.6250	5/8	.5615	6	2 1/4	9	342720	342820	342920	225.55	.5971 - .6280	269.05	247.25	239.95	236.50	232.75	229.80
.6562	21/32	.5615	6	2 1/4	9	342721	342821	342921	249.75	.6281 - .6590	293.30	271.50	264.15	260.75	256.95	254.05
.6875	11/16	.5615	6	2 1/4	9	342722	342822	342922	254.80	.6591 - .6910	298.35	276.55	269.25	265.80	262.05	259.10
.7188	23/32	.5615	6	2 1/4	9	342723	342823	342923	260.30	.6911 - .7220	303.75	281.95	274.70	271.20	267.50	264.50
.7500	3/4	.6245	6	2 1/2	9 1/2	342724	342824	342924	265.80	.7221 - .7530	309.35	287.50	280.20	276.75	273.00	270.10
.7812	25/32	.6245	6	2 1/2	9 1/2	342725	342825	342925	270.30	.7531 - .7840	313.85	292.05	284.80	281.30	277.50	274.60
.8125	13/16	.6245	6	2 1/2	9 1/2	342726	342826	342926	273.65	.7841 - .8160	317.15	295.30	288.05	284.55	280.85	277.90
.8438	27/32	.6245	6	2 1/2	9 1/2	342727	342827	342927	278.60	.8161 - .8470	322.20	300.35	293.00	289.55	285.80	282.85
.8750	7/8	.7495	6	2 5/8	10	342728	342828	342928	293.75	.8471 - .8780	338.95	316.30	308.70	305.05	301.20	298.15
.9062	29/32	.7495	6	2 5/8	10	342729	342829	342929	311.00	.8781 - .9090	356.20	333.55	326.00	322.40	318.45	315.45
.9375	15/16	.7495	8	2 5/8	10	342730	342830	342930	326.15	.9091 - .9410	371.35	348.75	341.10	337.55	333.65	330.65
.9688	31/32	.7495	8	2 5/8	10	342731	342831	342931	327.00	.9411 - .9720	372.20	349.60	341.95	338.35	334.50	331.40
1.0000	1	.8745	8	2 3/4	10 1/2	342732	342832	342932	327.50	.9721 - 1.0030	372.70	350.05	342.40	338.80	334.95	331.85
1.0625	1 1/16	.8745	8	2 3/4	10 1/2	342734	342834	342934	346.20	1.0031 - 1.0660	391.40	368.75	361.20	357.60	353.75	350.65
1.1250	1 1/8	.8745	8	2 3/4	11	342736	342836	342936	347.75	1.0661 - 1.1280	392.85	370.20	362.65	359.05	355.20	352.10
1.1875	1 3/16	.9995	8	2 7/8	11	342738	342838	342938	362.05	1.1281 - 1.1905	407.20	384.55	377.00	373.35	369.50	366.45
1.2500	1 1/4	.9995	8	3	11 1/2	342740	342840	342940	366.85	1.1906 - 1.2530	412.05	389.40	381.75	378.20	374.30	371.30
1.3125	1 5/16	.9995	8	3	11 1/2	342742	342842	342942	377.40	1.2531 - 1.3155	422.60	399.95	392.30	388.70	384.85	381.75
1.3750	1 3/8	.9995	8	3 1/4	12	342744	342844	342944	392.60	1.3156 - 1.3780	437.80	415.20	407.55	403.95	400.10	397.00
1.4375	1 7/16	.9995	8	3 1/4	12	342746	342846	342946	404.85	1.3781 - 1.4405	450.05	427.45	419.90	416.25	412.40	409.35
1.5000	1 1/2	1.2495	8	3 1/2	12 1/2	342748	342848	342948	418.50	1.4406 - 1.5030	463.70	441.05	433.45	429.80	425.95	422.90

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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 56.

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	\$135.40	.3181 - .3800	\$218.90	\$177.05	\$163.10	\$156.40	\$149.20	\$143.60
.4062	13/32	3/8	3/4	6	1/2	2 5/8	349013	137.40	.3801 - .4090	220.80	179.05	165.00	158.35	151.20	145.60
.4375	7/16	3/8	3/4	6	1/2	2 5/8	349014	137.40	.4091 - .4410	220.80	179.05	165.00	158.35	151.20	145.60
.4688	15/32	5/8	1	6	5/8	3 1/2	349015	141.15	.4411 - .4720	224.60	182.75	168.80	162.15	154.95	149.30
.5000	1/2	5/8	1	6	5/8	3 1/2	349016	141.15	.4721 - .5050	224.60	182.75	168.80	162.15	154.95	149.30
.5625	9/16	5/8	1	6	3/4	3 3/4	349018	154.25	.5051 - .5660	237.75	195.90	181.95	175.25	168.15	162.50
.6250	5/8	5/8	1	6	3/4	3 3/4	349020	154.25	.5661 - .6300	237.75	195.90	181.95	175.25	168.15	162.50
.6875	11/16	5/8	1	6	3/4	4 1/4	349022	171.20	.6301 - .6910	254.65	212.80	198.85	192.20	185.00	179.35
.7500	3/4	5/8	1	6	3/4	4 1/4	349024	171.20	.6911 - .7550	254.65	212.80	198.85	192.20	185.00	179.35
.8125	13/16	5/8	1	6	7/8	4 3/4	349026	180.55	.7551 - .8160	264.00	222.25	208.20	201.55	194.40	188.75
.8750	7/8	5/8	1	6	7/8	4 3/4	349028	187.35	.8161 - .8800	273.95	230.60	216.05	209.15	201.75	195.90
.9375	15/16	1	1 1/2	8	1	5 1/2	349030	224.55	.8801 - .9410	311.15	267.80	253.25	246.30	238.95	233.10
1.0000	1	1	1 1/2	8	1	5 1/2	349032	224.55	.9411 - 1.0050	311.15	267.80	253.25	246.30	238.95	233.10
1.0625	1 1/16	1	1 1/2	8	1 1/4	6	349034	248.50	1.0051 - 1.0660	338.80	293.50	278.45	271.20	263.40	257.35
1.1250	1 1/8	1	1 1/2	8	1 1/4	6	349036	248.50	1.0661 - 1.1300	338.80	293.50	278.45	271.20	263.40	257.35
1.1875	1 3/16	1	1 1/2	8	1 1/4	6	349038	254.65	1.1301 - 1.1900	345.05	299.75	284.60	277.35	269.65	263.50
1.2500	1 1/4	1	1 1/2	8	1 1/4	6	349040	254.65	1.1901 - 1.2550	345.05	299.75	284.60	277.35	269.65	263.50
1.3125	1 5/16	1	1 1/2	8	1 1/4	6	349042	273.05	1.2551 - 1.3155	363.45	318.15	303.00	295.75	288.00	281.90
1.3750	1 3/8	1	1 1/2	8	1 1/4	6	349044	273.05	1.3156 - 1.3800	363.45	318.15	303.00	295.75	288.00	281.90
1.4375	1 7/16	1	1 1/2	8	1 1/4	6	349046	291.35	1.3801 - 1.4405	381.70	336.40	321.25	314.10	306.30	300.20
1.5000	1 1/2	1	1 1/2	8	1 1/4	6	349048	291.35	1.4406 - 1.5050	381.70	336.40	321.25	314.10	306.30	300.20
1.5625	1 9/16	1	1 1/2	10	1 1/4	6	349050	305.55	1.5051 - 1.5660	395.95	350.65	335.50	328.35	320.55	314.45
1.6250	1 5/8	1	1 1/2	10	1 1/4	6	349052	305.55	1.5661 - 1.6300	395.95	350.65	335.50	328.35	320.55	314.45
1.6875	1 11/16	1	1 1/2	10	1 1/4	6	349054	323.95	1.6301 - 1.6910	414.35	369.05	353.90	346.65	338.95	332.80
1.7500	1 3/4	1	1 1/2	10	1 1/4	6	349056	323.95	1.6911 - 1.7550	414.35	369.05	353.90	346.65	338.95	332.80
1.8125	1 13/16	1	1 1/2	10	1 1/4	6	349058	340.20	1.7551 - 1.8160	430.60	385.30	370.15	363.00	355.20	349.10
1.8750	1 7/8	1	1 1/2	10	1 1/4	6	349060	340.20	1.8161 - 1.8800	430.60	385.30	370.15	363.00	355.20	349.10
1.9375	1 15/16	1	1 1/2	10	1 1/4	6	349062	356.50	1.8801 - 1.9410	446.85	401.55	386.40	379.20	371.45	365.35
2.0000	2	1	1 1/2	10	1 1/4	6	349064	356.50	1.9411 - 2.0150	446.85	401.55	386.40	379.20	371.45	365.35

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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	15/32	1/2	1 1/2	2 19/32	344601	\$160.70	2	4 11/32	344701	\$179.55
1/4 - 18*	3/4	.409	.450	2 1/32	1/2	1 1/2	2 29/32	344602	165.90	2	4 21/32	344702	185.55
3/8 - 18*	7/8	.543	.586	1 1/16	1/2	2	3 7/16	344603	190.20	2	4 11/16	344703	212.50
1/2 - 14*	1	.670	.725	7/8	1/2	2	3 7/8	344604	202.05	2	5 1/8	344704	226.30
3/4 - 14	1 1/4	.882	.937	7/8	1	2 1/2	4 5/8	344606	272.90	3	6 1/8	344706	305.15
1 - 11 1/2	1 1/2	1.107	1.173	1 1/16	1	2 1/2	5 1/16	344608	317.25	3	6 9/16	344708	355.30
1 - 11 1/2	1 1/2	1.107	1.173	1 1/16	-	-	-	-	-	4	7 9/16	344709	364.60
1 1/4 - 11 1/2	1 7/8	1.448	1.518	1 1/8	1 1/2	3	5 5/8	344610	378.85	3	6 5/8	344710	423.20
1 1/4 - 11 1/2	1 7/8	1.448	1.518	1 1/8	-	-	-	-	-	4	7 5/8	344711	454.30
1 1/2 - 11 1/2	2 1/8	1.687	1.757	1 1/8	1 1/2	3	5 7/8	344612	521.50	3	6 7/8	344712	584.60
1 1/2 - 11 1/2	2 1/8	1.687	1.757	1 1/8	-	-	-	-	-	4	7 7/8	344713	600.50
2 - 11 1/2	2 5/8	2.154	2.230	1 7/32	1 1/2	3	6 7/32	344616	590.80	3	7 3/32	344716	661.60
2 - 11 1/2	2 5/8	2.154	2.230	1 7/32	-	-	-	-	-	4	8 7/32	344717	679.45
2 1/2 - 8	3 1/8	2.561	2.670	1 3/4	1 1/2	3	6 3/4	344620	794.55	3	7 3/4	344720	889.75
2 1/2 - 8	3 1/8	2.561	2.670	1 3/4	-	-	-	-	-	4	8 3/4	344721	913.70
3 - 8	3 3/4	3.180	3.296	1 7/8	1 1/2	3	6 7/8	344624	819.50	3	7 7/8	344724	917.85

*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 56.

TOOL DIAMETER		MORSE TAPER	NO. OF FLUTES	LENGTH			TYPE 3403 EDP NO.	PRICE EACH	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*
.3750	3/8	1	4	2 1/2	5/8	5 13/16	340312	\$160.70	.3471 - .3780	\$201.40	\$180.95	\$174.20	\$170.95	\$167.45	\$164.70
.4375	7/16	1	4	2 3/4	5/8	6 1/8	340314	168.30	.4091 - .4410	208.95	188.55	181.70	178.55	175.05	172.30
.5000	1/2	1	6	3	5/8	6 7/16	340316	175.95	.4721 - .5030	216.60	196.20	189.35	186.15	182.70	179.95
.6250	5/8	2	6	3 1/2	5/8	7 9/16	340320	192.60	.5971 - .6280	233.30	212.90	206.15	202.85	199.40	196.65
.6875	11/16	2	6	3 7/8	5/8	8	340322	201.25	.6591 - .6910	241.80	221.50	214.65	211.40	207.90	205.15
.7500	3/4	2	6	4 3/16	3/4	8 3/8	340324	209.40	.7221 - .7530	250.05	229.70	222.90	219.65	216.15	213.40
.8125	13/16	2	6	4 9/16	3/4	8 13/16	340326	217.35	.7841 - .8160	257.90	237.60	230.75	227.55	224.10	221.35
.8750	7/8	2	6	4 7/8	3/4	9 3/16	340328	234.10	.8471 - .8780	276.20	255.10	248.00	244.65	241.00	238.15
.9375	15/16	3	8	5 1/8	3/4	10	340330	246.25	.9091 - .9410	280.60	267.25	260.20	256.80	253.20	250.35
1.0000	1	3	8	5 7/16	3/4	10 3/8	340332	251.35	.9721 - 1.0030	293.45	272.35	265.25	261.90	258.25	255.40

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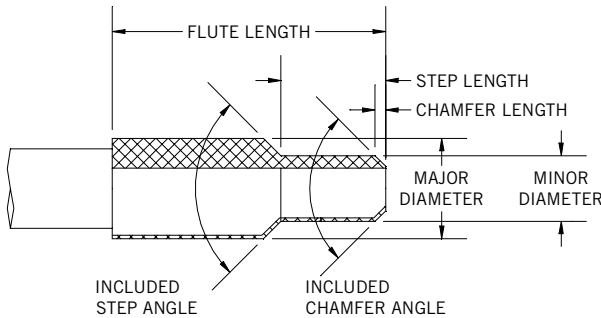
CARBIDE TIPPED RIGHT SPIRAL STEP REAMERS

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:

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

Shank diameter tolerance thru $\frac{3}{32}$ " tool diameter: +.0000"/-.0010"
over $\frac{3}{32}$ " 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 56.

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	\$180.70	\$142.45	\$129.70	\$123.60	\$117.10	\$111.95	\$104.45
.3151 - .3470	.2960	.2792	4	1 1/2	6	344211ST	344311ST	344411ST	191.30	153.05	140.30	134.25	127.70	122.60	115.10
.3471 - .3780	.3260	.3105	4	1 3/4	7	344212ST	344312ST	344412ST	192.35	154.20	141.45	135.35	128.80	123.60	116.20
.3781 - .4090	.3550	.3105	4	1 3/4	7	344213ST	344313ST	344413ST	197.50	159.30	146.55	140.45	133.95	128.80	121.30
.4091 - .4410	.3850	.3730	6	1 3/4	7	344214ST	344314ST	344414ST	202.20	164.00	151.20	145.15	138.60	133.50	126.00
.4411 - .4720	.4150	.3730	6	1 3/4	7	344215ST	344315ST	344415ST	210.20	172.00	159.25	153.15	146.60	141.50	134.00
.4721 - .5030	.4440	.4355	6	2	8	344216ST	344316ST	344416ST	225.70	185.00	171.35	164.85	157.90	152.40	144.45
.5031 - .5340	.4730	.4355	6	2	8	344217ST	344317ST	344417ST	229.95	189.20	175.65	169.10	162.15	156.65	148.70
.5341 - .5660	.5020	.4355	6	2	8	344218ST	344318ST	344418ST	229.95	189.20	175.65	169.10	162.15	156.65	148.70
.5661 - .5970	.5320	.4355	6	2	8	344219ST	344319ST	344419ST	234.30	193.65	180.00	173.55	166.50	161.10	153.05
.5971 - .6280	.5610	.5615	6	2 1/4	9	344220ST	344320ST	344420ST	234.30	193.65	180.00	173.55	166.50	161.10	153.05
.6281 - .6590	.5900	.5615	6	2 1/4	9	344221ST	344321ST	344421ST	239.15	198.50	184.85	178.40	171.35	165.90	157.90
.6591 - .6910	.6200	.5615	6	2 1/4	9	344222ST	344322ST	344422ST	249.00	208.30	194.65	188.15	181.20	175.70	167.70
.6911 - .7220	.6500	.5615	6	2 1/4	9	344223ST	344323ST	344423ST	251.55	210.80	197.20	190.70	183.70	178.25	170.30
.7221 - .7530	.6790	.6245	6	2 1/2	9 1/2	344224ST	344324ST	344424ST	254.05	213.30	199.65	193.20	186.25	180.75	172.75
.7531 - .7840	.7080	.6245	6	2 1/2	9 1/2	344225ST	344325ST	344425ST	258.60	217.95	204.25	197.80	190.85	185.35	177.35
.7841 - .8160	.7370	.6245	6	2 1/2	9 1/2	344226ST	344326ST	344426ST	258.60	217.95	204.25	197.80	190.85	185.35	177.35
.8161 - .8470	.7670	.6245	6	2 1/2	9 1/2	344227ST	344327ST	344427ST	268.25	227.55	213.90	207.45	200.40	195.00	187.00
.8471 - .8780	.7970	.7495	6	2 3/8	10	344228ST	344328ST	344428ST	278.35	236.15	222.00	215.30	208.00	202.35	194.05
.8781 - .9090	.8260	.7495	6	2 3/8	10	344229ST	344329ST	344429ST	310.30	268.05	253.85	247.15	239.95	234.25	225.90
.9091 - .9410	.8550	.7495	8	2 3/8	10	344230ST	344330ST	344430ST	310.30	268.05	253.85	247.15	239.95	234.25	225.90
.9411 - .9720	.8850	.7495	8	2 3/8	10	344231ST	344331ST	344431ST	321.40	279.10	265.05	258.25	251.00	245.30	237.10
.9721 - 1.0030	.9140	.8745	8	2 3/4	10 1/2	344232ST	344332ST	344432ST	321.40	279.10	265.05	258.25	251.00	245.30	237.10
1.0031 - 1.0660	.9430	.8745	8	2 3/4	10 1/2	344234ST	344334ST	344434ST	362.90	320.65	306.45	299.75	292.50	286.80	278.60
1.0661 - 1.1280	1.0020	.8745	8	2 3/8	11	344236ST	344336ST	344436ST	371.50	329.25	315.10	308.40	301.15	295.45	287.20
1.1281 - 1.1905	1.0610	.9995	8	2 7/8	11	344238ST	344338ST	344438ST	386.25	344.05	329.85	323.15	315.95	310.25	301.90
1.1906 - 1.2530	1.1200	.9995	8	3	11 1/2	344240ST	344340ST	344440ST	403.70	361.45	347.25	340.55	333.35	327.65	319.30
1.2531 - 1.3155	1.1780	.9995	8	3	11 1/2	344242ST	344342ST	344442ST	437.80	395.55	381.45	374.70	367.45	361.75	353.50
1.3156 - 1.3780	1.2370	.9995	8	3 1/4	12	344244ST	344344ST	344444ST	471.55	429.30	415.20	408.40	401.15	395.45	387.25
1.3781 - 1.4405	1.2960	.9995	8	3 1/4	12	344246ST	344346ST	344446ST	494.55	452.30	438.20	431.45	424.20	418.50	410.25
1.4406 - 1.5030	1.3550	1.2495	8	3 1/2	12 1/2	344248ST	344348ST	344448ST	517.75	475.55	461.40	454.70	447.45	441.75	433.45

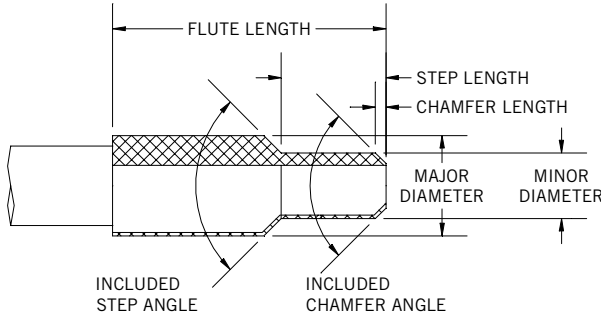
CARBIDE TIPPED LEFT SPIRAL STEP REAMERS

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 3/8" tool diameter: +.0000"/-.0010".

over 3/8" 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 56.

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	\$192.70	\$151.95	\$138.40	\$131.85	\$124.90	\$119.40	\$111.45
.3151 - .3470	.2960	.2792	4	1 1/2	6	348211ST	348311ST	348411ST	204.05	163.30	149.65	143.20	136.25	130.75	122.75
.3471 - .3780	.3260	.3105	4	1 3/4	7	348212ST	348312ST	348412ST	205.15	164.45	150.85	144.30	137.35	131.85	123.90
.3781 - .4090	.3550	.3105	4	1 3/4	7	348213ST	348313ST	348413ST	210.65	169.90	156.35	149.80	142.85	137.35	129.40
.4091 - .4410	.3850	.3730	6	1 3/4	7	348214ST	348314ST	348414ST	215.65	174.95	161.30	154.85	147.80	142.40	134.40
.4411 - .4720	.4150	.3730	6	1 3/4	7	348215ST	348315ST	348415ST	224.25	183.50	169.85	163.40	156.40	150.90	142.90
.4721 - .5030	.4440	.4355	6	2	8	348216ST	348316ST	348416ST	231.75	189.95	175.95	169.30	162.15	156.50	148.35
.5031 - .5340	.4730	.4355	6	2	8	348217ST	348317ST	348417ST	236.10	194.35	180.30	173.65	166.50	160.85	152.65
.5341 - .5660	.5020	.4355	6	2	8	348218ST	348318ST	348418ST	236.10	194.35	180.30	173.65	166.50	160.85	152.65
.5661 - .5970	.5320	.4355	6	2	8	348219ST	348319ST	348419ST	240.65	198.85	184.85	178.15	171.05	165.40	157.15
.5971 - .6280	.5610	.5615	6	2 1/4	9	348220ST	348320ST	348420ST	240.65	198.85	184.85	178.15	171.05	165.40	157.15
.6281 - .6590	.5900	.5615	6	2 1/4	9	348221ST	348321ST	348421ST	245.60	203.75	189.80	183.15	175.95	170.30	162.15
.6591 - .6910	.6200	.5615	6	2 1/4	9	348222ST	348322ST	348422ST	255.60	213.85	199.80	193.20	186.00	180.40	172.20
.6911 - .7220	.6500	.5615	6	2 1/4	9	348223ST	348323ST	348423ST	258.30	216.50	202.50	195.80	188.70	183.05	174.80
.7221 - .7530	.6790	.6245	6	2 1/2	9 1/2	348224ST	348324ST	348424ST	260.90	219.05	205.00	198.40	191.20	185.55	177.40
.7531 - .7840	.7080	.6245	6	2 1/2	9 1/2	348225ST	348325ST	348425ST	265.55	223.70	209.75	203.10	195.90	190.25	182.10
.7841 - .8160	.7370	.6245	6	2 1/2	9 1/2	348226ST	348326ST	348426ST	265.55	223.70	209.75	203.10	195.90	190.25	182.10
.8161 - .8470	.7670	.6245	6	2 1/2	9 1/2	348227ST	348327ST	348427ST	275.45	233.65	219.65	212.95	205.85	200.20	192.05
.8471 - .8780	.7970	.7495	6	2 3/8	10	348228ST	348328ST	348428ST	285.80	242.45	227.90	221.00	213.60	207.75	199.30
.8781 - .9090	.8260	.7495	6	2 3/8	10	348229ST	348329ST	348429ST	318.65	275.20	260.70	253.80	246.30	240.45	232.00
.9091 - .9410	.8550	.7495	8	2 3/8	10	348230ST	348330ST	348430ST	318.65	275.20	260.70	253.80	246.30	240.45	232.00
.9411 - .9720	.8850	.7495	8	2 3/8	10	348231ST	348331ST	348431ST	330.00	286.65	272.10	265.20	257.80	251.95	243.40
.9721 - 1.0030	.9140	.8745	8	2 3/4	10 1/2	348232ST	348332ST	348432ST	330.00	286.65	272.10	265.20	257.80	251.95	243.40
1.0031 - 1.0660	.9430	.8745	8	2 3/4	10 1/2	348234ST	348334ST	348434ST	372.60	329.25	314.70	307.75	300.40	294.50	286.00
1.0661 - 1.1280	1.0020	.8745	8	2 3/8	11	348236ST	348336ST	348436ST	381.45	338.10	323.55	316.60	309.25	303.40	294.90
1.1281 - 1.1905	1.0610	.9995	8	2 3/8	11	348238ST	348338ST	348438ST	396.65	353.20	338.70	331.80	324.30	318.55	310.00
1.1906 - 1.2530	1.1200	.9995	8	3	11 1/2	348240ST	348340ST	348440ST	414.50	371.15	356.60	349.65	342.25	336.40	327.85
1.2531 - 1.3155	1.1780	.9995	8	3	11 1/2	348242ST	348342ST	348442ST	449.60	406.20	391.60	384.75	377.30	371.45	363.00
1.3156 - 1.3780	1.2370	.9995	8	3 1/4	12	348244ST	348344ST	348444ST	484.20	440.80	426.25	419.35	411.95	406.10	397.65
1.3781 - 1.4405	1.2960	.9995	8	3 1/4	12	348246ST	348346ST	348446ST	507.80	464.45	449.90	443.00	435.60	429.75	421.25
1.4406 - 1.5030	1.3550	1.2495	8	3 1/2	12 1/2	348248ST	348348ST	348448ST	531.70	488.25	473.70	466.85	459.40	453.55	445.05

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 90 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	\$292.55	\$256.20	\$244.05	\$238.25	\$232.00	\$227.15
.1281-.1435*	.1255	4	1 1/2	3457045EL	3458045EL	3459045EL	2 17/32 - 6 1/2	293.60	257.25	245.10	239.30	233.05	228.15
.1436-.1590*	.1411	4	1 1/2	345705EL	345805EL	345905EL	2 17/32 - 7	298.45	262.05	249.90	244.10	237.90	233.00
.1591-.1750*	.1567	4	1 1/2	3457055EL	3458055EL	3459055EL	2 29/32 - 8	304.05	267.70	255.55	249.75	243.50	238.65
.1751-.1910*	.1724	4	1 1/2	345706EL	345806EL	345906EL	4 17/32 - 9	312.15	275.80	263.65	257.85	251.60	246.70
.1911-.2210*	.1880	4	1 1/2	345707EL	345807EL	345907EL	5 1/32 - 10	322.70	286.35	274.15	268.40	262.15	257.25
.2211-.2530*	.2193	4	1 1/2	345708EL	345808EL	345908EL	6 1/32 - 12	343.55	307.20	295.00	289.25	283.00	278.10
.2531-.2840*	.2505	4	1 1/2	345709EL	345809EL	345909EL	6 1/32 - 12	361.45	325.05	312.90	307.10	300.90	296.00
.2841-.3150	.2792	4	1 1/2	345710EL	345810EL	345910EL	6 1/32 - 12	256.50	220.15	208.00	202.20	195.95	191.05
.3151-.3470	.2792	4	1 1/2	345711EL	345811EL	345911EL	6 1/32 - 12	256.50	220.15	208.00	202.20	195.95	191.05
.3471-.3780	.3105	4	1 3/4	345712EL	345812EL	345912EL	7 1/32 - 14	264.90	228.55	216.35	210.60	204.35	199.45
.3781-.4090	.3105	4	1 3/4	345713EL	345813EL	345913EL	7 1/32 - 14	264.90	228.55	216.35	210.60	204.35	199.45
.4091-.4410	.3730	6	1 3/4	345714EL	345814EL	345914EL	7 1/32 - 14	273.30	236.90	224.75	218.95	212.75	207.85
.4411-.4720	.3730	6	1 3/4	345715EL	345815EL	345915EL	7 1/32 - 14	273.30	236.90	224.75	218.95	212.75	207.85
.4721-.5030	.4355	6	2	345716EL	345816EL	345916EL	8 1/32 - 16	278.90	242.55	230.40	224.60	218.35	213.45
.5031-.5340	.4355	6	2	345717EL	345817EL	345917EL	8 1/32 - 16	278.90	242.55	230.40	224.60	218.35	213.45
.5341-.5660	.4355	6	2	345718EL	345818EL	345918EL	8 1/32 - 16	284.10	242.55	235.60	229.80	223.55	218.65
.5661-.5970	.4355	6	2	345719EL	345819EL	345919EL	8 1/32 - 16	284.10	247.75	235.60	229.80	223.55	218.65
.5971-.6280	.5615	6	2 1/4	345720EL	345820EL	345920EL	9 1/32 - 18	290.10	253.75	241.60	235.80	229.55	224.70
.6281-.6590	.5615	6	2 1/4	345721EL	345821EL	345921EL	9 1/32 - 18	290.10	253.75	241.60	235.80	229.55	224.70
.6591-.6910	.5615	6	2 1/4	345722EL	345822EL	345922EL	9 1/32 - 18	290.95	254.60	242.40	236.60	230.40	225.50
.6911-.7220	.5615	6	2 1/4	345723EL	345823EL	345923EL	9 1/32 - 18	290.95	254.60	242.40	236.60	230.40	225.50
.7221-.7530	.6245	6	2 1/2	345724EL	345824EL	345924EL	9 17/32 - 18	312.30	275.95	263.80	258.00	251.75	246.85

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 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 and coolant through the flutes.

