

## TrueSize® Carbide Range Reamer Straight Flute Series 270

## TrueSize® Carbide Range Reamer Left Hand Spiral Series 270L



Before you order a 270 Series - check our listing of standard diameters in the 272 Series.



Competitors special sizes are our standards!



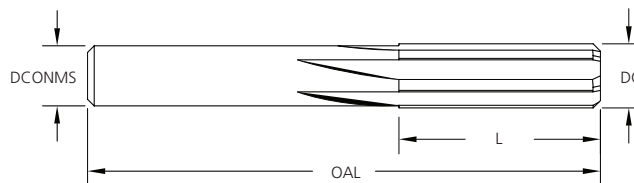
Recommended for general purpose reaming in most materials. Kept in stock as a semi-finished tool. When orders are received tools can be promptly finish ground to the desired diameter. Specify size when ordering.



Series 270      Series 270L

- Reamer Diameter  $\leq .0433"$  (1.09mm) = No Centers.
- Reamer Diameter  $.0434"$  -  $.1280"$  (1.10mm - 3.25mm) = Male Centers.
- Reamer Diameter  $\geq .1281"$  (3.26mm) = Female Centers.
- All Diameters with Male Centers, Chamfer Angle =  $42^\circ$  -  $44^\circ$  per side.
- All Diameters without Male Centers, Chamfer Angle =  $44^\circ$  -  $46^\circ$  per side.

### Right Hand Cutting



Inch	
DC	Tolerance
$\leq 3/8$	+ .0001/+ .0003
$> 3/8$	+ .0001/+ .0004
DCONMS	Tolerance
$\leq 3/8$	+ .000/- .001
$> 3/8$	+ .000/- .001
OAL	Tolerance
$\leq 3/8$	+/- 1/16
$> 3/8$	+/- 1/16
L	Tolerance
$\leq 3/8$	+/- 1/16
$> 3/8$	+/- 1/16

Metric (mm)	
DC	Tolerance
$\leq 9.52$	+ .0025/+ .0076
$> 9.52$	+ .0025/+ .0102
DCONMS	Tolerance
0.35 - 3.15	+0/-0.03
OAL	Tolerance
0.35 - 3.15	+/- 1.5
L	Tolerance
0.35 - 3.15	+/- 1.5

### Need a Reamer Fast?

Request Rapid Turn Around Service.  
Straight Flute sizes above  $.0433"$  (1.10mm)  
Contact Customer Service For Delivery Times.  
*25 piece maximum.*



