



# COMPLETE METALWORKING SOLUTIONS

(800) 991-4225

www.ahbinc.com

ISO Certified

customerservice@ahbinc.com

**YU-RM21** AMERICA

BEST VALUE IN THE WORLD OF CUTTING TOOLS



# **YG** YG-1 CO., LTD.

## YG-1 USA

730 Corporate Woods Parkway, Vernon Hills, IL 60061 U.S.A.

## YG-1 CANADA

3375 North Service Road, Unit A8, Burlington, ON, CANADA, L7N 3G2

## HEAD OFFICE

13-40, Songdogwahak-ro 16beon-gil, Yeonsu-gu, Incheon 21984, South Korea

YG-1 Global head office is relocating from December 2020 to a new address as above;

**Phone: +82-32-526-0909**

**E-mail: yg1@yg1.kr**

**www.yg1.kr**

The information is provided for reference only. Tool specifications are subject to change without prior notice.

Although we endeavor to supply accurate and timely information, there can be no guarantee to cover every particular application.  
YG-1 or publishers are not liable for any damage for use of the information.



Search 'YG-1' on social media outlets

YG1YURM21020001



# **YG** REAMERS

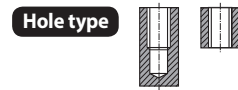
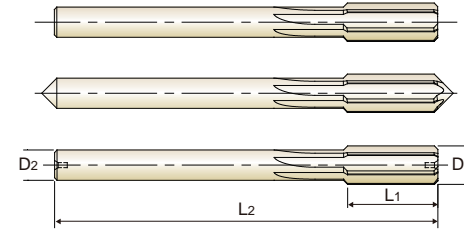
***Straight Shank Chucking Reamers - Straight Flute***  
*Precision reamers for a variety of materials, applications and sizes  
that ensure close hole tolerance and excellent surface finish*



## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.																																																																						
	Fractional	Letter	Wire Gauge	Decimal																																																																											
1/64	1/64	K6101	#80	.0135	.0135	3/8	3/4	2	K610200135																																																																						
										#79	.0145	.0145	3/8	3/4	2	K610200145																																																															
																	#78	.0156	.0156	3/8	3/4	2	K610100156																																																								
																								#77	.0160	.0160	3/8	7/8	2	K610200160																																																	
																															#76	.0180	.0180	3/8	7/8	2	K610200180																																										
																																						#75	.0200	.0200	3/8	7/8	2	K610200200																																			
																																													#74	.0210	.0210	1/2	1	3	K610200210																												
																																																				#73	.0225	.0225	1/2	1	3	K610200225																					
																																																											#72	.0240	.0240	1/2	1-1/8	3	K610200240														
																																																																		#71	.0250	.0250	1/2	1-1/8	3	K610200250							
																																																																									#70	.0260	.0260	1/2	1-1/4	3	K610200260
#68	.0292	.0292	1/2	1-3/8	3	K610200292																																																																									
							#67	.0310	.0310	1/2	1-3/8	3	K610200310																																																																		
														#66	.0312	.0312	1/2	1-3/8	3	K610100312																																																											
																					#65	.0320	.0320	1/2	1-3/8	3	K610200320																																																				
																												#64	.0330	.0330	1/2	1-3/8	3	K610200330																																													
																																			#63	.0350	.0350	1/2	1-1/2	3	K610200350																																						
																																										#62	.0360	.0360	1/2	1-1/2	3	K610200360																															
																																																	#61	.0370	.0370	1/2	1-1/2	3	K610200370																								
																																																								#60	.0380	.0380	1/2	1-1/2	3	K610200380																	
																																																															1.00	.0390	.0390	1/2	1-1/2	3	K610200390										
																																																																						.0394	.0394	1/2	2-1/2	4	K610600394				
																																																																												.0400	.0390	1/2	2-1/2

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

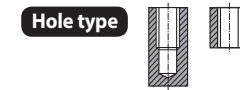
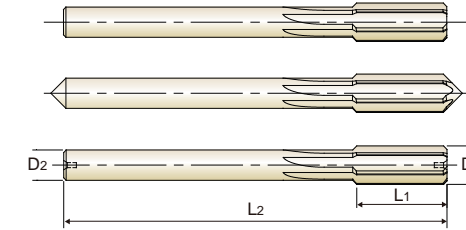
  

ISO Material Description	N										S						H					
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.																																																																									
	Fractional	Letter	Wire Gauge	Decimal																																																																														
1.50	3/64	K6101	#59	.0410	.0390	1/2	2-1/2	4	K610200410																																																																									
										#58	.0420	.0390	1/2	2-1/2	4	K610200420																																																																		
																	#57	.0430	.0390	1/2	2-1/2	4	K610200430																																																											
																								#56	.0465	.0455	1/2	2-1/2	4	K610200465																																																				
																															#55	.0520	.0510	1/2	2-1/2	4	K610200520																																													
																																						#54	.0550	.0510	1/2	2-1/2	4	K610200550																																						
																																													2.00	1/16	K6101	#53	.0595	.0585	1/2	2-1/2	4	K610200595																												
																																																							#52	.0625	.0585	1/2	2-1/2	4	K610100625																					
																																																														#51	.0635	.0585	1/2	2-1/2	4	K610200635														
																																																																					#50	.0670	.0660	3/4	3	4	K610200670							
																																																																												#49	.0700	.0660	3/4	3	4	K610200700
#47	.0760	.0720	3/4	3	4	K610100760																																																																												
							2.00	5/64	K6101	#47	.0785	.0720	3/4	3	4	K610200785																																																																		
																	#46	.0787	.0720	3/4	3	4	K610600787																																																											
																								#45	.0810	.0771	3/4	3	4	K610200810																																																				
																															#44	.0820	.0771	3/4	3	4	K610200820																																													
																																						#43	.0860	.0810	3/4	3	4	K610200860																																						
																																													#42	.0890	.0810	3/4	3	4	K610200890																															
																																																				3/32	K6101	#42	.0935	.0880	3/4	3	4	K610200935																						
																																																													.0938	.0880	3/4	3	4	K610100938																

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

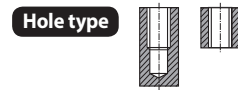
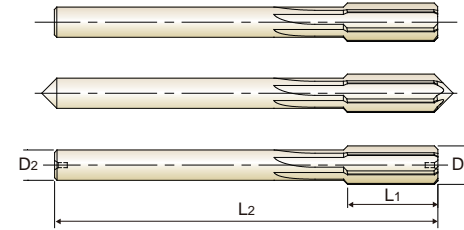
ISO Material Description	N										S						H					
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	



## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.	
	Fractional	Letter	Wire Gauge	Decimal						
2.50	7/64		#41	.0960	.0928	7/8	3-1/2	4	K610200960	
			#40	.0980	.0928	7/8	3-1/2	4	K610200980	
			#39	.0984	.0928	7/8	3-1/2	4	K610600984	
			#38	.0995	.0928	7/8	3-1/2	4	K610200995	
			#37	.1015	.0950	7/8	3-1/2	4	K610201015	
			#36	.1040	.0950	7/8	3-1/2	4	K610201040	
			#36	.1065	.1030	7/8	3-1/2	4	K610201065	
			#35	.1094	.1030	7/8	3-1/2	4	K610101094	
			#35	.1100	.1030	7/8	3-1/2	4	K610201100	
			#34	.1110	.1055	7/8	3-1/2	4	K610201110	
3.00			#33	.1130	.1055	7/8	3-1/2	4	K610201130	
			#32	.1160	.1120	7/8	3-1/2	4	K610201160	
			#31	.1181	.1120	7/8	3-1/2	4	K610601181	
			#31	.1200	.1120	7/8	3-1/2	4	K610201200	
			0.1240 U/S		.1240	.1190	7/8	3-1/2	4	K610501240
			1/8		.1250	.1190	7/8	3-1/2	4	K610101250
			0.1260 O/S		.1260	.1190	7/8	3-1/2	4	K610501260
			#30	.1285	.1190	7/8	3-1/2	4	K610201285	
			#29	.1360	.1275	1	4	4	K610201360	
			#28	.1378	.1350	1	4	4	K610601378	
3.50	9/64		#28	.1405	.1350	1	4	4	K610201405	
			#27	.1406	.1350	1	4	4	K610101406	
			#27	.1440	.1350	1	4	4	K610201440	
			#26	.1470	.1430	1	4	4	K610201470	

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

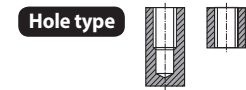
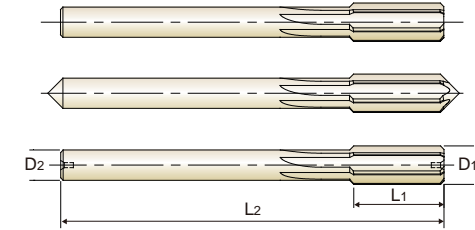
◎ : Excellent ○ : Good

