



TrueSize® Reamer



TrueSize® Reamer Series

TrueSize® Series 270 TrueSize® Series 270L
 TrueSize® Series 270P TrueSize® Series 272

ISO 9001:2015 Certified

Where **high performance** is the **standard**



All M.A. Ford® Reamers are ground between centers to assure maximum concentricity.

- No Centers OD .0433" (1.09mm) and below
- Male Centers OD .0434" (1.10mm) - .1280" (3.25mm)
- Female Centers OD .1281" (3.26mm) and larger
- All Diameters with Male Centers Chamfer Angle: 42 - 44 Degrees per side
- All Diameters without Male Centers Chamfer Angle: 44 - 46 Degrees per side

Solid Carbide TrueSize® Reamers Deliver High-Precision Hole Finishes

In applications that require high-precision hole finishes, or tighter diameter control, M.A. Ford® True Size® Reamers can be used with confidence. Solid Carbide Reamers are available in a wide range of sizes for virtually all materials, including cast iron, aluminum, stainless steel, exotic alloys, plastics and other non-ferrous materials.

Complete Family of Standard and Metric Sizes

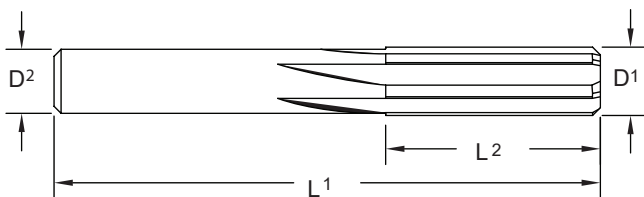
M.A. Ford® stocks over 900 inch and metric size reamers in its product line, ranging from .013 inch to 16mm diameter. These products are available for immediate shipment. M.A. Ford® also maintains an inventory of pre-finished blanks, which can be finished to your precise specifications and shipped within 72 hours upon request. **See our Rapid Turn Around Program for details.**

Material Removal Parameters

For proper finishing with a reamer, the correct amount of material must be left in the hole. If the hole is too close to the finish size, the reamer will tend to burnish the hole, and excessive tool wear will occur. If too much material is left, chips can clog the flutes of the reamer, resulting in a poor finish, poor size control, and possible tool breakage.

TrueSize® Carbide Range Reamer Straight Flute Series 270

TrueSize® Carbide Range Reamer Left Hand Spiral Series 270L



Recommended for general purpose reaming in most non-ferrous and non-metallic materials. Kept in stock as a semi-finished tool. When orders are received tools can be promptly finish ground to the desired diameter. Specify size when ordering.

Inch	
D1	Tolerance
≤ 3/8	+0.001/+0.003
> 3/8	+0.001/+0.004
D2	Tolerance
≤ 3/8	+0.000/-0.001
> 3/8	+0.000/-0.001
L1	Tolerance
≤ 3/8	+/- 1/16
> 3/8	+/- 1/16
L2	Tolerance
≤ 3/8	+/- 1/16
> 3/8	+/- 1/16



• Right hand cutting

TrueSize® Carbide Reamer Series 270P

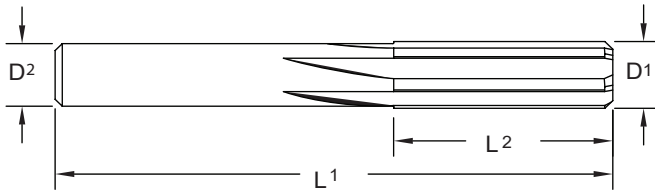
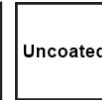


- Recommended for precision reaming in most materials.
- Kept in stock as a semi-finished tool. When orders are received tools can be promptly finish ground to the desired diameter. 1 week turn around. (25 piece order maximum).
- Specify size when ordering.
- Right hand cutting.

Inch	
D1	Tolerance
.0434 - .2530	+ .0001/+ .0000
.2531 - .6350	+ .0002/+ .0000
D2	Tolerance
.0434 - .6350	+ .000/- .001
L1/L2	Tolerance
.0434 - .6350	+/- 1/16

TrueSize® XP Xtreme Precision
Carbide Range Reamer
D1= .0434-.2530
D1 Tolerance = +.0001"/-.0000"
(+.0025mm/-.0000mm)

TrueSize® Carbide Reamer Series 272



- Recommended for general purpose reaming.
- Straight flutes.
- Well suited for ferrous metals and many non-ferrous and non-metallic materials.
- Special sizes, shank diameters, flute lengths, step reamers, coating, etc. available as specials. Call Customer Service at 800-553-8024 for a quote.

Inch	
D1	Tolerance
≤ 3/8	+ .0001/+ .0003
> 3/8	+ .0001/+ .0004
D2	Tolerance
≤ 3/8	+ .000/- .001
> 3/8	+ .000/- .001
L1	Tolerance
≤ 3/8	+/- 1/16
> 3/8	+/- 1/16
L2	Tolerance
≤ 3/8	+/- 1/16
> 3/8	+/- 1/16

Metric (mm)	
D1	Tolerance
0.35-16.0	DIN1420 H7
D2	Tolerance
0.35-16.0	+0.00/-0.03
L1	Tolerance
0.35-16.0	+/- 1.5
L2	Tolerance
0.35-16.0	+/- 1.5

DIN1420 H7	
D1	Tolerance (mm)
≤ 3mm	+ .004/+ .008
>3mm-6mm	+ .005/+ .010
>6mm-10mm	+ .006/+ .012
>10mm-16mm	+ .008/+ .015

Need a Reamer Fast?

Request Rapid Turn
Around Service.
Sizes above .0433"
(1.10mm)

**Contact Customer
Service for Delivery.**
1 (800) 553-8024



The M.A. Ford® Custom Tool Division will help you design a tool that fits your tooling needs when machining challenges just can't be solved with off-the-shelf tooling. Our Custom Tool Division develops and supplies custom engineered carbide tools of unmatched quality which meet or exceed their productivity, delivery and utilized cost expectations.

Call us today to increase your productivity and profits with Custom Tool: **877-522-2885** or email: customtools@maford.com. More information about our custom tool division can be found at: <https://www.maford.com/Page/CustomTools.aspx>