Additional reamer sizes and types are available on Grainger.com®



## **Taper Pin Reamers**

- High-speed steel
- Bright (uncoated) finish

Taper pin reamers enlarge, finish, or shape holes for a precise fit when installing taper pins into the hole. They have a 1/4" taper to the foot and are made from high-speed steel, which offers good wear resistance in general purpose metalworking applications.

during reaming and prevent chips from packing in the flutes. Operated with a machine such as a drill press, lathe, or screw machine.

**Spiral**—Pull chips out of the hole during reaming, which helps prevent damage to the reamers and workpiece. Suitable for reaming applications with blind holes and interrupted cuts. Operated with a machine such as a drill press, lathe, or screw machine.

Straight—Push chips forward into the Helical—Reduce the size of the chips created hole and are the most commonly used style of reamer. Operated with a tap wrench, adjustable wrench, or vise.

For Pin Size	End	Large End Dia.	Shank Dia.	Flute Length	Overall Length	HELICAL Brand	FLUTE Item No.	STRAIGH Brand	T FLUTE Item No.	SPIRAL Brand	FLUTE Item No.
#0	nanu əµ ⅓ in	5/32 in	11/64 in	1 11/16 in	2 15/16 in					Yankee	20D595
#1	%4 in	11/64 in	3/16 in	1 11/16 in	2 15/16 in	Yankee	20D575			- I allikee	
#2	5/32 in	3∕16 in	13/64 in	1 15/16 in	3 15/4c in	Yankee	20D576	_	_	Yankee	20D597
#2/0 #2/0	¹⁄% in	%4 in	5∕32 in	1 % in 1 % in	2 % in 2 % in	_	_	_	=	Yankee	20D611
#2/0	7/64 in	%4 in	5/32 in	1 5/8 in	2 5% in	Yankee	20D589				
#3	3/16 in	7∕32 in	15/64 in	2 5/16 in 2 5/16 in	3 11/16 in 3 11/16 in	Vankas	200577	_ _ _ _ _		Yankee	20D598
#3/0	11/64 in 1/8 in	7⁄32 in 1∕8 in	<sup>15</sup> / <sub>64</sub> in 9/ <sub>64</sub> in	1 5/16 in	2 5/16 in	Yankee	20D577			Yankee	20D612
#3/0	3/32 in	1/8 in	%4 in	1 5/16 in	2 5/16 in	Yankee	20D590	_	_	-	
#4	3/16 in	1/4 in	17/64 in	2 % in	4 % in		_	_	_	Yankee	20D599
#4	13/64 in	1/4 in	17/64 in	2 %16 in	4 % in	Yankee	20D578	_			
#4/0	1/16 in 1/4 in	7/64 in 19/64 in	1/8 in 5/16 in	1 5/16 in 2 13/16 in	2 5/16 in 4 5/16 in					Yankee	20D613 20D601
#5	15/64 in	19/64 in	5/16 in	2 13/16 in	4 5/16 in	Yankee	20D579	=	=	Yankee	<u></u>
#6	1/4 in	11/32 in	23/64 in	3 5/8 in	5 7/16 in	-	_			Yankee	20D602
#6	17/64 in	11/32 in	<sup>23</sup> / <sub>64</sub> in	3 % in	5 1/16 in	Yankee	20D580	=	_	_	_
#6/0	1/16 in	5/64 in	3/32 in	15/16 in	1 15/16 in					Yankee	20D615
#7	5/16 in 21/64 in	<sup>27</sup> / <sub>64</sub> in	13/32 in 13/32 in	4 1/16 in 4 1/16 in	6 5/16 in	Yankee	20D581			Yankee	20D603
#8	3% in	1/2 in	7/16 in	5 3/16 in	6 5/16 in 7 3/16 in	Tallkee	200301		=	Yankee	20D604
#8	25/64 in	1/6 in	7∕16 in	5 3/16 in	7 3/16 in	Yankee	20D582	=	_	_	
#9	1/4 in	41/64 in	%₁6 in	6 % in 6 % in	8 5/16 in 8 5/16 in	_	_	_	_	Yankee	20D605
#9	15/32 in	41/64 IN	9/16 in	6 % in	8 5/16 in	Yankee	20D583			_	
#10	9∕16 in 11∕16 in	<sup>23</sup> / <sub>32</sub> in <sup>7</sup> / <sub>8</sub> in	5% in 3⁄4 in	6 <sup>13</sup> / <sub>16</sub> in 8 <sup>1</sup> / <sub>4</sub> in	9 5/16 in 11 1/4 in			=		Yankee Yankee	20D606 20D607
#11	1 in	1 ½ in	1 ½ in	12 in	16 in					Yankee	20D607
	t Hand S	piral			10 111					rannoo	LUDUUJ
#0	1/8 in	5/32 in	11/64 in	1 11/16 in	2 <sup>15</sup> / <sub>16</sub> in	_	_	Yankee	20D553		_