ISO Material Description	P										M					K																									
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron																		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.	
	Fractional	Letter	Wire Gauge	Decimal						
4.00	5/32		#25	.1495	.1430	1	4	4	K610201495	
			#24	.1520	.1460	1	4	4	K610201520	
			#23	.1540	.1460	1	4	4	K610201540	
			#22	.1562	.1510	1	4	4	K610101562	
			#22	.1570	.1510	1	4	6	K610201570	
			#21	.1575	.1530	1	4	6	K610601575	
			#21	.1590	.1530	1-1/8	4-1/2	6	K610201590	
			#20	.1610	.1530	1-1/8	4-1/2	6	K610201610	
			#19	.1660	.1595	1-1/8	4-1/2	6	K610201660	
			#18	.1695	.1595	1-1/8	4-1/2	6	K610201695	
4.50	11/64		#17	.1719	.1645	1-1/8	4-1/2	6	K610101719	
			#17	.1730	.1645	1-1/8	4-1/2	6	K610201730	
			#16	.1770	.1704	1-1/8	4-1/2	6	K610201770	
			#15	.1772	.1704	1-1/8	4-1/2	6	K610601772	
			#15	.1800	.1755	1-1/8	4-1/2	6	K610201800	
			#14	.1820	.1755	1-1/8	4-1/2	6	K610201820	
			#13	.1850	.1805	1-1/8	4-1/2	6	K610201850	
			0.1865 U/S		.1865	.1805	1-1/8	4-1/2	6	K610501865
			3/16		.1875	.1805	1-1/8	4-1/2	6	K610101875
			0.1885 O/S		.1885	.1805	1-1/8	4-1/2	6	K610501885
			#12	.1890	.1805	1-1/8	4-1/2	6	K610201890	
			#11	.1910	.1860	1-1/4	5	6	K610201910	
			#10	.1935	.1860	1-1/4	5	6	K610201935	
			#9	.1960	.1895	1-1/4	5	6	K610201960	

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

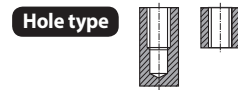
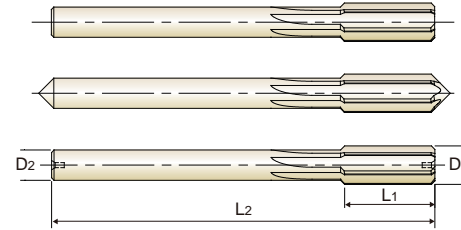
◎ : Excellent ○ : Good

ISO Material Description	P										M					K																									
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron																		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
5.00	13/64	A	#8	.1969	.1895	1-1/4	5	6	K610601969
			#7	.2010	.1945	1-1/4	5	6	K610202010
			#6	.2031	.1945	1-1/4	5	6	K610102031
			#5	.2040	.1945	1-1/4	5	6	K610202040
			#4	.2055	.2016	1-1/4	5	6	K610202055
			#3	.2090	.2016	1-1/4	5	6	K610202090
5.50	7/32	A	#3	.2130	.2075	1-1/4	5	6	K610202130
				.2165	.2075	1-1/4	5	6	K610602165
				.2188	.2075	1-1/4	5	6	K610102188
			#2	.2210	.2173	1-1/2	6	6	K610202210
			#1	.2280	.2173	1-1/2	6	6	K610202280
				.2340	.2265	1-1/2	6	6	K610302340
6.00	15/64	B		.2344	.2265	1-1/2	6	6	K610102344
				.2362	.2265	1-1/2	6	6	K610602362
				.2380	.2329	1-1/2	6	6	K610302380
				.2420	.2329	1-1/2	6	6	K610302420
				.2460	.2329	1-1/2	6	6	K610302460
				.2490	.2405	1-1/2	6	6	K610502490
6.50	0.2510 O/S	F		.2500	.2405	1-1/2	6	6	K610102500
				.2510	.2405	1-1/2	6	6	K610502510
				.2559	.2405	1-1/2	6	6	K610602559
				.2570	.2485	1-1/2	6	6	K610302570
				.2610	.2485	1-1/2	6	6	K610302610

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

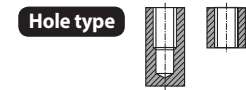
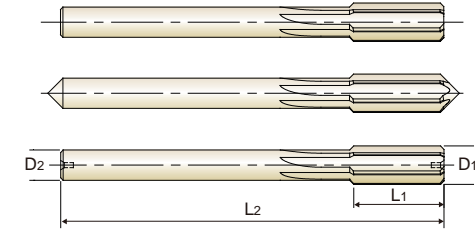
◎ : Excellent ○ : Good

ISO Material Description	P										M					K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25					
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
7.00	17/64	H		.2656	.2485	1-1/2	6	6	K610102656
				.2660	.2485	1-1/2	6	6	K610302660
				.2720	.2485	1-1/2	6	6	K610302720
				.2756	.2485	1-1/2	6	6	K610602756
				.2770	.2485	1-1/2	6	6	K610302770
				.2810	.2485	1-1/2	6	6	K610302810
7.50	9/32	I		.2812	.2485	1-1/2	6	6	K610102812
				.2900	.2792	1-1/2	6	6	K610302900
				.2950	.2792	1-1/2	6	6	K610302950
				.2953	.2792	1-1/2	6	6	K610602953
				.2969	.2792	1-1/2	6	6	K610102969
				.3020	.2792	1-1/2	6	6	K610303020
8.00	19/64	J		.3115	.2792	1-1/2	6	6	K610503115
				.3125	.2792	1-1/2	6	6	K610103125
				.3135	.2792	1-1/2	6	6	K610503135
				.3150	.2792	1-1/2	6	6	K610603150
				.3160	.2792	1-1/2	6	6	K610303160
				.3230	.2792	1-1/2	6	6	K610303230
8.50	21/64	K		.3281	.2792	1-1/2	6	6	K610103281
				.3320	.2792	1-1/2	6	6	K610303320
				.3346	.2792	1-1/2	6	6	K610603346
				.3390	.2792	1-1/2	6	6	K610303390
				.3438	.2792	1-1/2	6	6	K610103438
				.3480	.3105	1-3/4	7	6	K610303480

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

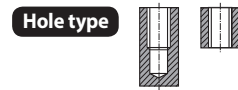
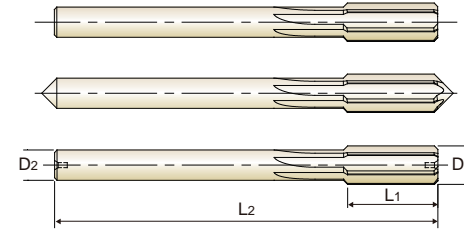
◎ : Excellent ○ : Good

ISO Material Description	P										M					K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25					
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb

HSS 45° P40~41

Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
9.00				.3543	.3105	1-3/4	7	6	K610603543
		T		.3580	.3105	1-3/4	7	6	K610303580
	23/64			.3594	.3105	1-3/4	7	6	K610103594
		U		.3680	.3105	1-3/4	7	6	K610303680
	0.3740 U/S			.3740	.3105	1-3/4	7	6	K610503740
	3/8			.3750	.3105	1-3/4	7	6	K610103750
	0.3760 O/S			.3760	.3105	1-3/4	7	6	K610503760
		V		.3770	.3105	1-3/4	7	6	K610303770
		W		.3860	.3105	1-3/4	7	6	K610303860
				.3906	.3105	1-3/4	7	6	K610103906
10.00			.3937	.3105	1-3/4	7	6	K610603937	
		X		.3970	.3105	1-3/4	7	6	K610303970
		Y		.4040	.3105	1-3/4	7	6	K610304040
	13/32			.4062	.3105	1-3/4	7	6	K610104062
10.50		Z		.4130	.3730	1-3/4	7	6	K610304130
				.4134	.3730	1-3/4	7	6	K610604134
	27/64			.4219	.3730	1-3/4	7	6	K610104219
11.00			.4331	.3730	1-3/4	7	6	K610604331	
	0.4365 U/S			.4365	.3730	1-3/4	7	6	K610504365
	7/16			.4375	.3730	1-3/4	7	6	K610104375
11.50	0.4385 O/S			.4385	.3730	1-3/4	7	6	K610504385
				.4528	.3730	1-3/4	7	6	K610604528
	29/64			.4531	.3730	1-3/4	7	6	K610104531
			.4688	.3730	1-3/4	7	6	K610104688	

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

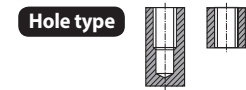
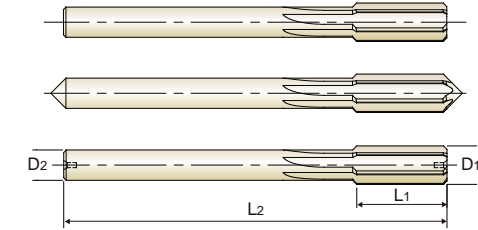
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb

HSS 45° P40~41

Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
12.00				.4724	.4355	2	8	6	K610604724
	31/64			.4844	.4355	2	8	6	K610104844
12.50				.4921	.4355	2	8	6	K610604921
	0.4990 U/S			.4990	.4355	2	8	6	K610504990
13.00				.5000	.4355	2	8	6	K610105000
	1/2			.5010	.4355	2	8	6	K610505010
	0.5010 O/S			.5010	.4355	2	8	6	K610505010
13.50				.5118	.4355	2	8	6	K610605118
	33/64			.5156	.4355	2	8	6	K610105156
14.00				.5312	.4355	2	8	6	K610105312
	17/32			.5315	.4355	2	8	6	K610605315
14.50				.5469	.4355	2	8	8	K610105469
	35/64			.5512	.4355	2	8	8	K610605512
15.00				.5625	.4355	2	8	8	K610105625
	9/16			.5709	.4355	2	8	8	K610605709
15.50				.5781	.4355	2	8	8	K610105781
	37/64			.5906	.4355	2	8	8	K610605906
	19/32			.5938	.4355	2	8	8	K610105938
16.00				.6094	.5620	2-1/4	9	8	K610106094
	39/64			.6102	.5620	2-1/4	9	8	K610606102
	0.6240 U/S			.6240	.5615	2-1/4	9	8	K610506240
16.50	5/8			.6250	.5620	2-1/4	9	8	K610106250
	0.6260 O/S			.6260	.5615	2-1/4	9	8	K610506260
				.6299	.5620	2-1/4	9	8	K610606299
			.6406	.5620	2-1/4	9	8	K610106406	

