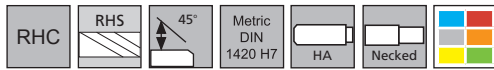


TrueSize® NC Machine Reamer - Series 275



- Solid Carbide
- Recommended for CNC reaming applications
- Common metric shanks for high-accuracy clamping
- Extended reach for increased hole depths
- RH Spiral / RH Cut design for both blind and through hole applications
- Suited for most materials



Inch Sizes	
DC	Tolerance
.0000 - .4375	+0.0001/+0.0003
DCONMS	Tolerance (h6)
.0000 - .1181	+0/-0.00024
.1182 - .2362	+0/-0.00031
.2363 - .3937	+0/-0.00035
.3938 - .5512	+0/-0.00043

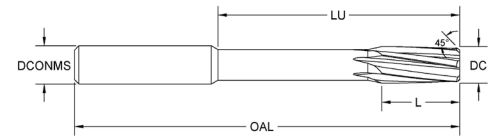
Metric (mm) Sizes	
DC	Tolerance
1.00 - 12.00	DIN 1420 H7
DCONMS	Tolerance (h6)
0.00 - 3.00	+0/-0.006
3.01 - 6.00	+0/-0.008
6.01 - 10.00	+0/-0.009
10.01 - 14.00	+0/-0.011

DIN 1420 H7	
DC	Tolerance
≤ 3mm	+0.0041/+0.0078
>3mm - 6mm	+0.0051/+0.0100
> 6mm - 10mm	+0.0061/+0.0120
> 10mm - 12mm	+0.0078/+0.0150

Lead Chamfer Width (45° ± 1°)	
DC	Width
.0000 - .0970	21% - 23% of DC
.0971 - .1360	.015 - 23% of DC
.1361 - .3750	.020 - .040
.3751 - .4724	.030 - .050

Lead Chamfer Width (45° ± 1°)	
DC	Width
0.00 - 2.45	21% - 23% of DC
2.46 - 3.45	0.38 - 23% of DC
3.46 - 9.52	0.5 - 1.02
9.53 - 12.00	0.76 - 1.27

Tool No.	EDP	DC				DCONMS	OAL	L	LU	NOF
		Inch	Wire	mm	Decimal					
275M0100	27530			1.00	0.0394	3	50	6	22	4
275M0150	27531			1.50	0.0590	3	50	9	22	4
27506200	27532				0.0620	3	50	9	22	4
27506250	27533	1/16			0.0625	3	50	9	22	4
27506350	27534		52		0.0635	3	50	9	22	4
275M0200	27535			2.00	0.0787	3	50	12	22	4
27509350	27536		42		0.0935	3	50	12	22	4
27509370	27537	3/32			0.0937	3	50	12	22	4
275M0250	27538			2.50	0.0984	3	50	12	22	4



TrueSize® NC Machine Reamer - Series 275

Tool No.	EDP	DC				DCONMS	OAL	L	LU	NOF
		Inch	Wire	mm	Decimal					
275M0300	27539			3.00	0.1181	4	66	12	38	4
27512450	27540	1/8 DP2			0.1245	4	66	12	38	4
27512500	27541	1/8			0.1250	4	66	12	38	4
27512550	27542				0.1255	4	66	12	38	4
27512600	27543	1/8 OS			0.1260	4	66	12	38	4
27512850	27544		30		0.1285	4	66	12	38	4
27513000	27545				0.1300	4	66	12	38	4
275M0350	27546			3.50	0.1378	4	66	12	38	4
27515620	27547	5/32			0.1562	4	66	12	38	4
275M0400	27548			4.00	0.1575	6	76	12	40	4
275M0450	27549			4.50	0.1772	6	76	12	40	4
27518150	27550				0.1815	6	76	12	40	4
27518700	27551	3/16 DP2			0.1870	6	76	12	40	4
27518750	27552	3/16			0.1875	6	76	12	40	4
27518800	27553				0.1880	6	76	12	40	4
275M0500	27554			5.00	0.1969	6	76	12	40	4
275M0550	27555			5.50	0.2165	6	76	12	40	4
27521870	27556	7/32			0.2187	6	76	12	40	4
275M0600	27557			6.00	0.2362	8	101	12	65	4
27524950	27558	1/4 DP2			0.2495	8	101	16	65	4
27525000	27559	1/4			0.2500	8	101	16	65	4
27525050	27560				0.2505	8	101	16	65	4
27525100	27561	1/4 OS			0.2510	8	101	16	65	4
275M0650	27562			6.50	0.2559	8	101	16	65	6
275M0700	27563			7.00	0.2756	8	101	16	65	6
27528120	27564	9/32			0.2812	8	101	16	65	6
275M0750	27566			7.50	0.2953	8	101	16	65	6
27531250	27567	5/16			0.3125	8	101	16	65	6
275M0800	27568			8.00	0.3150	10	103	16	63	6
275M0850	27569			8.50	0.3346	10	103	19	63	6
275M0900	27570			9.00	0.3543	10	103	19	63	6
275M0950	27571			9.50	0.3740	10	103	19	63	6
27537450	27572	3/8 DP2			0.3745	10	103	19	63	6
27537500	27573	3/8			0.3750	10	103	19	63	6
27537600	27574	3/8 OS			0.3760	10	103	19	63	6
275M1000	27575			10.00	0.3937	12	120	19	75	6
275M1050	27576			10.50	0.4134	12	120	19	75	6
275M1100	27577			11.00	0.4331	12	120	19	75	6
27543750	27578	7/16			0.4375	12	120	19	75	6
275M1150	27579			11.50	0.4527	12	120	19	75	6
275M1200	27581			12.00	0.4724	14	125	19	80	6

