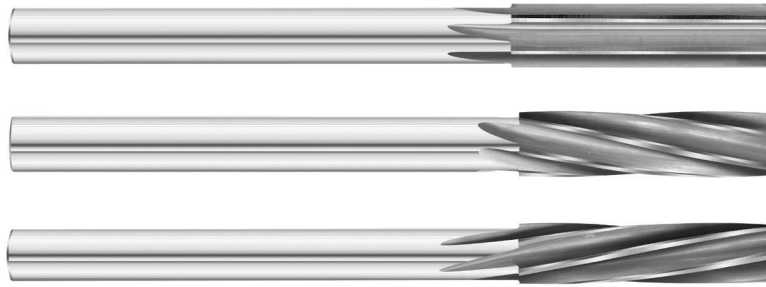


REAMERS

1410 JIT Decimal Size Reamers Solid Carbide



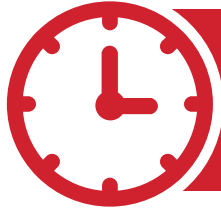
SIZE RANGE	FLUTE LENGTH	SHANK	OAL	FLUTES	EDP		
					ST	RH	LH
.0312 - .0394	3/8	.0312	1 1/2	4	1410S01	1410R01	1410L01
.0395 - .0484	3/8	.0312	1 1/2	4	1410S02	1410R02	1410L02
.0485 - .0574	3/8	.0469	1 1/2	4	1410S03	1410R03	1410L03
.0575 - .0654	3/8	.0469	1 1/2	4	1410S04	1410R04	1410L04
.0655 - .0804	1/2	.0625	2	4	1410S05	1410R05	1410L05
.0805 - .0964	1/2	.0781	2	4	1410S06	1410R06	1410L06
.0965 - .1124	5/8	.0938	2 1/4	4	1410S07	1410R07	1410L07
.1125 - .1284	5/8	.1094	2 1/4	4	1410S08	1410R08	1410L08
.1285 - .1444	3/4	.1250	2 1/2	4	1410S09	1410R09	1410L09
.1445 - .1594	3/4	.1406	2 1/2	4	1410S10	1410R10	1410L10
.1595 - .1744	7/8	.1562	2 3/4	4	1410S11	1410R11	1410L11
.1745 - .1914	7/8	.1719	2 3/4	4	1410S12	1410R12	1410L12
.1915 - .2234	1	.1875	3	6	1410S13	1410R13	1410L13
.2235 - .2544	1	.2188	3	6	1410S14	1410R14	1410L14
.2545 - .2844	1 1/8	.2500	3 1/4	6	1410S15	1410R15	1410L15
.2845 - .3164	1 1/8	.2812	3 1/4	6	1410S16	1410R16	1410L16
.3165 - .3484	1 1/4	.3125	3 1/2	6	1410S17	1410R17	1410L17
.3485 - .3794	1 1/4	.3438	3 1/2	6	1410S18	1410R18	1410L18
.3795 - .4104	1 1/2	.3750	4	6	1410S19	1410R19	1410L19
.4105 - .4414	1 1/2	.4062	4	6	1410S20	1410R20	1410L20
.4415 - .4724	1 1/2	.4375	4	6	1410S21	1410R21	1410L21
.4725 - .5054	1 1/2	.4688	4	6	1410S22	1410R22	1410L22

TOLERANCES	DIAMETER		SHANK
	UP TO 1.0100"	+0.0002"-.0000"	+0.0005"-.0005"
	OVER 1.0100"	+0.0003"-.0000"	+0.013mm-0.013mm
	UP TO 25.654mm	+0.005mm-0.000mm	
	OVER 25.655mm	+0.008mm-0.000mm	
.0001" Tolerances Available (+20%)			

REAMERS

1410 **JIT** Decimal Size Reamers Solid Carbide

24/HR
Just-in-time
delivery.