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000" Over 1/2 to 5/8 Inch : +.0003"/-.0000" Over 5/8 to 1 Inch : +.0004"/+.0001"	Up to .4355" : +.0000"/-.0010" Over .4355" : +.0000"/-.0015"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

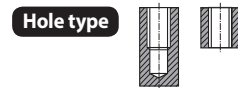
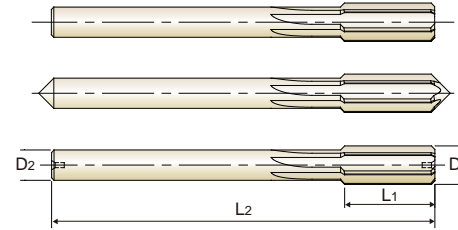
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## HSS, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Type of Center
  - Up to .0393" : Non-Center
  - Over .0393" to .1799" : External
  - Over .1799" : Internal

Metric **K6106** SERIES Letter **K6103** SERIES  
 Fractional **K6101/K6105** SERIES Wire Gauge **K6102** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
16.50				.6496	.5620	2-1/4	9	8	K610606496
	21/32			.6562	.5620	2-1/4	9	8	K610106562
17.00				.6693	.5620	2-1/4	9	8	K610606693
	43/64			.6719	.5620	2-1/4	9	8	K610106719
	0.6865 U/S			.6865	.5615	2-1/4	9	8	K610506865
	11/16			.6875	.5620	2-1/4	9	8	K610106875
	0.6885 O/S			.6885	.5615	2-1/4	9	8	K610506885
17.50				.6890	.5620	2-1/4	9	8	K610606890
	45/64			.7031	.5620	2-1/4	9	8	K610107031
18.00				.7087	.5620	2-1/4	9	8	K610607087
	23/32			.7188	.5620	2-1/4	9	8	K610107188
18.50				.7283	.6245	2-1/4	9	8	K610607283
	47/64			.7344	.6245	2-1/2	9-1/2	8	K610107344
19.00				.7480	.6245	2-1/4	9	8	K610607480
	0.7490 U/S			.7490	.6240	2-1/2	9	8	K610507490
	3/4			.7500	.6245	2-1/2	9-1/2	8	K610107500

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/2 Inch : +.0002"/-.0000"	Up to .4355" : +.0000"/-.0010"
Over 1/2 to 5/8 Inch : +.0003"/-.0000"	Over .4355" : +.0000"/-.0015"
Over 5/8 to 1 Inch : +.0004"/+.0001"	

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

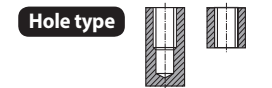
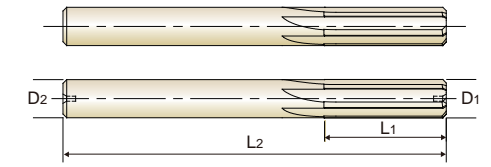
  

ISO Material Description	N										S				H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≠ Nominal Reamer Diameter
- Type of Center
  - Up to .1177" : Non-Center
  - Over .1177" : Internal

Metric **K9106** SERIES Letter **K9103** SERIES  
 Fractional **K9101** SERIES Wire Gauge **K9102** SERIES  
 Dowel Pin **K9104** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
			#70	.0280	.0280	1/4	1-1/2	4	K910200280
			#69	.0292	.0292	1/4	1-1/2	4	K910200292
			#68	.0310	.0310	1/4	1-1/2	4	K910200310
			#67	.0320	.0320	1/4	1-1/2	4	K910200320
			#66	.0330	.0330	1/4	1-1/2	4	K910200330
			#65	.0350	.0350	1/4	1-1/2	4	K910200350
			#64	.0360	.0360	1/4	1-1/2	4	K910200360
			#63	.0370	.0370	1/4	1-1/2	4	K910200370
			#62	.0380	.0380	1/4	1-1/2	4	K910200380
			#61	.0390	.0390	1/4	1-1/2	4	K910200390
			#60	.0400	.0400	1/4	1-1/2	4	K910200400
			#59	.0410	.0410	3/8	1-1/2	4	K910200410
			#58	.0420	.0420	3/8	1-1/2	4	K910200420
			#57	.0430	.0430	3/8	1-1/2	4	K910200430
			#56	.0465	.0465	3/8	1-1/2	4	K910200465
			#55	.0520	.0520	3/8	1-1/2	4	K910200520
			#54	.0550	.0550	3/8	1-1/2	4	K910200550
1.50			#53	.0591	.0591	3/8	1-1/2	4	K910600591
			#52	.0635	.0635	3/8	1-1/2	4	K910200635
			#51	.0670	.0670	1/2	1-3/4	4	K910200670
			#50	.0700	.0700	1/2	1-3/4	4	K910200700
			#49	.0730	.0730	1/2	1-3/4	4	K910200730
			#48	.0760	.0760	1/2	1-3/4	4	K910200760

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002"	+.0000"/-.0010"
Over 1/4 Inch : +.0000"/-.0003"	

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

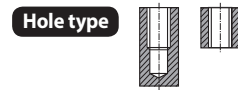
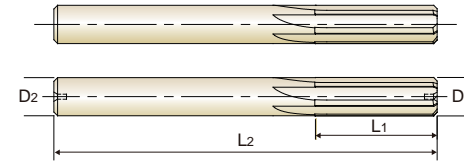
ISO Material Description	N										S				H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													



## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter = Nominal Reamer Diameter
- Type of Center  
Up to .1177" : Non-Center  
Over .1177" : Internal

Metric **K9106** SERIES  
Fractional **K9101** SERIES  
Letter **K9103** SERIES  
Wire Gauge **K9102** SERIES  
Dowel Pin **K9104** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
2.00			#47	.0785	.0785	1/2	1-3/4	4	K910200785
				.0787	.0787	1/2	1-3/4	4	K910600787
				.0810	.0810	1/2	2	4	K910200810
				.0820	.0820	1/2	2	4	K910200820
				.0860	.0860	1/2	2	4	K910200860
				.0890	.0890	1/2	2	4	K910200890
2.45			#42	.0935	.0935	1/2	2	4	K910200935
				.0960	.0960	5/8	2	4	K910200960
				.0965	.0965	1/2	2	4	K910600965
2.50			#40	.0980	.0980	5/8	2	4	K910200980
				.0984	.0984	5/8	2	4	K910600984
3.00			#39	.0995	.0995	5/8	2-1/4	4	K910200995
				.1015	.1015	5/8	2-1/4	4	K910201015
				.1040	.1040	5/8	2-1/4	4	K910201040
				.1065	.1065	5/8	2-1/4	4	K910201065
				.1100	.1100	5/8	2-1/4	4	K910201100
				.1110	.1110	5/8	2-1/4	4	K910201110
				.1130	.1130	5/8	2-1/4	4	K910201130
				.1160	.1160	5/8	2-1/4	4	K910201160
				.1181	.1181	5/8	2-1/4	4	K910601181
				.1200	.1200	5/8	2-1/4	4	K910201200
3.25			#31	.1280	.1280	5/8	2-1/4	4	K910601280
				.1285	.1285	5/8	2-1/4	4	K910201285
				.1360	.1360	3/4	2-1/2	4	K910201360

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002" Over 1/4 Inch : +.0000"/-.0003"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

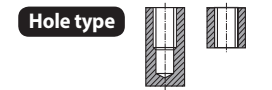
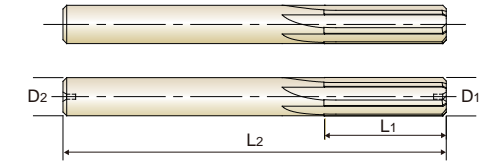
  

ISO Material Description	N										S				H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter = Nominal Reamer Diameter
- Type of Center  
Up to .1177" : Non-Center  
Over .1177" : Internal

Metric **K9106** SERIES  
Fractional **K9101** SERIES  
Letter **K9103** SERIES  
Wire Gauge **K9102** SERIES  
Dowel Pin **K9104** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
3.50			#28	.1378	.1378	3/4	2-1/2	4	K910601378
				.1405	.1405	3/4	2-1/2	4	K910201405
				.1440	.1440	3/4	2-1/2	4	K910201440
				.1470	.1470	3/4	2-1/2	4	K910201470
				.1495	.1495	3/4	2-1/2	4	K910201495
				.1520	.1520	3/4	2-1/2	4	K910201520
4.00			#23	.1540	.1540	3/4	2-1/2	4	K910201540
				.1570	.1570	3/4	2-1/2	4	K910201570
				.1575	.1575	3/4	2-1/2	4	K910601575
				.1590	.1590	3/4	2-1/2	4	K910201590
				.1610	.1610	7/8	2-1/2	4	K910201610
				.1660	.1660	7/8	2-3/4	4	K910201660
4.50			#18	.1695	.1695	7/8	2-3/4	4	K910201695
				.1730	.1730	7/8	2-3/4	4	K910201730
				.1770	.1770	7/8	2-3/4	4	K910201770
				.1772	.1772	7/8	2-3/4	4	K910601772
				.1800	.1800	7/8	2-3/4	4	K910201800
				.1820	.1820	7/8	2-3/4	4	K910201820
				.1850	.1850	7/8	2-3/4	4	K910201850
				.1890	.1890	7/8	2-3/4	4	K910201890
				.1910	.1910	7/8	2-3/4	4	K910201910
				.1935	.1935	7/8	2-3/4	4	K910201935
5.00			#9	.1960	.1960	1	3	4	K910201960
				.1969	.1969	1	3	4	K910601969

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002" Over 1/4 Inch : +.0000"/-.0003"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

