

HIGH PRECISION

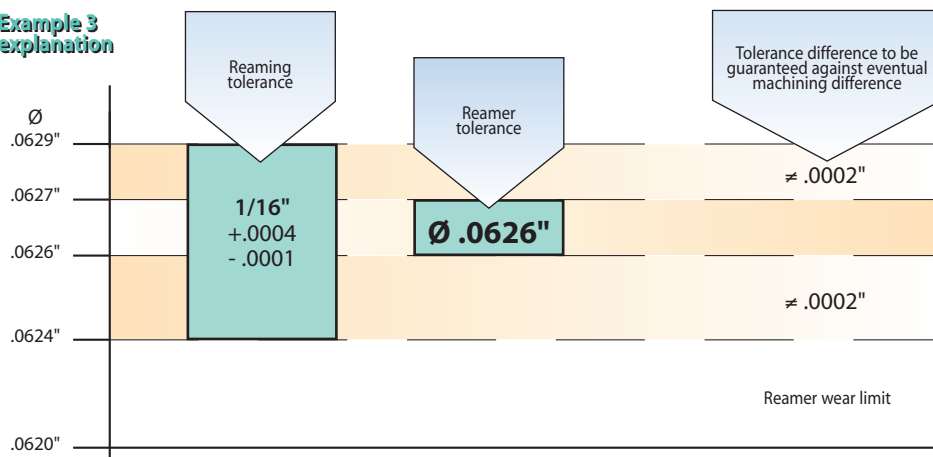


REAMERS

1 - HOW TO CHOOSE STANDARD INCH REAMERS

Examples	REAMING (Hole)		REAMER (Tool)	
	Ø	Tolerance	Ø	Tolerance
1	1/64" + .00006 - .00012	.01568" .01550"	EDP # 861000395 .01551"	.01559" .01551"
2	1/32" + .0001 - .0002	.03135" .03105"	EDP # 86000079 .03110"	.03122" .03110"
3	1/16" + .0004 - .0001	.0629" .0624"	EDP # 86000159 .0626"	.06272" .06260"

Example 3 explanation

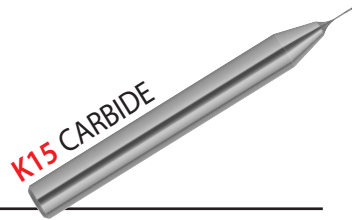


2 - HOW TO CHOOSE METRIC REAMERS

Code 8610 - 8600 : pages 37-41

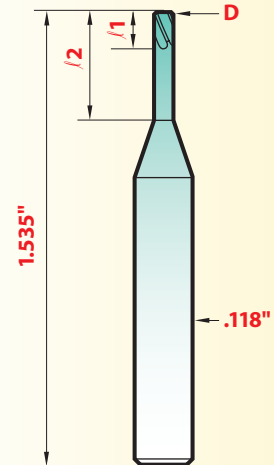
Tolerance	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14
D10	2,04	3,04	4,05	5,06	6,06	8,07	10,08	12,10	14,10
E 8	2,02	3,02	4,03	5,03	6,03	8,03	10,03	12,04	14,04
E 9	2,03	3,03	4,04	5,04	6,04	8,05	10,05	12,06	14,06
F 7	2,01	3,01	4,01	5,01	6,01	8,02	10,02	12,02	14,02
F 8	2,01	3,01	4,02	5,02	5,02	8,02	10,02	12,03	14,03
G 7	2,00	3,00	4,01	5,02	5,02	8,01	10,01	12,01	14,01
H 6	2,00	3,00	4,00	5,00	6,00	8,00	10,00	12,00	14,00
H 8	2,01	3,01	4,01	5,01	6,01	8,01	10,01	12,01	14,01
H 9	2,01	3,01	4,02	5,02	6,02	8,02	10,02	12,03	14,03
M 7	1,99	2,99	3,99	4,99	5,99	7,99	9,99	11,99	13,99
N 7	1,99	2,99	3,99	4,99	5,99	7,98	9,98	11,98	13,98
P 7	1,99	2,99	3,98	4,98	5,98	7,98	9,98	11,97	13,97
R 7	1,98	2,98	3,98	4,98	5,98	7,98	9,98	11,97	13,97





HIGH PRECISION MICRO-REAMERS

REAMING



MICRO-PRECISION

D .0002" increment	\1	\2	magaforce 8610
.0079 to .0096	.036	.079	EDP # SEE BELOW
.0098 to .0116	.043	.098	
.0118 to .0136	.055	.118	
.0138 to .0156	.067	.138	
.0157 to .0195	.079	.157	
.0197 to .0234	.091	.197	

Micro-reamers manufactured and stocked in all diameters at every .0002" increment. Their reinforced shank offers a greater stability necessary for these high precision tools.