#1	1/8 in	11/64 in	3∕16 IN	1 11/16 in	2 15/16 in					Cleveland	445N25
#1	%4 in	11/64 in 3/16 in	3/16 in 13/64 in	1 11/16 in 1 15/16 in	2 <sup>15</sup> / <sub>16</sub> in 3 <sup>3</sup> / <sub>16</sub> in			Yankee	20D554	Claveland	44ENOC
#2	3∕16 in 5∕32 in	3/16 in	13/64 in	1 15/16 in	3 3/16 in	Cleveland	445M93			Cleveland	443NZ0
#2	5/32 in	3/16 in	13/64 in	1 15/16 in	3 15/16 in	-	_	Yankee	20D555	_	
#2/0	7/64 in	%4 in	5∕32 in	1 5/8 in	2 5% in	_	_	Yankee	20D568	_	_
#3	3/16 in	7⁄32 in	15/64 in	2 5/16 in	3 11/16 in					Cleveland	445N27
#3	3/32 in	1/8 in 7/32 in	9⁄64 in 15∕64 in	1 5/16 in	2 5/16 in 3 11/16 in			Cleveland			
#3	11/64 in 11/64 in	7/32 III 7/32 in	15/64 in	2 5/16 in 2 5/16 in		Cleveland	445M94	Cleveland	20D556		
#3/0	3/32 in	1/8 in	%4 in	1 5/16 in	2 5/16 in 4 1/16 in 4 5/8 in	-	_	Yankee	20D569	_	
#4	3/16 in	1/4 in	17/64 in	2 %16 in 2 %16 in	4 ½16 in	_	_			Cleveland	445N28
#4	13/64 in	1/4 in	17/64 in	2 9/16 in	4 % in			Yankee Cleveland	20D557		
#4	13/64 in 5/64 in	1/4 in 7/64 in	17/64 in 1/8 in	2 9/16 in 1 5/16 in	4 ½ in 2 ½ in	Cleveland	445W95	Cieveiand	445N12		
#4/0	1/4 in	19/64 in	5/16 in	2 <sup>13</sup> / <sub>16</sub> in	4 5/16 in	—	44311100	=		Cleveland	445N29
#5	15/64 in	19/64 in	5/16 in	2 13/16 In	4 5/16 in	Cleveland	445M96	Yankee	20D558	-	
#5	<sup>15</sup> / <sub>64</sub> in	<sup>19</sup> / <sub>64</sub> in	5/16 in	2 <sup>13</sup> / <sub>16</sub> in	4 5/16 in			Cleveland	445N13		_
#5/0	1/16 in	3/32 in	7/64 in	1 3/16 in	2 3/16 in	Cleveland	445M87	Yankee	20D571	— Olavada ad	4451100
#6	1/4 in 17/64 in	11/32 in 11/32 in	<sup>23</sup> / <sub>64</sub> in	3 11/16 in 3 11/16 in	5 ½16 in 5 ½16 in	Cleveland	445M07	— Cleveland	445N1A	Cleveland	4431130
#6	17/64 in	11/32 in	23/64 in	3 % in	5 1/16 in	—	——	Yankee			
#6/0	3/64 in	5/64 in	3/32 in	15/16 in	1 15/16 in	_	_	Yankee	20D572	_	_
#7	5/16 in	<sup>27</sup> / <sub>64</sub> in	13/32 in	4 1/16 in	6 5/16 in	_			<del></del>	Cleveland	445N31
#7	21/64 in	27/64 in	13/32 in	4 7/16 in	6 5/16 in	— —	4458400	Cleveland		_	
#7 #7/0	<sup>21</sup> / <sub>64</sub> in <sup>3</sup> / <sub>64</sub> in	<sup>27</sup> / <sub>64</sub> in 1/ <sub>16</sub> in	13/32 in 5/64 in	4 7/16 in 13/16 in	6 5/16 in	Cleveland	445W98	Vankee	20D560 20D573		
#8	3/8 in	½ in	7/16 in	5 3/16 in	7 3/16 in	—	-	— I AIINGG		Cleveland	445N32
#8	<sup>25</sup> / <sub>64</sub> in	½ in	7/16 in	5 3/16 in	7 3/16 in	_	_	Cleveland		_	_
#8	25/64 in	1/2 in	7∕16 in	5 3/16 in	7 3/16 in	Cleveland	445M99	Yankee	20D561		4451100
#9	1/4 in 15/32 in	41/64 in 41/64 in	9/16 in	6 ½ in	8 5/16 in	Clavaland	44END4	Claveland		Cleveland	445N33
#9	15/32 III	41/64 IN	9/16 in 9/16 in	6 ½ in	8 5/16 in	UIEVEIAIIO	445NUI	Cleveland Yankee	20D562	=	
#10	9/16 in	23/32 in	5% in	6 5/8 in 6 13/16 in	8 5/16 in 8 5/16 in 9 5/16 in	_		—	_	Cleveland	445N34
#10	37/64 in	23/32 in	5⁄8 in	6 13/16 in	9 5/16 in	Cleveland	445N02	Yankee	20D563	_	
#10	37/64 in	<sup>23</sup> / <sub>32</sub> in	5/8 in	6 13/16 in	9 5/16 in		_	Cleveland	445N18		
#11	45/64 in 53/64 in	7/8 in 1 3/64 in	3/4 in 3/4 in	8 1/4 in 10 in	11 ¼ in 13 % in			Yankee	20D564 20D565		
2 in	9/16 in	47/64 in	5/8 in	3 ½ in	6 in		=	Yankee Yankee	20D537	$\vdash \equiv -$	
3 in	49/64 in	63/64 in	7∕8 in	4 1/4 in	7 1/4 in	_		Yankee	20D538		