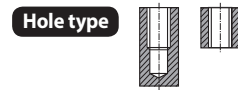
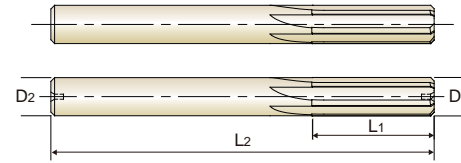
ISO Material Description	N										S				H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		



## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter = Nominal Reamer Diameter
- Type of Center  
Up to .1177" : Non-Center  
Over .1177" : Internal

Metric **K9106** SERIES  
Fractional **K9101** SERIES  
Letter **K9103** SERIES  
Wire Gauge **K9102** SERIES  
Dowel Pin **K9104** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.	
	Fractional	Letter	Wire Gauge	Decimal						
5.50	13/64		#8	.1990	.1990	1	3	4	K910201990	
			#7	.2010	.2010	1	3	4	K910202010	
				.2031	.2031	1	3	4	K910102031	
			#6	.2040	.2040	1	3	4	K910202040	
			#5	.2055	.2055	1	3	4	K910202055	
	6.00	15/64	A	#4	.2090	.2090	1	3	4	K910202090
				#3	.2130	.2130	1	3	4	K910202130
					.2165	.2165	1	3	4	K910602165
				#2	.2210	.2210	1	3	4	K910202210
				#1	.2280	.2280	1	3	4	K910202280
6.50	17/64	H		.2340	.2340	1	3	4	K910302340	
				.2344	.2344	1	3	4	K910102344	
				.2362	.2362	1	3	4	K910602362	
			B	.2380	.2380	1	3	4	K910302380	
			C	.2420	.2420	1	3	4	K910302420	
	7.00	17/64	I		.2460	.2460	1	3	4	K910302460
					.2498	.2498	1	3	4	K910402498
					.2559	.2559	1-1/8	3-1/4	6	K910602559
				F	.2570	.2570	1-1/8	3-1/4	6	K910302570
				G	.2610	.2610	1-1/8	3-1/4	6	K910302610
7.00	17/64	I		.2656	.2656	1-1/8	3-1/4	6	K910102656	
				.2660	.2660	1-1/8	3-1/4	6	K910302660	
				.2720	.2720	1-1/8	3-1/4	6	K910302720	
				.2756	.2756	1-1/8	3-1/4	6	K910602756	

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002" Over 1/4 Inch : +.0000"/-.0003"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	35	10	29	32	38	42	15	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	◎	○	○	○	○	○	○	◎	◎	◎	◎	◎	◎

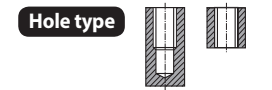
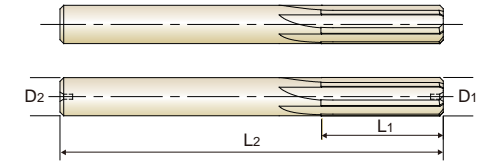
  

ISO Material Description	N										S				H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended	○	○	○	○	○	○	○	○															

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter = Nominal Reamer Diameter
- Type of Center  
Up to .1177" : Non-Center  
Over .1177" : Internal

Metric **K9106** SERIES  
Fractional **K9101** SERIES  
Letter **K9103** SERIES  
Wire Gauge **K9102** SERIES  
Dowel Pin **K9104** SERIES



Unit : inb



Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
7.50	19/64		J	.2770	.2770	1-1/8	3-1/4	6	K910302770
			K	.2810	.2810	1-1/8	3-1/4	6	K910302810
			L	.2900	.2900	1-1/8	3-1/4	6	K910302900
			M	.2950	.2950	1-1/8	3-1/4	6	K910302950
				.2953	.2953	1-1/8	3-1/4	6	K910602953
				.2969	.2969	1-1/8	3-1/4	6	K910102969
				.3020	.3020	1-1/8	3-1/4	6	K910303020
				.3150	.3150	1-1/8	3-1/4	6	K910603150
				.3160	.3160	1-1/8	3-1/4	6	K910303160
			8.50	21/64		P	.3230	.3230	1-1/4
Q	.3281	.3281				1-1/4	3-1/2	6	K910103281
	.3320	.3320				1-1/4	3-1/2	6	K910303320
	.3346	.3346				1-1/4	3-1/2	6	K910603346
	.3390	.3390				1-1/4	3-1/2	6	K910303390
	.3480	.3480				1-1/4	3-1/2	6	K910303480
	.3543	.3543				1-1/4	3-1/2	6	K910603543
	.3580	.3580				1-1/4	3-1/2	6	K910303580
	.3594	.3594				1-1/4	3-1/2	6	K910103594
9.50	23/64					U	.3680	.3680	1-1/4
			V	.3740	.3740	1-1/4	3-1/2	6	K910603740
				.3770	.3770	1-1/4	3-1/2	6	K910303770
				.3860	.3860	1-1/4	3-1/2	6	K910303860
				.3906	.3906	1-1/4	3-1/2	6	K910103906
				.3937	.3937	1-1/4	3-1/2	6	K910603937

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002" Over 1/4 Inch : +.0000"/-.0003"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	35	10	29	32	38	42	15	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	◎	○	○	○	○	○	○	◎	◎	◎	◎	◎	◎

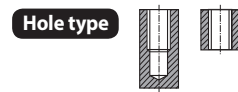
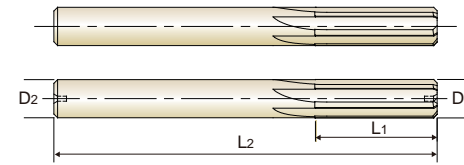
  

ISO Material Description	N										S				H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended	○	○	○	○	○	○	○	○															

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center  
Up to .1177" : Non-Center  
Over .1177" : Internal

**Metric** **K9106** SERIES      **Letter** **K9103** SERIES  
**Fractional** **K9101** SERIES      **Wire Gauge** **K9102** SERIES  
**Dowel Pin** **K9104** SERIES



CARBIDE 45° P42~43

Metric	Nominal Size				Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
	Fractional	Letter	Wire Gauge	Decimal					
10.50	13/32	X		.3970	.3970	1-1/4	3-1/2	6	K910303970
		Y		.4040	.4040	1-1/4	3-1/2	6	K910304040
		Z		.4062	.4062	1-1/4	3-1/2	6	K910104062
	27/64			.4130	.4130	1-1/4	3-1/2	6	K910304130
				.4134	.4134	1-1/4	3-1/2	6	K910604134
				.4219	.4219	1-3/8	4	6	K910104219
11.00			.4331	.4331	1-3/8	4	6	K910604331	
11.50			.4528	.4528	1-3/8	4	6	K910604528	
	29/64		.4531	.4531	1-3/8	4	6	K910104531	
12.00	15/32		.4688	.4688	1-3/8	4	6	K910104688	
			.4724	.4724	1-3/8	4	6	K910604724	
12.50	31/64		.4844	.4844	1-1/2	4	6	K910104844	
			.4921	.4921	1-1/2	4	6	K910604921	
13.00			.5118	.5118	1-1/2	4	6	K910605118	
14.00			.5512	.5512	1-1/2	4	6	K910605512	
	9/16		.5625	.5625	1-1/2	4	6	K910105625	
16.00	5/8		.6250	.6250	1-3/4	4	6	K910106250	
			.6299	.6299	1-3/4	4	6	K910606299	

O.D. Tolerance	Shank Dia. Tolerance
Up to 1/4 Inch : +.0000"/-.0002" Over 1/4 Inch : +.0000"/-.0003"	+.0000"/-.0010"

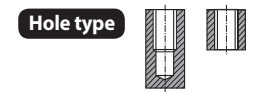
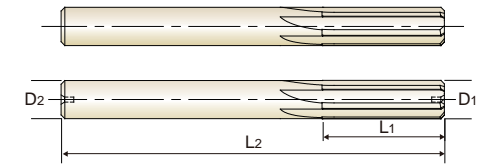
◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	35	38	40	42	45	48	50	52	54	56	58	60	62	64	66	68
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center  
Up to .1175" : Non-Center  
Over .1175" : Internal

**Decimal** **K9107** SERIES



CARBIDE 45° P42~43

Nominal Size Decimal	Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
.0355	.0355	1/4	1-1/2	4	K910700355
.0365	.0365	1/4	1-1/2	4	K910700365
.0375	.0375	1/4	1-1/2	4	K910700375
.0385	.0385	1/4	1-1/2	4	K910700385
.0395	.0395	1/4	1-1/2	4	K910700395
.0405	.0405	3/8	1-1/2	4	K910700405
.0425	.0425	3/8	1-1/2	4	K910700425
.0435	.0435	3/8	1-1/2	4	K910700435
.0440	.0440	3/8	1-1/2	4	K910700440
.0450	.0450	3/8	1-1/2	4	K910700450
.0460	.0460	3/8	1-1/2	4	K910700460
.0469	.0469	3/8	1-1/2	4	K910700469
.0470	.0470	3/8	1-1/2	4	K910700470
.0475	.0475	3/8	1-1/2	4	K910700475
.0480	.0480	3/8	1-1/2	4	K910700480
.0485	.0485	3/8	1-1/2	4	K910700485
.0490	.0490	3/8	1-1/2	4	K910700490
.0500	.0500	3/8	1-1/2	4	K910700500
.0505	.0505	3/8	1-1/2	4	K910700505
.0510	.0510	3/8	1-1/2	4	K910700510
.0515	.0515	3/8	1-1/2	4	K910700515
.0525	.0525	3/8	1-1/2	4	K910700525
.0530	.0530	3/8	1-1/2	4	K910700530
.0540	.0540	3/8	1-1/2	4	K910700540

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

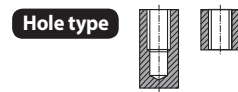
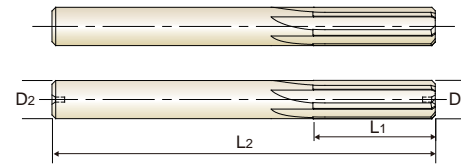
◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	35	38	40	42	45	48	50	52	54	56	58	60	62	64	66	68
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb