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	\$373.45	\$337.10	\$324.90	\$319.15	\$312.90	\$308.00
.1911-.2210*	.1880	4	1 1/2	341607EL	342607EL	343507EL	5 1/32 - 10	387.85	351.50	339.30	333.55	327.30	322.40
.2211-.2530*	.2193	4	1 1/2	341608EL	342608EL	343508EL	6 1/32 - 12	430.90	394.50	382.35	376.55	370.35	365.45
.2531-.2840*	.2505	4	1 1/2	341609EL	342609EL	343509EL	6 1/32 - 12	451.75	415.35	403.20	397.40	391.20	386.30
.2841-.3150	.2792	4	1 1/2	341610EL	342610EL	343510EL	6 1/32 - 12	334.05	297.70	285.50	279.75	273.50	268.60
.3151-.3470	.2792	4	1 1/2	341611EL	342611EL	343511EL	6 1/32 - 12	334.05	297.70	285.50	279.75	273.50	268.60
.3471-.3780	.3105	4	1 3/4	341612EL	342612EL	343512EL	7 1/32 - 14	340.65	304.30	292.15	286.35	280.10	275.20
.3781-.4090	.3105	4	1 3/4	341613EL	342613EL	343513EL	7 1/32 - 14	340.65	304.30	292.15	286.35	280.10	275.20
.4091-.4410	.3730	6	1 3/4	341614EL	342614EL	343514EL	7 1/32 - 14	342.05	305.70	293.55	287.75	281.50	276.60
.4411-.4720	.3730	6	1 3/4	341615EL	342615EL	343515EL	7 1/32 - 14	342.05	305.70	293.55	287.75	281.50	276.60
.4721-.5030	.4355	6	2	341616EL	342616EL	343516EL	8 1/32 - 16	372.10	335.75	323.60	317.80	311.55	306.65
.5031-.5340	.4355	6	2	341617EL	342617EL	343517EL	8 1/32 - 16	372.10	335.75	323.60	317.80	311.55	306.65
.5341-.5660	.4355	6	2	341618EL	342618EL	343518EL	8 1/32 - 16	374.70	338.35	326.20	320.40	314.15	309.25
.5661-.5970	.4355	6	2	341619EL	342619EL	343519EL	8 1/32 - 16	374.70	338.35	326.20	320.40	314.15	309.25
.5971-.6280	.5615	6	2 1/4	341620EL	342620EL	343520EL	9 1/32 - 18	382.15	345.75	333.60	327.80	321.60	316.70
.6281-.6590	.5615	6	2 1/4	341621EL	342621EL	343521EL	9 1/32 - 18	382.15	345.75	333.60	327.80	321.60	316.70
.6591-.6910	.5615	6	2 1/4	341622EL	342622EL	343522EL	9 1/32 - 18	386.30	349.95	337.75	331.95	325.75	320.85
.6911-.7220	.5615	6	2 1/4	341623EL	342623EL	343523EL	9 1/32 - 18	386.30	349.95	337.75	331.95	325.75	320.85
.7221-.7530	.6245	6	2 1/2	341624EL	342624EL	343524EL	9 17/32 - 18	402.15	365.80	353.65	347.85	341.60	336.70

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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 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 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	\$412.25	\$368.65	\$354.00	\$347.10	\$339.60	\$333.75
.2531 - .2840*	.2505	4	1 1/2	344209EL	344309EL	344409EL	6 1/2 - 12	433.70	390.05	375.45	368.55	361.05	355.20
.2841 - .3150	.2792	4	1 1/2	344210EL	344310EL	344410EL	6 1/2 - 12	307.80	264.15	249.60	242.65	235.15	229.30
.3151 - .3470	.2792	4	1 1/2	344211EL	344311EL	344411EL	6 1/2 - 12	307.80	264.15	249.60	242.65	235.15	229.30
.3471 - .3780	.3105	4	1 3/4	344212EL	344312EL	344412EL	7 1/2 - 14	317.85	274.25	259.65	252.75	245.25	239.35
.3781 - .4090	.3105	4	1 3/4	344213EL	344313EL	344413EL	7 1/2 - 14	317.85	274.25	259.65	252.75	245.25	239.35
.4091 - .4410	.3730	6	1 3/4	344214EL	344314EL	344414EL	7 1/2 - 14	327.95	284.35	269.70	262.75	255.25	249.40
.4411 - .4720	.3730	6	1 3/4	344215EL	344315EL	344415EL	7 1/2 - 14	327.95	284.35	269.70	262.75	255.25	249.40
.4721 - .5030	.4355	6	2	344216EL	344316EL	344416EL	8 1/2 - 16	334.70	291.10	276.45	269.50	262.05	256.15
.5031 - .5340	.4355	6	2	344217EL	344317EL	344417EL	8 1/2 - 16	334.70	291.10	276.45	269.50	262.05	256.15
.5341 - .5660	.4355	6	2	344218EL	344318EL	344418EL	8 1/2 - 16	340.95	297.30	282.70	275.75	268.30	262.35
.5661 - .5970	.4355	6	2	344219EL	344319EL	344419EL	8 1/2 - 16	340.95	297.30	282.70	275.75	268.30	262.35
.5971 - .6280	.5615	6	2 1/4	344220EL	344320EL	344420EL	9 1/2 - 18	348.15	304.50	289.90	283.00	275.50	269.65
.6281 - .6590	.5615	6	2 1/4	344221EL	344321EL	344421EL	9 1/2 - 18	348.15	304.50	289.90	283.00	275.50	269.65
.6591 - .6910	.5615	6	2 1/4	344222EL	344322EL	344422EL	9 1/2 - 18	349.10	305.50	290.85	283.95	276.45	270.60
.6911 - .7220	.5615	6	2 1/4	344223EL	344323EL	344423EL	9 1/2 - 18	349.10	305.50	290.85	283.95	276.45	270.60
.7221 - .7530	.6245	6	2 1/2	344224EL	344324EL	344424EL	9 1/2 - 18	374.80	331.15	316.55	309.55	302.15	296.20

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 105 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 and coolant through the end of the tool.



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	\$517.05	\$473.40	\$458.85	\$451.90	\$444.40	\$438.50
.2531 - .2840*	.2505	4	1 1/2	341109EL	341309EL	341509EL	6 1/2 - 12	542.10	498.50	483.85	476.90	469.40	463.55
.2841 - .3150	.2792	4	1 1/2	341110EL	341310EL	341510EL	6 1/2 - 12	400.85	357.20	342.65	335.70	328.20	322.30
.3151 - .3470	.2792	4	1 1/2	341111EL	341311EL	341511EL	6 1/2 - 12	400.85	357.20	342.65	335.70	328.20	322.30
.3471 - .3780	.3105	4	1 3/4	341112EL	341312EL	341512EL	7 1/2 - 14	408.75	365.15	350.50	343.60	336.15	330.25
.3781 - .4090	.3105	4	1 3/4	341113EL	341313EL	341513EL	7 1/2 - 14	408.75	365.15	350.50	343.60	336.15	330.25
.4091 - .4410	.3730	6	1 3/4	341114EL	341314EL	341514EL	7 1/2 - 14	410.45	366.85	352.25	345.35	337.85	331.95
.4411 - .4720	.3730	6	1 3/4	341115EL	341315EL	341515EL	7 1/2 - 14	410.45	366.85	352.25	345.35	337.85	331.95
.4721 - .5030	.4355	6	2	341116EL	341316EL	341516EL	8 1/2 - 16	446.55	402.90	388.30	381.40	373.90	368.05
.5031 - .5340	.4355	6	2	341117EL	341317EL	341517EL	8 1/2 - 16	446.55	402.90	388.30	381.40	373.90	368.05
.5341 - .5660	.4355	6	2	341118EL	341318EL	341518EL	8 1/2 - 16	449.65	406.00	391.40	384.50	377.00	371.15
.5661 - .5970	.4355	6	2	341119EL	341319EL	341519EL	8 1/2 - 16	449.65	406.00	391.40	384.50	377.00	371.15
.5971 - .6280	.5615	6	2 1/4	341120EL	341320EL	341520EL	9 1/2 - 18	458.55	414.95	400.30	393.40	385.90	380.05
.6281 - .6590	.5615	6	2 1/4	341121EL	341321EL	341521EL	9 1/2 - 18	458.55	414.95	400.30	393.40	385.90	380.05
.6591 - .6910	.5615	6	2 1/4	341122EL	341322EL	341522EL	9 1/2 - 18	463.55	419.90	405.30	398.40	390.90	385.00
.6911 - .7220	.5615	6	2 1/4	341123EL	341323EL	341523EL	9 1/2 - 18	463.55	419.90	405.30	398.40	390.90	385.00
.7221 - .7530	.6245	6	2 1/2	341124EL	341324EL	341524EL	9 1/2 - 18	482.60	438.95	424.35	417.45	409.95	404.10

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 95 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	\$412.25	\$368.65	\$354.00	\$347.10	\$339.60	\$333.75
.2531 - .2840*	.2505	4	1 1/2	348209EL	348309EL	348409EL	6 1/32 - 12	433.70	390.05	375.45	368.55	361.05	355.20
.2841 - .3150	.2792	4	1 1/2	348210EL	348310EL	348410EL	6 1/32 - 12	307.80	264.15	249.60	242.65	235.15	229.30
.3151 - .3470	.2792	4	1 1/2	348211EL	348311EL	348411EL	6 1/32 - 12	307.80	264.15	249.60	242.65	235.15	229.30
.3471 - .3780	.3105	4	1 3/4	348212EL	348312EL	348412EL	7 1/32 - 14	317.85	274.25	259.65	252.75	245.25	239.35
.3781 - .4090	.3105	4	1 3/4	348213EL	348313EL	348413EL	7 1/32 - 14	317.85	274.25	259.65	252.75	245.25	239.35
.4091 - .4410	.3730	6	1 3/4	348214EL	348314EL	348414EL	7 1/32 - 14	327.95	284.35	269.70	262.75	255.25	249.40
.4411 - .4720	.3730	6	1 3/4	348215EL	348315EL	348415EL	7 1/32 - 14	327.95	284.35	269.70	262.75	255.25	249.40
.4721 - .5030	.4355	6	2	348216EL	348316EL	348416EL	8 1/32 - 16	334.70	291.10	276.45	269.50	262.05	256.15
.5031 - .5340	.4355	6	2	348217EL	348317EL	348417EL	8 1/32 - 16	334.70	291.10	276.45	269.50	262.05	256.15
.5341 - .5660	.4355	6	2	348218EL	348318EL	348418EL	8 1/32 - 16	340.95	297.30	282.70	275.75	268.30	262.35
.5661 - .5970	.4355	6	2	348219EL	348319EL	348419EL	8 1/32 - 16	340.95	297.30	282.70	275.75	268.30	262.35
.5971 - .6280	.5615	6	2 1/4	348220EL	348320EL	348420EL	9 1/32 - 18	348.15	304.50	289.90	283.00	275.50	269.65
.6281 - .6590	.5615	6	2 1/4	348221EL	348321EL	348421EL	9 1/32 - 18	348.15	304.50	289.90	283.00	275.50	269.65
.6591 - .6910	.5615	6	2 1/4	348222EL	348322EL	348422EL	9 1/32 - 18	349.10	305.50	290.85	283.95	276.45	270.60
.6911 - .7220	.5615	6	2 1/4	348223EL	348323EL	348423EL	9 1/32 - 18	349.10	305.50	290.85	283.95	276.45	270.60
.7221 - .7530	.6245	6	2 1/2	348224EL	348324EL	348424EL	9 17/32 - 18	374.80	331.15	316.55	309.55	302.15	296.20

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 106 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 and coolant through the flutes.



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	\$517.05	\$473.40	\$458.85	\$451.90	\$444.40	\$438.50
.2531 - .2840*	.2505	4	1 1/2	342709EL	342809EL	342909EL	6 1/32 - 12	542.10	498.50	483.85	476.90	469.40	463.55
.2841 - .3150	.2792	4	1 1/2	342710EL	342810EL	342910EL	6 1/32 - 12	400.85	357.20	342.65	335.70	328.20	322.30
.3151 - .3470	.2792	4	1 1/2	342711EL	342811EL	342911EL	6 1/32 - 12	400.85	357.20	342.65	335.70	328.20	322.30
.3471 - .3780	.3105	4	1 3/4	342712EL	342812EL	342912EL	7 1/32 - 14	408.75	365.15	350.50	343.60	336.15	330.25
.3781 - .4090	.3105	4	1 3/4	342713EL	342813EL	342913EL	7 1/32 - 14	408.75	365.15	350.50	343.60	336.15	330.25
.4091 - .4410	.3730	6	1 3/4	342714EL	342814EL	342914EL	7 1/32 - 14	410.45	366.85	352.25	345.35	337.85	331.95
.4411 - .4720	.3730	6	1 3/4	342715EL	342815EL	342915EL	7 1/32 - 14	410.45	366.85	352.25	345.35	337.85	331.95
.4721 - .5030	.4355	6	2	342716EL	342816EL	342916EL	8 1/32 - 16	446.55	402.90	388.30	381.40	373.90	368.05
.5031 - .5340	.4355	6	2	342717EL	342817EL	342917EL	8 1/32 - 16	446.55	402.90	388.30	381.40	373.90	368.05
.5341 - .5660	.4355	6	2	342718EL	342818EL	342918EL	8 1/32 - 16	449.65	406.00	391.40	384.50	377.00	371.15
.5661 - .5970	.4355	6	2	342719EL	342819EL	342919EL	8 1/32 - 16	449.65	406.00	391.40	384.50	377.00	371.15
.5971 - .6280	.5615	6	2 1/4	342720EL	342820EL	342920EL	9 1/32 - 18	458.55	414.95	400.30	393.40	385.90	380.05
.6281 - .6590	.5615	6	2 1/4	342721EL	342821EL	342921EL	9 1/32 - 18	458.55	414.95	400.30	393.40	385.90	380.05
.6591 - .6910	.5615	6	2 1/4	342722EL	342822EL	342922EL	9 1/32 - 18	463.55	419.90	405.30	398.40	390.90	385.00
.6911 - .7220	.5615	6	2 1/4	342723EL	342823EL	342923EL	9 1/32 - 18	463.55	419.90	405.30	398.40	390.90	385.00
.7221 - .7530	.6245	6	2 1/2	342724EL	342824EL	342924EL	9 17/32 - 18	482.60	438.95	424.35	417.45	409.95	404.10

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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.

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

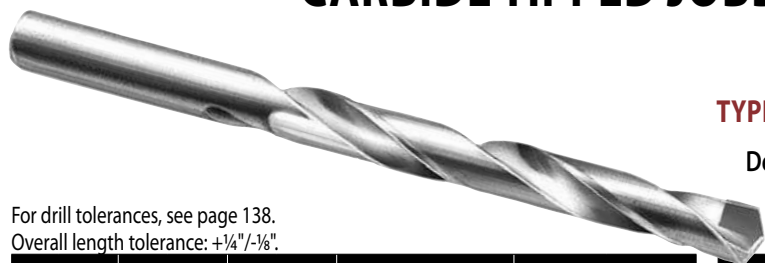


CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM	FEED RATE (INCHES PER REVOLUTION)					HOLE DIAMETER IN INCHES			
			GENERAL PURPOSE (G.P.)	1/8	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	250-350	.003	.005	.007	.008	.010	.011	.014	.017	.019
	MAGNESIUM ALLOY	50 - 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	-	-	-	-	-	-	-	-	-	-

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 118.
 (Not usually recommended for steel.)

For drill tolerances, see page 138.

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

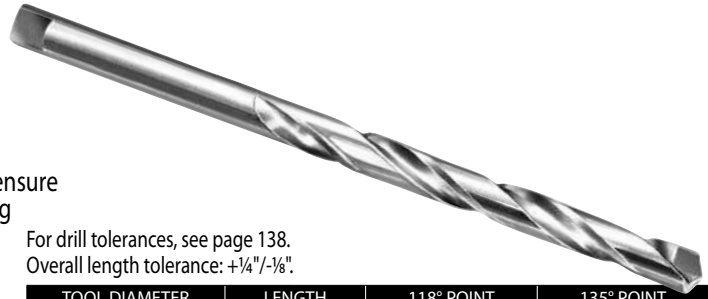
TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		118° POINT		135° POINT	
mm	INCH	mm	INCH	mm	INCH	TYPE 3600 EDP NO.	PRICE EACH	TYPE 3601 EDP NO.	PRICE EACH
3.0	.1181	41	1 5/8	70	2 3/4	3600030	\$20.25	3601030	\$20.65
3.1	.1220	41	1 5/8	70	2 3/4	3600031	21.15	3601031	21.45
3.2	.1260	41	1 5/8	70	2 3/4	3600032	21.15	3601032	21.45
3.3	.1299	44	1 3/4	73	2 7/8	3600033	21.15	3601033	21.45
3.4	.1339	44	1 3/4	73	2 7/8	3600034	21.15	3601034	21.45
3.5	.1378	44	1 3/4	73	2 7/8	3600035	19.50	3601035	20.25
3.6	.1417	48	1 7/8	76	3	3600036	20.25	3601036	20.65
3.7	.1457	48	1 7/8	76	3	3600037	20.25	3601037	20.65
3.8	.1496	48	1 7/8	76	3	3600038	20.25	3601038	20.65
3.9	.1535	51	2	79	3 1/8	3600039	20.25	3601039	20.65
4.0	.1575	54	2 1/8	83	3 1/4	3600040	19.05	3601040	19.50
4.1	.1614	54	2 1/8	83	3 1/4	3600041	18.35	3601041	20.85
4.2	.1654	54	2 1/8	83	3 1/4	3600042	19.50	3601042	20.85
4.3	.1693	54	2 1/8	83	3 1/4	3600043	19.50	3601043	20.85
4.4	.1732	56	2 3/16	86	3 3/8	3600044	19.50	3601044	20.85
4.5	.1772	56	2 3/16	86	3 3/8	3600045	20.25	3601045	20.85
4.6	.1811	56	2 3/16	86	3 3/8	3600046	22.05	3601046	22.35
4.7	.1850	59	2 5/16	89	3 1/2	360213	18.70	360313	19.75
4.8	.1890	59	2 5/16	89	3 1/2	360212	19.50	360312	20.65
4.9	.1929	62	2 7/16	92	3 5/8	3600049	22.05	3601049	22.35
5.0	.1969	62	2 7/16	92	3 5/8	3600050	21.15	3601050	21.75
5.1	.2008	62	2 7/16	92	3 5/8	3600051	22.95	3601051	23.30
5.2	.2047	64	2 1/2	95	3 3/4	3600052	22.95	3601052	23.30
5.3	.2087	64	2 1/2	95	3 3/4	3600053	22.95	3601053	23.30
5.4	.2126	64	2 1/2	95	3 3/4	3600054	22.95	3601054	23.30
5.5	.2165	64	2 1/2	95	3 3/4	3600055	22.50	3601055	22.70
5.6	.2205	67	2 5/8	98	3 7/8	3600056	23.60	3601056	24.05
5.7	.2244	67	2 5/8	98	3 7/8	3600057	23.60	3601057	24.05
5.8	.2283	67	2 5/8	98	3 7/8	3600058	23.60	3601058	24.05
5.9	.2323	67	2 5/8	98	3 7/8	3600059	23.60	3601059	24.05
6.0	.2362	70	2 3/4	102	4	3600060	23.30	3601060	24.65
6.1	.2402	70	2 3/4	102	4	3600061	24.65	3601061	25.30
6.2	.2441	70	2 3/4	102	4	3600062	24.65	3601062	25.30
6.3	.2480	70	2 3/4	102	4	3600063	24.65	3601063	25.30
6.4	.2520	73	2 7/8	105	4 1/8	3600064	24.65	3601064	25.30
6.5	.2559	73	2 7/8	105	4 1/8	3600065	24.10	3601065	24.65
6.6	.2598	73	2 7/8	105	4 1/8	3600066	25.75	3601066	28.85
6.7	.2638	73	2 7/8	105	4 1/8	3600067	25.75	3601067	28.85
6.8	.2677	73	2 7/8	105	4 1/8	3600068	25.75	3601068	28.85
6.9	.2717	73	2 7/8	105	4 1/8	3600069	25.75	3601069	28.85
7.0	.2756	73	2 7/8	105	4 1/8	3600070	25.25	3601070	28.85
7.1	.2795	75	2 15/16	108	4 1/4	3600071	26.40	3601071	28.85
7.2	.2835	75	2 15/16	108	4 1/4	3600072	26.40	3601072	28.85
7.3	.2874	75	2 15/16	108	4 1/4	3600073	26.40	3601073	28.85
7.4	.2913	78	3 1/16	111	4 3/8	3600074	26.40	3601074	31.25
7.5	.2953	78	3 1/16	111	4 3/8	3600075	26.40	3601075	31.25
7.6	.2992	78	3 1/16	111	4 3/8	3600076	27.70	3601076	31.25
7.7	.3031	81	3 3/16	114	4 1/2	3600077	27.70	3601077	31.25
7.8	.3071	81	3 3/16	114	4 1/2	3600078	27.70	3601078	31.25
7.9	.3110	81	3 3/16	114	4 1/2	3600079	27.70	3601079	31.25
8.0	.3150	81	3 3/16	114	4 1/2	3600080	27.00	3601080	31.25
8.1	.3189	84	3 5/16	117	4 5/8	3600081	29.55	3601081	33.25
8.2	.3228	84	3 5/16	117	4 5/8	3600082	29.55	3601082	33.25
8.3	.3268	84	3 5/16	117	4 5/8	3600083	29.55	3601083	33.25
8.4	.3307	87	3 7/16	121	4 3/4	3600084	29.55	3601084	33.25
8.5	.3346	87	3 7/16	121	4 3/4	3600085	28.25	3601085	33.25
8.6	.3386	87	3 7/16	121	4 3/4	3600086	29.55	3601086	33.25
8.7	.3425	87	3 7/16	121	4 3/4	3600087	\$29.55	3601087	\$33.25
8.8	.3465	89	3 1/2	124	4 7/8	3600088	29.55	3601088	33.25
8.9	.3504	89	3 1/2	124	4 7/8	3600089	29.55	3601089	35.40
9.0	.3543	89	3 1/2	124	4 7/8	3600090	28.85	3601090	35.40
9.1	.3583	89	3 1/2	124	4 7/8	3600091	32.00	3601091	35.40
9.2	.3622	92	3 5/8	127	5	3600092	32.00	3601092	35.40
9.3	.3661	92	3 5/8	127	5	3600093	32.00	3601093	35.40
9.4	.3701	92	3 5/8	127	5	3600094	32.00	3601094	35.40
9.5	.3740	92	3 5/8	127	5	3600095	31.40	3601095	35.40
9.6	.3780	95	3 3/4	130	5 1/8	3600096	32.50	3601096	38.60
9.7	.3819	95	3 3/4	130	5 1/8	3600097	32.50	3601097	38.60
9.8	.3858	95	3 3/4	130	5 1/8	3600098	32.50	3601098	38.60
9.9	.3898	95	3 3/4	130	5 1/8	3600099	32.50	3601099	38.60
10.0	.3937	95	3 3/4	130	5 1/8	3600100	32.50	3601100	38.60
10.1	.3976	98	3 7/8	133	5 1/4	3600101	38.75	3601101	39.75
10.2	.4016	98	3 7/8	133	5 1/4	3600102	38.75	3601102	39.75
10.3	.4055	98	3 7/8	133	5 1/4	3600103	38.75	3601103	39.75
10.4	.4094	98	3 7/8	133	5 1/4	3600104	38.75	3601104	41.70
10.5	.4134	98	3 7/8	133	5 1/4	3600105	37.45	3601105	41.70
10.6	.4173	100	3 15/16	137	5 3/8	3600106	42.45	3601106	43.20
10.7	.4213	100	3 15/16	137	5 3/8	3600107	42.45	3601107	43.20
10.8	.4252	103	4 1/16	140	5 1/2	3600108	42.45	3601108	43.20
10.9	.4291	103	4 1/16	140	5 1/2	3600109	42.45	3601109	43.20
11.0	.4331	103	4 1/16	140	5 1/2	3600110	40.60	3601110	41.70
11.1	.4370	103	4 1/16	140	5 1/2	3600111	47.35	3601111	48.10
11.2	.4409	106	4 3/16	143	5 5/8	3600112	47.35	3601112	48.45
11.3	.4449	106	4 3/16	143	5 5/8	3600113	47.35	3601113	48.45
11.4	.4488	106	4 3/16	143	5 5/8	3600114	47.35	3601114	47.05
11.5	.4528	106	4 3/16	143	5 5/8	3600115	45.50	3601115	47.05
11.6	.4567	110	4 5/16	146	5 3/4	3600116	51.55	3601116	52.40
11.7	.4606	110	4 5/16	146	5 3/4	3600117	51.55	3601117	52.40
11.8	.4646	110	4 5/16	146	5 3/4	3600118	51.55	3601118	52.40
11.9	.4685	110	4 5/16	146	5 3/4	3600119	51.55	3601119	52.40
12.0	.4724	111	4 3/8	149	5 7/8	3600120	49.25	3601120	52.60
12.1	.4764	111	4 3/8	149	5 7/8	3600121	53.65	3601121	54.40
12.2	.4803	111	4 3/8	149	5 7/8	3600122	53.65	3601122	54.40
12.3	.4843	111	4 3/8	149	5 7/8	3600123	53.65	3601123	54.40
12.4	.4882	114	4 1/2	152	6	3600124	53.65	3601124	54.40
12.5	.4921	114	4 1/2	152	6	3600125	51.10	3601125	52.60
12.6	.4961	114	4 1/2	152	6	3600126	55.50	3601126	56.25
12.7	.5000	114	4 1/2	152	6	360032	47.20	360132	49.80
12.8	.5039	114	4 1/2	152	6	3600128	60.90	3601128	77.55
12.9	.5079	114	4 1/2	152	6	3600129	60.90	3601129	77.55
13.0	.5118	114	4 1/2	152	6	3600130	60.90	3601130	77.55
13.5	.5315	122	4 13/16	168	6 5/8	3600135	78.80	3601135	85.05
14.0	.5512	122	4 13/16	168	6 5/8	3600140	83.55	3601140	90.15
14.5	.5709	122	4 13/16	168	6 5/8	3600145	89.65	3601145	96.90
15.0	.5906	132	5 3/16	181	7 1/8	3600150	89.65	3601150	96.90
15.5	.6102	132	5 3/16	181	7 1/8	3600155	90.80	3601155	98.10
16.0	.6299	132	5 3/16	181	7 1/8	3600160	92.45	3601160	99.80
16.5	.6496	132	5 3/16	181	7 1/8	3600165	92.45	3601165	99.80
17.0	.6693	143	5 5/8	194	7 5/8	3600170	96.00	3601170	103.75
17.5	.6890	143	5 5/8	194	7 5/8	3600175	96.00	3601175	103.75
18.0	.7087	143	5 5/8	194	7 5/8	3600180	97.15	3601180	104.70
18.5	.7283	143	5 5/8	194	7 5/8	3600185	97.65	3601185	105.45
19.0	.7480	148	5 13/16	203	8	3600190	98.90	3601190	106.90

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.)



