

REAMERS

1450 JIT Decimal Size Reamers



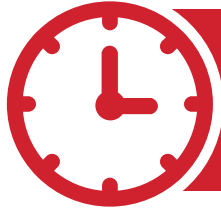
SIZE RANGE	FLUTE LENGTH	SHANK	OAL	FLUTES	STEEL SHANK	EDP		
						ST	RH	LH
.1105 - .1284	7/8	.1094	3 1/2	4		1450S01	1450R01	1450L01
.1285 - .1444	7/8	.1250	3 1/2	4		1450S02	1450R02	1450L02
.1445 - .1594	1	.1406	4	4		1450S03	1450R03	1450L03
.1595 - .1744	1	.1562	4	4		1450S04	1450R04	1450L04
.1745 - .1914	1 1/8	.1719	4 1/2	4		1450S05	1450R05	1450L05
.1915 - .2234	1 1/4	.1875	5	6		1450S06	1450R06	1450L06
.2235 - .2544	1 1/2	.2188	6	6		1450S07	1450R07	1450L07
.2545 - .2844	1 1/2	.2500	6	6		1450S08	1450R08	1450L08
.2845 - .3164	1 5/8	.2812	6	6		1450S09	1450R09	1450L09
.3165 - .3484	1 5/8	.3125	6	6		1450S10	1450R10	1450L10
.3485 - .3794	1 3/4	.3438	7	6	✓	1450S11	1450R11	1450L11
.3795 - .4104	1 3/4	.3750	7	6	✓	1450S12	1450R12	1450L12
.4105 - .4414	1 3/4	.4062	7	6	✓	1450S13	1450R13	1450L13
.4415 - .4724	1 3/4	.4375	8	6	✓	1450S14	1450R14	1450L14
.4725 - .5054	1 3/4	.4688	8	6	✓	1450S15	1450R15	1450L15
.5055 - .5360	1 7/8	.5000	9	6	✓	1450S16	1450R16	1450L16
.5361 - .5670	1 7/8	.5000	9	6	✓	1450S16B	1450R16B	1450L16B
.5671 - .5990	1 7/8	.5625	9	6	✓	1450S17	1450R17	1450L17
.5991 - .6300	1 7/8	.5625	9	6	✓	1450S17B	1450R17B	1450L17B
.6301 - .6630	2	.6250	9 1/2	6	✓	1450S18	1450R18	1450L18
.6631 - .6930	2	.6250	9 1/2	6	✓	1450S18B	1450R18B	1450L18B
.6931 - .7250	2	.6875	9 1/2	6	✓	1450S19	1450R19	1450L19
.7251 - .7560	2	.6875	9 1/2	6	✓	1450S19B	1450R19B	1450L19B
.7561 - .7870	2	.7500	10	8	✓	1450S20	1450R20	1450L20
.7871 - .8190	2	.7812	10	8	✓	1450S21	1450R21	1450L21
.8191 - .8500	2	.8125	10	8	✓	1450S22	1450R22	1450L22
.8501 - .8820	2	.8438	10	8	✓	1450S23	1450R23	1450L23
.8821 - .9120	2	.8750	10	8	✓	1450S24	1450R24	1450L24
.9121 - .9440	2	.9062	10	8	✓	1450S25	1450R25	1450L25
.9441 - .9760	2	.9375	10	8	✓	1450S26	1450R26	1450L26
.9761 - 1.0100	2	.9688	10	8	✓	1450S27	1450R27	1450L27

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%)			

REAMERS

1450 JIT Decimal Size Reamers

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 Standard Available with Coatings at Tolerances as Low as .0001" (Additional Charges May Apply)
Steel Shanks on items with Cutting Diameter .3485" and over
Female Centers
45° Lead Angle
Speeds and Feeds, see fullertontool.com

Due to temperatures reached in the coating process, Fullerton Tool cannot guarantee concentricity on reamers with Cutting Diameter .3485" and over.

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.