CARBIDE 45° P42~43

Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.0560	.0560	3/8	1-1/2	4	K910700560
.0570	.0570	3/8	1-1/2	4	K910700570
.0580	.0580	3/8	1-1/2	4	K910700580
.0590	.0590	3/8	1-1/2	4	K910700590
.0600	.0600	3/8	1-1/2	4	K910700600
.0605	.0605	3/8	1-1/2	4	K910700605
.0610	.0610	3/8	1-1/2	4	K910700610
.0615	.0615	3/8	1-1/2	4	K910700615
.0620	.0620	3/8	1-1/2	4	K910700620
.0625	.0625	3/8	1-1/2	4	K910700625
.0630	.0630	3/8	1-1/2	4	K910700630
.0640	.0640	3/8	1-1/2	4	K910700640
.0645	.0645	3/8	1-1/2	4	K910700645
.0650	.0650	3/8	1-1/2	4	K910700650
.0655	.0655	3/8	1-1/2	4	K910700655
.0660	.0660	1/2	1-3/4	4	K910700660
.0675	.0675	1/2	1-3/4	4	K910700675
.0680	.0680	1/2	1-3/4	4	K910700680
.0690	.0690	1/2	1-3/4	4	K910700690
.0705	.0705	1/2	1-3/4	4	K910700705
.0710	.0710	1/2	1-3/4	4	K910700710
.0720	.0720	1/2	1-3/4	4	K910700720
.0740	.0740	1/2	1-3/4	4	K910700740
.0750	.0750	1/2	1-3/4	4	K910700750

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	45	15	35	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	200	240	180	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

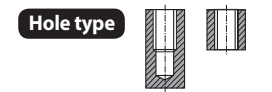
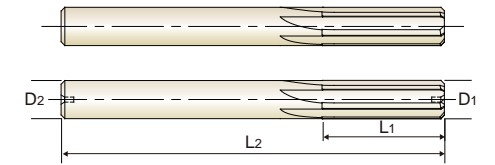
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb

CARBIDE 45° P42~43

Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.0765	.0765	1/2	1-3/4	4	K910700765
.0770	.0770	1/2	1-3/4	4	K910700770
.0775	.0775	1/2	1-3/4	4	K910700775
.0780	.0780	1/2	1-3/4	4	K910700780
.0781	.0781	1/2	1-3/4	4	K910700781
.0790	.0790	1/2	1-3/4	4	K910700790
.0795	.0795	1/2	1-3/4	4	K910700795
.0800	.0800	1/2	1-3/4	4	K910700800
.0830	.0830	1/2	2	4	K910700830
.0840	.0840	1/2	2	4	K910700840
.0850	.0850	1/2	2	4	K910700850
.0865	.0865	1/2	2	4	K910700865
.0870	.0870	1/2	2	4	K910700870
.0880	.0880	1/2	2	4	K910700880
.0900	.0900	1/2	2	4	K910700900
.0905	.0905	1/2	2	4	K910700905
.0910	.0910	1/2	2	4	K910700910
.0915	.0915	1/2	2	4	K910700915
.0920	.0920	1/2	2	4	K910700920
.0925	.0925	1/2	2	4	K910700925
.0930	.0930	1/2	2	4	K910700930
.0938	.0938	1/2	2	4	K910700938
.0940	.0940	1/2	2	4	K910700940
.0945	.0945	1/2	2	4	K910700945

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	45	15	35	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	200	240	180	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

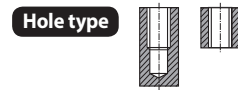
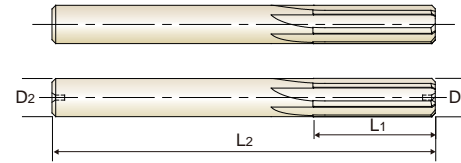
ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													



## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.0950	.0950	1/2	2	4	K910700950
.0955	.0955	1/2	2	4	K910700955
.0970	.0970	5/8	2	4	K910700970
.0975	.0975	5/8	2-1/4	4	K910700975
.0985	.0985	5/8	2-1/4	4	K910700985
.0990	.0990	5/8	2-1/4	4	K910700990
.1000	.1000	5/8	2-1/4	4	K910701000
.1010	.1010	5/8	2-1/4	4	K910701010
.1020	.1020	5/8	2-1/4	4	K910701020
.1030	.1030	5/8	2-1/4	4	K910701030
.1050	.1050	5/8	2-1/4	4	K910701050
.1060	.1060	5/8	2-1/4	4	K910701060
.1070	.1070	5/8	2-1/4	4	K910701070
.1080	.1080	5/8	2-1/4	4	K910701080
.1090	.1090	5/8	2-1/4	4	K910701090
.1094	.1094	5/8	2-1/4	4	K910701094
.1120	.1120	5/8	2-1/4	4	K910701120
.1140	.1140	5/8	2-1/4	4	K910701140
.1150	.1150	5/8	2-1/4	4	K910701150
.1170	.1170	5/8	2-1/4	4	K910701170
.1175	.1175	5/8	2-1/4	4	K910701175
.1180	.1180	5/8	2-1/4	4	K910701180
.1185	.1185	5/8	2-1/4	4	K910701185
.1190	.1190	5/8	2-1/4	4	K910701190

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

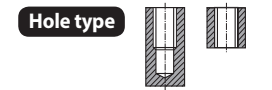
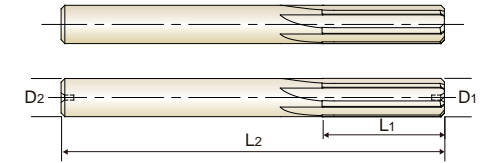
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.1195	.1195	5/8	2-1/4	4	K910701195
.1205	.1205	5/8	2-1/4	4	K910701205
.1210	.1210	5/8	2-1/4	4	K910701210
.1215	.1215	5/8	2-1/4	4	K910701215
.1220	.1220	5/8	2-1/4	4	K910701220
.1225	.1225	5/8	2-1/4	4	K910701225
.1230	.1230	5/8	2-1/4	4	K910701230
.1235	.1235	5/8	2-1/4	4	K910701235
.1240	.1240	5/8	2-1/4	4	K910701240
.1245	.1245	5/8	2-1/4	4	K910701245
.1247	.1247	5/8	2-1/4	4	K910701247
.1250	.1250	5/8	2-1/4	4	K910701250
.1255	.1255	5/8	2-1/4	4	K910701255
.1260	.1260	5/8	2-1/4	4	K910701260
.1265	.1265	5/8	2-1/4	4	K910701265
.1270	.1270	5/8	2-1/4	4	K910701270
.1275	.1275	5/8	2-1/4	4	K910701275
.1290	.1290	5/8	2-1/4	4	K910701290
.1295	.1295	3/4	2-1/2	4	K910701295
.1300	.1300	5/8	2-1/2	4	K910701300
.1305	.1305	3/4	2-1/2	4	K910701305
.1310	.1310	3/4	2-1/2	4	K910701310
.1315	.1315	3/4	2-1/2	4	K910701315
.1320	.1320	3/4	2-1/2	4	K910701320

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

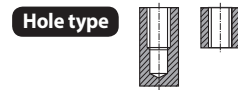
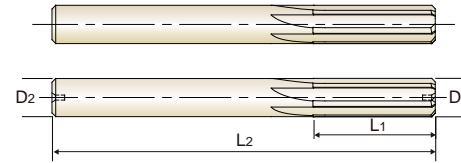
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.1330	.1330	3/4	2-1/2	4	K910701330
.1340	.1340	3/4	2-1/2	4	K910701340
.1350	.1350	3/4	2-1/2	4	K910701350
.1365	.1365	3/4	2-1/2	4	K910701365
.1370	.1370	3/4	2-1/2	4	K910701370
.1380	.1380	3/4	2-1/2	4	K910701380
.1390	.1390	3/4	2-1/2	4	K910701390
.1400	.1400	3/4	2-1/2	4	K910701400
.1406	.1406	3/4	2-1/2	4	K910701406
.1410	.1410	3/4	2-1/2	4	K910701410
.1415	.1415	3/4	2-1/2	4	K910701415
.1420	.1420	3/4	2-1/2	4	K910701420
.1430	.1430	3/4	2-1/2	4	K910701430
.1435	.1435	3/4	2-1/2	4	K910701435
.1450	.1450	3/4	2-1/2	4	K910701450
.1460	.1460	3/4	2-1/2	4	K910701460
.1480	.1480	3/4	2-1/2	4	K910701480
.1490	.1490	3/4	2-1/2	4	K910701490
.1500	.1500	3/4	2-1/2	4	K910701500
.1510	.1510	3/4	2-1/2	4	K910701510
.1530	.1530	3/4	2-1/2	4	K910701530
.1545	.1545	3/4	2-1/2	4	K910701545
.1550	.1550	3/4	2-1/2	4	K910701550
.1555	.1555	3/4	2-1/2	4	K910701555