275 Series Recommended Cutting Data - Inch

Workpiece Material Group	I S O	Vc - SFM Low - High	Tool Diameter (Inch)					
			.039 - .062	.063 - .124	.125 - .188	.189 - .281	.282 - .375	.376 - .472
			Feed (in/rev)					
Low Carbon Steels	P	100 - 140	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Medium Carbon Steels		80 - 120	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Alloy Steels		70 - 110	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Die / Tool Steels		50 - 90	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Free Machining Stainless Steels	M	60 - 100	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Austenitic Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Difficult Stainless Steels		20 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
PH Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
High Temp Alloys	S	20 - 50	.0005 - .003	.004 - .008	.006 - .012	.008 - .012	.008 - .016	.010 - .018
Titanium Alloys		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Gray Cast Irons	K	80 - 120	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Ductile Cast Irons		70 - 110	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Malleable Cast Irons		60 - 100	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminum - ≤ 10% Si	N	250 - 350	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminium - > 10% Si		200 - 300	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Copper / Brass		180 - 250	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Hardened Steels 45-50 HRC	H	40 - 70	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Hardened Steels 50-55 HRC		30 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024

Stock Allowance for NC Machine Reamers - Inch	
Reamer Diameter (Inch)	Total Allowance
.039 - .062	.003 - .006
.062 - .125	.005 - .009
.125 - .250	.007 - .012
.250 - .472	.010 - .015

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

275 Series Recommended Cutting Data - Metric

Workpiece Material Group	I S O	Vc - M/Min Low - High	Drill Diameter (mm)					
			1.0 - 1.5	1.6 - 3.0	3.1 - 5.0	5.1 - 7.0	7.1 - 9.5	9.6 - 12.0
			Feed (mm/rev)					
Low Carbon Steels	P	30 - 45	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Medium Carbon Steels		25 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Alloy Steels		20 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Die / Tool Steels		15 - 25	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Free Machining Stainless Steels	M	20 - 30	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Austenitic Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Difficult Stainless Steels		5 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
PH Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
High Temp Alloys	S	5 - 15	.015 - .075	.100 - .205	.105 - .305	.205 - .305	.205 - .405	.255 - .455
Titanium Alloys		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Gray Cast Irons	K	25 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Ductile Cast Irons		20 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Malleable Cast Irons		20 - 30	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminum - ≤ 10% Si	N	75 - 105	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminium - > 10% Si		60 - 90	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Copper / Brass		55 - 75	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Hardened Steels 45-50 HRC	H	10 - 20	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Hardened Steels 50-55 HRC		10 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610

Stock Allowance for NC Machine Reamers - Metric	
Reamer Diameter (mm)	Total Allowance
1.0 - 1.5	.08 - .15
1.5 - 3.0	.13 - .23
3.0 - 6.0	.18 - .30
6.0 - 12.0	.25 - .38

If you don't see
the size you need -
Contact Customer
Service for
assistance.

Safety Note

Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.



WARNING: This product can expose you to chemicals including cobalt which is known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov.

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.



www.mafor.com



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