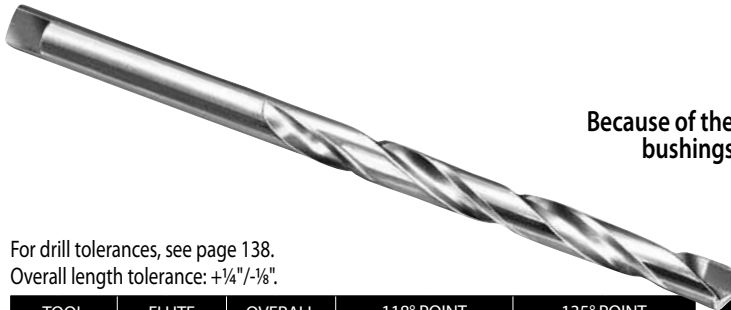
For drill tolerances, see page 138.
 Overall length tolerance: $\pm \frac{1}{4}"/- \frac{1}{8}''$.

TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH
.1250	$\frac{1}{8}$		2 $\frac{3}{4}$	5 $\frac{1}{8}$	363008	\$20.25	363108	\$23.95
.1285		30	3	5 $\frac{3}{8}$	363230	26.85	363330	29.00
.1360		29	3	5 $\frac{3}{8}$	363229	26.85	363329	29.00
.1405		28	3	5 $\frac{3}{8}$	363228	26.85	363328	29.00
.1406	$\frac{9}{64}$		3	5 $\frac{3}{8}$	363009	23.30	363109	25.30
.1440		27	3	5 $\frac{3}{8}$	363227	26.85	363327	29.00
.1470		26	3	5 $\frac{3}{8}$	363226	26.85	363326	29.00
.1495		25	3	5 $\frac{3}{8}$	363225	26.85	363325	29.00
.1520		24	3	5 $\frac{3}{8}$	363224	26.85	363324	29.00
.1540		23	3	5 $\frac{3}{8}$	363223	26.85	363323	29.00
.1562	$\frac{5}{32}$		3	5 $\frac{3}{8}$	363010	21.45	363110	25.30
.1570		22	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363222	27.80	363322	30.15
.1590		21	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363221	27.80	363321	30.15
.1610		20	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363220	27.80	363320	30.15
.1660		19	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363219	27.80	363319	30.15
.1695		18	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363218	27.80	363318	30.15
.1719	$\frac{11}{64}$		3 $\frac{3}{8}$	5 $\frac{3}{4}$	363011	21.75	363111	26.20
.1730		17	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363217	27.80	363317	30.15
.1770		16	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363216	27.80	363316	30.15
.1800		15	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363215	27.80	363315	30.15
.1820		14	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363214	27.80	363314	30.15
.1850		13	3 $\frac{3}{8}$	5 $\frac{3}{4}$	363213	27.80	363313	30.15
.1875	$\frac{3}{16}$		3 $\frac{3}{8}$	5 $\frac{3}{4}$	363012	21.75	363112	26.20
.1890		12	3 $\frac{5}{8}$	6	363212	29.40	363312	31.70
.1910		11	3 $\frac{5}{8}$	6	363211	29.40	363311	31.70
.1935		10	3 $\frac{5}{8}$	6	363210	29.40	363310	31.70
.1960		9	3 $\frac{5}{8}$	6	363209	29.40	363309	31.70
.1990		8	3 $\frac{5}{8}$	6	363208	29.40	363308	31.70
.2010		7	3 $\frac{5}{8}$	6	363207	29.40	363307	31.70
.2031	$\frac{13}{64}$		3 $\frac{5}{8}$	6	363013	23.00	363113	27.60
.2040		6	3 $\frac{5}{8}$	6	363206	29.40	363306	31.70
.2055		5	3 $\frac{5}{8}$	6	363205	29.40	363305	31.70
.2090		4	3 $\frac{5}{8}$	6	363204	29.40	363304	31.70
.2130		3	3 $\frac{5}{8}$	6	363203	29.40	363303	31.70
.2188	$\frac{7}{32}$		3 $\frac{5}{8}$	6	363014	23.00	363114	27.60
.2210		2	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363202	33.25	363302	36.00
.2280		1	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363201	33.25	363301	36.00
.2340		A	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363401	33.25	363501	36.00
.2344	$\frac{15}{64}$		3 $\frac{3}{4}$	6 $\frac{1}{8}$	363015	26.10	363115	31.25
.2380		B	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363402	33.25	363502	36.00
.2420		C	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363403	33.25	363503	36.00
.2460		D	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363404	33.25	363504	36.00
.2500	$\frac{1}{4}$	E	3 $\frac{3}{4}$	6 $\frac{1}{8}$	363016	26.10	363116	31.25
.2570		F	3 $\frac{3}{4}$	6 $\frac{1}{4}$	363406	37.15	363506	40.20
.2610		G	3 $\frac{7}{8}$	6 $\frac{1}{4}$	363407	37.15	363507	40.20
.2656	$\frac{17}{64}$		3 $\frac{7}{8}$	6 $\frac{1}{4}$	363017	29.25	363117	35.00
.2660		H	3 $\frac{7}{8}$	6 $\frac{1}{4}$	363408	37.15	363508	40.20
.2720		I	3 $\frac{7}{8}$	6 $\frac{1}{4}$	363409	37.15	363509	40.20
.2770		J	3 $\frac{7}{8}$	6 $\frac{1}{4}$	363410	37.15	363510	40.20
.2810		K	3 $\frac{7}{8}$	6 $\frac{1}{4}$	363411	37.15	363511	40.20
.2812	$\frac{9}{32}$		3 $\frac{7}{8}$	6 $\frac{1}{4}$	363018	29.25	363118	35.00
.2900		L	4	6 $\frac{3}{8}$	363412	40.30	363512	43.50
.2950		M	4	6 $\frac{3}{8}$	363413	40.30	363513	43.50
.2969	$\frac{19}{64}$		4	6 $\frac{3}{8}$	363019	31.55	363119	37.75
.3020		N	4	6 $\frac{3}{8}$	363414	40.30	363514	43.50
.3125	$\frac{5}{16}$		4	6 $\frac{3}{8}$	363020	31.55	363120	37.75

TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3630 EDP NO.	PRICE EACH	TYPE 3631 EDP NO.	PRICE EACH
.3160		O	4 $\frac{1}{8}$	6 $\frac{1}{2}$	363415	\$45.70	363515	\$49.40
.3230		P	4 $\frac{1}{8}$	6 $\frac{1}{2}$	363416	45.70	363516	49.40
.3281	$\frac{21}{64}$		4 $\frac{1}{8}$	6 $\frac{1}{2}$	363021	34.75	363121	42.95
.3320		Q	4 $\frac{1}{8}$	6 $\frac{1}{2}$	363417	45.70	363517	49.40
.3390		R	4 $\frac{1}{8}$	6 $\frac{1}{2}$	363418	45.70	363518	49.40
.3438	$\frac{11}{32}$		4 $\frac{1}{8}$	6 $\frac{1}{2}$	363022	34.75	363122	43.50
.3480		S	4 $\frac{1}{4}$	6 $\frac{3}{4}$	363419	50.00	363519	54.00
.3580		T	4 $\frac{1}{4}$	6 $\frac{3}{4}$	363420	50.00	363520	54.00
.3594	$\frac{23}{64}$		4 $\frac{1}{4}$	6 $\frac{3}{4}$	363023	39.10	363123	47.05
.3680		U	4 $\frac{1}{4}$	6 $\frac{3}{4}$	363421	50.00	363521	54.00
.3750	$\frac{3}{8}$		4 $\frac{1}{4}$	6 $\frac{3}{4}$	363024	39.10	363124	47.05
.3770		V	4 $\frac{3}{8}$	7	363422	53.65	363522	57.95
.3860		W	4 $\frac{3}{8}$	7	363423	53.65	363523	57.95
.3906	$\frac{25}{64}$		4 $\frac{3}{8}$	7	363025	42.00	363125	50.45
.3970		X	4 $\frac{3}{8}$	7	363424	53.65	363524	57.95
.4040		Y	4 $\frac{3}{8}$	7	363425	53.65	363525	57.95
.4062	$\frac{13}{32}$		4 $\frac{3}{8}$	7	363026	42.00	363126	50.45
.4130		Z	4 $\frac{3}{8}$	7 $\frac{1}{4}$	363426	61.75	363526	66.65
.4219	$\frac{27}{64}$		4 $\frac{3}{8}$	7 $\frac{1}{4}$	363027	48.45	363127	57.95
.4375	$\frac{7}{16}$		4 $\frac{3}{8}$	7 $\frac{1}{4}$	363028	48.45	363128	57.95
.4531	$\frac{29}{64}$		4 $\frac{3}{4}$	7 $\frac{1}{2}$	363029	53.35	363129	64.05
.4688	$\frac{15}{32}$		4 $\frac{3}{4}$	7 $\frac{1}{2}$	363030	53.35	363130	64.05
.4844	$\frac{31}{64}$		4 $\frac{3}{4}$	7 $\frac{3}{4}$	363031	56.00	363131	67.15
.5000	$\frac{1}{2}$		4 $\frac{3}{4}$	7 $\frac{3}{4}$	363032	56.00	363132	67.15
.5156	$\frac{33}{64}$		4 $\frac{3}{4}$	8	363033	62.95	363133	74.20
.5312	$\frac{17}{32}$		4 $\frac{3}{4}$	8	363034	64.35	363134	74.20
.5469	$\frac{35}{64}$		4 $\frac{7}{8}$	8 $\frac{1}{4}$	363035	64.95	363135	78.00
.5625	$\frac{9}{16}$		4 $\frac{7}{8}$	8 $\frac{1}{4}$	363036	64.95	363136	78.00
.5781	$\frac{37}{64}$		4 $\frac{7}{8}$	8 $\frac{3}{4}$	363037	68.45	363137	82.45
.5938	$\frac{19}{32}$		4 $\frac{7}{8}$	8 $\frac{3}{4}$	363038	69.70	363138	82.45
.6094	$\frac{39}{64}$		4 $\frac{7}{8}$	8 $\frac{3}{4}$	363039	79.00	363139	94.85
.6250	$\frac{5}{8}$		4 $\frac{7}{8}$	8 $\frac{3}{4}$	363040	79.00	363140	94.85
.6406	$\frac{41}{64}$		5 $\frac{1}{8}$	9	363041	81.95	363141	96.60
.6562	$\frac{21}{32}$		5 $\frac{1}{8}$	9	363042	80.60	363142	92.25
.6719	$\frac{43}{64}$		5 $\frac{1}{8}$	9 $\frac{1}{4}$	363043	84.75	363143	97.65
.6875	$\frac{11}{16}$		5 $\frac{1}{8}$	9 $\frac{1}{4}$	363044	81.90	363144	97.65
.7031	$\frac{45}{64}$		5 $\frac{1}{8}$	9 $\frac{1}{2}$	363045	82.75	363145	99.40
.7188	$\frac{23}{32}$		5 $\frac{1}{8}$	9 $\frac{1}{2}$	363046	83.60	363146	100.40
.7344	$\frac{47}{64}$		5 $\frac{7}{8}$	9 $\frac{3}{4}$	363047	84.05	363147	101.00
.7500	$\frac{3}{4}$		5 $\frac{7}{8}$	9 $\frac{3}{4}$	363048	85.40	363148	102.50
.7656	$\frac{49}{64}$		6	9 $\frac{7}{8}$	363049	103.30	363149	111.60
.7812	$\frac{25}{32}$		6	9 $\frac{7}{8}$	363050	103.30	363150	111.60
.7969	$\frac{51}{64}$		6 $\frac{1}{8}$	10	363051	103.75	363151	112.05
.8125	$\frac{13}{16}$		6 $\frac{1}{8}$	10	363052	93.20	363152	112.05
.8281	$\frac{53}{64}$		6 $\frac{1}{8}$	10	363053	103.75	363153	112.05
.8438	$\frac{27}{32}$		6 $\frac{1}{8}$	10	363054	103.75	363154	112.05
.8594	$\frac{55}{64}$		6 $\frac{1}{8}$	10	363055	109.80	363155	118.55
.8750	$\frac{7}{8}$		6 $\frac{1}{8}$	10	363056	98.60	363156	118.55
.8906	$\frac{57}{64}$		6 $\frac{1}{8}$	10	363057	113.55	363157	122.65
.9062	$\frac{29}{32}$		6 $\frac{1}{8}$	10	363058	113.55	363158	122.65
.9219	$\frac{59}{64}$		6 $\frac{1}{8}$	10 $\frac{3}{4}$	363059	115.25	363159	124.45
.9375	$\frac{15}{16}$		6 $\frac{1}{8}$	10 $\frac{3}{4}$	363060	103.50	363160	124.45
.9531	$\frac{61}{64}$		6 $\frac{3}{8}$	11	363061	120.65	363161	130.30
.9688	$\frac{31}{32}$		6 $\frac{3}{8}$	11	363062	120.65	363162	130.30
.9844	$\frac{63}{64}$		6 $\frac{3}{8}$	11	363063	124.45	363163	134.30
1.0000	1		6 $\frac{3}{8}$	11	363064	111.75	363164	134.30

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 138.
 Overall length tolerance: +1/4"/-1/8".

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	\$24.80	3631032	\$26.70	8.6	.3386	105	4 1/8	165	6 1/2	3630086	\$40.50	3631086	\$43.80
3.3	.1299	76	3	137	5 3/8	3630033	24.80	3631033	26.70	8.7	.3425	105	4 1/8	165	6 1/2	3630087	40.50	3631087	43.80
3.4	.1339	76	3	137	5 3/8	3630034	24.80	3631034	26.70	8.8	.3465	108	4 1/4	171	6 3/4	3630088	40.50	3631088	43.80
3.5	.1378	76	3	137	5 3/8	3630035	24.05	3631035	26.10	8.9	.3504	108	4 1/4	171	6 3/4	3630089	40.50	3631089	43.80
3.6	.1417	76	3	137	5 3/8	3630036	24.05	3631036	26.10	9.0	.3543	108	4 1/4	171	6 3/4	3630090	39.85	3631090	48.00
3.7	.1457	76	3	137	5 3/8	3630037	24.05	3631037	26.10	9.1	.3583	108	4 1/4	171	6 3/4	3630091	44.35	3631091	48.00
3.8	.1496	76	3	137	5 3/8	3630038	24.05	3631038	26.10	9.2	.3622	108	4 1/4	171	6 3/4	3630092	44.35	3631092	48.00
3.9	.1535	76	3	137	5 3/8	3630039	24.05	3631039	26.10	9.3	.3661	108	4 1/4	171	6 3/4	3630093	44.35	3631093	48.00
4.0	.1575	86	3 3/8	146	5 3/4	3630040	23.50	3631040	25.45	9.4	.3701	108	4 1/4	171	6 3/4	3630094	44.35	3631094	48.00
4.1	.1614	86	3 3/8	146	5 3/4	3630041	24.80	3631041	26.70	9.5	.3740	108	4 1/4	171	6 3/4	3630095	40.80	3631095	48.00
4.2	.1654	86	3 3/8	146	5 3/4	3630042	24.80	3631042	26.70	9.6	.3780	111	4 3/8	178	7	3630096	46.60	3631096	50.30
4.3	.1693	86	3 3/8	146	5 3/4	3630043	24.80	3631043	26.70	9.7	.3819	111	4 3/8	178	7	3630097	46.60	3631097	50.30
4.4	.1732	86	3 3/8	146	5 3/4	3630044	26.10	3631044	28.10	9.8	.3858	111	4 3/8	178	7	3630098	46.60	3631098	50.30
4.5	.1772	86	3 3/8	146	5 3/4	3630045	26.10	3631045	28.10	9.9	.3898	111	4 3/8	178	7	3630099	46.60	3631099	50.30
4.6	.1811	86	3 3/8	146	5 3/4	3630046	26.10	3631046	28.10	10.0	.3937	111	4 3/8	178	7	3630100	42.80	3631100	51.50
4.7	.1850	86	3 3/8	146	5 3/4	363213	27.80	363313	30.15	10.1	.3976	111	4 3/8	178	7	3630101	47.65	3631101	51.50
4.8	.1890	92	3 5/8	152	6	363212	29.40	363312	31.70	10.2	.4016	111	4 3/8	178	7	3630102	49.70	3631102	53.80
4.9	.1929	92	3 5/8	152	6	3630049	26.10	3631049	28.10	10.3	.4055	111	4 3/8	178	7	3630103	49.70	3631103	53.80
5.0	.1969	92	3 5/8	152	6	3630050	27.40	3631050	28.10	10.4	.4094	117	4 5/8	184	7 1/4	3630104	51.95	3631104	56.00
5.1	.2008	92	3 5/8	152	6	3630051	27.15	3631051	29.30	10.5	.4134	117	4 5/8	184	7 1/4	3630105	48.80	3631105	56.00
5.2	.2047	92	3 5/8	152	6	3630052	24.40	3631052	29.30	10.6	.4173	117	4 5/8	184	7 1/4	3630106	54.40	3631106	58.75
5.3	.2087	92	3 5/8	152	6	3630053	27.15	3631053	29.30	10.7	.4213	117	4 5/8	184	7 1/4	3630107	54.40	3631107	58.75
5.4	.2126	92	3 5/8	152	6	3630054	27.15	3631054	29.30	10.8	.4252	117	4 5/8	184	7 1/4	3630108	54.40	3631108	58.75
5.5	.2165	92	3 5/8	152	6	3630055	29.15	3631055	29.30	10.9	.4291	117	4 5/8	184	7 1/4	3630109	54.40	3631109	58.75
5.6	.2205	95	3 3/4	156	6 1/8	3630056	27.15	3631056	29.30	11.0	.4331	117	4 5/8	184	7 1/4	3630110	52.75	3631110	59.05
5.7	.2244	95	3 3/4	156	6 1/8	3630057	27.15	3631057	29.30	11.5	.4528	121	4 3/4	190	7 1/2	3630115	59.20	3631115	65.30
5.8	.2283	95	3 3/4	156	6 1/8	3630058	27.15	3631058	29.30	12.0	.4724	121	4 3/4	197	7 3/4	3630120	64.05	3631120	68.50
5.9	.2323	95	3 3/4	156	6 1/8	3630059	28.25	3631059	30.55	12.5	.4921	121	4 3/4	197	7 3/4	3630125	66.35	3631125	68.50
6.0	.2362	95	3 3/4	156	6 1/8	3630060	30.25	3631060	31.75	13.0	.5118	121	4 3/4	203	8	3630130	68.05	3631130	72.25
6.1	.2402	95	3 3/4	156	6 1/8	3630061	30.15	3631061	32.50	13.5	.5315	121	4 3/4	203	8	3630135	72.25	3631135	72.25
6.2	.2441	95	3 3/4	156	6 1/8	3630062	30.15	3631062	32.50	14.0	.5512	124	4 7/8	210	8 1/4	3630140	76.70	3631140	80.05
6.3	.2480	95	3 3/4	156	6 1/8	3630063	30.15	3631063	32.50	14.5	.5709	124	4 7/8	222	8 3/4	3630145	82.30	3631145	85.80
6.4	.2520	98	3 7/8	159	6 1/4	3630064	33.00	3631064	35.70	15.0	.5906	124	4 7/8	222	8 3/4	3630150	82.30	3631150	85.80
6.5	.2559	98	3 7/8	159	6 1/4	3630065	31.40	3631065	35.70	15.5	.6102	124	4 7/8	222	8 3/4	3630155	93.35	3631155	97.35
6.6	.2598	98	3 7/8	159	6 1/4	3630066	34.05	3631066	36.65	16.0	.6299	130	5 1/8	229	9	3630160	93.35	3631160	97.95
6.7	.2638	98	3 7/8	159	6 1/4	3630067	34.05	3631067	36.65	16.5	.6496	130	5 1/8	229	9	3630165	99.65	3631165	97.95
6.8	.2677	98	3 7/8	159	6 1/4	3630068	34.05	3631068	36.65	17.0	.6693	137	5 3/8	235	9 1/4	3630170	96.70	3631170	101.00
6.9	.2717	98	3 7/8	159	6 1/4	3630069	34.05	3631069	36.65	17.5	.6890	143	5 5/8	241	9 1/2	3630175	96.70	3631175	101.00
7.0	.2756	98	3 7/8	159	6 1/4	3630070	32.70	3631070	35.70	18.0	.7087	143	5 5/8	241	9 1/2	3630180	98.75	3631180	103.00
7.1	.2795	98	3 7/8	159	6 1/4	3630071	34.05	3631071	36.65	18.5	.7283	149	5 7/8	248	9 3/4	3630185	100.90	3631185	105.15
7.2	.2835	102	4	162	6 3/8	3630072	34.05	3631072	36.65	19.0	.7480	149	5 7/8	248	9 3/4	3630190	100.90	3631190	105.15
7.3	.2874	102	4	162	6 3/8	3630073	34.05	3631073	36.65	19.5	.7677	152	6	251	9 7/8	3630195	115.90	3631195	125.20
7.4	.2913	102	4	162	6 3/8	3630074	34.05	3631074	36.65	20.0	.7874	156	6 1/8	254	10	3630200	116.40	3631200	125.70
7.5	.2953	102	4	162	6 3/8	3630075	34.65	3631075	38.60	20.5	.8071	156	6 1/8	254	10	3630205	116.40	3631205	125.70
7.6	.2992	102	4	162	6 3/8	3630076	35.70	3631076	38.60	21.0	.8268	156	6 1/8	254	10	3630210	116.40	3631210	125.70
7.7	.3031	102	4	162	6 3/8	3630077	35.70	3631077	38.60	21.5	.8465	156	6 1/8	254	10	3630215	116.40	3631215	125.70
7.8	.3071	102	4	162	6 3/8	3630078	35.70	3631078	38.60	22.0	.8661	156	6 1/8	254	10	3630220	123.15	3631220	132.95
7.9	.3110	102	4	162	6 3/8	3630079	35.70	3631079	38.60	22.5	.8858	156	6 1/8	254	10	3630225	127.50	3631225	137.65
8.0	.3150	105	4 1/8	165	6 1/2	3630080	35.15	3631080	38.60	23.0	.9055	156	6 1/8	254	10	3630230	127.50	3631230	137.65
8.1	.3189	105	4 1/8	165	6 1/2	3630081	35.70	3631081	38.60	23.5	.9252	156	6 1/8	273	10 3/4	3630235	129.25	3631235	139.55
8.2	.3228	105	4 1/8	165	6 1/2	3630082	38.05	3631082	41.05	24.0	.9449	162	6 3/8	279	11	3630240	135.35	3631240	146.25
8.3	.3268	105	4 1/8	165	6 1/2	3630083	38.05	3631083	41.05	24.5	.9646	162	6 3/8	279	11	3630245	135.35	3631245	146.25
8.4	.3307	105	4 1/8	165	6 1/2	3630084	38.05	3631084	41.05	25.0	.9843	162	6 3/8	279	11	3630250	139.55	3631250	150.75
8.5	.3346	105	4 1/8	165	6 1/2	3630085	36.80	3631085	43.80	-	-	-	-	-	-	-	-	-	-

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 138.