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

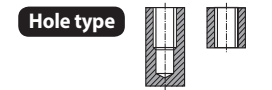
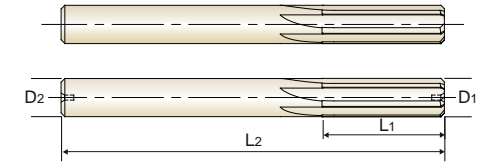
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.1560	.1560	3/4	2-1/2	4	K910701560
.1562	.1562	3/4	2-1/2	4	K910701562
.1565	.1565	3/4	2-1/2	4	K910701565
.1580	.1580	3/4	2-1/2	4	K910701580
.1585	.1585	3/4	2-1/2	4	K910701585
.1600	.1600	3/4	2-1/2	4	K910701600
.1605	.1605	7/8	2-3/4	4	K910701605
.1615	.1615	7/8	2-3/4	4	K910701615
.1620	.1620	7/8	2-3/4	4	K910701620
.1630	.1630	7/8	2-3/4	4	K910701630
.1640	.1640	7/8	2-3/4	4	K910701640
.1650	.1650	7/8	2-3/4	4	K910701650
.1670	.1670	7/8	2-3/4	4	K910701670
.1680	.1680	7/8	2-3/4	4	K910701680
.1690	.1690	7/8	2-3/4	4	K910701690
.1700	.1700	7/8	2-3/4	4	K910701700
.1710	.1710	7/8	2-3/4	4	K910701710
.1719	.1719	7/8	2-3/4	4	K910701719
.1720	.1720	7/8	2-3/4	4	K910701720
.1740	.1740	7/8	2-3/4	4	K910701740
.1750	.1750	7/8	2-3/4	4	K910701750
.1760	.1760	7/8	2-3/4	4	K910701760
.1780	.1780	7/8	2-3/4	4	K910701780
.1790	.1790	7/8	2-3/4	4	K910701790

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

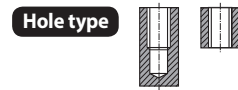
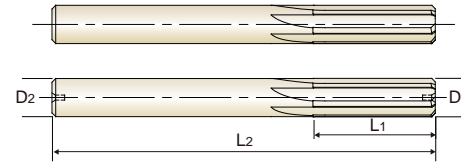
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.1810	.1810	7/8	2-3/4	4	K910701810
.1830	.1830	7/8	2-3/4	4	K910701830
.1840	.1840	7/8	2-3/4	4	K910701840
.1855	.1855	7/8	2-3/4	4	K910701855
.1860	.1860	7/8	2-3/4	4	K910701860
.1865	.1865	7/8	2-3/4	4	K910701865
.1870	.1870	7/8	2-3/4	4	K910701870
.1875	.1875	7/8	2-3/4	4	K910701875
.1880	.1880	7/8	2-3/4	4	K910701880
.1885	.1885	7/8	2-3/4	4	K910701885
.1895	.1895	7/8	2-3/4	4	K910701895
.1900	.1900	7/8	2-3/4	4	K910701900
.1905	.1905	7/8	2-3/4	4	K910701905
.1915	.1915	1	3	4	K910701915
.1920	.1920	7/8	2-3/4	4	K910701920
.1925	.1925	1	3	4	K910701925
.1930	.1930	7/8	2-3/4	4	K910701930
.1940	.1940	7/8	2-3/4	4	K910701940
.1950	.1950	7/8	2-3/4	4	K910701950
.1955	.1955	1	3	4	K910701955
.1965	.1965	1	3	4	K910701965
.1970	.1970	1	3	4	K910701970
.1980	.1980	1	3	4	K910701980
.2000	.2000	1	3	4	K910702000

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

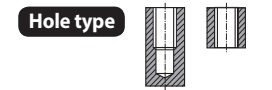
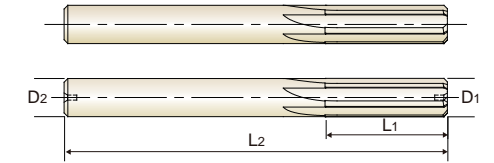
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.2005	.2005	1	3	4	K910702005
.2015	.2015	1	3	4	K910702015
.2020	.2020	1	3	4	K910702020
.2025	.2025	1	3	4	K910702025
.2030	.2030	1	3	4	K910702030
.2050	.2050	1	3	4	K910702050
.2060	.2060	1	3	4	K910702060
.2070	.2070	1	3	4	K910702070
.2080	.2080	1	3	4	K910702080
.2100	.2100	1	3	4	K910702100
.2110	.2110	1	3	4	K910702110
.2120	.2120	1	3	4	K910702120
.2140	.2140	1	3	4	K910702140
.2150	.2150	1	3	4	K910702150
.2160	.2160	1	3	4	K910702160
.2170	.2170	1	3	4	K910702170
.2180	.2180	1	3	4	K910702180
.2188	.2188	1	3	4	K910702188
.2190	.2190	1	3	4	K910702190
.2200	.2200	1	3	4	K910702200
.2220	.2220	1	3	4	K910702220
.2230	.2230	1	3	4	K910702230
.2240	.2240	1	3	4	K910702240
.2250	.2250	1	3	4	K910702250

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

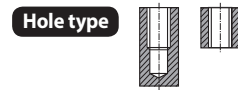
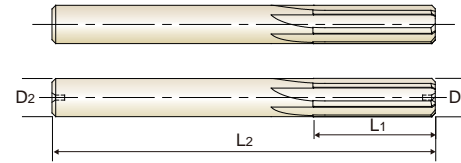
ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													



## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.2260	.2260	1	3	4	K910702260
.2270	.2270	1	3	4	K910702270
.2290	.2290	1	3	4	K910702290
.2300	.2300	1	3	4	K910702300
.2310	.2310	1	3	4	K910702310
.2320	.2320	1	3	4	K910702320
.2330	.2330	1	3	4	K910702330
.2350	.2350	1	3	4	K910702350
.2355	.2355	1	3	4	K910702355
.2360	.2360	1	3	4	K910702360
.2365	.2365	1	3	4	K910702365
.2370	.2370	1	3	4	K910702370
.2375	.2375	1	3	4	K910702375
.2390	.2390	1	3	4	K910702390
.2400	.2400	1	3	4	K910702400
.2410	.2410	1	3	4	K910702410
.2430	.2430	1	3	4	K910702430
.2440	.2440	1	3	4	K910702440
.2450	.2450	1	3	4	K910702450
.2470	.2470	1	3	4	K910702470
.2480	.2480	1	3	4	K910702480
.2485	.2485	1	3	4	K910702485
.2490	.2490	1	3	4	K910702490
.2495	.2495	1	3	4	K910702495

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

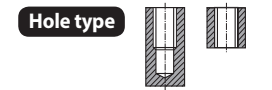
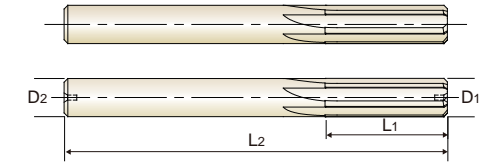
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.2500	.2500	1	3	4	K910702500
.2505	.2505	1	3	4	K910702505
.2510	.2510	1	3	4	K910702510
.2515	.2515	1	3	4	K910702515
.2520	.2520	1	3	4	K910702520
.2530	.2530	1	3	4	K910702530
.2540	.2540	1	3	4	K910702540
.2550	.2550	1	3	6	K910702550
.2560	.2560	1-1/8	3-1/4	6	K910702560
.2580	.2580	1-1/8	3-1/4	6	K910702580
.2590	.2590	1-1/8	3-1/4	6	K910702590
.2600	.2600	1-1/8	3-1/4	6	K910702600
.2620	.2620	1-1/8	3-1/4	6	K910702620
.2630	.2630	1-1/8	3-1/4	6	K910702630
.2640	.2640	1-1/8	3-1/4	6	K910702640
.2650	.2650	1-1/8	3-1/4	6	K910702650
.2670	.2670	1-1/8	3-1/4	6	K910702670
.2680	.2680	1-1/8	3-1/4	6	K910702680
.2690	.2690	1-1/8	3-1/4	6	K910702690
.2700	.2700	1-1/8	3-1/4	6	K910702700
.2710	.2710	1-1/8	3-1/4	6	K910702710
.2730	.2730	1-1/8	3-1/4	6	K910702730
.2740	.2740	1-1/8	3-1/4	6	K910702740
.2750	.2750	1-1/8	3-1/4	6	K910702750

► NEXT PAGE

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

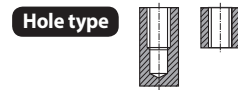
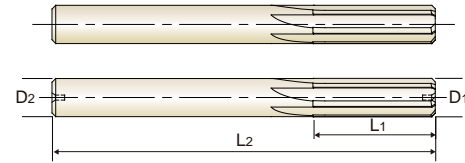
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.2760	.2760	1-1/8	3-1/4	6	K910702760
.2780	.2780	1-1/8	3-1/4	6	K910702780
.2790	.2790	1-1/8	3-1/4	6	K910702790
.2800	.2800	1-1/8	3-1/4	6	K910702800
.2812	.2812	1-1/8	3-1/4	6	K910702812
.2820	.2820	1-1/8	3-1/4	6	K910702820
.2830	.2830	1-1/8	3-1/4	6	K910702830
.2840	.2840	1-1/8	3-1/4	6	K910702840
.2850	.2850	1-1/8	3-1/4	6	K910702850
.2860	.2860	1-1/8	3-1/4	6	K910702860
.2870	.2870	1-1/8	3-1/4	6	K910702870
.2880	.2880	1-1/8	3-1/4	6	K910702880
.2890	.2890	1-1/8	3-1/4	6	K910702890
.2910	.2910	1-1/8	3-1/4	6	K910702910
.2920	.2920	1-1/8	3-1/4	6	K910702920
.2930	.2930	1-1/8	3-1/4	6	K910702930
.2940	.2940	1-1/8	3-1/4	6	K910702940
.2960	.2960	1-1/8	3-1/4	6	K910702960
.2970	.2970	1-1/8	3-1/4	6	K910702970
.2980	.2980	1-1/8	3-1/4	6	K910702980
.2990	.2990	1-1/8	3-1/4	6	K910702990
.3000	.3000	1-1/8	3-1/4	6	K910703000
.3010	.3010	1-1/8	3-1/4	6	K910703010
.3030	.3030	1-1/8	3-1/4	6	K910703030