# **High-Speed Steel Bridge Reamers**

Bridge reamers install into compatible power tools to enlarge, debur, and finish holes in structural materials to a specific size. They have tapered flutes that ease their entry into rough-cut or misaligned holes. Designed for reaming difficult-to-machine materials such as iron and structural steel in applications where extreme precision is not required. Also commonly used to ream rivet holes in parts for automobile. bridges, rail cars, ships, and pressure vessels.

#### **HEX NUT SHANK**

Hex nut keeps the reamer securely in place in tools that have a square drive. Typically used to ensure the reamer won't come loose when it's used in a power tool that is being operated at a high location. Hex nut shank with safety magnet also have a magnet on the shank and provide a stronger hold than reamers that are secured with only a hex nut.

### **MORSE TAPER SHANK**

Can be directly inserted into the spindle of a compatible tool or into an adapter such as a Morse taper sleeve or socket. This maximizes efficiency when installing and removing the reamers. These reamers provide accurate centering, and their self-locking taper shank is held in place by the friction between the shank and the toolholder.

## STRAIGHT SHANK

Straight shank reamers with safety collars prevent the reamer from going too deep into the workpiece. Straight shank reamers with three flats are used in pneumatic or electric power tools.

		Flute	Overall	Shank	Item
	Size - Decimal	Length	Length	Dia.	No.
	Hex Nut Shank,			4.17	40112
	9/16 in - 0.5625	5 1/8 in	6 % in	1 ½ in	13H855
	11/16 in - 0.6875	4 ½ in	6 % in	1 ½ in	13H856
	11/16 in - 0.6875	7 ½ in	9 ½ in	1 1/16 in	13H857
	13/16 in - 0.8125	5 in	7 in	1 1/4 in	13H858
	13/16 in - 0.8125	7 3/8 in	9 ¾ in	1 1/4 in	13H859
	15/16 in - 0.9375	5 in	7 in	1 7/16 in	13H860
	15/16 in - 0.9375	7 3/8 in	9 % in	1 ½16 in	13H861
	1 ½ in - 1.0625	7 % in	9 % in	1 % in	13H863
	Hex Nut Shank			net, Bla	
l	5% in - 0.625	4 ½ in	6 in	1 1/16 in	12G353
	11/16 in - 0.6875	4 ½ in	6 % in 7 in	1 1/16 in	12G354
	3/4 in - 0.75	5 in		1 1/4 in	12G355
	13/16 in - 0.8125	5 in	7 in	1 1/4 in	12G356
	% in - 0.875	5 in	7 in	1 7/16 in	12G357
	15/16 in - 0.9375	5 in	7 in	1 7/16 in	12G358
	1 in - 1.0000	5 in	7 in	1 7/16 in	12G359