TOOL DIAMETER			LENGTH		118° POINT		135° POINT		
DECIMAL	FRACTION	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	\$20.65	364332	\$22.85	
.1200		31	7/8	1 7/8	364231	20.65	364331	22.85	
.1250	1/8		7/8	1 7/8	364008	16.10	364108	17.50	
.1285		30	15/16	1 15/16	364230	21.75	364330	24.05	
.1360		29	15/16	1 15/16	364229	21.75	364329	24.05	
.1405		28	15/16	1 15/16	364228	21.75	364328	24.05	
.1406	3/64		15/16	1 15/16	364009	19.50	364109	23.00	
.1440		27	1	2 1/16	364227	21.75	364327	24.05	
.1470		26	1	2 1/16	364226	21.75	364326	24.05	
.1495		25	1	2 1/16	364225	21.75	364325	24.05	
.1520		24	1	2 1/16	364224	21.75	364324	24.05	
.1540		23	1	2 1/16	364223	21.75	364323	24.05	
.1562	5/32		1	2 1/16	364010	17.15	364110	18.60	
.1570		22	1 1/16	2 1/8	364222	21.75	364322	24.05	
.1590		21	1 1/16	2 1/8	364221	21.75	364321	24.05	
.1610		20	1 1/16	2 1/8	364220	25.30	364320	28.10	
.1660		19	1 1/16	2 1/8	364219	25.30	364319	28.10	
.1695		18	1 1/16	2 1/8	364218	25.30	364318	28.10	
.1719	1/64		1 1/16	2 1/8	364011	23.20	364111	25.00	
.1730		17	1 1/16	2 3/16	364217	25.80	364317	28.65	
.1770		16	1 1/16	2 3/16	364216	25.80	364316	28.65	
.1800		15	1 1/16	2 3/16	364215	25.80	364315	28.65	
.1820		14	1 1/16	2 3/16	364214	25.80	364314	28.65	
.1850		13	1 1/16	2 3/16	364213	25.80	364313	28.65	
.1875	3/16		1 1/16	2 3/16	364012	17.95	364112	19.75	
.1890		12	1 3/16	2 1/4	364212	25.60	364312	28.35	
.1910		11	1 3/16	2 1/4	364211	25.60	364311	28.35	
.1935		10	1 3/16	2 1/4	364210	25.60	364310	28.35	
.1960		9	1 3/16	2 1/4	364209	25.60	364309	28.35	
.1990		8	1 3/16	2 1/4	364208	25.60	364308	28.35	
.2010		7	1 3/16	2 1/4	364207	23.60	364307	28.35	
.2031	13/64		1 3/16	2 1/4	364013	23.20	364113	25.00	
.2040		6	1 1/4	2 3/8	364206	25.80	364306	28.65	
.2055		5	1 1/4	2 3/8	364205	25.80	364305	28.65	
.2090		4	1 1/4	2 3/8	364204	25.80	364304	28.65	
.2130		3	1 1/4	2 3/8	364203	23.60	364303	28.35	
.2188	7/32		1 1/4	2 3/8	364014	19.30	364114	21.50	
.2210		2	1 5/16	2 7/16	364202	25.60	364302	28.35	
.2280		1	1 5/16	2 7/16	364201	23.60	364301	28.35	
.2340		A	1 5/16	2 7/16	364401	25.60	364501	28.35	
.2344	15/64		1 5/16	2 7/16	364015	21.50	364115	25.60	
.2380		B	1 3/8	2 1/2	364402	25.60	364502	28.35	
.2420		C	1 3/8	2 1/2	364403	25.60	364503	28.35	
.2460		D	1 3/8	2 1/2	364404	23.60	364504	28.35	
.2500	1/4		E	1 3/8	2 1/2	364016	19.65	364116	22.80
.2570		F	1 7/16	2 5/8	364406	27.40	364506	32.85	
.2610		G	1 7/16	2 5/8	364407	27.40	364507	32.85	
.2656	17/64		1 7/16	2 5/8	364017	23.95	364117	28.40	
.2660		H	1 1/2	2 11/16	364408	26.55	364508	32.85	
.2720		I	1 1/2	2 11/16	364409	27.40	364509	32.85	
.2770		J	1 1/2	2 11/16	364410	29.60	364510	32.85	
.2810		K	1 1/2	2 11/16	364411	29.60	364511	32.85	
.2812	5/32		1 1/2	2 11/16	364018	22.70	364118	26.35	
.2900		L	1 1/16	2 3/4	364412	30.50	364512	33.90	
.2950		M	1 1/16	2 3/4	364413	30.50	364513	33.90	
.2969	19/64		1 1/16	2 3/4	364019	27.40	364119	32.55	
.3020		N	1 5/8	2 13/16	364414	35.00	364514	38.95	
.3125	5/16		1 5/8	2 13/16	364020	24.10	364120	28.05	
.3160		O	1 11/16	2 15/16	364415	33.85	364515	40.75	
.3230		P	1 11/16	2 15/16	364416	36.60	364516	40.75	
.3281	21/64		1 11/16	2 15/16	364021	29.75	364121	34.60	

TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	WIRE LETTER	FLUTE	OVER-ALL	TYPE 3640 EDP NO.	PRICE EACH	TYPE 3641 EDP NO.	PRICE EACH
.3320		Q	1 11/16	3	364417	\$33.85	364517	\$40.75
.3390		R	1 11/16	3	364418	33.85	364518	40.75
.3438	11/32		1 11/16	3	364022	28.10	364122	32.55
.3480		S	1 3/4	3 1/16	364419	37.05	364519	41.20
.3580		T	1 3/4	3 1/16	364420	37.05	364520	41.20
.3594	23/64		1 3/4	3 1/16	364023	30.65	364123	35.70
.3680		U	1 13/16	3 1/8	364421	34.75	364521	41.70
.3750	3/8		1 13/16	3 1/8	364024	28.80	364124	33.40
.3770		V	1 7/8	3 1/4	364422	42.65	364522	47.35
.3860		W	1 7/8	3 1/4	364423	39.45	364523	47.50
.3906	25/64		1 7/8	3 1/4	364025	34.15	364125	39.70
.3970		X	1 15/16	3 5/16	364424	39.45	364524	47.35
.4040		Y	1 15/16	3 5/16	364425	42.65	364525	47.35
.4062	13/32		1 15/16	3 5/16	364026	34.15	364126	39.70
.4130		Z	2	3 3/8	364426	48.55	364526	53.95
.4219	27/64		2	3 3/8	364027	37.85	364127	43.10
.4375	7/16		2 1/16	3 7/16	364028	36.50	364128	40.50
.4531	29/64		2 1/8	3 9/16	364029	48.70	364129	62.50
.4688	15/32		2 1/8	3 5/8	364030	51.95	364130	60.40
.4844	31/64		2 3/16	3 11/16	364031	46.60	364131	59.90
.5000	1/2		2 1/4	3 3/4	364032	49.70	364132	57.80
.5156	33/64		2 3/8	3 7/8	364033	70.85	364133	78.80
.5312	17/32		2 3/8	3 7/8	364034	61.95	364134	69.90
.5469	35/64		2 1/2	4	364035	70.85	364135	78.80
.5625	9/16		2 1/2	4	364036	61.95	364136	69.90
.5781	37/64		2 5/8	4 1/8	364037	82.75	364137	92.00
.5938	19/32		2 5/8	4 1/8	364038	71.10	364138	80.15
.6094	39/64		2 3/4	4 1/4	364039	82.75	364139	92.00
.6250	5/8		2 3/4	4 1/4	364040	71.10	364140	80.15
.6406	41/64		2 7/8	4 1/2	364041	98.70	364141	109.80
.6562	21/32		2 7/8	4 1/2	364042	85.40	364142	96.40
.6719	43/64		2 7/8	4 5/8	364043	101.20	364143	112.55
.6875	11/16		2 7/8	4 5/8	364044	87.70	364144	98.90
.7031	45/64		3	4 3/4	364045	114.40	364145	127.10
.7188	23/32		3	4 3/4	364046	99.45	364146	115.45
.7344	47/64		3 1/8	5	364047	114.50	364147	127.50
.7500	3/4		3 1/8	5	364048	99.65	364148	112.25
.7656	49/64		3 1/4	5 1/8	364049	122.60	364149	136.40
.7812	25/32		3 1/4	5 1/8	364050	123.10	364150	142.90
.7969	51/64		3 3/8	5 1/4	364051	137.20	364151	152.65
.8125	13/16		3 3/8	5 1/4	364052	123.25	364152	139.05
.8281	53/64		3 1/2	5 3/8	364053	134.40	364153	149.45
.8438	27/32		3 1/2	5 3/8	364054	134.95	364154	156.70
.8594	55/64		3 1/2	5 1/2	364055	150.50	364155	167.45
.8750	7/8		3 1/2	5 1/2	364056	135.20	364156	152.40
.8906	57/64		3 5/8	5 3/8	364057	144.40	364157	160.55
.9062	29/32		3 5/8	5 3/8	364058	145.00	364158	168.30
.9219	59/64		3 3/4	5 3/4	364059	161.55	364159	179.80
.9375	15/16		3 3/4	5 3/4	364060	145.15	364160	163.75
.9531	61/64		3 7/8	5 7/8	364061	161.55	364161	179.80
.9688	31/32		3 7/8	5 7/8	364062	153.15	364162	177.85
.9844	63/64		4	6	364063	170.75	364163	190.05
1.0000	1		4	6	364064	153.35	364164	173.05
1.0312	1 1/32*		4	6 1/4	364066	213.90	364166	237.95
1.0625	1 1/16*		4	6 1/4	364068	192.20	364168	216.75
1.0938	1 3/32*		4	6 3/8	364070	237.45	364170	264.15
1.1250	1 1/8*		4	6 3/8	364072	213.30	364172	240.50
1.1562	1 5/32*		4 1/4	6 5/8	364074	289.85	364174	322.40
1.1875	1 3/16*		4 1/4	6 5/8	364076	260.35	364176	291.85
1.2188	1 7/32*		4 3/8	6 3/4	364078	289.85	364178	322.40
1.2500	1 1/4*		4 3/8	6 3/4	364080	260.35	364180	291.85

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

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 138.

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
3.0	.1181	22	7/8	48	1 7/8	3640030	\$22.40	3641030	\$24.70
3.1	.1220	22	7/8	48	1 7/8	3640031	22.40	3641031	24.70
3.2	.1260	24	15/16	49	1 15/16	3640032	22.40	3641032	24.70
3.3	.1299	24	15/16	49	1 15/16	3640033	22.40	3641033	24.70
3.4	.1339	24	15/16	49	1 15/16	3640034	22.40	3641034	24.70
3.5	.1378	24	15/16	49	1 15/16	3640035	20.10	3641035	23.00
3.6	.1417	25	1	52	2 1/16	3640036	22.40	3641036	24.70
3.7	.1457	25	1	52	2 1/16	3640037	22.40	3641037	24.70
3.8	.1496	25	1	52	2 1/16	3640038	22.40	3641038	24.70
3.9	.1535	25	1	52	2 1/16	3640039	22.40	3641039	24.70
4.0	.1575	27	1 1/16	54	2 1/8	3640040	20.10	3641040	23.10
4.1	.1614	27	1 1/16	54	2 1/8	3640041	26.70	3641041	29.40
4.2	.1654	27	1 1/16	54	2 1/8	3640042	26.70	3641042	29.40
4.3	.1693	27	1 1/16	54	2 1/8	3640043	26.70	3641043	29.40
4.4	.1732	29	1 1/8	56	2 3/16	3640044	26.70	3641044	29.40
4.5	.1772	29	1 1/8	56	2 3/16	3640045	23.95	3641045	27.45
4.6	.1811	29	1 1/8	56	2 3/16	3640046	26.70	3641046	29.40
4.7	.1850	29	1 1/8	56	2 3/16	364213	25.80	364313	28.65
4.8	.1890	30	1 3/16	57	2 1/4	364212	25.60	364312	28.35
4.9	.1929	30	1 3/16	57	2 1/4	3640049	26.70	3641049	29.40
5.0	.1969	30	1 3/16	57	2 1/4	3640050	23.95	3641050	27.45
5.1	.2008	30	1 3/16	57	2 1/4	3640051	26.70	3641051	29.40
5.2	.2047	32	1 1/4	60	2 3/8	3640052	26.70	3641052	29.40
5.3	.2087	32	1 1/4	60	2 3/8	3640053	26.70	3641053	29.40
5.4	.2126	32	1 1/4	60	2 3/8	3640054	26.70	3641054	29.40
5.5	.2165	32	1 1/4	60	2 3/8	3640055	23.95	3641055	27.45
5.6	.2205	33	1 1/2	62	2 7/16	3640056	26.70	3641056	29.40
5.7	.2244	33	1 1/2	62	2 7/16	3640057	26.70	3641057	29.40
5.8	.2283	33	1 1/2	62	2 7/16	3640058	26.70	3641058	29.40
5.9	.2323	33	1 1/2	62	2 7/16	3640059	26.70	3641059	29.40
6.0	.2362	35	1 3/8	64	2 1/2	3640060	22.40	3641060	25.60
6.1	.2402	35	1 3/8	64	2 1/2	3640061	27.60	3641061	30.50
6.2	.2441	35	1 3/8	64	2 1/2	3640062	27.60	3641062	30.50
6.3	.2480	35	1 3/8	64	2 1/2	3640063	27.60	3641063	30.50
6.4	.2520	37	1 7/16	67	2 5/8	3640064	27.60	3641064	30.50
6.5	.2559	37	1 7/16	67	2 5/8	3640065	24.80	3641065	28.40
6.6	.2598	37	1 7/16	67	2 5/8	3640066	27.60	3641066	30.50
6.7	.2638	37	1 7/16	67	2 5/8	3640067	27.60	3641067	30.50
6.8	.2677	38	1 1/2	68	2 11/16	3640068	27.60	3641068	30.50
6.9	.2717	38	1 1/2	68	2 11/16	3640069	27.60	3641069	30.50
7.0	.2756	38	1 1/2	68	2 11/16	3640070	24.80	3641070	28.40
7.1	.2795	38	1 1/2	68	2 11/16	3640071	27.60	3641071	30.50
7.2	.2835	40	1 9/16	70	2 3/4	3640072	31.70	3641072	34.95
7.3	.2874	40	1 9/16	70	2 3/4	3640073	31.70	3641073	34.95
7.4	.2913	40	1 9/16	70	2 3/4	3640074	31.70	3641074	34.95
7.5	.2953	40	1 9/16	70	2 3/4	3640075	28.50	3641075	32.55
7.6	.2992	41	1 5/8	71	2 13/16	3640076	31.70	3641076	34.95
7.7	.3031	41	1 5/8	71	2 13/16	3640077	31.70	3641077	34.95
7.8	.3071	41	1 5/8	71	2 13/16	3640078	31.70	3641078	34.95
7.9	.3110	41	1 5/8	71	2 13/16	3640079	31.70	3641079	34.95
8.0	.3150	43	1 1/2	75	2 15/16	3640080	28.50	3641080	32.55

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
8.1	.3189	43	1 1/16	75	2 15/16	3640081	\$34.05	3641081	\$37.40
8.2	.3228	43	1 1/16	75	2 15/16	3640082	34.05	3641082	37.40
8.3	.3268	43	1 1/16	75	2 15/16	3640083	34.05	3641083	37.40
8.4	.3307	43	1 1/16	76	3	3640084	34.05	3641084	37.40
8.5	.3346	43	1 1/16	76	3	3640085	30.55	3641085	34.60
8.6	.3386	43	1 1/16	76	3	3640086	34.05	3641086	37.40
8.7	.3425	43	1 1/16	76	3	3640087	34.65	3641087	38.15
8.8	.3465	44	1 3/4	78	3 1/16	3640088	34.65	3641088	38.15
8.9	.3504	44	1 3/4	78	3 1/16	3640089	34.65	3641089	38.15
9.0	.3543	44	1 3/4	78	3 1/16	3640090	31.15	3641090	35.70
9.1	.3583	44	1 3/4	78	3 1/16	3640091	34.65	3641091	38.15
9.2	.3622	46	1 13/16	79	3 1/8	3640092	34.65	3641092	38.15
9.3	.3661	46	1 13/16	79	3 1/8	3640093	34.65	3641093	38.15
9.4	.3701	46	1 13/16	79	3 1/8	3640094	34.65	3641094	38.15
9.5	.3740	46	1 13/16	79	3 1/8	3640095	31.15	3641095	35.70
9.6	.3780	48	1 7/8	83	3 1/4	3640096	38.60	3641096	42.50
9.7	.3819	48	1 7/8	83	3 1/4	3640097	38.60	3641097	42.50
9.8	.3858	48	1 7/8	83	3 1/4	3640098	38.60	3641098	42.50
9.9	.3898	48	1 7/8	83	3 1/4	3640099	38.60	3641099	42.50
10.0	.3937	49	1 15/16	84	3 3/16	3640100	34.65	3641100	39.70
10.5	.4134	51	2	86	3 3/8	3640105	38.75	3641105	43.10
11.0	.4331	52	2 1/16	87	3 7/16	3640110	38.75	3641110	43.10
11.5	.4528	54	2 1/8	90	3 9/16	3640115	54.55	3641115	60.40
12.0	.4724	56	2 3/16	94	3 1/2	3640120	52.15	3641120	57.80
12.5	.4921	57	2 1/4	95	3 3/4	3640125	52.15	3641125	57.80
13.0	.5118	60	2 3/8	98	3 7/8	3640130	64.40	3641130	69.90
13.5	.5315	60	2 3/8	98	3 7/8	3640135	63.20	3641135	69.90
14.0	.5512	64	2 1/2	102	4	3640140	63.20	3641140	69.90
14.5	.5709	67	2 5/8	105	4 1/8	3640145	84.95	3641145	93.55
15.0	.5906	67	2 5/8	105	4 1/8	3640150	84.95	3641150	93.55
15.5	.6102	70	2 3/4	108	4 1/4	3640155	95.80	3641155	105.60
16.0	.6299	73	2 7/8	114	4 1/2	3640160	107.95	3641160	119.00
16.5	.6496	73	2 7/8	114	4 1/2	3640165	107.95	3641165	119.00
17.0	.6693	73	2 7/8	117	4 5/8	3640170	107.95	3641170	119.00
17.5	.6890	76	3	121	4 3/4	3640175	119.10	3641175	131.20
18.0	.7087	76	3	121	4 3/4	3640180	119.10	3641180	131.20
18.5	.7283	79	3 1/8	127	5	3640185	130.05	3641185	143.35
19.0	.7480	79	3 1/8	127	5	3640190	130.05	3641190	143.35
19.5	.7677	83	3 1/4	130	5 1/8	3640195	143.85	3641195	158.55
20.0	.7874	86	3 3/8	133	5 1/4	3640200	160.85	3641200	177.20
20.5	.8071	86	3 3/8	133	5 1/4	3640205	160.85	3641205	177.20
21.0	.8268	89	3 1/2	137	5 3/8	3640210	176.60	3641210	194.55
21.5	.8465	89	3 1/2	140	5 1/2	3640215	176.60	3641215	194.55
22.0	.8661	89	3 1/2	140	5 1/2	3640220	176.60	3641220	194.55
22.5	.8858	92	3 5/8	143	5 3/8	3640225	181.70	3641225	200.10
23.0	.9055	92	3 5/8	143	5 3/8	3640230	181.70	3641230	200.10
23.5	.9252	95	3 3/4	146	5 3/4	3640235	186.15	3641235	205.10
24.0	.9449	98	3 7/8	149	5 7/8	3640240	189.65	3641240	209.00
24.5	.9646	98	3 7/8	149	5 7/8	3640245	189.65	3641245	209.00
25.0	.9843	102	4	152	6	3640250	200.35	3641250	220.50
-	-	-	-	-	-	-	-	-	-

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 129.
 For drill tolerances, see page 138.

TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	MORSE TAPER	FLUTE	OVERALL	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
.2500	1/4	1	2 7/8	6 1/8	366016	\$42.35	366116	\$48.10
.2656	17/64	1	3	6 1/4	366017	43.35	366117	49.10
.2812	9/32	1	3	6 1/4	366018	43.35	366118	49.10
.2969	19/64	1	3 1/8	6 3/8	366019	43.35	366119	49.10
.3125	5/16	1	3 1/8	6 3/8	366020	43.35	366120	49.10
.3281	21/64	1	3 1/4	6 1/2	366021	55.15	366121	62.40
.3438	11/32	1	3 1/4	6 1/2	366022	55.15	366122	62.40
.3594	23/64	1	3 1/2	6 3/4	366023	55.15	366123	62.40
.3750	3/8	1	3 1/2	6 3/4	366024	55.15	366124	62.40
.3906	25/64	1	3 5/8	7	366025	63.80	366125	72.35
.4062	13/32	1	3 5/8	7	366026	63.80	366126	72.35
.4219	27/64	1	3 7/8	7 1/4	366027	63.80	366127	72.35
.4375	7/16	1	3 7/8	7 1/4	366028	63.80	366128	72.35
.4531	29/64	1	4 1/8	7 1/2	366029	77.55	366129	87.95
.4688	15/32	1	4 1/8	7 1/2	366030	77.55	366130	87.95
.4844	31/64	2	4 3/8	8 1/4	366031	77.55	366131	87.95
.5000	1/2	2	4 3/8	8 1/4	366032	61.00	366132	81.30
.5156	33/64	2	4 5/8	8 1/2	366033	75.25	366133	90.30
.5312	17/32	2	4 5/8	8 1/2	366034	64.40	366134	83.60
.5469	35/64	2	4 7/8	8 3/4	366035	76.30	366135	91.55
.5625	9/16	2	4 7/8	8 3/4	366036	64.90	366136	84.75
.5781	37/64	2	4 7/8	8 3/4	366037	79.85	366137	95.85
.5938	19/32	2	4 7/8	8 3/4	366038	67.80	366138	88.80
.6094	39/64	2	4 7/8	8 3/4	366039	92.55	366139	111.00
.6250	5/8	2	4 7/8	8 3/4	366040	78.95	366140	102.75
.6406	41/64	2	5 1/8	9	366041	94.00	366141	112.85
.6562	21/32	2	5 1/8	9	366042	76.95	366142	104.45
.6719	43/64	2	5 3/8	9 1/4	366043	95.05	366143	114.25
.6875	11/16	2	5 3/8	9 1/4	366044	79.40	366144	105.75
.7031	45/64	2	5 5/8	9 1/2	366045	97.70	366145	117.25
.7188	23/32	2	5 5/8	9 1/2	366046	81.30	366146	108.55
.7344	47/64	2	5 7/8	9 3/4	366047	99.65	366147	119.60
.7500	3/4	2	5 7/8	9 3/4	366048	87.80	366148	110.80
.7656	49/64	2	6	9 7/8	366049	106.05	366149	127.25
.7812	25/32	2	6	9 7/8	366050	95.00	366150	117.75
.7969	51/64	3	6 1/8	10 3/4	366051	107.05	366151	128.50
.8125	13/16	3	6 1/8	10 3/4	366052	96.05	366152	119.00

TOOL DIAMETER			LENGTH		118° POINT		135° POINT	
DECIMAL	FRACTION	MORSE TAPER	FLUTE	OVERALL	TYPE 3660 EDP NO.	PRICE EACH	TYPE 3661 EDP NO.	PRICE EACH
.8281	53/64	3	6 1/8	10 3/4	366053	\$107.05	366153	\$128.50
.8438	27/32	3	6 1/8	10 3/4	366054	98.10	366154	119.00
.8594	55/64	3	6 1/8	10 3/4	366055	113.15	366155	135.80
.8750	7/8	3	6 1/8	10 3/4	366056	104.25	366156	125.70
.8906	57/64	3	6 1/8	10 3/4	366057	116.85	366157	140.25
.9062	29/32	3	6 1/8	10 3/4	366058	112.10	366158	129.90
.9219	59/64	3	6 1/8	10 3/4	366059	119.10	366159	142.85
.9375	15/16	3	6 1/8	10 3/4	366060	119.70	366160	132.30
.9531	61/64	3	6 3/8	11	366061	124.90	366161	149.80
.9688	31/32	3	6 3/8	11	366062	119.70	366162	138.70
.9844	63/64	3	6 3/8	11	366063	128.05	366163	153.75
1.0000	1	3	6 3/8	11	366064	117.85	366164	142.40
1.0156	1 1/64	3	6 1/2	11 1/8	366065	198.35	366165	224.70
1.0312	1 1/32	3	6 1/2	11 1/8	366066	172.45	366166	195.45
1.0469	1 3/64	3	6 5/8	11 1/4	366067	203.30	366167	230.25
1.0625	1 1/16	3	6 5/8	11 1/4	366068	146.30	366168	185.45
1.0781	1 5/64	4	6 7/8	12 1/2	366069	220.45	366169	249.85
1.0938	1 3/32	4	6 7/8	12 1/2	366070	191.75	366170	217.25
1.1094	1 7/64	4	7 1/8	12 3/4	366071	225.40	366171	255.30
1.1250	1 1/8	4	7 1/8	12 3/4	366072	162.00	366172	205.60
1.1406	1 9/64	4	7 1/4	12 7/8	366073	252.95	366173	286.65
1.1562	1 5/32	4	7 1/4	12 7/8	366074	220.00	366174	249.25
1.1719	1 11/64	4	7 3/8	13	366075	257.90	366175	292.05
1.1875	1 3/16	4	7 3/8	13	366076	185.55	366176	235.30
1.2031	1 13/64	4	7 1/2	13 1/8	366077	271.50	366177	307.50
1.2188	1 7/32	4	7 1/2	13 1/8	366078	236.05	366178	267.40
1.2344	1 15/64	4	7 1/2	13 1/2	366079	276.30	366179	313.10
1.2500	1 1/4	4	7 7/8	13 1/2	366080	198.55	366180	252.05
1.2812	1 9/32	4	8 1/2	14 1/8	366082	337.10	366182	381.90
1.3125	1 5/16	4	8 5/8	14 1/4	366084	293.15	366184	332.05
1.3438	1 11/32	4	8 3/4	14 3/8	366086	362.00	366186	410.20
1.3750	1 3/8	4	8 7/8	14 1/2	366088	314.85	366188	356.70
1.4062	1 13/32	4	9	14 5/8	366090	389.55	366190	441.50
1.4375	1 7/16	4	9 1/8	14 3/4	366092	338.80	366192	383.85
1.4688	1 15/32	4	9 1/4	14 7/8	366094	414.65	366194	469.70
1.5000	1 1/2	4	9 3/8	15	366096	360.45	366196	408.40
-	-	-	-	-	-	-	-	-

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 138.