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	60	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

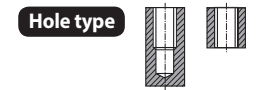
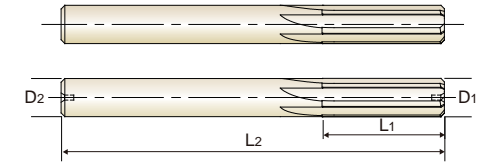
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

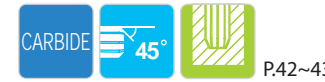
## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.3040	.3040	1-1/8	3-1/4	6	K910703040
.3050	.3050	1-1/8	3-1/4	6	K910703050
.3060	.3060	1-1/8	3-1/4	6	K910703060
.3070	.3070	1-1/8	3-1/4	6	K910703070
.3080	.3080	1-1/8	3-1/4	6	K910703080
.3090	.3090	1-1/8	3-1/4	6	K910703090
.3100	.3100	1-1/8	3-1/4	6	K910703100
.3105	.3105	1-1/8	3-1/4	6	K910703105
.3110	.3110	1-1/8	3-1/4	6	K910703110
.3115	.3115	1-1/8	3-1/4	6	K910703115
.3120	.3120	1-1/8	3-1/4	6	K910703120
.3125	.3125	1-1/8	3-1/4	6	K910703125
.3130	.3130	1-1/8	3-1/4	6	K910703130
.3135	.3135	1-1/8	3-1/4	6	K910703135
.3140	.3140	1-1/8	3-1/4	6	K910703140
.3170	.3170	1-1/8	3-1/4	6	K910703170
.3180	.3180	1-1/8	3-1/4	6	K910703180
.3190	.3190	1-1/8	3-1/4	6	K910703190
.3200	.3200	1-1/8	3-1/4	6	K910703200
.3210	.3210	1-1/4	3-1/2	6	K910703210
.3220	.3220	1-1/4	3-1/2	6	K910703220
.3240	.3240	1-1/4	3-1/2	6	K910703240
.3250	.3250	1-1/4	3-1/2	6	K910703250
.3260	.3260	1-1/4	3-1/2	6	K910703260

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	60	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

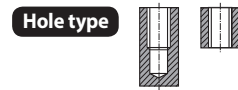
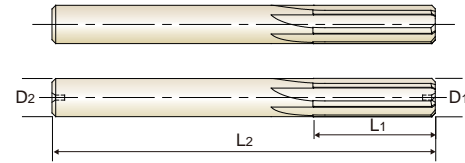
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- ▶ Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- ▶ Straight Flute, Right Hand Cut
- ▶ Shank Diameter ≈ Nominal Reamer Diameter
- ▶ Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size Decimal	Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
.3270	.3270	1-1/4	3-1/2	6	K910703270
.3280	.3280	1-1/4	3-1/2	6	K910703280
.3290	.3290	1-1/4	3-1/2	6	K910703290
.3300	.3300	1-1/4	3-1/2	6	K910703300
.3310	.3310	1-1/4	3-1/2	6	K910703310
.3330	.3330	1-1/4	3-1/2	6	K910703330
.3340	.3340	1-1/4	3-1/2	6	K910703340
.3350	.3350	1-1/4	3-1/2	6	K910703350
.3360	.3360	1-1/4	3-1/2	6	K910703360
.3370	.3370	1-1/4	3-1/2	6	K910703370
.3380	.3380	1-1/4	3-1/2	6	K910703380
.3400	.3400	1-1/4	3-1/2	6	K910703400
.3410	.3410	1-1/4	3-1/2	6	K910703410
.3420	.3420	1-1/4	3-1/2	6	K910703420
.3430	.3430	1-1/4	3-1/2	6	K910703430
.3438	.3438	1-1/4	3-1/2	6	K910703438
.3440	.3440	1-1/4	3-1/2	6	K910703440
.3450	.3450	1-1/4	3-1/2	6	K910703450
.3460	.3460	1-1/4	3-1/2	6	K910703460
.3470	.3470	1-1/4	3-1/2	6	K910703470
.3490	.3490	1-1/4	3-1/2	6	K910703490
.3500	.3500	1-1/4	3-1/2	6	K910703500
.3510	.3510	1-1/4	3-1/2	6	K910703510
.3520	.3520	1-1/4	3-1/2	6	K910703520

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

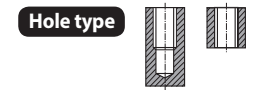
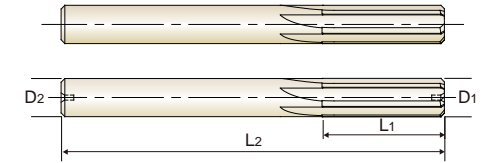
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- ▶ Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- ▶ Straight Flute, Right Hand Cut
- ▶ Shank Diameter ≈ Nominal Reamer Diameter
- ▶ Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size Decimal	Shank Diameter D2	Flute Length L1	Overall Length L2	No. of Flute	EDP No.
.3530	.3530	1-1/4	3-1/2	6	K910703530
.3540	.3540	1-1/4	3-1/2	6	K910703540
.3550	.3550	1-1/4	3-1/2	6	K910703550
.3560	.3560	1-1/4	3-1/2	6	K910703560
.3570	.3570	1-1/4	3-1/2	6	K910703570
.3590	.3590	1-1/4	3-1/2	6	K910703590
.3600	.3600	1-1/4	3-1/2	6	K910703600
.3610	.3610	1-1/4	3-1/2	6	K910703610
.3620	.3620	1-1/4	3-1/2	6	K910703620
.3630	.3630	1-1/4	3-1/2	6	K910703630
.3640	.3640	1-1/4	3-1/2	6	K910703640
.3650	.3650	1-1/4	3-1/2	6	K910703650
.3660	.3660	1-1/4	3-1/2	6	K910703660
.3670	.3670	1-1/4	3-1/2	6	K910703670
.3690	.3690	1-1/4	3-1/2	6	K910703690
.3700	.3700	1-1/4	3-1/2	6	K910703700
.3710	.3710	1-1/4	3-1/2	6	K910703710
.3720	.3720	1-1/4	3-1/2	6	K910703720
.3730	.3730	1-1/4	3-1/2	6	K910703730
.3745	.3745	1-1/4	3-1/2	6	K910703745
.3750	.3750	1-1/4	3-1/2	6	K910703750
.3755	.3755	1-1/4	3-1/2	6	K910703755
.3760	.3760	1-1/4	3-1/2	6	K910703760
.3765	.3765	1-1/4	3-1/2	6	K910703765

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

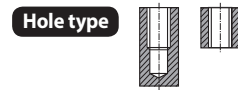
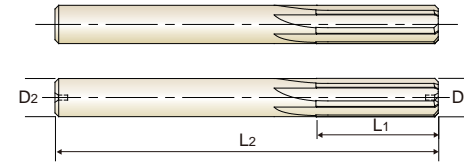
ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													



## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.3780	.3780	1-1/4	3-1/2	6	K910703780
.3790	.3790	1-1/4	3-1/2	6	K910703790
.3800	.3800	1-1/4	3-1/2	6	K910703800
.3810	.3810	1-1/4	3-1/2	6	K910703810
.3820	.3820	1-1/4	3-1/2	6	K910703820
.3830	.3830	1-1/4	3-1/2	6	K910703830
.3840	.3840	1-1/4	3-1/2	6	K910703840
.3850	.3850	1-1/4	3-1/2	6	K910703850
.3870	.3870	1-1/4	3-1/2	6	K910703870
.3880	.3880	1-1/4	3-1/2	6	K910703880
.3890	.3890	1-1/4	3-1/2	6	K910703890
.3900	.3900	1-1/4	3-1/2	6	K910703900
.3910	.3910	1-1/4	3-1/2	6	K910703910
.3920	.3920	1-1/4	3-1/2	6	K910703920
.3930	.3930	1-1/4	3-1/2	6	K910703930
.3940	.3940	1-1/4	3-1/2	6	K910703940
.3950	.3950	1-1/4	3-1/2	6	K910703950
.3960	.3960	1-1/4	3-1/2	6	K910703960
.3980	.3980	1-1/4	3-1/2	6	K910703980
.3990	.3990	1-1/4	3-1/2	6	K910703990
.4000	.4000	1-1/4	3-1/2	6	K910704000
.4010	.4010	1-1/4	3-1/2	6	K910704010
.4020	.4020	1-1/4	3-1/2	6	K910704020
.4030	.4030	1-1/4	3-1/2	6	K910704030

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

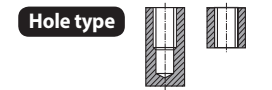
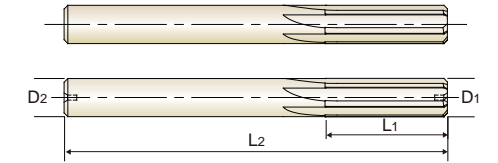
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.4050	.4050	1-1/4	3-1/2	6	K910704050
.4060	.4060	1-1/4	3-1/2	6	K910704060
.4070	.4070	1-1/4	3-1/2	6	K910704070
.4080	.4080	1-1/4	3-1/2	6	K910704080
.4090	.4090	1-1/4	3-1/2	6	K910704090
.4100	.4100	1-1/4	3-1/2	6	K910704100
.4110	.4110	1-1/4	3-1/2	6	K910704110
.4120	.4120	1-1/4	3-1/2	6	K910704120
.4140	.4140	1-1/4	3-1/2	6	K910704140
.4150	.4150	1-1/4	3-1/2	6	K910704150
.4160	.4160	1-3/8	4	6	K910704160
.4170	.4170	1-3/8	4	6	K910704170
.4180	.4180	1-3/8	4	6	K910704180
.4190	.4190	1-3/8	4	6	K910704190
.4200	.4200	1-3/8	4	6	K910704200
.4210	.4210	1-3/8	4	6	K910704210
.4220	.4220	1-3/8	4	6	K910704220
.4230	.4230	1-3/8	4	6	K910704230
.4240	.4240	1-3/8	4	6	K910704240
.4250	.4250	1-3/8	4	6	K910704250
.4260	.4260	1-3/8	4	6	K910704260
.4270	.4270	1-3/8	4	6	K910704270
.4280	.4280	1-3/8	4	6	K910704280
.4290	.4290	1-3/8	4	6	K910704290

