

CARBIDE, Straight Shank Chucking Reamers - Straight Flute

| ISO | VDI 3323 | Material Description | SFM (ft/min.) | IPR(inch/rev.) | | | |
|-----|----------|---|---------------|----------------|-------------|-------------|-------------|
| | | | | <Ø.0394 | Ø.0394 | Ø.0787 | Ø.1575 |
| P | 1 | Non-alloy steel | 59 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 2 | | 56 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 3 | | 49 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 4 | | 49 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 5 | | 49 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 6 | Low alloy steel | 56 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 7 | | 46 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 8 | | 46 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 9 | | | | | | |
| | 10 | High alloyed steel, and tool steel | 43 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 11 | | | | | | |
| M | 12 | Stainless steel | 26 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 13 | | 23 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| | 14 | | 20 | .0008~.0016 | .0016~.0024 | .0024~.0031 | .0031~.0039 |
| K | 15 | Grey cast iron | 66 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 16 | | 49 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 17 | Nodular cast iron | 59 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 18 | | 43 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 19 | Malleable cast iron | 59 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| | 20 | | 43 | .0008~.002 | .002~.0031 | .0031~.0039 | .0039~.0047 |
| N | 21 | Aluminum-wrought alloy | 98 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 22 | | 98 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 23 | Aluminum-cast, alloyed | 98 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 24 | | 82 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 25 | | | | | | |
| | 26 | | 82 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 27 | Copper and Copper Alloys (Bronze / Brass) | 72 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 28 | | 75 | .0008~.0024 | .0024~.0039 | .0039~.0051 | .0051~.0063 |
| | 29 | Non Metallic Materials | | | | | |
| | 30 | | | | | | |

SFM = ft/min.
IPR = inch/rev.

| IPR(inch/rev.) | | | | | |
|----------------|-------------|-------------|-------------|-------------|-------------|
| Ø.2362 | Ø.315 | Ø.3937 | Ø.4724 | Ø.5512 | Ø.6299 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0039~.0047 | .0047~.0059 | .0059~.0071 | .0071~.0083 | .0083~.0094 | .0094~.0106 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0047~.0063 | .0063~.0079 | .0079~.0094 | .0094~.011 | .011~.0126 | .0126~.0142 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |
| .0063~.0079 | .0079~.0098 | .0098~.0118 | .0118~.0138 | .0138~.0157 | .0157~.0177 |