	1 1/16 in - 1.0625	5 in	7 in 7 in	1 5% in	12G360
	1 1/8 in - 1.125	5 in		1 5% in	12G361
	1 ¼ in - 1.25 1 ½ in - 1.5	5 in	7 in	1 13/16 in	12G363
	1 ½ in - 1.5	7 % in	10 in	2 in	12G367
	Morse Taper Sh	ank, Bla 2 ¾ in	ack Uxid 5 11/16 in	e MT1	13H785
	3/8 in - 0.375				
	½ in - 0.5	5 ½ in 4 ½ in	9 in 8 ½ 6 in	MT2 MT2	13H788 13H791
	5/8 in - 0.625	4 /2 III		MT3	
	13/16 in - 0.8125 1 1/16 in - 1.0625	5 in	9 ½ in 9 ½ in		13H797
		5 in		MT3	13H806
	1 1/8 in - 1.125 1 1/16 in - 1 0625	5 in 7 % in	9 ½ in 12 in	MT3	13H808
	1 7 10 III 1100E0			MT3 MT3	13H807 13H809
	1 ½ in - 1.125 1 ¾ in - 1.375	7 % in	12 in 13 in		
	1 ½ in - 1.5	7 % in 7 % in		MT4	13H812
	1 ½ in - 1.5 Straight with S	7 98 III	13 in	MT4	13H813
	3/16 in - 0.1875	1 % in	3 ½ in	1/4 in	13H830
	%2 in - 0.2812	1 78 in	4 in	1/4 in	13H833
	3/8 in - 0.375	2 % in	5 in	3/8 in	13H836
	7/16 in - 0.4375	3 1/8 in	5 1/4 in	7/16 in	13H837
		3 13/16 in	5 15/16 in	1/2 in	13H838
		4 1/8 in	6 ½ in	½ in	13H839
	% in - 0.5625 % in - 0.625	4 78 III 4 7/16 in	6 % in	1/2 in	13H840
	11/16 in - 0.6875	4 % in	7 in	½ in	13H841
	3/4 in - 0.75	4 % in	7 in	1/2 in	13H842
	13/16 in - 0.8125	5 1/8 in	7 1/4 in	1/2 in	13H843
	% in - 0.875	5 1/8 in	7 1/4 in	½ in	13H844
	15/4c in = 0 0375	5 1/8 in	7 1/4 in	1/2 in	13H845
	1 in - 1.0000	5 1/8 in	7 1/4 in	½ in	13H846
	1 1/16 in - 1 0625	5 1/8 in	7 1/4 in	1/2 in	13H847
	1 1/16 in - 1.0625 1 1/8 in - 1.125	5 1/8 in	7 1/4 in	½ in	13H848
	1 3/16 in - 1.1875	5 1/8 in	7 1/4 in	½ in	13H849
	1 ¼ in - 1.25	5 % in	7 ½ in	1/2 in	13H850
,	1 5/16 in - 1.3125	5 % in	7 ½ in	½ in	13H851
	1 % in - 1.375	5 % in	7 ½ in	1/2 in	13H852
	1 ½ in - 1.5	5 3/8 in	7 ½ in	½ in	13H853
	Straight with T				
	3/8 in - 0.375	2 ½ in	4 5% in	3/8 in	13H816
	7/16 in - 0.4375	3 1/4 in	5 % in	7/16 in	13H817
	½ in - 0.5	3 ¾ in	5 % in	1/2 in	13H818
	%16 in - 0.5625	3 ¾ in	5 % in	1/2 in	13H819
ı	5% in - 0.625	4 1/4 in	6 % in	½ in	13H820
•	21/32 in - 0.6562	4 1/4 in	6 % in	½ in	13H821
	11/16 in - 0.6875	4 1/4 in	6 % in	1/2 in	13H822
	3/4 in - 0.75	4 ½ in	6 % in	1/2 in	13H823
	13/16 in - 0.8125	4 ½ in	6 % in	1/2 in	13H825
	7/8 in - 0.875	4 ½ in	6 % in	½ in	13H826
	15/16 in - 0.9375	4 ½ in	6 % in	1/2 in	13H827
	15/16 in - 0.9375 1 in - 1.0000	4 ½ in	6 % in	½ in	13H828
	1 1/16 in - 1.0625	4 ½ in	6 % in	½ in	13H829

Flute Overall Shank