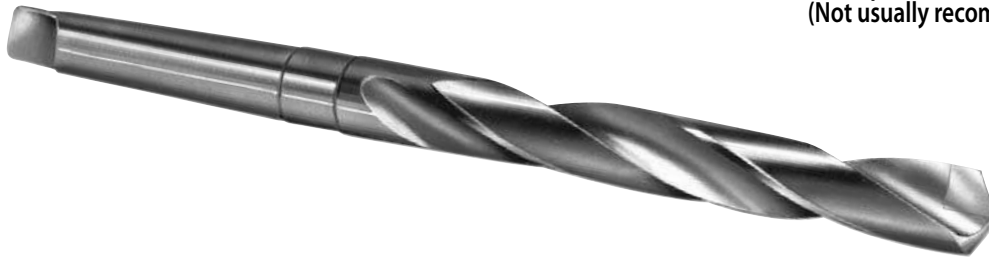
TOOL DIAMETER		MORSE TAPER	LENGTH		TYPE 3668 EDP NO.	PRICE EACH
DECIMAL	FRACTION		FLUTE	OVERALL		
.4844	31/64	1	4 3/8	7 3/4	366831	\$93.10
.5000	1/2	1	4 3/8	7 3/4	366832	73.15
.5156	33/64	1	4 5/8	8	366833	90.30
.5312	17/32	1	4 5/8	8	366834	77.30
.5469	35/64	1	4 7/8	8 1/4	366835	91.55
.5625	9/16	1	4 7/8	8 1/4	366836	77.90
.7969	51/64	2	6 1/8	10	366851	128.50
.8125	13/16	2	6 1/8	10	366852	109.05
.8281	53/64	2	6 1/8	10	366853	128.50
.8438	27/32	2	6 1/8	10	366854	111.35

TOOL DIAMETER		MORSE TAPER	LENGTH		TYPE 3668 EDP NO.	PRICE EACH
DECIMAL	FRACTION		FLUTE	OVERALL		
.8594	55/64	2	6 1/8	10	366855	\$135.80
.8750	7/8	2	6 1/8	10	366856	118.50
.8906	57/64	2	6 1/8	10	366857	140.25
.9062	29/32	2	6 1/8	10	366858	127.40
1.0938	1 3/32	3	6 7/8	11 1/2	366870	270.55
1.1250	1 1/8	3	7 1/8	11 3/4	366872	194.40
1.1562	1 5/32	3	7 1/4	11 7/8	366874	263.95
1.1875	1 3/16	3	7 3/8	12	366876	222.65
1.2188	1 7/32	3	7 1/2	12 1/8	366878	283.20
1.2500	1 1/4	3	7 7/8	12 1/2	366880	238.25

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 124.
 (Not usually recommended for drilling steel.)



For drill tolerances, see page 138.

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	\$76.70	3661130	\$92.10
13.5	.5315	2	117	4 5/8	216	8 1/2	3660135	71.10	3661135	85.25
14.0	.5512	2	124	4 7/8	222	8 3/4	3660140	72.05	3661140	86.45
14.5	.5709	2	124	4 7/8	222	8 3/4	3660145	81.40	3661145	97.80
15.0	.5906	2	124	4 7/8	222	8 3/4	3660150	75.45	3661150	90.50
15.5	.6102	2	124	4 7/8	222	8 3/4	3660155	94.40	3661155	113.25
16.0	.6299	2	130	5 1/8	229	9	3660160	95.85	3661160	115.15
16.5	.6496	2	130	5 1/8	229	9	3660165	88.90	3661165	106.55
17.0	.6693	2	137	5 3/8	235	9 1/4	3660170	97.00	3661170	116.55
17.5	.6890	2	143	5 5/8	241	9 1/2	3660175	99.65	3661175	119.60
18.0	.7087	2	143	5 5/8	241	9 1/2	3660180	92.30	3661180	110.80
18.5	.7283	2	149	5 7/8	248	9 3/4	3660185	101.65	3661185	122.00
19.0	.7480	2	149	5 7/8	248	9 3/4	3660190	94.10	3661190	112.95

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	\$109.15	3661200	\$131.05
21.0	.8268	3	156	6 1/8	273	10 3/4	3660210	109.15	3661210	131.05
22.0	.8661	3	156	6 1/8	273	10 3/4	3660220	106.85	3661220	128.30
23.0	.9055	3	156	6 1/8	273	10 3/4	3660230	110.40	3661230	132.60
24.0	.9449	3	162	6 3/8	279	11	3660240	127.40	3661240	152.80
25.0	.9843	3	162	6 3/8	279	11	3660250	130.65	3661250	156.80
26.0	1.0236	3	165	6 1/2	283	11 1/8	3660260	195.75	3661260	234.90
28.0	1.1024	4	181	7 1/8	324	12 3/4	3660280	217.05	3661280	260.35
30.0	1.1811	4	187	7 3/8	330	13	3660300	261.40	3661300	313.65
32.0	1.2598	4	216	8 1/2	359	14 1/8	3660320	324.55	3661320	389.55
34.0	1.3386	4	222	8 3/4	365	14 3/8	3660340	348.60	3661340	418.40
36.0	1.4173	4	232	9 1/8	375	14 3/4	3660360	399.20	3661360	479.05
38.0	1.4961	4	238	9 3/8	381	15	3660380	415.05	3661380	498.25

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 126.



For drill tolerances, see page 138.

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		NEG. 118° PT TYPE 3670	POS. 118° PT TYPE 3672	BOTH TYPES PRICE
mm	INCH	mm	INCH	mm	INCH	EDP NO.	EDP NO.	
5.0	.1969	38	1 1/2	89	3 1/2	3670050	3672050	\$31.85
5.5	.2165	45	1 3/4	95	3 3/4	3670055	3672055	35.45
6.0	.2362	51	2	102	4	3670060	3672060	35.70
6.5	.2559	51	2	102	4	3670065	3672065	37.75
7.0	.2756	57	2 1/4	108	4 1/4	3670070	3672070	37.75
7.5	.2953	57	2 1/4	108	4 1/4	3670075	3672075	39.45
8.0	.3150	64	2 1/2	114	4 1/2	3670080	3672080	42.65
8.5	.3346	70	2 3/4	121	4 3/4	3670085	3672085	42.65
9.0	.3543	70	2 3/4	121	4 3/4	3670090	3672090	45.40
9.5	.3740	76	3	127	5	3670095	3672095	43.05

TOOL DIAMETER		FLUTE LENGTH		OVERALL LENGTH		NEG. 118° PT TYPE 3670	POS. 118° PT TYPE 3672	BOTH TYPES PRICE
mm	INCH	mm	INCH	mm	INCH	EDP NO.	EDP NO.	
10.0	.3937	76	3	133	5 1/4	3670100	3672100	\$53.00
10.5	.4134	76	3	133	5 1/4	3670105	3672105	61.45
11.0	.4331	76	3	140	5 1/2	3670110	3672110	86.45
11.5	.4528	76	3	140	5 1/2	3670115	3672115	64.80
12.0	.4724	83	3 1/4	146	5 3/4	3670120	3672120	79.10
12.5	.4921	89	3 1/2	152	6	3670125	3672125	79.10
13.0	.5118	89	3 1/2	152	6	3670130	3672130	90.75
13.5	.5315	89	3 1/2	152	6	3670135	3672135	90.75
14.0	.5512	89	3 1/2	152	6	3670140	3672140	93.95
-	-	-	-	-	-	-	-	-

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 125.
For drill tolerances, see page 138.

TOOL DIAMETER		LENGTH		NEG. 118° POINT	POS. 118° POINT	BOTH TYPES PRICE	NEG. 140° POINT	POS. 140° POINT	BOTH TYPES PRICE
DECIMAL	FRACTION	FLUTE	OVERALL	TYPE 3670 EDP NO.	TYPE 3672 EDP NO.		TYPE 3671 EDP NO.	TYPE 3673 EDP NO.	
.0625	1/16*	-	1 1/2	367004	-	\$28.85	367104	-	\$28.85
.0781	5/64*	-	1 1/2	367005	-	28.85	367105	-	28.85
.0938	3/32*	-	2	367006	-	31.70	367106	-	31.70
.1094	7/64*	-	2	367007	-	31.70	367107	-	31.70
.1250	1/8*	-	2	367008	-	32.70	367108	-	32.70
.1406	9/64*	-	2	367009	-	32.70	367109	-	32.70
.1562	5/32*	-	2	367010	-	34.35	367110	-	34.35
.1719	11/64*	-	2 3/8	367011	-	34.35	367111	-	34.35
.1875	3/16	1 1/2	3 1/2	367012	367212	31.25	367112	367312	31.25
.2031	13/64	1 1/2	3 1/2	367013	367213	31.25	367113	367313	31.25
.2188	7/32	1 3/4	3 3/4	367014	367214	32.20	367114	367314	32.20
.2344	15/64	1 3/4	3 3/4	367015	367215	33.25	367115	367315	33.25
.2500	1/4	2	4	367016	367216	33.25	367116	367316	33.25
.2656	17/64	2	4	367017	367217	35.15	367117	367317	35.15
.2812	9/32	2 1/4	4 1/4	367018	367218	35.15	367118	367318	35.15
.2969	19/64	2 1/4	4 1/4	367019	367219	36.80	367119	367319	36.80
.3125	5/16	2 1/2	4 1/2	367020	367220	36.80	367120	367320	36.80
.3281	21/64	2 1/2	4 1/2	367021	367221	39.20	367121	367321	39.20
.3438	11/32	2 3/4	4 3/4	367022	367222	39.20	367122	367322	39.20
.3594	23/64	2 3/4	4 3/4	367023	367223	42.15	367123	367323	42.15
.3750	3/8	3	5	367024	367224	42.15	367124	367324	42.15
.3906	25/64	3	5	367025	367225	47.55	367125	367325	47.55
.4062	13/32	3	5 1/4	367026	367226	49.35	367126	367326	49.35
.4219	27/64	3	5 1/4	367027	367227	53.30	367127	367327	53.30
.4375	7/16	3	5 1/2	367028	367228	57.30	367128	367328	57.30
.4531	29/64	3	5 1/2	367029	367229	60.05	367129	367329	60.05
.4688	15/32	3 1/4	5 3/4	367030	367230	62.85	367130	367330	62.85
.4844	31/64	3 1/4	5 3/4	367031	367231	76.30	367131	367331	76.30
.5000	1/2	3 1/2	6	367032	367232	73.75	367132	367332	73.75
.5312	17/32	3 1/2	6	367034	367234	84.60	367134	367334	84.60
.5625	9/16	3 1/2	6	367036	367236	87.50	367136	367336	87.50
.5938	19/32	4	7	367038	367238	92.60	367138	367338	92.60
.6250	5/8	4	7	367040	367240	95.40	367140	367340	95.40
.6562	21/32	4 1/2	7 1/2	367042	367242	102.10	367142	367342	102.10
.6875	11/16	4 1/2	7 1/2	367044	367244	104.85	367144	367344	104.85
.7188	23/32	4 3/4	8	367046	367246	109.90	367146	367346	109.90
.7500	3/4	4 3/4	8	367048	367248	112.85	367148	367348	112.85
.7812	25/32	4 3/4	8	367050	367250	218.00	367150	367350	218.00
.8125	13/16	4 3/4	8	367052	367252	202.35	367152	367352	202.35
.8750	7/8	4 3/4	8	367056	367256	206.50	367156	367356	206.50
.9375	15/16	4 3/4	8	367060	367260	230.10	367160	367360	230.10
1.0000	1	4 3/4	8	367064	367264	244.10	367164	367364	244.10

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	\$14.60
.0625	1/16	5/8	1 3/4	389304	14.60
.0781	5/64	3/4	1 3/4	389305	15.05
.0938	3/32	3/4	1 3/4	389306	15.65
.1094	7/64	7/8	1 7/8	389307	16.40
.1250	1/8	7/8	1 7/8	389308	17.30
.1406	9/64	1	2	389309	20.30
.1562	5/32	1	2 1/8	389310	21.30
.1719	11/64	1 1/8	2 1/8	389311	26.15
.1875	3/16	1 1/8	2 1/4	389312	28.40
.2031	13/64	1 3/16	2 1/4	389313	31.35
.2188	7/32	1 1/4	2 1/2	389314	32.75
.2344	15/64	1 5/16	2 1/2	389315	38.00
.2500	1/4	1 3/8	2 1/2	389316	35.80
.2656	17/64	1 7/16	2 3/4	389317	58.55
.2812	9/32	1 1/2	2 3/4	389318	60.60
.2969	19/64	1 9/16	2 3/4	389319	63.70
.3125	5/16	1 5/8	2 3/4	389320	55.70
.3281	21/64	1 3/4	3	389321	66.35
.3438	11/32	1 3/4	3	389322	69.55
.3594	23/64	1 3/4	3	389323	77.00
.3750	3/8	1 7/8	3	389324	73.40
.3906	25/64	2	3 1/4	389325	86.25
.4062	13/32	2	3 1/4	389326	95.75
.4219	27/64	2	3 1/2	389327	98.20
.4375	7/16	2 1/16	3 1/2	389328	98.35
.4531	29/64	2 1/8	3 3/4	389329	120.70
.4688	15/32	2 1/8	3 3/4	389330	121.20
.4844	31/64	2 1/4	3 3/4	389331	122.05
.5000	1/2	2 1/4	3 3/4	389332	108.75

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	\$20.25
.1094	7/64*	2	367407	367507	20.55
.1250	1/8*	2	367408	367508	20.55
.1406	9/64*	2	367409	367509	22.35
.1562	5/32*	2	367410	367510	25.65
.1719	11/64*	3	367411	367511	27.40
.1875	3/16*	3	367412	367512	32.50
.2031	13/64*	3	367413	367513	36.50
.2188	7/32	3 1/2	367414	367514	36.95
.2344	15/64	3 1/2	367415	367515	37.55
.2500	1/4	4	367416	367516	38.60
.2656	17/64	4	367417	367517	39.20
.2812	9/32	4	367418	367518	40.35
.2969	19/64	4	367419	367519	41.10
.3125	5/16	4	367420	367520	42.15
.3281	21/64	4	367421	367521	44.20
.3438	11/32	4	367422	367522	45.70
.3594	23/64	4	367423	367523	47.20
.3750	3/8	4	367424	367524	48.75
.3906	25/64	4	367425	367525	49.95
.4062	13/32	4	367426	367526	56.70
.4219	27/64	4	367427	367527	58.75
.4375	7/16	4 1/2	367428	367528	65.95
.4531	29/64	4 1/2	367429	367529	68.70
.4688	15/32	4 1/2	367430	367530	71.85
.4844	31/64	4 1/2	367431	367531	78.85
.5000	1/2	5	367432	367532	85.25

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 138.
For standard flute length, see page 124.

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3664 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.5000	1/2	8	12	2	366432	\$158.05
.5156	33/64	8	12	2	366433	193.65
.5312	17/32	8	12	2	366434	182.70
.5469	35/64	8	12	2	366435	193.65
.5625	9/16	8	12	2	366436	182.70
.5781	37/64	8	12	2	366437	193.65
.5938	19/32	8	12	2	366438	182.70
.6094	39/64	8	12	2	366439	256.35
.6250	5/8	8	12	2	366440	241.90
.6406	41/64	8	12	2	366441	269.20

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3664 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.6562	21/32	8	12	2	366442	\$253.90
.6719	43/64	8	12	2	366443	269.20
.6875	11/16	8	12	2	366444	253.90
.7031	45/64	8	12	2	366445	282.70
.7188	23/32	8	12	2	366446	266.65
.7344	47/64	8	12	2	366447	282.70
.7500	3/4	8	12	2	366448	266.65
.7656	49/64	8	12	2	366449	296.80
.7812	25/32	8	12	2	366450	280.05
-	-	-	-	-	-	-

For drill tolerances, see page 138.

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

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3665 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.6094	39/64	11	14 3/4	2	366539	\$274.40
.6250	5/8	11	14 3/4	2	366540	258.90
.6406	41/64	11	14 3/4	2	366541	288.05
.6562	21/32	11	14 3/4	2	366542	271.70
.6719	43/64	11	14 3/4	2	366543	288.05
.6875	11/16	11	14 3/4	2	366544	271.70
.7031	45/64	11	14 3/4	2	366545	302.45
.7188	23/32	11	14 3/4	2	366546	285.30
.7344	47/64	11	14 3/4	2	366547	302.45
.7500	3/4	11	14 3/4	2	366548	285.30
.7656	49/64	11	14 3/4	2	366549	317.60
.7812	25/32	11	14 3/4	2	366550	299.60
.7969	51/64	11	15 1/2	3	366551	347.10
.8125	13/16	11	15 1/2	3	366552	327.35

TOOL DIAMETER		LENGTH		MORSE TAPER	TYPE 3665 EDP NO.	PRICE EACH
DECIMAL	FRAC.	FLUTE	OVERALL			
.8281	53/64	11	15 1/2	3	366553	\$347.10
.8438	27/32	11	15 1/2	3	366554	327.35
.8594	55/64	11	15 1/2	3	366555	347.10
.8750	7/8	11	15 1/2	3	366556	327.35
.8906	57/64	11	15 1/2	3	366557	424.00
.9062	29/32	11	15 1/2	3	366558	399.95
.9219	59/64	11	15 1/2	3	366559	424.00
.9375	15/16	11	15 1/2	3	366560	399.95
.9531	61/64	11	15 1/2	3	366561	445.20
.9688	31/32	11	15 1/2	3	366562	419.95
.9844	63/64	11	15 1/2	3	366563	445.20
1.0000	1	11	15 1/2	3	366564	419.95
1.0312	1 1/32	11	15 1/2	3	366566	432.60
1.0625	1 1/16	11	15 1/2	3	366568	445.55

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	\$269.00	.3100 - .3160
.3438	11/32	8	10	365822	269.00	.3281 - .3460
.3750	3/8	9	11	365824	284.20	.3594 - .3770
.4062	13/32	9	11	365826	323.50	.3906 - .4080
.4375	7/16	9	11	365828	323.50	.4200 - .4390
.4688	15/32	9 3/4	12	365830	341.70	.4531 - .4710
.5000	1/2	9 3/4	12	365832	341.70	.4800 - .5030
.5312	17/32	9 3/4	12	365834	366.70	.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	\$395.05	.5430 - .5650
.6250	5/8	10 3/4	13	365840	417.10	.6070 - .6270
.6875	11/16	11 3/4	14	365844	434.30	.6693 - .6900
.7500	3/4	11 3/4	14	365848	459.60	.7320 - .7530
.8125	13/16	12 3/4	15	365852	488.10	.7953 - .8160
.8750	7/8	12 3/4	15	365856	526.00	.8570 - .8780
.9375	15/16	13 3/4	16	365860	562.00	.9180 - .9390
1.0000	1	13 3/4	16	365864	608.60	.9820 - 1.0030

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*Call for decimal size pricing.

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	FRACTION	FLUTE	OVERALL			
.2500	1/4	4 5/8	6 1/8	365016	\$186.30	.2490 - .2530
.2656	17/64	4 3/4	6 1/4	365017	186.30	-
.2812	9/32	4 3/4	6 1/4	365018	186.30	.2640 - .2840
.2969	19/64	4 7/8	6 3/8	365019	186.30	-
.3125	5/16	4 7/8	6 3/8	365020	186.30	.2950 - .3160
.3281	21/64	5	6 1/2	365021	179.40	-
.3438	11/32	5	6 1/2	365022	179.40	.3260 - .3460
.3594	23/64	5 1/4	6 3/4	365023	174.80	-
.3750	3/8	5 1/4	6 3/4	365024	181.50	.3540 - .3770
.3906	25/64	5 1/2	7	365025	179.40	-
.4062	13/32	5 1/2	7	365026	179.40	.3850 - .4080
.4219	27/64	5 3/4	7 1/4	365027	185.15	-
.4375	7/16	5 3/4	7 1/4	365028	185.15	.4100 - .4390
.4531	29/64	5 3/4	7 1/2	365029	196.85	-
.4688	15/32	5 3/4	7 1/2	365030	196.85	.4391 - .4724
.4844	31/64	5 3/4	7 3/4	365031	202.70	-
.5000	1/2	5 3/4	7 3/4	365032	202.70	.4725 - .5030
.5156	33/64	6	8	365033	217.50	-
.5312	17/32	6	8	365034	217.50	.5031 - .5330
.5469	35/64	6 1/4	8 1/4	365035	225.25	-
.5625	9/16	6 1/4	8 1/4	365036	229.15	.5331 - .5650

TOOL DIAMETER		LENGTH		TYPE 3650 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTION	FLUTE	OVERALL			
.5781	37/64	6 3/4	8 3/4	365037	\$271.30	-
.5938	19/32	6 3/4	8 3/4	365038	275.90	.5651 - .5950
.6094	39/64	6 3/4	8 3/4	365039	271.30	-
.6250	5/8	6 3/4	8 3/4	365040	275.90	.5951 - .6270
.6406	41/64	7	9	365041	285.90	-
.6562	21/32	7	9	365042	290.80	.6271 - .6570
.6719	43/64	7 1/4	9 1/4	365043	306.10	-
.6875	11/16	7 1/4	9 1/4	365044	311.50	.6571 - .6900
.7031	45/64	7 1/2	9 1/2	365045	317.70	-
.7188	23/32	7 1/2	9 1/2	365046	323.05	.6901 - .7220
.7344	47/64	7 3/4	9 3/4	365047	320.40	-
.7500	3/4	7 3/4	9 3/4	365048	325.95	.7221 - .7530
.7656	49/64	7 7/8	9 7/8	365049	346.60	-
.7812	25/32	7 7/8	9 7/8	365050	346.60	.7531 - .7840
.8125	13/16	8	10	365052	352.45	.7841 - .8160
.8438	27/32	8	10	365054	373.10	.8161 - .8470
.8750	7/8	8	10	365056	381.85	.8471 - .8780
.9062	29/32	8	10	365058	423.10	.8781 - .9090
.9375	15/16	8 3/4	10 3/4	365060	440.60	.9091 - .9390
.9688	31/32	9	11	365062	444.85	.9391 - .9700
1.0000	1	9	11	365064	444.85	.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	FRACTION	FLUTE	OVERALL			
.2500	1/4	2 1/2	4 29/32	365216	\$170.15	.2490 - .2530
.2656	17/64	2 3/4	5 5/32	365217	170.15	-
.2812	9/32	2 3/4	5 5/32	365218	170.15	.2640 - .2840
.2969	19/64	3 3/16	5 19/32	365219	170.15	-
.3125	5/16	3 3/16	5 19/32	365220	170.15	.2950 - .3160
.3281	21/64	3 7/16	5 27/32	365221	170.15	-
.3438	11/32	3 7/16	5 27/32	365222	170.15	.3260 - .3460
.3594	23/64	3 5/8	6 1/32	365223	171.90	-
.3750	3/8	3 5/8	6 1/32	365224	171.90	.3540 - .3770
.3906	25/64	3 7/8	6 5/32	365225	176.20	-
.4062	13/32	3 7/8	6 5/32	365226	176.20	.3850 - .4080
.4219	27/64	4 1/16	6 15/32	365227	182.25	-
.4375	7/16	4 1/16	6 15/32	365228	182.25	.4100 - .4390
.4531	29/64	4 5/16	6 23/32	365229	193.95	-
.4688	15/32	4 5/16	6 23/32	365230	193.95	.4391 - .4724
.4844	31/64	4 1/2	6 29/32	365231	199.65	-
.5000	1/2	4 1/2	6 29/32	365232	199.65	.4725 - .5030
.5156	33/64	4 13/16	7 7/32	365233	208.05	-
.5312	17/32	4 13/16	7 7/32	365234	211.60	.5031 - .5330
.5469	35/64	4 13/16	7 7/32	365235	219.50	-
.5625	9/16	4 13/16	7 7/32	365236	223.25	.5331 - .5650