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	10	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○

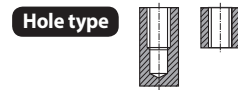
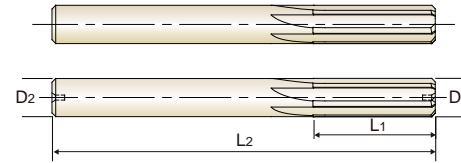
  

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.4300	.4300	1-3/8	4	6	K910704300
.4310	.4310	1-3/8	4	6	K910704310
.4320	.4320	1-3/8	4	6	K910704320
.4330	.4330	1-3/8	4	6	K910704330
.4340	.4340	1-3/8	4	6	K910704340
.4350	.4350	1-3/8	4	6	K910704350
.4360	.4360	1-3/8	4	6	K910704360
.4365	.4365	1-3/8	4	6	K910704365
.4370	.4370	1-3/8	4	6	K910704370
.4375	.4375	1-3/8	4	6	K910704375
.4380	.4380	1-3/8	4	6	K910704380
.4385	.4385	1-3/8	4	6	K910704385
.4390	.4390	1-3/8	4	6	K910704390
.4400	.4400	1-3/8	4	6	K910704400
.4410	.4410	1-3/8	4	6	K910704410
.4420	.4420	1-3/8	4	6	K910704420
.4430	.4430	1-3/8	4	6	K910704430
.4440	.4440	1-3/8	4	6	K910704440
.4450	.4450	1-3/8	4	6	K910704450
.4460	.4460	1-3/8	4	6	K910704460
.4470	.4470	1-3/8	4	6	K910704470
.4480	.4480	1-3/8	4	6	K910704480
.4490	.4490	1-3/8	4	6	K910704490
.4500	.4500	1-3/8	4	6	K910704500

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M					K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○	

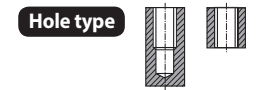
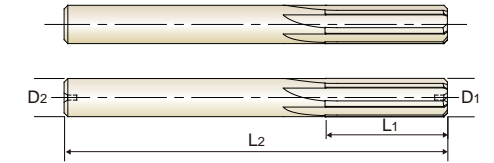
  

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

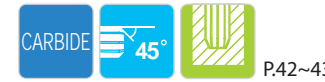
## CARBIDE, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTE

- Precision reamers for a variety of materials, applications and sizes that ensure close hole tolerance and excellent surface finish
- Straight Flute, Right Hand Cut
- Shank Diameter ≈ Nominal Reamer Diameter
- Type of Center
  - Up to .1175" : Non-Center
  - Over .1175" : Internal

Decimal **K9107** SERIES



Unit : inb



Nominal Size	Shank Diameter	Flute Length	Overall Length	No. of Flute	EDP No.
Decimal	D2	L1	L2		
D1					
.4510	.4510	1-3/8	4	6	K910704510
.4520	.4520	1-3/8	4	6	K910704520
.4530	.4530	1-3/8	4	6	K910704530
.4540	.4540	1-3/8	4	6	K910704540
.4550	.4550	1-3/8	4	6	K910704550
.4560	.4560	1-3/8	4	6	K910704560
.4570	.4570	1-3/8	4	6	K910704570
.4580	.4580	1-3/8	4	6	K910704580
.4590	.4590	1-3/8	4	6	K910704590
.4600	.4600	1-3/8	4	6	K910704600
.4610	.4610	1-3/8	4	6	K910704610
.4620	.4620	1-3/8	4	6	K910704620
.4630	.4630	1-3/8	4	6	K910704630
.4640	.4640	1-3/8	4	6	K910704640
.4650	.4650	1-3/8	4	6	K910704650
.4660	.4660	1-3/8	4	6	K910704660
.4670	.4670	1-3/8	4	6	K910704670
.4680	.4680	1-3/8	4	6	K910704680
.4690	.4690	1-3/8	4	6	K910704690
.4700	.4700	1-3/8	4	6	K910704700
.4710	.4710	1-3/8	4	6	K910704710
.4720	.4720	1-3/8	4	6	K910704720
.4730	.4730	1-3/8	4	6	K910704730
.4740	.4740	1-3/8	4	6	K910704740

O.D. Tolerance	Shank Dia. Tolerance
Up to .2504" : +.0002"/-.0000" Over .2504" : +.0003"/-.0000"	+.0000"/-.0010"

► NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M					K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○	

ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													



HSS, Straight Shank Chucking Reamers - Straight Flute

ISO	VDI 3323	Material Description	SFM (ft/min.)	IPR(inch/rev.)			
				<Ø.0394	Ø.0394	Ø.0787	Ø.1575
P	1	Non-alloy steel	46	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	2		46	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	3		33	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	4		26	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	5						
	6	Low alloy steel	39	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	7		26	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	8						
	9						
	10	High alloyed steel, and tool steel	20	.0004~.0008	.0008~.0012	.0012~.0016	.0016~.002
	11						
M	12	Stainless steel	20	.0004~.0008	.0008~.0012	.0012~.0016	.0016~.002
	13		16	.0004~.0008	.0008~.0012	.0012~.0016	.0016~.002
	14		13	.0004~.0008	.0008~.0012	.0012~.0016	.0016~.002
K	15	Grey cast iron	46	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	16		36	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	17	Nodular cast iron	39	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	18		33	.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
	19		Malleable cast iron	39	.0004~.0012	.0012~.002	.002~.0028
	20	33		.0004~.0012	.0012~.002	.002~.0028	.0028~.0035
N	21	Aluminum-wrought alloy	59	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	22		59	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	23	Aluminum-cast, alloyed	59	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	24		56	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	25						
	26		59	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	27	Copper and Copper Alloys (Bronze / Brass)	52	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	28		66	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	29						
	30	Non Metallic Materials					

SFM = ft/min.  
IPR = inch/rev.

IPR(inch/rev.)						
Ø.2362	Ø.315	Ø.3937	Ø.4724	Ø.5512	Ø.6299	Ø.7874
.0035~.0043	.0043~.0055	.0055~.0067	.0067~.0079	.0079~.0091	.0091~.0102	.0102~.0114
.0035~.0043	.0043~.0055	.0055~.0067	.0067~.0079	.0079~.0091	.0091~.0102	.0102~.0114
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.002~.0024	.0024~.0028	.0028~.0031	.0031~.0039	.0039~.0047	.0047~.0055	.0055~.0063
.002~.0024	.0024~.0028	.0028~.0031	.0031~.0039	.0039~.0047	.0047~.0055	.0055~.0063
.002~.0024	.0024~.0028	.0028~.0031	.0031~.0039	.0039~.0047	.0047~.0055	.0055~.0063
.0035~.0043	.0043~.0055	.0055~.0067	.0067~.0079	.0079~.0091	.0091~.0102	.0102~.0114
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0035~.0043	.0043~.0055	.0055~.0067	.0067~.0079	.0079~.0091	.0091~.0102	.0102~.0114
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0035~.0043	.0043~.0055	.0055~.0067	.0067~.0079	.0079~.0091	.0091~.0102	.0102~.0114
.0035~.0043	.0043~.0051	.0051~.0059	.0059~.0067	.0067~.0075	.0075~.0083	.0083~.0091
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146
.0063~.0075	.0075~.0087	.0087~.0098	.0098~.011	.011~.0122	.0122~.0134	.0134~.0146



**CARBIDE, Straight Shank Chucking Reamers - Straight Flute**

ISO	VDI 3323	Material Description	SFM (ft/min.)	IPR(inch/rev.)			
				<Ø.0394	Ø.0394	Ø.0787	Ø.1575
P	1	Non-alloy steel	59	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	2		56	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	3		49	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	4		49	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	5		49	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	6	Low alloy steel	56	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	7		46	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	8		46	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	9						
	10	High alloyed steel, and tool steel	43	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	11						
M	12	Stainless steel	26	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	13		23	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
	14		20	.0008~.0016	.0016~.0024	.0024~.0031	.0031~.0039
K	15	Grey cast iron	66	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	16		49	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	17	Nodular cast iron	59	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	18		43	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	19	Malleable cast iron	59	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
	20		43	.0008~.002	.002~.0031	.0031~.0039	.0039~.0047
N	21	Aluminum-wrought alloy	98	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	22		98	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	23	Aluminum-cast, alloyed	98	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	24		82	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	25						
	26		82	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	27	Copper and Copper Alloys (Bronze / Brass)	72	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	28		75	.0008~.0024	.0024~.0039	.0039~.0051	.0051~.0063
	29	Non Metallic Materials					
	30						

SFM = ft/min.  
IPR = inch/rev.

IPR(inch/rev.)					
Ø.2362	Ø.315	Ø.3937	Ø.4724	Ø.5512	Ø.6299
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0039~.0047	.0047~.0059	.0059~.0071	.0071~.0083	.0083~.0094	.0094~.0106
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0047~.0063	.0063~.0079	.0079~.0094	.0094~.011	.011~.0126	.0126~.0142
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177
.0063~.0079	.0079~.0098	.0098~.0118	.0118~.0138	.0138~.0157	.0157~.0177