Series 270		Series 270L		DCONMS		OAL		L		NOF
DC				Inch	mm	Inch	mm	Inch	mm	
Inch	mm	Inch	mm							
.0135-.0200	00.34-0.50	.0135-.0200	00.34-0.50	.0135-.0433 are no longer a standard item. Contact customer service for price and availability as a special quoted item. 800-553-8024 or 563-391-6220						
.0201-.0400	00.51-1.01	.0201-.0400	00.51-1.01							
.0401-.0433	01.02-1.09	.0401-.0433	01.02-1.09							
.0434-.0519	01.10-1.31	.0434-.0519	01.10-1.31	.043	1.09	1-1/2	38	3/8	9.5	4
.0520-.0590	01.32-1.49	.0520-.0590	01.32-1.49	.046	1.17	1-1/2	38	3/8	9.5	4
.0591-.0660	01.50-1.67	.0591-.0660	01.50-1.67	.058	1.47	1-1/2	38	3/8	9.5	4
.0661-.0740	01.68-1.87	.0661-.0740	01.68-1.87	.065	1.65	2	51	1/2	12.5	4
.0741-.0810	01.88-2.05	.0741-.0810	01.88-2.05	.073	1.85	2	51	1/2	12.5	4
.0811-.0890	02.06-2.26	.0811-.0890	02.06-2.26	.080	2.03	2	51	1/2	12.5	4
.0891-.0970	02.27-2.46	.0891-.0970	02.27-2.46	.088	2.24	2	51	1/2	12.5	4
.0971-.1050	02.47-2.66	.0971-.1050	02.47-2.66	.096	2.44	2-1/2	64	5/8	16	4
.1051-.1130	02.67-2.87	.1051-.1130	02.67-2.87	.104	2.64	2-1/2	64	5/8	16	4
.1131-.1210	02.88-3.07	.1131-.1210	02.88-3.07	.112	2.84	2-1/2	64	5/8	16	4
.1211-.1280	03.08-3.25	.1211-.1280	03.08-3.25	.120	3.05	2-1/2	64	5/8	16	4
.1281-.1360	03.26-3.45	.1281-.1360	03.26-3.45	.127	3.23	2-1/2	64	3/4	19	4
.1361-.1440	03.46-3.65	.1361-.1440	03.46-3.65	.135	3.43	2-1/2	64	3/4	19	4
.1441-.1520	03.66-3.86	.1441-.1520	03.66-3.86	.143	3.63	2-1/2	64	3/4	19	4
.1521-.1590	03.87-4.03	.1521-.1590	03.87-4.03	.151	3.84	2-1/2	64	3/4	19	4
.1591-.1670	04.04-4.24	.1591-.1670	04.04-4.24	.158	4.01	3	76	7/8	22	4
.1671-.1750	04.25-4.44	.1671-.1750	04.25-4.44	.166	4.22	3	76	7/8	22	4
.1751-.1830	04.45-4.64	.1751-.1830	04.45-4.64	.174	4.42	3	76	7/8	22	4
.1831-.1910	04.65-4.85	.1831-.1910	04.65-4.85	.182	4.62	3	76	7/8	22	4
.1911-.1990	04.86-5.05	.1911-.1990	04.86-5.05	.190	4.83	3	76	1	25.5	4
.1991-.2060	05.06-5.23	.1991-.2060	05.06-5.23	.198	5.03	3	76	1	25.5	4
.2061-.2140	05.24-5.43	.2061-.2140	05.24-5.43	.205	5.21	3	76	1	25.5	4
.2141-.2220	05.44-5.63	.2141-.2220	05.44-5.63	.213	5.41	3	76	1	25.5	4
.2221-.2300	05.64-5.84	.2221-.2300	05.64-5.84	.221	5.61	3	76	1	25.5	4
.2301-.2370	05.85-6.01	.2301-.2370	05.85-6.01	.229	5.82	3	76	1	25.5	4
.2371-.2450	06.02-6.22	.2371-.2450	06.02-6.22	.236	5.99	3	76	1	25.5	4
.2451-.2530	06.23-6.42	.2451-.2530	06.23-6.42	.244	6.20	3	76	1	25.5	4
.2531-.2710	06.43-6.88	.2531-.2710	06.43-6.88	.252	6.40	3-1/2	89	1-1/8	28.5	6
.2711-.2860	06.89-7.26	.2711-.2860	06.89-7.26	.270	6.86	3-1/2	89	1-1/8	28.5	6
.2861-.3020	07.27-7.67	.2861-.3020	07.27-7.67	.285	7.24	3-1/2	89	1-1/8	28.5	6
.3021-.3180	07.68-8.07	.3021-.3180	07.68-8.07	.301	7.65	3-1/2	89	1-1/8	28.5	6
.3181-.3330	08.08-8.45	.3181-.3330	08.08-8.45	.317	8.05	3-1/2	89	1-1/4	32	6
.3331-.3490	08.46-8.86	.3331-.3490	08.46-8.86	.332	8.43	3-1/2	89	1-1/4	32	6
.3491-.3640	08.87-9.24	.3491-.3640	08.87-9.24	.348	8.84	3-1/2	89	1-1/4	32	6
.3641-.3860	09.25-9.80	.3641-.3860	09.25-9.80	.363	9.22	3-1/2	89	1-1/4	32	6
.3861-.4150	09.81-10.54			.380	9.65	3-1/2	89	1-1/4	32	6
.4151-.4450	10.55-11.30			.410	10.41	4	102	1-3/8	35	6
.4451-.4750	11.31-12.06			.440	11.18	4	102	1-3/8	35	6
.4751-.5100	12.07-12.95			.470	11.93	4	102	1-1/2	38	6
.5101-.5400	12.96-13.71			.505	12.83	4	102	1-1/2	38	6
.5401-.5700	13.72-14.47			.535	13.59	4	102	1-1/2	38	6
.5701-.6000	14.48-15.24			.565	14.35	4	102	1-3/4	44.5	6
.6001-.6350	15.25-16.13			.595	15.11	4	102	1-3/4	44.5	6