TOOL DIAMETER		LENGTH		TYPE 3652 EDP NO.	PRICE EACH	DECIMAL SIZE RANGE*
DECIMAL	FRACTION	FLUTE	OVERALL			
.5781	37/64	5 3/16	7 19/32	365237	\$263.05	-
.5938	19/32	5 3/16	7 19/32	365238	267.50	.5651 - .5950
.6094	39/64	5 3/16	7 19/32	365239	263.05	-
.6250	5/8	5 3/16	7 19/32	365240	267.50	.5951 - .6270
.6406	41/64	5 3/16	7 19/32	365241	282.05	-
.6562	21/32	5 3/16	7 19/32	365242	282.05	.6271 - .6570
.6719	43/64	5 5/8	8 1/32	365243	305.10	-
.6875	11/16	5 5/8	8 1/32	365244	305.55	.6571 - .6900
.7031	45/64	5 5/8	8 1/32	365245	314.25	-
.7188	23/32	5 5/8	8 1/32	365246	314.25	.6901 - .7220
.7344	47/64	6 1/16	8 15/32	365247	317.30	-
.7500	3/4	6 1/16	8 15/32	365248	317.30	.7221 - .7530
.7656	49/64	6 1/16	8 9/16	365249	332.20	-
.7812	25/32	6 1/16	8 9/16	365250	338.00	.7531 - .7840
.8125	13/16	6 1/16	8 9/16	365252	343.60	.7841 - .8160
.8438	27/32	6 1/2	9	365254	364.30	.8161 - .8470
.8750	7/8	6 1/2	9	365256	373.10	.8471 - .8780
.9062	29/32	6 15/16	9 7/16	365258	399.25	.8781 - .9090
.9375	15/16	6 15/16	9 7/16	365260	428.90	.9091 - .9390
.9688	31/32	6 15/16	9 7/16	365262	446.45	.9391 - .9700
1.0000	1	7 3/8	9 7/8	365264	458.20	.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	\$194.20	-
7.0	.2756	121	4 3/4	159	6 1/4	3650070	194.20	6.706 - 7.214
7.5	.2953	124	4 7/8	162	6 3/8	3650075	194.20	7.493 - 8.026
8.0	.3150	124	4 7/8	162	6 3/8	3650080	194.20	-
8.5	.3346	127	5	165	6 1/2	3650085	187.50	8.280 - 8.788
9.0	.3543	133	5 1/4	171	6 3/4	3650090	187.50	8.992 - 9.576
9.5	.3740	133	5 1/4	171	6 3/4	3650095	187.50	-
10.0	.3937	140	5 1/2	178	7	3650100	187.50	9.779 - 10.363
10.5	.4134	146	5 3/4	184	7 1/4	3650105	194.20	10.414 - 11.151
11.0	.4331	146	5 3/4	184	7 1/4	3650110	194.20	-
11.5	.4528	146	5 3/4	191	7 1/2	3650115	209.85	11.153 - 12.000
12.0	.4724	146	5 3/4	191	7 1/2	3650120	209.85	-
12.5	.4921	146	5 3/4	197	7 3/4	3650125	214.35	12.002 - 12.776
13.0	.5118	152	6	203	8	3650130	227.65	12.779 - 13.538
13.5	.5315	152	6	203	8	3650135	227.65	-
14.0	.5512	159	6 1/4	210	8 1/4	3650140	238.85	13.541 - 14.351
14.5	.5709	171	6 3/4	222	8 3/4	3650145	290.10	14.354 - 15.113
15.0	.5906	171	6 3/4	222	8 3/4	3650150	290.10	-
15.5	.6102	171	6 3/4	222	8 3/4	3650155	290.10	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	\$296.85	15.928 - 16.688
16.5	.6496	178	7	229	9	3650165	296.85	-
17.0	.6693	184	7 1/4	235	9 1/4	3650170	317.00	16.690 - 17.526
17.5	.6890	184	7 1/4	235	9 1/4	3650175	317.00	-
18.0	.7087	191	7 1/2	241	9 1/2	3650180	332.65	17.529 - 18.339
18.5	.7283	197	7 3/4	248	9 3/4	3650185	334.80	18.341 - 19.126
19.0	.7480	197	7 3/4	248	9 3/4	3650190	334.80	-
19.5	.7677	200	7 7/8	251	9 7/8	3650195	354.95	19.129 - 19.914
20.0	.7874	203	8	254	10	3650200	359.40	19.916 - 20.726
20.5	.8071	203	8	254	10	3650205	359.40	-
21.0	.8268	203	8	254	10	3650210	379.45	20.729 - 21.514
21.5	.8465	203	8	254	10	3650215	379.45	-
22.0	.8661	203	8	254	10	3650220	388.45	21.516 - 22.301
22.5	.8858	203	8	254	10	3650225	428.60	22.304 - 23.089
23.0	.9055	203	8	254	10	3650230	428.60	-
23.5	.9252	222	8 3/4	273	10 3/4	3650235	444.25	23.091 - 23.851
24.0	.9449	229	9	279	11	3650240	462.05	23.853 - 24.638
24.5	.9646	229	9	279	11	3650245	462.05	-
25.0	.9843	229	9	279	11	3650250	462.05	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	\$219.85	-
7.0	.2756	70	2 3/4	131	5 5/32	3652070	219.85	6.706 - 7.214
7.5	.2953	81	3 3/16	142	5 19/32	3652075	219.85	7.493 - 8.026
8.0	.3150	81	3 3/16	142	5 19/32	3652080	219.85	-
8.5	.3346	87	3 7/16	148	5 27/32	3652085	212.25	8.280 - 8.788
9.0	.3543	92	3 5/8	153	6 1/32	3652090	212.25	8.992 - 9.576
9.5	.3740	92	3 5/8	153	6 1/32	3652095	212.25	-
10.0	.3937	98	3 7/8	159	6 9/32	3652100	212.25	9.779 - 10.363
10.5	.4134	103	4 1/16	164	6 15/32	3652105	219.85	10.414 - 11.151
11.0	.4331	103	4 1/16	164	6 15/32	3652110	219.85	-
11.5	.4528	109	4 3/16	171	6 23/32	3652115	237.55	11.153 - 12.000
12.0	.4724	109	4 3/16	171	6 23/32	3652120	237.55	-
12.5	.4921	114	4 1/2	175	6 29/32	3652125	242.70	12.002 - 12.776
13.0	.5118	122	4 13/16	183	7 1/32	3652130	257.70	12.779 - 13.538
13.5	.5315	122	4 13/16	183	7 1/32	3652135	257.70	-
14.0	.5512	122	4 13/16	183	7 1/32	3652140	270.40	13.541 - 14.351
14.5	.5709	131	5 3/16	193	7 19/32	3652145	328.45	14.354 - 15.113
15.0	.5906	131	5 3/16	193	7 19/32	3652150	328.45	-
15.5	.6102	131	5 3/16	193	7 19/32	3652155	328.45	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	\$336.10	15.928 - 16.688
16.5	.6496	131	5 3/16	193	7 19/32	3652165	336.10	-
17.0	.6693	143	5 5/8	204	8 1/32	3652170	358.85	16.690 - 17.526
17.5	.6890	143	5 5/8	204	8 1/32	3652175	358.85	-
18.0	.7087	143	5 5/8	204	8 1/32	3652180	376.55	17.529 - 18.339
18.5	.7283	154	6 1/16	215	8 15/32	3652185	379.00	18.341 - 19.126
19.0	.7480	154	6 1/16	215	8 15/32	3652190	379.00	-
19.5	.7677	154	6 1/16	217	8 9/16	3652195	401.85	19.129 - 19.914
20.0	.7874	154	6 1/16	217	8 9/16	3652200	406.90	19.916 - 20.726
20.5	.8071	154	6 1/16	217	8 9/16	3652205	406.90	-
21.0	.8268	165	6 1/2	229	9	3652210	429.60	20.729 - 21.514
21.5	.8465	165	6 1/2	229	9	3652215	429.60	-
22.0	.8661	165	6 1/2	229	9	3652220	439.75	21.516 - 22.301
22.5	.8858	176	6 15/16	240	9 7/16	3652225	485.20	22.304 - 23.089
23.0	.9055	176	6 15/16	240	9 7/16	3652230	485.20	-
23.5	.9252	176	6 15/16	240	9 7/16	3652235	502.90	23.091 - 23.851
24.0	.9449	176	6 15/16	240	9 7/16	3652240	523.05	23.853 - 24.638
24.5	.9646	176	6 15/16	240	9 7/16	3652245	518.70	-
25.0	.9843	187	7 3/8	251	9 7/8	3652250	523.05	24.641 - 25.476

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*Call for modified metric pricing. **6.5mm tool has 6.35mm shank.

Made in U.S.A.

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	\$186.90	365716	\$223.25	-
.2812	9/32	3 7/8	6 1/4	365618	186.90	365718	219.80	.2650 - .2840
.3125	5/16	4	6 3/8	365620	186.90	365720	219.80	.2953 - .3150
.3438	11/32	4 1/8	6 1/2	365622	186.90	365722	219.80	.3280 - .3460
.3750	3/8	4 1/4	6 3/4	365624	186.90	365724	219.80	.3543 - .3770
.4062	13/32	4 3/8	7	365626	186.90	365726	235.90	.3900 - .4080
.4375	7/16	4 5/8	7 1/4	365628	186.90	365728	235.90	.4130 - .4390
.4688	15/32	4 7/8	7 1/2	365630	198.70	365730	235.50	.4391 - .4710
.5000	1/2	5	7 3/4	365632	204.55	365732	235.60	.4711 - .5020
.5312	17/32	5 1/4	8	365634	219.65	365734	252.80	.5021 - .5330
.5625	9/16	5 3/8	8 1/4	365636	231.45	365736	266.40	.5331 - .5640
.5938	19/32	5 5/8	8 1/2	365638	275.95	365738	314.10	.5641 - .5940
.6250	5/8	5 3/4	8 3/4	365640	275.95	365740	314.10	.5941 - .6260
.6562	21/32	5 7/8	9	365642	293.55	365742	334.10	.6261 - .6570
.6875	11/16	6	9 1/4	365644	314.45	365744	357.85	.6571 - .6900
.7188	23/32	6 3/16	9 1/2	365646	327.60	365746	367.05	.6901 - .7210
.7500	3/4	6 3/8	9 3/4	365648	329.35	365748	369.05	.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	\$173.40	365516	\$213.25
.2656	17/64	1 19/32	.2500	4	365417	197.75	365517	227.65
.2812	9/32	1 19/32	.2656	4	365418	185.80	365518	225.05
.2969	19/64	1 3/4	.2812	4 5/32	365419	197.75	365519	227.65
.3125	5/16	1 3/4	.2969	4 5/32	365420	185.80	365520	225.05
.3281	21/64	1 15/16	.3125	4 11/32	365421	197.75	365521	227.65
.3438	11/32	1 15/16	.3281	4 11/32	365422	185.80	365522	225.05
.3594	23/64	2 1/8	.3438	4 17/32	365423	197.75	365523	236.85
.3750	3/8	2 1/8	.3594	4 17/32	365424	185.80	365524	225.05
.3906	25/64	2 9/32	.3750	4 11/16	365425	197.75	365525	250.65
.4062	13/32	2 9/32	.3906	4 11/16	365426	185.80	365526	241.35
.4219	27/64	2 1/2	.4062	4 29/32	365427	197.75	365527	250.65
.4375	7/16	2 1/2	.4219	4 29/32	365428	185.80	365528	241.35
.4531	29/64	2 23/32	.4375	5 1/16	365429	209.25	365529	250.65
.4688	15/32	2 21/32	.4531	5 1/16	365430	197.80	365530	241.35
.4844	31/64	2 13/16	.4688	5 7/32	365431	213.85	365531	250.65
.5000	1/2	2 13/16	.4844	5 7/32	365432	203.70	365532	241.35
.5156	33/64	3	.5000	5 13/32	365433	211.45	365533	250.65
.5312	17/32	3	.5156	5 13/32	365434	203.70	365534	241.35
.5469	35/64	3 1/8	.5312	5 17/32	365435	211.45	365535	250.65
.5625	9/16	3 1/8	.5469	5 17/32	365436	203.70	365536	241.35
.5781	37/64	3 9/32	.5625	5 11/16	365437	227.65	365537	262.05
.5938	19/32	3 9/32	.5781	5 11/16	365438	218.00	365538	255.55
.6094	39/64	3 7/16	.5938	5 27/32	365439	227.65	365539	262.05
.6250	5/8	3 7/16	.6094	5 27/32	365440	218.00	365540	255.55
.6406	41/64	3 23/32	.6250	6 1/16	365441	227.65	365541	262.05
.6562	21/32	3 23/32	.6406	6 1/16	365442	218.00	365542	255.55

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	\$227.65	365543	\$262.05
.6875	11/16	3 13/16	.6719	6 7/32	365444	218.00	365544	255.55
.7031	45/64	3 15/16	.6875	6 11/32	365445	252.95	365545	289.75
.7188	23/32	3 15/16	.7031	6 11/32	365446	243.75	365546	281.30
.7344	47/64	4 1/8	.7188	6 17/32	365447	252.95	365547	289.75
.7500	3/4	4 1/8	.7344	6 17/32	365448	243.75	365548	281.30
.7656	49/64	4 9/32	.7500	6 25/32	365449	252.95	365549	289.75
.7812	25/32	4 9/32	.7656	6 25/32	365450	243.75	365550	281.30
.7969	51/64	4 7/16	.7812	6 15/16	365451	301.25	365551	335.75
.8125	13/16	4 7/16	.7969	6 15/16	365452	290.70	365552	328.10
.8281	53/64	4 19/32	.8125	7 3/32	365453	301.25	365553	335.75
.8438	27/32	4 19/32	.8281	7 3/32	365454	290.70	365554	328.10
.8594	55/64	4 11/16	.8438	7 3/16	365455	301.25	365555	335.75
.8750	7/8	4 11/16	.8594	7 3/16	365456	290.70	365556	328.10
.8906	57/64	4 7/8	.8750	7 3/8	365457	319.60	365557	356.45
.9062	29/32	4 7/8	.8906	7 3/8	365458	309.50	365558	346.90
.9219	59/64	5 1/32	.9062	7 17/32	365459	319.60	365559	356.45
.9375	15/16	5 1/32	.9219	7 17/32	365460	309.50	365560	346.90
.9531	61/64	5 3/16	.9375	7 11/16	365461	338.05	365561	374.80
.9688	31/32	5 3/16	.9531	7 11/16	365462	325.80	365562	363.20
.9844	63/64	5 5/16	.9688	7 13/16	365463	338.05	365563	374.80
1.0000	1	5 5/16	.9844	7 13/16	365464	325.80	365564	363.20
1.0312	1 1/32	5 11/16	1.0000	8 3/16	365466	351.65	365566	389.05
1.0625	1 1/16	5 11/16	1.0000	8 3/16	365468	363.20	365568	400.85
1.0938	1 3/32	5 11/16	1.0000	8 3/16	365470	372.70	365570	410.20
1.1250	1 1/8	5 11/16	1.0000	8 3/16	365472	386.75	365572	424.30
-	-	-	-	-	-	-	-	-

CARBIDE TIPPED COOLANT TWIST DRILLS

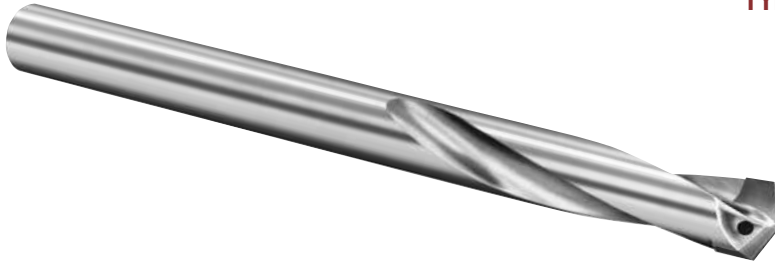
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TYPE 3654 - 125° 4 FACET POINT - STUB LENGTH

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	\$186.30	3655065	\$218.35
7.0	.2756	40	1 19/32	6.5	.2559	102	4	3654070	197.75	3655070	227.65
7.5	.2953	40	1 19/32	7.0	.2756	102	4	3654075	197.75	3655075	227.65
8.0	.3150	44	1 3/4	7.5	.2953	106	4 5/32	3654080	197.75	3655080	227.65
8.5	.3346	49	1 15/16	8.0	.3150	110	4 11/32	3654085	197.75	3655085	236.85
9.0	.3543	49	1 15/16	8.5	.3346	110	4 11/32	3654090	197.75	3655090	236.85
9.5	.3740	54	2 1/8	9.0	.3543	115	4 17/32	3654095	197.75	3655095	236.85
10.0	.3937	58	2 9/32	9.5	.3740	119	4 11/16	3654100	197.75	3655100	250.65
10.5	.4134	58	2 9/32	10.0	.3937	119	4 11/16	3654105	197.75	3655105	250.65
11.0	.4331	64	2 1/2	10.5	.4134	125	4 29/32	3654110	197.75	3655110	250.65
11.5	.4528	67	2 21/32	11.0	.4331	129	5 1/16	3654115	209.25	3655115	250.65
12.0	.4724	67	2 21/32	11.5	.4528	129	5 1/16	3654120	209.25	3655120	250.65
12.5	.4921	71	2 13/16	12.0	.4724	133	5 7/32	3654125	213.85	3655125	250.65
13.0	.5118	76	3	12.5	.4921	137	5 13/32	3654130	211.45	3655130	250.65
13.5	.5315	76	3	13.0	.5118	137	5 13/32	3654135	211.45	3655135	250.65
14.0	.5512	79	3 1/8	13.5	.5315	140	5 17/32	3654140	211.45	3655140	250.65
14.5	.5709	83	3 9/32	14.0	.5512	144	5 11/16	3654145	227.65	3655145	262.05
15.0	.5906	83	3 9/32	14.5	.5709	144	5 11/16	3654150	227.65	3655150	262.05
15.5	.6102	87	3 7/16	15.0	.5906	148	5 27/32	3654155	227.65	3655155	262.05
16.0	.6299	87	3 7/16	15.5	.6102	148	5 27/32	3654160	227.65	3655160	262.05
16.5	.6496	93	3 21/32	16.0	.6299	154	6 1/16	3654165	227.65	3655165	262.05
17.0	.6693	93	3 21/32	16.5	.6496	154	6 1/16	3654170	227.65	3655170	262.05
17.5	.6890	97	3 13/16	17.0	.6693	158	6 7/32	3654175	227.65	3655175	289.75
18.0	.7087	100	3 15/16	17.5	.6890	161	6 11/32	3654180	252.95	3655180	289.75
18.5	.7283	100	3 15/16	18.0	.7087	161	6 11/32	3654185	252.95	3655185	289.75
19.0	.7480	105	4 1/8	18.5	.7283	166	6 17/32	3654190	252.95	3655190	289.75
19.5	.7677	109	4 9/32	19.0	.7480	172	6 25/32	3654195	252.95	3655195	289.75
20.0	.7874	109	4 9/32	19.5	.7677	172	6 25/32	3654200	252.95	3655200	335.75
20.5	.8071	113	4 7/16	20.0	.7874	176	6 15/16	3654205	301.25	3655205	335.75
21.0	.8268	117	4 19/32	20.5	.8071	180	7 3/32	3654210	301.25	3655210	335.75
21.5	.8465	117	4 19/32	21.0	.8268	180	7 3/32	3654215	301.25	3655215	335.75
22.0	.8661	119	4 11/16	21.5	.8465	183	7 3/16	3654220	301.25	3655220	335.75
22.5	.8858	124	4 7/8	22.0	.8661	187	7 3/8	3654225	319.60	3655225	356.45
23.0	.9055	124	4 7/8	22.5	.8858	187	7 3/8	3654230	319.60	3655230	356.45
23.5	.9252	128	5 1/2	23.0	.9055	191	7 17/32	3654235	319.60	3655235	356.45
24.0	.9449	132	5 3/16	23.5	.9252	195	7 11/16	3654240	338.05	3655240	374.80
24.5	.9646	132	5 3/16	24.0	.9449	195	7 11/16	3654245	338.05	3655245	374.80
25.0	.9843	135	5 3/16	24.5	.9646	198	7 13/16	3654250	338.05	3655250	374.80
26.0	1.0236	144	5 11/16	25.5	1.0039	208	8 3/16	3654260	363.20	3655260	400.15

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 136 & 137.



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	\$107.15	.3471 - .3780	\$146.30	\$126.65	\$120.15	\$117.00	\$113.60	\$111.00
.4062	13/32*	.284	3 5/8	5/8	7	13/32	362013	1	362213	107.15	.3781 - .4090	146.30	126.65	120.15	117.00	113.60	111.00
.4375	7/16*	.306	3 7/8	3/4	7 1/4	7/16	362014	1	362214	107.15	.4091 - .4410	146.30	126.65	120.15	117.00	113.60	111.00
.4688	15/32*	.328	4 1/8	3/4	7 1/2	15/32	362015	1	362215	107.15	.4411 - .4720	146.30	126.65	120.15	117.00	113.60	111.00
.5000	1/2	.350	4 3/8	3/4	8 1/4	1/2	362016	2	362216	107.15	.4721 - .5030	146.30	126.65	120.15	117.00	113.60	111.00
.5312	17/32	.372	4 3/8	3/4	8 1/4	17/32	362017	2	362217	107.60	.5031 - .5340	146.85	127.20	120.60	117.45	114.10	111.45
.5625	9/16	.394	4 3/8	3/4	8 1/4	9/16	362018	2	362218	107.60	.5341 - .5660	146.85	127.20	120.60	117.45	114.10	111.45
.5938	19/32	.416	4 3/8	3/4	8 1/4	19/32	362019	2	362219	113.00	.5661 - .5970	152.20	132.50	126.00	122.90	119.45	116.85
.6250	5/8	.438	4 3/8	3/4	8 1/4	5/8	362020	2	362220	113.00	.5971 - .6280	152.20	132.50	126.00	122.90	119.45	116.85
.6562	21/32	.459	4 3/8	3/4	8 1/4	21/32	362021	2	362221	114.35	.6281 - .6590	153.50	133.95	127.35	124.20	120.85	118.20
.6875	11/16	.481	4 3/8	7/8	8 1/4	11/16	362022	2	362222	115.30	.6591 - .6910	154.50	134.90	128.30	125.20	121.85	119.15
.7188	23/32	.503	4 3/8	7/8	8 1/4	23/32	362023	2	362223	115.30	.6911 - .7220	154.50	134.90	128.30	125.20	121.85	119.15
.7500	3/4	.525	4 3/8	7/8	8 1/4	3/4	362024	2	362224	115.30	.7221 - .7530	154.50	134.90	128.30	125.20	121.85	119.15
.7812	25/32	.547	4 3/8	7/8	8 1/4	25/32	362025	2	362225	117.90	.7531 - .7840	157.10	137.40	130.90	127.75	124.35	121.75
.8125	13/16	.569	4 7/8	7/8	9 1/2	13/16	362026	3	362226	121.15	.7841 - .8160	160.35	140.70	134.15	131.05	127.60	125.05
.8438	27/32	.591	4 7/8	7/8	9 1/2	27/32	362027	3	362227	127.60	.8161 - .8470	166.90	147.20	140.60	137.50	134.15	131.50
.8750	7/8	.612	4 7/8	7/8	9 1/2	7/8	362028	3	362228	127.60	.8471 - .8780	166.90	147.20	140.60	137.50	134.15	131.50
.9062	29/32	.634	4 7/8	7/8	9 1/2	29/32	362029	3	362229	128.45	.8781 - .9090	167.60	148.05	141.45	138.30	134.95	132.30
.9375	19/16	.656	4 7/8	7/8	9 1/2	19/16	362030	3	362230	128.45	.9091 - .9410	167.60	148.05	141.45	138.30	134.95	132.30
.9688	31/32	.678	4 7/8	7/8	9 1/2	31/32	362031	3	362231	133.20	.9411 - .9720	172.35	152.70	146.15	143.05	139.65	137.05
1.0000	1	.700	4 7/8	7/8	9 1/2	1	362032	3	362232	135.65	.9721 - 1.0030	174.90	155.25	148.60	145.50	142.15	139.50
1.0312	1 1/32	.722	4 7/8	7/8	9 1/2	1 1/32	362033	3	362233	136.80	1.0031 - 1.0340	176.00	156.35	149.80	146.60	143.30	140.60
1.0625	1 1/16	.744	4 7/8	7/8	9 1/2	1 1/16	362034	3	362234	138.70	1.0341 - 1.0660	177.95	158.25	151.65	148.55	145.20	142.55
1.0938	1 3/32	.766	4 7/8	1	10 1/2	1 3/32	362035	4	362235	161.55	1.0661 - 1.0970	200.70	181.10	174.50	171.40	168.05	165.40
1.1250	1 1/8	.787	4 7/8	1	10 1/2	1 1/8	362036	4	362236	161.55	1.0971 - 1.1280	200.70	181.10	174.50	171.40	168.05	165.40
1.1562	1 9/32	.809	4 7/8	1	10 1/2	1 9/32	362037	4	362237	176.35	1.1281 - 1.1590	215.55	195.95	189.35	186.25	182.90	180.25
1.1875	1 3/16	.831	4 7/8	1	10 1/2	1 3/16	362038	4	362238	181.50	1.1591 - 1.1905	220.65	201.10	194.50	191.35	188.00	185.35
1.2188	1 7/32	.853	4 7/8	1	10 1/2	1 7/32	362039	4	362239	182.15	1.1906 - 1.2220	221.35	201.70	195.15	192.05	188.60	186.00
1.2500	1 1/4	.875	4 7/8	1	10 1/2	1 1/4	362040	4	362240	182.90	1.2221 - 1.2530	222.10	202.40	195.90	192.70	189.35	186.70
1.2812	1 9/32	.897	4 7/8	1	10 1/2	1 9/32	362041	4	362241	195.95	1.2531 - 1.2840	235.15	215.50	208.95	205.75	202.40	199.75
1.3125	1 5/16	.919	4 7/8	1	10 1/2	1 5/16	362042	4	362242	201.40	1.2841 - 1.3150	240.55	220.95	214.35	211.25	207.90	205.25
1.3438	1 11/32	.940	4 7/8	1	10 1/2	1 11/32	362043	4	362243	205.60	1.3151 - 1.3470	244.80	225.20	218.60	215.50	212.15	209.45
1.3750	1 3/8	.962	4 7/8	1	10 1/2	1 3/8	362044	4	362244	210.60	1.3471 - 1.3780	249.75	230.15	223.55	220.45	217.10	214.45
1.4062	1 13/32	.984	4 7/8	1	10 1/2	1 13/32	362045	4	362245	215.40	1.3781 - 1.4090	254.60	235.00	228.40	225.25	221.95	219.25
1.4375	1 7/16	1.006	4 7/8	1	10 1/2	1 7/16	362046	4	362246	221.70	1.4091 - 1.4410	260.90	241.30	234.70	231.60	228.25	225.55
1.4688	1 15/32	1.025	4 7/8	1	10 1/2	1 15/32	362047	4	362247	228.30	1.4411 - 1.4720	267.50	247.85	241.30	238.20	234.75	232.15
1.5000	1 1/2	1.050	4 7/8	1	10 1/2	1 1/2	362048	4	362248	233.20	1.4721 - 1.5030	272.40	252.75	246.20	243.10	239.65	237.05

CARBIDE TIPPED CORE DRILLS FOR NON-FERROUS & CAST IRON

METRIC

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 136 & 137.