12 pieces or less
ALL STYLES

ORDER DEADLINE
3:00pm est

Straight Flutes

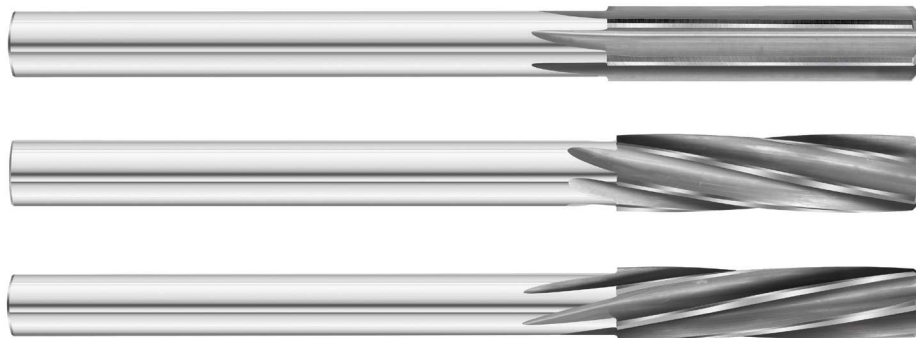
For all types of general reaming applications.

RH Spiral Flutes

For blind holes and abrasive, ductile materials. Do not use for holes with interruptions unless material is reasonably soft.

LH Spiral Flutes

Produces better finishes on hard materials such as heat-treated steels. Shear action is excellent for holes with interruptions; i.e., keyways, elongated slots, etc.



AVAILABLE ON



Quote JIT
reamers online
with FAST quotes!

Straight Flute Standard Sizes available in 1400 Series Stub
Coatings at Tolerances as Low as .0001" (Additional Charges May Apply)
Manufactured using Female and Male Centers for improved concentricity
Male Centers on items up to .1124" (2.86mm)
45° Lead Angle
Speeds and Feeds, see fullertontool.com

TOLERANCES	DIAMETER		SHANK
	UP TO 1.0100"	+0.0002"-0.0000"	+0.0005"-0.0005"
OVER 1.0100"	+0.0003"-0.0000"	+0.013mm-0.013mm	
UP TO 25.654mm	+0.005mm-0.000mm		
OVER 25.655mm	+0.008mm-0.000mm		
.0001" Tolerances Available (+20%)			



FULLERTON

S P E E D S / F E E D S

Material	Speed SFM	Feed (IPR)			SMPM	Feed (MMPR)		
		.1250	.2500	.5000		3.00mm	6.00mm	12.00mm
High Si Aluminum >10%	75-200	.0040	.0080	.0120	22-60	.1016	.2032	.3048
Low Si Aluminum <10%	100-300	.0050	.0100	.0150	30-91	.1270	.2540	.3810
Composites	-	-	-	-	-	-	-	-
Plastics	-	-	-	-	-	-	-	-
Brass & Copper	75-150	.0030	.0040	.0060	22-45	.0762	.1016	.1524
Graphite	-	-	-	-	-	-	-	-
Cast Iron								
Soft	75-150	.0050	.0080	.0120	22-45	.1270	.2032	.3048
Medium	60-100	.0050	.0080	.0120	18-30	.1270	.2032	.3048
Malleable	40-100	.0030	.0060	.0100	12-30	.0762	.1524	.2540
Bronze	65-125	.0030	.0040	.0060	19-38	.0762	.1016	.1524
Hardened Steels	30-90	.0020	.0020	.0040	9-27	.0508	.0508	.1016
Steels								
Low Carbon	60-125	.0030	.0060	.0100	18-28	.0762	.1524	.2540
Medium Carbon	100-150	.0030	.0050	.0080	30-45	.0762	.1270	.2032
Stainless Steels								
Free Machining	50-90	.0050	.0080	.0120	15-27	.1270	.2032	.3048
Work Hardening	30-75	.0030	.0060	.0100	9-22	.0762	.1524	.2540
Super Alloys	40-80	.0025	.0035	.0055	12-24	.0635	.0889	.1397
Titanium								
Soft	50-125	.0030	.0060	.0100	15-38	.0762	.1524	.2540
Hard	20-60	.0020	.0040	.0080	6-18	.0508	.1016	.2032

Stock Removal

Sufficient amount of stock should be left in the work area to permit the reamer to cut rather than to burnish or glaze.

The amount of stock removal for machine reaming:

Reamer Diameter	Suggested Stock Removal
.2500"	.008" - .010"
.2501" - .5000"	.012" - .015"
.5001" - 1.0000"	.017" - .020"
1.001" - 1.5000"	.020" - .025"

The use of coolants will help produce a superior finish when reaming.

Not Recommended for Composites, Plastics, or Graphite. The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process, then cautiously progress incrementally to achieve optimum performance.