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	\$120.15	8.815-9.601	\$149.60	\$130.05	\$123.45	\$120.30	\$117.00	\$114.25	\$110.50
10.0*	.3937	.284	3 3/8	5/8	7	13/32	3620100	1	3622100	120.15	9.602-10.389	149.60	130.05	123.45	120.30	117.00	114.25	110.50
11.0*	.4331	.306	3 7/8	3/4	7 1/4	7/16	3620110	1	3622110	120.15	10.390-11.201	149.60	130.05	123.45	120.30	117.00	114.25	110.50
-*	-	.328	4 1/8	3/4	7 1/2	15/32	3620119	1	3622119	-	11.202-11.989	149.60	130.05	123.45	120.30	117.00	114.25	110.50
12.0	.4724	.350	4 3/8	3/4	8 1/4	1/2	3620120	2	3622120	120.15	11.990-12.776	149.60	130.05	123.45	120.30	117.00	114.25	110.50
13.0	.5118	.372	4 3/8	3/4	8 1/4	17/32	3620130	2	3622130	120.60	12.777-13.564	150.10	130.50	124.00	120.80	117.45	114.80	111.00
14.0	.5512	.394	4 3/8	3/4	8 1/4	9/16	3620140	2	3622140	120.60	13.565-14.376	150.10	130.50	124.00	120.80	117.45	114.80	111.00
15.0	.5906	.416	4 3/8	3/4	8 1/4	19/32	3620150	2	3622150	126.00	14.377-15.164	155.45	135.95	129.35	126.15	122.90	120.15	116.35
-	-	.438	4 3/8	3/4	8 1/4	5/8	3620159	2	3622159	-	15.165-15.951	155.45	135.95	129.35	126.15	122.90	120.15	116.35
16.0	.6299	.459	4 3/8	3/4	8 1/4	21/32	3620160	2	3622160	127.35	15.952-16.739	156.85	137.25	130.65	127.50	124.20	121.45	117.75
17.0	.6693	.481	4 3/8	7/8	8 1/4	11/16	3620170	2	3622170	128.30	16.740-17.551	157.80	138.25	131.65	128.45	125.20	122.45	118.65
18.0	.7087	.503	4 3/8	7/8	8 1/4	23/32	3620180	2	3622180	128.30	17.552-18.339	157.80	138.25	131.65	128.45	125.20	122.45	118.65
19.0	.7480	.525	4 3/8	7/8	8 1/4	3/4	3620190	2	3622190	128.30	18.340-19.126	157.80	138.25	131.65	128.45	125.20	122.45	118.65
-	-	.547	4 3/8	7/8	8 1/4	25/32	3620199	2	3622199	-	19.127-19.914	160.35	140.85	134.25	131.05	127.75	125.05	121.25
20.0	.7874	.569	4 7/8	7/8	9 1/2	13/16	3620200	3	3622200	134.15	19.915-20.726	163.60	144.10	137.50	134.30	131.05	128.30	124.50
21.0	.8268	.591	4 7/8	7/8	9 1/2	27/32	3620210	3	3622210	140.60	20.727-21.514	170.15	150.55	144.00	140.85	137.50	134.80	131.05
22.0	.8661	.612	4 7/8	7/8	9 1/2	7/8	3620220	3	3622220	140.60	21.515-22.301	170.15	150.55	144.00	140.85	137.50	134.80	131.05
23.0	.9055	.634	4 7/8	7/8	9 1/2	29/32	3620230	3	3622230	141.45	22.302-23.089	170.95	151.35	144.85	141.55	138.30	135.55	131.85
-	-	.656	4 7/8	7/8	9 1/2	15/16	3620239	3	3622239	-	23.090-23.901	170.95	151.35	144.85	141.55	138.30	135.55	131.85
24.0	.9449	.678	4 7/8	7/8	9 1/2	31/32	3620240	3	3622240	146.15	23.902-24.689	175.65	156.10	149.50	146.30	143.05	140.30	136.55
25.0	.9843	.700	4 7/8	7/8	9 1/2	1	3620250	3	3622250	148.60	24.690-25.476	178.15	158.55	152.05	148.85	145.50	142.85	139.05
26.0	1.0236	.722	4 7/8	7/8	9 1/2	1 1/32	3620260	3	3622260	149.80	25.477-26.264	179.25	159.70	153.15	149.95	146.60	143.95	140.15
27.0	1.0630	.744	4 7/8	7/8	9 1/2	1 1/16	3620270	3	3622270	151.65	26.265-27.076	181.20	161.60	155.10	151.90	148.55	145.90	142.10
-	-	.766	4 3/8	1	10 1/2	1 3/32	3620279	4	3622279	-	27.077-27.864	204.05	184.45	177.95	174.65	171.40	168.65	164.95
28.0	1.1024	.787	4 7/8	1	10 1/2	1 1/8	3620280	4	3622280	174.50	27.865-28.651	204.05	184.45	177.95	174.65	171.40	168.65	164.95
29.0	1.1417	.809	4 7/8	1	10 1/2	1 5/32	3620290	4	3622290	189.35	28.652-29.439	218.80	199.30	192.70	189.50	186.25	183.50	179.70
30.0	1.1811	.831	4 7/8	1	10 1/2	1 3/16	3620300	4	3622300	194.50	29.440-30.239	224.00	204.40	197.90	194.65	191.35	188.60	184.90
31.0	1.2205	.853	4 7/8	1	10 1/2	1 7/32	3620310	4	3622310	195.15	30.240-31.039	224.60	205.10	198.50	195.30	192.05	189.30	185.50
-	-	.875	4 7/8	1	10 1/2	1 1/4	3620319	4	3622319	-	31.040-31.826	225.35	205.75	199.25	196.05	192.70	190.05	186.25
32.0	1.2598	.897	4 7/8	1	10 1/2	1 9/32	3620320	4	3622320	208.95	31.827-32.614	238.40	218.80	212.30	209.10	205.75	203.10	199.30
33.0	1.2992	.919	4 7/8	1	10 1/2	1 5/16	3620330	4	3622330	214.35	32.615-33.401	243.80	224.30	217.70	214.50	211.25	208.50	204.70
34.0	1.3386	.940	4 7/8	1	10 1/2	1 11/32	3620340	4	3622340	218.60	33.402-34.214	248.10	228.55	222.00	218.75	215.50	212.75	209.00
35.0	1.3780	.962	4 7/8	1	10 1/2	1 3/8	3620350	4	3622350	223.55	34.215-35.001	253.10	233.50	227.00	223.70	220.45	217.70	214.00
-	-	.984	4 7/8	1	10 1/2	1 13/32	3620359	4	3622359	-	35.002-35.789	257.85	238.35	231.75	228.55	225.25	222.55	218.75
36.0	1.4173	1.006	4 7/8	1	10 1/2	1 7/16	3620360	4	3622360	234.70	35.790-36.601	264.25	244.65	238.10	234.85	231.60	228.85	225.10
37.0	1.4567	1.025	4 7/8	1	10 1/2	1 15/32	3620370	4	3622370	241.30	36.602-37.389	270.75	251.25	244.65	241.45	238.20	235.45	231.65
38.0	1.4961	1.050	4 7/8	1	10 1/2	1 1/2	3620380	4	3622380	246.20	37.390-38.176	275.65	256.15	249.55	246.35	243.10	240.35	236.55

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*3 flutes.

Made in U.S.A.

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 134 and 135.



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	\$118.00	.3471 - .3780	\$157.15	137.50	130.95	\$127.85	\$124.45	\$121.85
.4062	13/32*	.284	3 5/8	5/8	7	13/32	362113	1	362313	118.00	.3781 - .4090	157.15	137.50	130.95	127.85	124.45	121.85
.4375	7/16*	.306	3 7/8	3/4	7 1/4	7/16	362114	1	362314	118.00	.4091 - .4410	157.15	137.50	130.95	127.85	124.45	121.85
.4688	15/32*	.328	4 1/8	3/4	7 1/2	15/32	362115	1	362315	118.00	.4411 - .4720	157.15	137.50	130.95	127.85	124.45	121.85
.5000	1/2	.350	4 3/8	3/4	8 1/4	1/2	362116	2	362316	118.00	.4721 - .5030	157.15	137.50	130.95	127.85	124.45	121.85
.5312	17/32	.372	4 3/8	3/4	8 1/4	17/32	362117	2	362317	118.35	.5031 - .5340	157.55	137.95	131.35	128.20	124.90	122.20
.5625	9/16	.394	4 3/8	3/4	8 1/4	9/16	362118	2	362318	118.35	.5341 - .5660	157.55	137.95	131.35	128.20	124.90	122.20
.5938	19/32	.416	4 3/8	3/4	8 1/4	19/32	362119	2	362319	124.35	.5661 - .5970	163.55	143.95	137.35	134.25	130.90	128.20
.6250	5/8	.438	4 3/8	3/4	8 1/4	5/8	362120	2	362320	124.35	.5971 - .6280	163.55	143.95	137.35	134.25	130.90	128.20
.6562	21/32	.459	4 3/8	3/4	8 1/4	21/32	362121	2	362321	125.75	.6281 - .6590	164.95	145.30	138.70	135.55	132.20	129.55
.6875	11/16	.481	4 3/8	7/8	8 1/4	11/16	362122	2	362322	126.90	.6591 - .6910	166.05	146.40	139.85	136.70	133.35	130.65
.7188	23/32	.503	4 3/8	7/8	8 1/4	23/32	362123	2	362323	126.90	.6911 - .7220	166.05	146.40	139.85	136.70	133.35	130.65
.7500	3/4	.525	4 3/8	7/8	8 1/4	3/4	362124	2	362324	126.90	.7221 - .7530	166.05	146.40	139.85	136.70	133.35	130.65
.7812	25/32	.547	4 3/8	7/8	8 1/4	25/32	362125	2	362325	129.55	.7531 - .7840	168.75	149.15	142.55	139.40	136.10	133.40
.8125	13/16	.569	4 7/8	7/8	9 1/2	13/16	362126	3	362326	133.25	.7841 - .8160	172.45	152.85	146.25	143.15	139.80	137.10
.8438	27/32	.591	4 7/8	7/8	9 1/2	27/32	362127	3	362327	140.40	.8161 - .8470	179.55	160.00	153.35	150.25	146.90	144.25
.8750	7/8	.612	4 7/8	7/8	9 1/2	7/8	362128	3	362328	140.40	.8471 - .8780	179.55	160.00	153.35	150.25	146.90	144.25
.9062	29/32	.634	4 7/8	7/8	9 1/2	29/32	362129	3	362329	141.30	.8781 - .9090	180.45	160.85	154.25	151.15	147.80	145.15
.9375	15/16	.656	4 7/8	7/8	9 1/2	15/16	362130	3	362330	141.30	.9091 - .9410	180.45	160.85	154.25	151.15	147.80	145.15
.9688	31/32	.678	4 7/8	7/8	9 1/2	31/32	362131	3	362331	146.45	.9411 - .9720	185.65	166.05	159.45	156.35	153.00	150.35
1.0000	1	.700	4 7/8	7/8	9 1/2	1	362132	3	362332	149.30	.9721 - 1.0030	188.45	168.90	162.30	159.15	155.80	153.15
1.0312	1 1/32	.722	4 7/8	7/8	9 1/2	1 1/32	362133	3	362333	150.40	1.0031 - 1.0340	189.60	170.00	163.40	160.25	156.95	154.25
1.0625	1 1/16	.744	4 7/8	7/8	9 1/2	1 1/16	362134	3	362334	152.50	1.0341 - 1.0660	191.65	172.05	165.45	162.35	159.00	156.35
1.0938	1 3/32	.766	4 7/8	1	10 1/2	1 3/32	362135	4	362335	177.65	1.0661 - 1.0970	216.80	197.20	190.60	187.50	184.15	181.50
1.1250	1 1/8	.787	4 7/8	1	10 1/2	1 1/8	362136	4	362336	185.70	1.0971 - 1.1280	224.95	205.30	198.70	195.60	192.25	189.60
1.1562	1 3/32	.809	4 7/8	1	10 1/2	1 3/32	362137	4	362337	194.05	1.1281 - 1.1590	233.20	213.55	207.00	203.90	200.50	197.90
1.1875	1 3/16	.831	4 7/8	1	10 1/2	1 3/16	362138	4	362338	199.65	1.1591 - 1.1905	238.85	219.25	212.65	209.55	206.20	203.55
1.2188	1 7/32	.853	4 7/8	1	10 1/2	1 7/32	362139	4	362339	200.40	1.1906 - 1.2220	239.60	220.00	213.40	210.30	206.95	204.25
1.2500	1 1/4	.875	4 7/8	1	10 1/2	1 1/4	362140	4	362340	201.15	1.2221 - 1.2530	240.35	220.65	214.15	211.00	207.60	205.00
1.2812	1 9/32	.897	4 7/8	1	10 1/2	1 9/32	362141	4	362341	215.50	1.2531 - 1.2840	254.65	235.05	228.45	225.35	222.00	219.35
1.3125	1 5/16	.919	4 7/8	1	10 1/2	1 5/16	362142	4	362342	221.50	1.2841 - 1.3150	260.65	241.10	234.45	231.35	228.00	225.35
1.3438	1 11/32	.940	4 7/8	1	10 1/2	1 11/32	362143	4	362343	226.25	1.3151 - 1.3470	265.40	245.75	239.20	236.10	232.70	230.10
1.3750	1 3/8	.962	4 7/8	1	10 1/2	1 3/8	362144	4	362344	231.65	1.3471 - 1.3780	270.85	251.25	244.65	241.50	238.20	235.50
1.4062	1 13/32	.984	4 7/8	1	10 1/2	1 13/32	362145	4	362345	237.05	1.3781 - 1.4090	276.25	256.60	250.05	246.85	243.50	240.85
1.4375	1 7/16	1.006	4 7/8	1	10 1/2	1 7/16	362146	4	362346	243.95	1.4091 - 1.4410	283.15	263.50	256.90	253.75	250.40	247.75
1.4688	1 15/32	1.025	4 7/8	1	10 1/2	1 15/32	362147	4	362347	251.15	1.4411 - 1.4720	290.35	270.70	264.15	261.05	257.60	255.05
1.5000	1 1/2	1.050	4 7/8	1	10 1/2	1 1/2	362148	4	362348	256.50	1.4721 - 1.5030	295.70	276.10	269.50	266.40	263.05	260.35

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 134 & 135.



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	\$130.95	8.815 - 9.601	\$160.40	\$140.90	\$134.30	\$131.10	\$127.85	\$125.10	\$121.30
10.0*	.3937	.284	3 5/8	5/8	7	13/32	3621100	1	3623100	130.95	9.602 - 10.389	160.40	140.90	134.30	131.10	127.85	125.10	121.30
11.0*	.4331	.306	3 7/8	3/4	7 1/4	7/16	3621110	1	3623110	130.95	10.390 - 11.201	160.40	140.90	134.30	131.10	127.85	125.10	121.30
-*	-	.328	4 1/8	3/4	7 1/2	15/32	3621119	1	3623119	-	11.202 - 11.989	160.40	140.90	134.30	131.10	127.85	125.10	121.30
12.0	.4724	.350	4 3/8	3/4	8 1/4	1/2	3621120	2	3623120	130.95	11.990 - 12.776	160.40	140.90	134.30	131.10	127.85	125.10	121.30
13.0	.5118	.372	4 3/8	3/4	8 1/4	17/32	3621130	2	3623130	131.35	12.777 - 13.564	160.85	141.30	134.65	131.50	128.20	125.45	121.75
14.0	.5512	.394	4 3/8	3/4	8 1/4	9/16	3621140	2	3623140	131.35	13.565 - 14.376	160.85	141.30	134.65	131.50	128.20	125.45	121.75
15.0	.5906	.416	4 3/8	3/4	8 1/4	19/32	3621150	2	3623150	137.35	14.377 - 15.164	166.90	147.30	140.70	137.50	134.25	131.50	127.75
-	-	.438	4 3/8	3/4	8 1/4	5/8	3621159	2	3623159	-	15.165 - 15.951	166.90	147.30	140.70	137.50	134.25	131.50	127.75
16.0	.6299	.459	4 3/8	3/4	8 1/4	21/32	3621160	2	3623160	138.70	15.952 - 16.739	168.20	148.60	142.10	138.90	135.55	132.90	129.10
17.0	.6693	.481	4 3/8	7/8	8 1/4	11/16	3621170	2	3623170	139.85	16.740 - 17.551	169.30	149.80	143.20	140.00	136.70	134.00	130.20
18.0	.7087	.503	4 3/8	7/8	8 1/4	23/32	3621180	2	3623180	139.85	17.552 - 18.339	169.30	149.80	143.20	140.00	136.70	134.00	130.20
19.0	.7480	.525	4 3/8	7/8	8 1/4	3/4	3621190	2	3623190	139.85	18.340 - 19.126	169.30	149.80	143.20	140.00	136.70	134.00	130.20
-	-	.547	4 3/8	7/8	8 1/4	25/32	3621199	2	3623199	-	19.127 - 19.914	172.05	152.50	145.95	142.70	139.40	136.70	132.95
20.0	.7874	.569	4 7/8	7/8	9 1/2	13/16	3621200	3	3623200	146.25	19.915 - 20.726	175.70	156.20	149.60	146.40	143.15	140.40	136.60
21.0	.8268	.591	4 7/8	7/8	9 1/2	27/32	3621210	3	3623210	153.35	20.727 - 21.514	182.90	163.30	156.70	153.50	150.25	147.50	143.80
22.0	.8661	.612	4 7/8	7/8	9 1/2	7/8	3621220	3	3623220	153.35	21.515 - 22.301	182.90	163.30	156.70	153.50	150.25	147.50	143.80
23.0	.9055	.634	4 7/8	7/8	9 1/2	29/32	3621230	3	3623230	154.25	22.302 - 23.089	183.70	164.20	157.60	154.40	151.15	148.40	144.60
-	-	.656	4 7/8	7/8	9 1/2	15/16	3621239	3	3623239	-	23.090 - 23.901	183.70	164.20	157.60	154.40	151.15	148.40	144.60
24.0	.9449	.678	4 7/8	7/8	9 1/2	31/32	3621240	3	3623240	159.45	23.902 - 24.689	189.00	169.40	162.85	159.60	156.35	153.60	149.90
25.0	.9843	.700	4 7/8	7/8	9 1/2	1	3621250	3	3623250	162.30	24.690 - 25.476	191.75	172.20	165.60	162.40	159.15	156.40	152.65
26.0	1.0236	.722	4 7/8	7/8	9 1/2	1 1/32	3621260	3	3623260	163.40	25.477 - 26.264	192.90	173.35	166.75	163.55	160.25	157.55	153.80
27.0	1.0630	.744	4 7/8	7/8	9 1/2	1 1/16	3621270	3	3623270	165.45	26.265 - 27.076	195.00	175.40	168.90	165.60	162.35	159.60	155.90
-	-	.766	4 7/8	1	10 1/2	1 3/32	3621279	4	3623279	-	27.077 - 27.864	220.15	200.55	194.05	190.75	187.50	184.75	181.05
28.0	1.1024	.787	4 7/8	1	10 1/2	1 1/8	3621280	4	3623280	198.70	27.865 - 28.651	228.25	208.65	202.10	198.95	195.60	192.90	189.15
29.0	1.1417	.809	4 7/8	1	10 1/2	1 5/32	3621290	4	3623290	207.00	28.652 - 29.439	236.50	216.95	210.35	207.15	203.90	201.15	197.35
30.0	1.1811	.831	4 7/8	1	10 1/2	1 3/16	3621300	4	3623300	212.65	29.440 - 30.239	242.20	222.60	216.05	212.80	209.55	206.80	203.10
31.0	1.2205	.853	4 7/8	1	10 1/2	1 7/32	3621310	4	3623310	213.40	30.240 - 31.039	242.85	223.35	216.75	213.55	210.30	207.55	203.75
-	-	.875	4 7/8	1	10 1/2	1 1/4	3621319	4	3623319	-	31.040 - 31.826	243.60	224.10	217.50	214.30	211.00	208.30	204.50
32.0	1.2598	.897	4 7/8	1	10 1/2	1 9/32	3621320	4	3623320	228.45	31.827 - 32.614	258.00	238.40	231.80	228.60	225.35	222.60	218.80
33.0	1.2992	.919	4 7/8	1	10 1/2	1 5/16	3621330	4	3623330	234.45	32.615 - 33.401	264.00	244.40	237.80	234.60	231.35	228.60	224.85
34.0	1.3386	.940	4 7/8	1	10 1/2	1 11/32	3621340	4	3623340	239.20	33.402 - 34.214	268.70	249.15	242.55	239.35	236.10	233.35	229.55
35.0	1.3780	.962	4 7/8	1	10 1/2	1 3/8	3621350	4	3623350	244.65	34.215 - 35.001	274.15	254.60	248.05	244.80	241.50	238.80	235.05
-	-	.984	4 7/8	1	10 1/2	1 13/32	3621359	4	3623359	-	35.002 - 35.789	279.50	260.00	253.40	250.20	246.85	244.20	240.40
36.0	1.4173	1.006	4 7/8	1	10 1/2	1 7/16	3621360	4	3623360	256.90	35.790 - 36.601	286.40	266.80	260.30	257.10	253.75	251.10	247.30
37.0	1.4567	1.025	4 7/8	1	10 1/2	1 15/32	3621370	4	3623370	264.15	36.602 - 37.389	293.60	274.10	267.50	264.30	261.05	258.30	254.50
38.0	1.4961	1.050	4 7/8	1	10 1/2	1 1/2	3621380	4	3623380	269.50	37.390 - 38.176	298.95	279.45	272.85	269.65	266.40	263.65	259.85

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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 122)				JOBBER'S LENGTH DRILLS (see page 118)				HARD STEEL DIE DRILLS (see page 126)					
	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	\$34.05	3641618	\$39.55	4 1/4	3600618	\$35.40	3601618	\$41.05	-	-	-	-
	.3125	5/16	2 13/16	3640620	36.20	3641620	42.05	4 1/2	3600620	38.30	3601620	44.50	4 1/2	3670620	3672620	\$55.20
	.3438	11/32	3	3640622	42.15	3641622	48.80	4 3/4	3600622	40.65	3601622	47.35	4 3/4	3670622	3672622	58.75
	.3750	3/8	3 1/8	3640624	43.20	3641624	50.10	5	3600624	43.25	3601624	50.30	5	3670624	3672624	63.20
	.4062	13/32	3 5/16	3640626	51.20	3641626	59.60	5 1/4	3600626	47.05	3601626	54.75	5 1/4	3670626	3672626	74.05
	.4375	7/16	3 7/16	3640628	54.75	3641628	60.75	5 1/2	3600628	51.20	3601628	59.45	5 1/2	3670628	3672628	85.90
	.4688	15/32	3 5/8	3640630	77.90	3641630	90.60	5 3/4	3600630	57.60	3601630	66.65	5 3/4	3670630	3672630	94.30
	.5000	1/2	3 3/4	3640632	74.55	3641632	86.75	6	3600632	70.80	3601632	74.65	6	3670632	3672632	110.65
3/8	.4062	13/32	3 5/16	3640726	51.20	3641726	59.60	5 1/4	3600726	47.05	3601726	54.75	-	-	-	-
	.4375	7/16	3 7/16	3640728	54.75	3641728	60.75	5 1/2	3600728	51.20	3601728	59.45	5 1/2	3670728	3672728	85.90
	.4688	15/32	3 5/8	3640730	77.90	3641730	90.60	5 3/4	3600730	57.60	3601730	66.65	5 3/4	3670730	3672730	94.30
	.5000	1/2	3 3/4	3640732	74.55	3641732	86.75	6	3600732	70.80	3601732	74.65	6	3670732	3672732	110.65
	.5312	17/32	3 7/8	3640734	92.95	3641734	104.70	6 5/8	3600734	92.15	3601734	107.05	6	3670734	3672734	126.90
	.5625	9/16	4	3640736	92.95	3641736	104.70	6 5/8	3600736	93.05	3601736	108.05	6	3670736	3672736	131.25
	.5938	19/32	4 1/8	3640738	106.65	3641738	120.20	7 1/8	3600738	99.95	3601738	115.95	7	3670738	3672738	138.90
	.6250	5/8	4 1/4	3640740	106.65	3641740	120.20	7 1/8	3600740	113.25	3601740	131.25	7	3670740	3672740	143.15
	.6562	21/32	4 1/2	3640742	128.20	3641742	144.60	7 1/8	3600742	115.10	3601742	133.55	7 1/2	3670742	3672742	153.15
	.6875	11/16	4 5/8	3640744	131.55	3641744	148.40	7 5/8	3600744	117.30	3601744	136.10	7 1/2	3670744	3672744	157.30
.7188	23/32	4 3/4	3640746	149.15	3641746	173.20	7 5/8	3600746	138.45	3601746	153.95	8	3670746	3672746	164.80	
.7500	3/4	5	3640748	149.50	3641748	168.45	8	3600748	141.45	3601748	157.15	8	3670748	3672748	169.25	
1/2	.5312	17/32	3 7/8	3640834	92.95	3641834	104.70	6 5/8	3600834	92.15	3601834	107.05	-	-	-	-
	.5625	9/16	4	3640836	92.95	3641836	104.70	6 5/8	3600836	93.05	3601836	108.05	6	3670836	3672836	131.25
	.5938	19/32	4 1/8	3640838	106.65	3641838	120.20	7 1/8	3600838	99.95	3601838	115.95	7	3670838	3672838	138.90
	.6250	5/8	4 1/4	3640840	106.65	3641840	120.20	7 1/8	3600840	113.25	3601840	131.25	7	3670840	3672840	143.15
	.6562	21/32	4 1/2	3640842	128.20	3641842	144.60	7 1/8	3600842	115.10	3601842	133.55	7 1/2	3670842	3672842	153.15
	.6875	11/16	4 5/8	3640844	131.55	3641844	148.40	7 5/8	3600844	117.30	3601844	136.10	7 1/2	3670844	3672844	157.30
	.7188	23/32	4 3/4	3640846	149.15	3641846	173.20	7 5/8	3600846	138.45	3601846	153.95	8	3670846	3672846	164.80
	.7500	3/4	5	3640848	149.50	3641848	168.45	8	3600848	141.45	3601848	157.15	8	3670848	3672848	169.25
	.8125	13/16	5 1/4	3640852	184.85	3641852	208.60	-	-	-	-	-	8	3670852	3672852	303.50
	.8750	7/8	5 1/2	3640856	202.80	3641856	228.60	-	-	-	-	-	8	3670856	3672856	309.80
	.9375	15/16	5 3/4	3640860	217.70	3641860	245.60	-	-	-	-	-	8	3670860	3672860	345.20
1.0000	1	6	3640864	230.00	3641864	259.55	-	-	-	-	-	8	3670864	3672864	366.20	
3/4	.8125	13/16	5 1/4	3640952	184.85	3641952	208.60	-	-	-	-	-	8	3670952	3672952	303.50
	.8750	7/8	5 1/2	3640956	202.80	3641956	228.60	-	-	-	-	-	8	3670956	3672956	309.80
	.9375	15/16	5 3/4	3640960	217.70	3641960	245.60	-	-	-	-	-	8	3670960	3672960	345.20
	1.0000	1	6	3640964	230.00	3641964	259.55	-	-	-	-	-	8	3670964	3672964	366.20
	1.0625	1 1/16	6 1/4	3640968	288.25	3641968	325.00	-	-	-	-	-	-	-	-	-
	1.1250	1 1/8	6 3/8	3640972	320.00	3641972	360.75	-	-	-	-	-	-	-	-	-
	1.1875	1 3/16	6 5/8	3640976	390.50	3641976	437.80	-	-	-	-	-	-	-	-	-
	1.2500	1 1/4	6 3/4	3640980	390.50	3641980	437.80	-	-	-	-	-	-	-	-	-

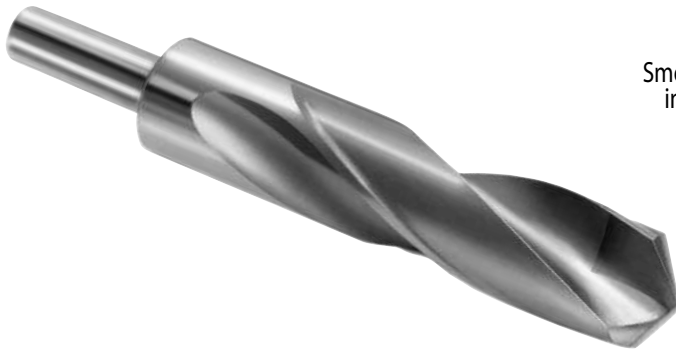
DRILL TOLERANCES & STANDARDS

DRILL DIAMETER RANGE (INCH)	DRILL DIAMETER TOLERANCES	SHANK 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"	-0.0000"/-0.0025"	+5°/-5°	.0020"	
OVER 1/8" THRU 1/4"	+0.0000"/-0.0007"	-0.0005"/-0.0030"	+5°/-5°	.0030"	
OVER 1/4" THRU 1/2"	+0.0000"/-0.0010"	-0.0005"/-0.0045"	+5°/-5°	.0040"	
OVER 1/2" THRU 1"	+0.0000"/-0.0012"	-0.0005"/-0.0030"	+3°/-3°	.0050"	
OVER 1" THRU 1 1/2"	+0.0000"/-0.0015"	-0.0005"/-0.0030"	+3°/-3°	.0060"	

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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 138.

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	\$56.55	361832	\$65.00
.5312	17/32	3 1/8	6	361634	82.75	361834	95.10
.5625	9/16	3 1/8	6	361636	85.80	361836	98.60
.5938	19/32	3 1/8	6	361638	89.20	361838	102.55
.6250	5/8	3 1/8	6	361640	99.05	361840	113.90
.6562	21/32	3 1/8	6	361642	107.35	361842	123.45
.6875	11/16	3 1/8	6	361644	111.60	361844	128.35
.7188	23/32	3 1/8	6	361646	115.75	361846	133.10
.7500	3/4	3 1/8	6	361648	121.30	361848	139.50
.7812	25/32	3 1/8	6	361650	133.80	361850	153.80
.8125	13/16	3 1/8	6	361652	134.10	361852	154.20
.8438	27/32	3 1/8	6	361654	134.10	361854	154.20
.8750	7/8	3 1/8	6	361656	139.40	361856	160.35

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	\$142.85	361858	\$164.30
.9375	15/16	3 1/8	6	361660	144.25	361860	165.90
.9688	31/32	3 1/8	6	361662	149.15	361862	171.50
1.0000	1	3 1/8	6	361664	152.35	361864	175.20
1.0312	1 1/32	3 1/8	6	361666	147.05	361866	169.10
1.0625	1 1/16	3 1/8	6	361668	159.45	361868	183.35
1.0938	1 3/32	3 1/8	6	361670	163.25	361870	187.75
1.1250	1 1/8	3 1/8	6	361672	166.45	361872	191.35
1.1562	1 5/32	3 1/8	6	361674	202.05	361874	232.30
1.1875	1 3/16	3 1/8	6	361676	205.70	361876	236.55
1.2188	1 7/32	3 1/8	6	361678	216.00	361878	248.40
1.2500	1 1/4	3 1/8	6	361680	197.20	361880	226.85
-	-	-	-	-	-	-	-

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	\$87.55
.3750	3/8	1 1/8	5	367724	367824	367924	102.25
.5000	1/2	1 1/2	6	367732	367832	367932	137.50
.6250	5/8	1 5/8	7	367740	367840	367940	199.15
.7500	3/4	1 7/8	8	367748	367848	367948	231.00
1.0000	1	2 1/4	8	367764	367864	367964	306.15

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	\$83.25
.3750	3/8	1 1/8	3 1/8	364724	364824	364924	97.15
.5000	1/2	1 1/2	3 3/4	364732	364832	364932	130.65
.6250	5/8	1 5/8	4 1/4	364740	364840	364940	189.20
.7500	3/4	1 7/8	5	364748	364848	364948	219.50
1.0000	1	2 1/4	6	364764	364864	364964	290.85

SINGLE POINT TOOLS WITH PREMIUM CARBIDE GRADE

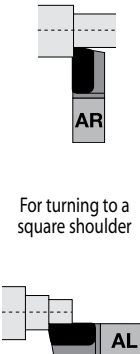
TYPE 3980 - SILVER SHANK 883 / PREMIUM C2 CARBIDE GRADE

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



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	\$12.80	393AR04	\$9.40	1/4	1/4	2	12
AR-5	398AR05	11.30	393AR05	9.95	5/16	5/16	2 1/4	12
AR-6	398AR06	11.55	393AR06	10.15	3/8	3/8	2 1/2	12
AR-7	398AR07	12.40	393AR07	11.00	7/16	7/16	3	12
AR-8	398AR08	10.55	393AR08	10.55	1/2	1/2	3 1/2	12
AR-10	398AR10	15.80	393AR10	14.65	5/8	5/8	4	12
AR-12	398AR12	20.30	393AR12	18.15	3/4	3/4	4 1/2	12
AR-16	398AR16	37.15	393AR16	36.20	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



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

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



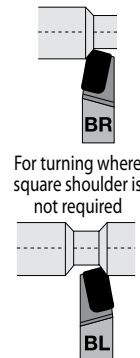
0° SIDE CUTTING EDGE ANGLE
For machining to a square shoulder.

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	\$12.80	393AL04	\$9.40	1/4	1/4	2	12
AL-5	398AL05	11.30	393AL05	9.95	5/16	5/16	2 1/4	12
AL-6	398AL06	11.55	393AL06	10.15	3/8	3/8	2 1/2	12
AL-7	398AL07	12.40	393AL07	11.00	7/16	7/16	3	12
AL-8	398AL08	10.55	393AL08	10.55	1/2	1/2	3 1/2	12
AL-10	398AL10	15.00	393AL10	14.65	5/8	5/8	4	12
AL-12	398AL12	19.35	393AL12	19.15	3/4	3/4	4 1/2	12
AL-16	398AL16	37.65	393AL16	37.65	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



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	\$12.80	393BR04	\$9.40	1/4	1/4	2	12
BR-5	398BR05	11.30	393BR05	9.95	5/16	5/16	2 1/4	12
BR-6	398BR06	11.55	393BR06	10.15	3/8	3/8	2 1/2	12
BR-7	398BR07	12.40	393BR07	11.00	7/16	7/16	3	12
BR-8	398BR08	10.55	393BR08	10.55	1/2	1/2	3 1/2	12
BR-10	398BR10	15.80	393BR10	14.65	5/8	5/8	4	12
BR-12	398BR12	20.30	393BR12	18.15	3/4	3/4	4 1/2	12
BR-16	398BR16	37.15	393BR16	36.20	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



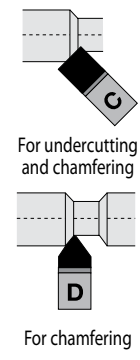
15° SIDE CUTTING EDGE ANGLE
For interrupted or irregular cuts.

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	\$12.80	393BL04	\$9.40	1/4	1/4	2	12
BL-5	398BL05	11.30	393BL05	9.95	5/16	5/16	2 1/4	12
BL-6	398BL06	11.55	393BL06	10.15	3/8	3/8	2 1/2	12
BL-7	398BL07	12.40	393BL07	11.00	7/16	7/16	3	12
BL-8	398BL08	10.55	393BL08	10.55	1/2	1/2	3 1/2	12
BL-10	398BL10	15.00	393BL10	14.65	5/8	5/8	4	12
BL-12	398BL12	19.35	393BL12	19.15	3/4	3/4	4 1/2	12
BL-16	398BL16	37.65	393BL16	37.65	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



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	\$8.40	393C04	\$8.40	1/4	1/4	2	12
C-5	398C05	9.30	393C05	9.00	5/16	5/16	2 1/4	12
C-6	398C06	12.00	393C06	9.95	3/8	3/8	2 1/2	12
C-7	398C07	9.15	393C07	12.70	7/16	7/16	3	12
C-8	398C08	14.80	393C08	13.70	1/2	1/2	3 1/2	12
C-10	398C10	16.65	393C10	18.15	5/8	5/8	4	12
C-12	398C12	22.95	393C12	26.05	3/4	3/4	4 1/2	12
C-16	398C16	47.60	393C16	45.80	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



40° SIDE CUTTING EDGE ANGLE
80° pointed nose.

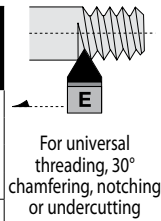
TOOL TYPE & SIZE NO.	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION			STD. PKG. QTY.
	EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L	
D-4	398D04	\$7.85	393D04	\$7.85	1/4	1/4	2	12
D-5	398D05	9.10	393D05	9.40	5/16	5/16	2 1/4	12
D-6	398D06	9.30	393D06	10.00	3/8	3/8	2 1/2	12
D-7	398D07	12.70	393D07	15.40	7/16	7/16	3	12
D-8	398D08	12.15	393D08	12.95	1/2	1/2	3 1/2	12
D-10	398D10	17.10	393D10	18.85	5/8	5/8	4	12
D-12	398D12	24.40	393D12	21.50	3/4	3/4	4 1/2	12
D-16	398D16	36.25	393D16	37.35	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	\$7.85	393E04	\$7.85	1/4	1/4	2	12
E-5	398E05	8.55	393E05	8.55	3/16	3/16	2 1/4	12
E-6	398E06	8.95	393E06	8.70	3/8	3/8	2 1/2	12
E-7	398E07	13.80	393E07	16.55	7/16	7/16	3	12
E-8	398E08	20.40	393E08	10.95	1/2	1/2	3 1/2	12
E-10	398E10	16.95	393E10	15.30	5/8	5/8	4	12
E-12	398E12	21.10	393E12	21.35	3/4	3/4	4 1/2	12
E-16	398E16	36.95	393E16	35.55	1	1	7	6

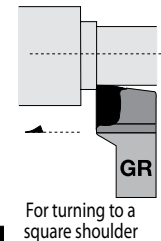


60° INCLUDED ANGLE
30° SIDE CUTTING EDGE ANGLE
For threading, chamfering, notching, or undercutting.



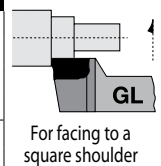
0° SIDE CUTTING EDGE ANGLE
Offset for facing or turning to a square shoulder or close to chuck jaws.

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	\$14.80	393GR08	\$14.00	1/2	1/2	3 1/2	12
GR-10	398GR10	22.20	393GR10	20.25	5/8	5/8	4	12
GR-12	398GR12	28.50	393GR12	25.20	3/4	3/4	4 1/2	6
GR-16	398GR16	60.05	393GR16	60.45	1	1	7	4
GR-20	398GR20	CALL	393GR20	CALL	1 1/4	1 1/4	8	1
GR-44	398GR44	CALL	393GR44	CALL	1/2	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	\$14.70	393GL08	\$14.50	1/2	1/2	3 1/2	12
GL-10	398GL10	21.25	393GL10	20.25	5/8	5/8	4	12
GL-12	398GL12	27.40	393GL12	27.20	3/4	3/4	4 1/2	6
GL-16	398GL16	58.20	393GL16	60.45	1	1	7	4
GL-20	398GL20	CALL	393GL20	CALL	1 1/4	1 1/4	8	1
GL-44	398GL44	CALL	393GL44	CALL	1/2	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.	CUT OFF WIDTH	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION		
		EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L
CT-111	1/8	398CT01	\$18.95	393CT01	\$19.70	1/2	1	5
CT-122	3/16	398CT02	19.55	393CT02	20.15	1/2	1	5
CT-121	1/4	398CT03	20.25	393CT03	20.85	1/2	1	5
CT-120	5/16	398CT04	20.15	393CT04	20.85	1/2	1	5
CT-130	3/8	398CT13	24.40	393CT13	25.95	5/8	1 1/4	5
CT-140	3/8	398CT14	27.10	393CT14	28.05	3/4	1 1/2	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.

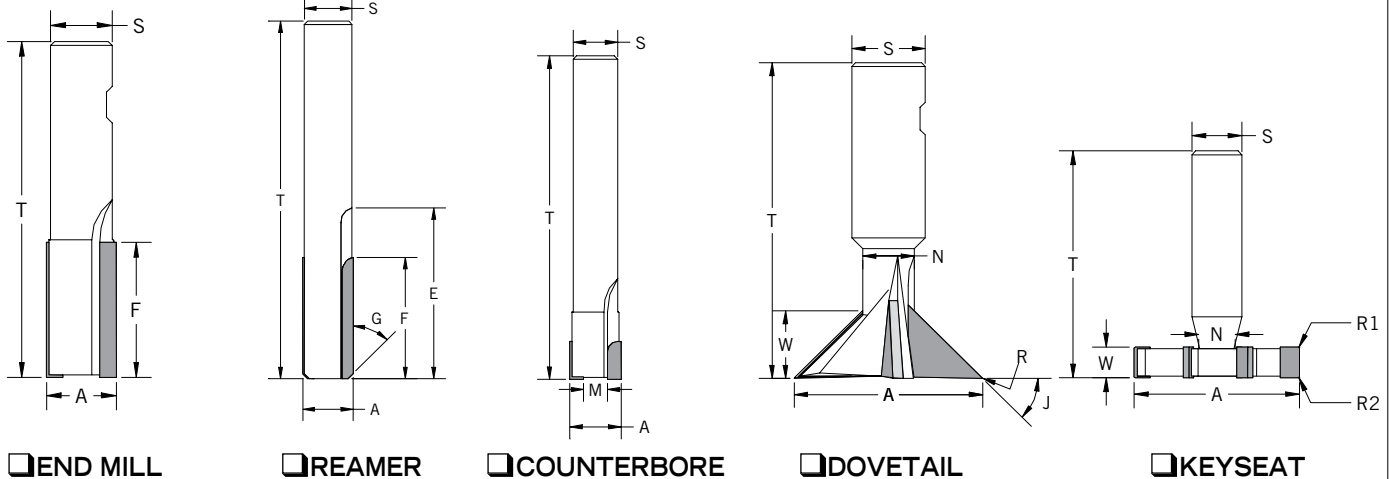
TOOL TYPE & SIZE NO.	CUT OFF WIDTH	883 / PREMIUM C2*		370 / PREMIUM C5-C6*		SHANK DIMENSION		
		EDP NO.	PRICE EACH	EDP NO.	PRICE EACH	W	H	L
CTL-111	1/8	398CL01	\$18.95	393CL01	\$19.70	1/2	1	5
CTL-122	3/16	398CL02	19.55	393CL02	20.15	1/2	1	5
CTL-121	1/4	398CL03	20.25	393CL03	20.85	1/2	1	5
CTL-120	5/16	398CL04	20.15	393CL04	20.85	1/2	1	5
CTL-130	3/8	398CL13	24.40	393CL13	25.95	5/8	1 1/4	5
CTL-140	3/8	398CL14	27.10	393CL14	28.05	3/4	1 1/2	6

CARBIDE TIPPED SPECIALS QUOTE FORM - FAX TO 941-739-2827

LEXINGTON MANUFACTURES QUALITY SPECIALS TO MEET OUR CUSTOMERS' NEEDS.
BELOW IS INFORMATION NEEDED TO QUOTE SPECIALS.

Name _____ Phone _____
 Company _____ Fax _____
 Full Address _____
 Material Being Cut _____ Quantities _____

CARBIDE TIPPED - SHANK TYPE TOOLS



END MILL

REAMER

COUNTERBORE

DOVETAILED

KEYSEAT

BODY OF TOOL

T= _____ Overall Length S= _____ Shank Diameter A= _____ Major Diameter

FLUTES

E= _____ Flute Length F= _____ Carbide Length

G= _____ ° Chamfer Angle

Straight Flutes

Right Hand Cutting

Left Hand Cutting

Number of Flutes _____

Right Hand Spiral _____ °

Left Hand Spiral _____ °

IF PILOTED

Head Diam. _____

Head Length _____

M= Min. Cutting Diam. _____

IF STEP REAMER

(Also see pages 104-106) Minor Diam. _____ Step Length _____ Step Angle _____ °

IF KEYSEAT

W= _____ Width

Straight Tooth

R1= _____ Radius/Chamfer

N= _____ Neck Diameter

Staggered Tooth

R2= _____ Radius/Chamfer

IF DOVETAILED

N= _____ Neck Diam. J= _____ ° Angle R= _____ Radius W= _____ Width

CARBIDE TIPPED - ARBOR TYPE TOOLS

D= _____ Cutter Diameter

W= _____ Cutter Width

A= _____ Arbor Hole Diam.

N= _____ # of Teeth

H= _____ Hub Diameter

K= _____ Keyway Size

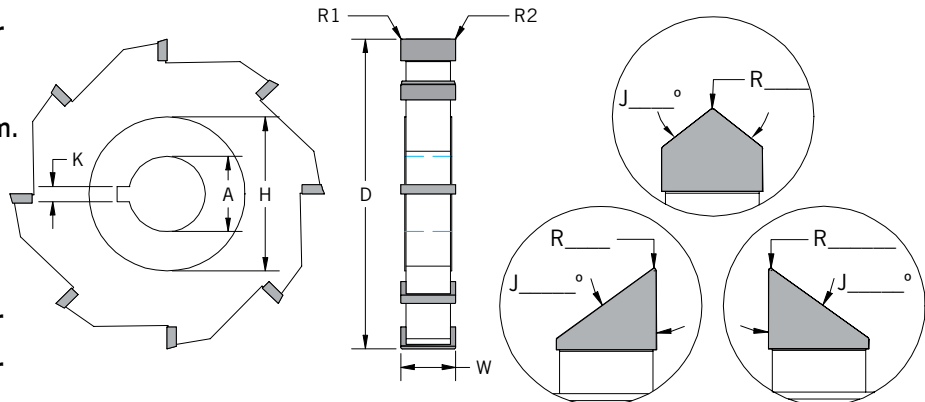
R1= _____ Radius/Chamfer

R2= _____ Radius/Chamfer

Straight Tooth

Straight Stagger

Herringbone Stagger



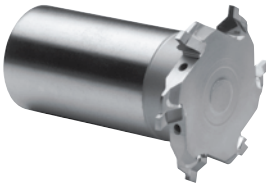
MILLING CUTTER

SLITTING SAW

ANGLE CUTTER

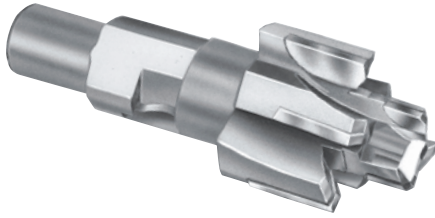
(Fill in "J" & "R")

DESIGN AND MANUFACTURING OF SPECIAL CUTTING TOOLS



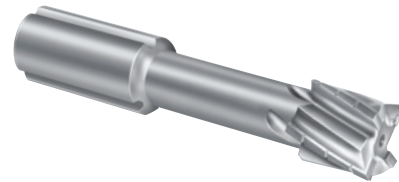
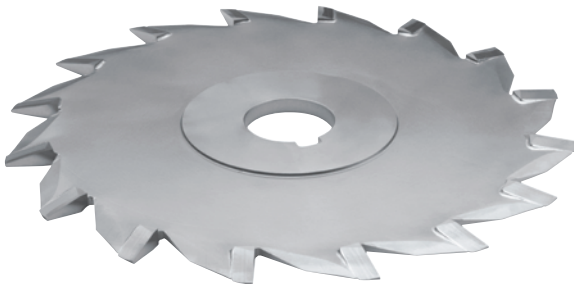
QUOTE FROM PRINT

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			DOVETAIL CUTTERS		
3300		25	3435	101	100	3488		75	3616		139	3734		11
3302		26	3435EL		113	3490		107	3618		139	3735		11
3304		26	3436		96	Semi Finished		65	3620	135	134	3736		11
3305		26	3437		97	F & S Reamers		55	3621	137	136	3737		11
3306		26	3438		96	COUNTERBORES			3622	135	134	CORNER ROUNDING		
3307		26	3439		97	3500		41	3623	137	136	3740		23
3308		25	3440	87	86	3510	39	38	3630	121	120	3741		23
3310		25	3442		94	3511	39	38	3631	121	120	DOUBLE ANGLE CUTTERS		
3312		23	3442ST		111	3512	35	34	3640	123	122, 138	3746		10
3314		23	3442EL		114	3513	33	33	3641	123	122, 138	3747		10
3318		23	3443		94	3514	35	34	3647		139	3748		10
3320		27	3443ST		111	3515	33	33	3648		139	3749		10
3322		24	3443EL		114	3516	37	36	3649		139	3750		21
3323		24	3444		94	3518	37	36	3650	131	130	3752		21
3325		27	3444ST		111	3522		40	3652	131	130	3754		21
3327		27	3444EL		114	F & S Counterbore		32	3654	133	132	PORT CONTOUR CUTTERS		
3337		24	3446		108	SHELL MILLS			3655	133	132	3780		28
3350		25	3447		108	3530		21	3656		132	3781		28
3353		24	3450	69	68-72	3531		21	3657		132	3782		31
3355		24	3452	77	76	3532		21	3658		129	3783		31
3375		27	3453		93	FACE MILLS			3660	125	124	3784		31
REAMERS			3454		93	3536		22	3661	125	124	3785		31
3400	60	58-64	3455		93	3537		22	3664		129	3786	28	
3401		56	3457	91	90	3538		22	3665		129	3787	28	
3402	67	66	3457ST		110	MILLING CUTTERS			3668		124	3790	30	
3403		108	3457EL		113	3540		20	3670	125	126, 138	3791	30	
3407	89	88	3458	91	90	3541		20	3671		126	3792		29
3408	89	88	3458ST		110	3542		20	3672	125	126, 138	3793		29
3409	89	88	3458EL		113	3543		20	3673		126	3794		30
3410	80	78	3459	91	90	SLITTING SAWS			3674		127	3795		30
3411		105	3459ST		110	3550		14	3675		127	SOLID CARBIDE		
3411EL		114	3459EL		113	3551		15	3677		139	3800		44, 46
3412		81	3461		99	3552		14	3678		139	3801		44, 46
3413		105	3462		99	3553		15	3679		139	3802		46
3413EL		114	3463		99	3554		14	F & S Drills		116	3803		46
3414	103	102	3464		98	3556		15	KEYSEAT CUTTERS			3804	50	50-54
3415		105	3465	83	82	3558		14	3700		6	3806		48
3415EL		114	3466		98	3559		15-19	3701		7	3807		48
3416	101	100	3467	85	84	F & S Mills & Saws		13	3702		8	3808		48
3416EL		113	3468		98	COUNTERSINKS			3703		9	3809		48
3417		104	3472		92	3561		22	3704		5	3810		45, 47
3418		104	3473		92	3563		22	F & S Keyseats		12	3811		45, 47
3419		104	3474		92	COUNTERBORES			45° ANGLE CUTTERS			3812		47
3420	80	79	3476		57	3573		42	3714		21	3813		47
3422		81	3476 Set		57	3574		42	3716		21	3816		49
3424	103	102	3477		57	3575		43	RADIUS CUTTERS			3817		49
3426	101	100	3478		57	3576		43	3718		10	3820		45, 47
3426EL		113	3479		57	COUNTERSINKS			3719		10	3821		45, 47
3427		106	3480	73	74-75	3581		22	T-SLOT CUTTERS			3822		47
3427EL		115	3482		95	3583		22	3720		11	3823		47
3428		106	3482ST		112	3584		22	3721		11	3828		49
3428EL		115	3482EL		115	3585		22	60° ANGLE CUTTERS			3829		49
3429		106	3483		95	3590		22	3724		21	3860		117
3429EL		115	3483ST		112	3591		22	3726		21	3893		127
3430	87	86	3483EL		115	DRILLS			CHAMFER CUTTERS			SINGLE POINTS		
3431		109	3484		95	3600	119	118, 138	3730		10	3930		140-141
3432		96	3484ST		112	3601	119	118, 138	3731		10	3980		140-141
3433		97	3484EL		115	3610		128	3732		10	Specials Quote Form 142		
3434	103	102	3486		75	3611		128	3733		10	Coating Guide 145		

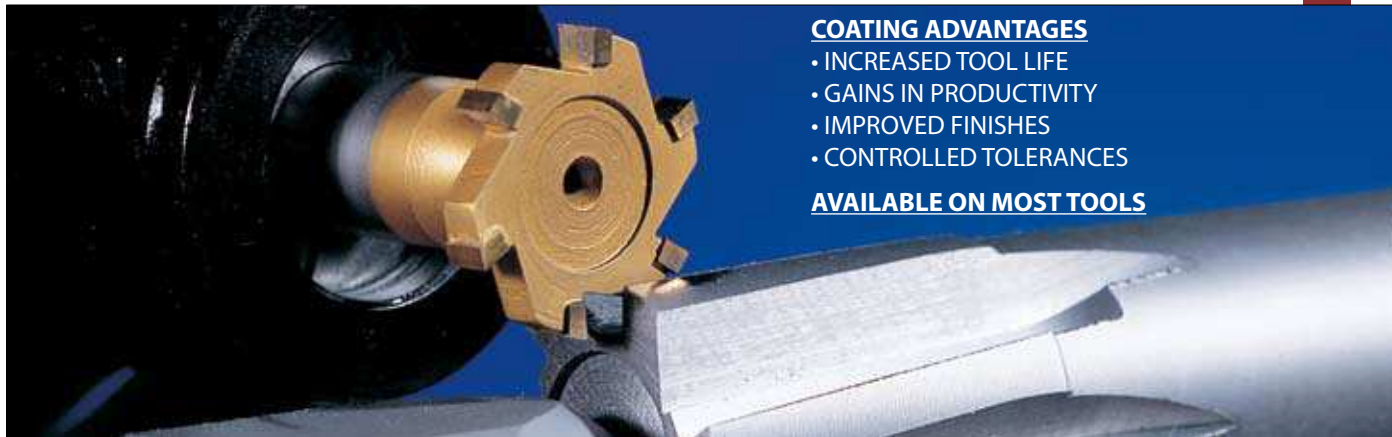
COATINGS FOR LEXINGTON CARBIDE TIPPED TOOLS

TiN - TITANIUM NITRIDE	
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.	
TECHNICAL DATA	
Hardness (Vickers):	2300
Max. Service Temperature:	525° C (975° F)
Friction Coefficient:	.50
Thickness	2-4 microns
Surface Roughness (R _a μM):	.20

TiCN - TITANIUM CARBONITRIDE	
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.	
TECHNICAL DATA	
Hardness (Vickers):	3000
Max. Service Temperature:	400° C (750° F)
Friction Coefficient:	.40
Thickness	2-4 microns
Surface Roughness (R _a μM):	.17

AlTiN - ALUM. TITANIUM NITRIDE	
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.	
TECHNICAL DATA	
Hardness (Vickers):	3600
Max. Service Temperature:	750° C (1380° F)
Friction Coefficient:	.60
Thickness	2-4 microns
Surface Roughness (R _a μM):	.30

ZrN - ZIRCONIUM NITRIDE	
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.	
TECHNICAL DATA	
Hardness (Vickers):	2500
Max. Service Temperature:	600° C (1110° F)
Friction Coefficient:	.50
Thickness	2-4 microns
Surface Roughness (R _a μM):	.20



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	*

*High Temperature Alloys should not be machined dry.

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.

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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