TOLERANCE ± .00004"

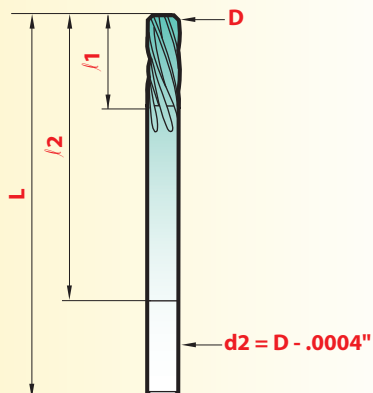
4 flutes, 10 degree left spiral, right hand cut.

EDP 8610				SIZE
#	mm	Decimal	inch	Wire
86100	0.200	.0079		92
86100	0.205	.0081		
86100	0.210	.0083		91
86100	0.215	.0085		
86100	0.220	.0087		90
86100	0.225	.0089		
86100	0.230	.0091		89
86100	0.235	.0093		
86100	0.240	.0094		88
86100	0.245	.0096		
86100	0.250	.0098		
86100	0.255	.0100		87
86100	0.260	.0102		
86100	0.265	.0104		86
86100	0.270	.0106		
86100	0.275	.0108		
86100	0.280	.0110		85
86100	0.285	.0112		
86100	0.290	.0114		84
86100	0.295	.0116		
86100	0.300	.0118		
86100	0.305	.0120		83
86100	0.310	.0122		
86100	0.315	.0124		82
86100	0.320	.0126		
86100	0.325	.0128		
86100	0.330	.0130		81

EDP 8610				SIZE
#	mm	Decimal	inch	Wire
86100	0.335	.0132		
86100	0.340	.0134		80
86100	0.345	.0136		
86100	0.350	.0138		
86100	0.355	.0140		
86100	0.360	.0142		
86100	0.365	.0144		79
86100	0.370	.0146		
86100	0.375	.0148		
86100	0.380	.0150		
86100	0.385	.0152		
86100	0.390	.0154		
86100	0.395	.0156	1/64	
86100	0.400	.0157		
86100	0.405	.0159		78
86100	0.410	.0161		
86100	0.415	.0163		
86100	0.420	.0165		
86100	0.425	.0167		
86100	0.430	.0169		
86100	0.435	.0171		
86100	0.440	.0173		
86100	0.445	.0175		
86100	0.450	.0177		
86100	0.455	.0179		77
86100	0.460	.0181		
86100	0.465	.0183		

EDP 8610				SIZE
#	mm	Decimal	inch	Wire
86100	0.470	.0185		
86100	0.475	.0187		
86100	0.480	.0189		
86100	0.485	.0191		
86100	0.490	.0193		
86100	0.495	.0195		
86100	0.500	.0197		
86100	0.505	.0199		76
86100	0.510	.0201		
86100	0.515	.0203		
86100	0.520	.0205		
86100	0.525	.0207		
86100	0.530	.0209		75
86100	0.535	.0211		
86100	0.540	.0213		
86100	0.545	.0215		
86100	0.550	.0217		
86100	0.555	.0219		
86100	0.560	.0220		
86100	0.565	.0222		
86100	0.570	.0224		74
86100	0.575	.0226		
86100	0.580	.0228		
86100	0.585	.0230		
86100	0.590	.0232		
86100	0.595	.0234		

HIGH PRECISION MINIATURE REAMERS



TOLERANCE 0 + .00012"

Ø .0236" to .0929 = 4 flutes,
Ø .0933" to .5138 = 6 flutes,
10 degree left spiral/right hand cut.



MICRO-PRECISION

D .0004" increment	\1	\2	L	d2	magaforce 8600
.0236 to .0413	.275	.393	1.30	D	EDP # SEE BELOW
.0417 to .0610	.393	.944	1.58	D	
.0614 to .0929	.433	1.220	1.97	D	
.0933 to .1476	.590	1.500	2.25	D	
.1480 to .1673	.748	1.930	2.95	.158	
.1677 to .1870	.827	2"	3.15	.177	
.1874 to .2087	.906	2.32	3.39	.197	
.209 to .228	1.024	2.560	3.66	.216	
.229 to .263	1.100	2.795	3.975	.236	

Note: larger sizes up to .790" Code 8600 and/or HSS-CO M35
Code 600 are available within 2 weeks. Call for information

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	0.60	.0236			
86000	0.61	.0240		73	
86000	0.62	.0244			
86000	0.63	.0248		72	
86000	0.64	.0252			
86000	0.65	.0256			
86000	0.66	.0260		71	
86000	0.67	.0264			
86000	0.68	.0268			
86000	0.69	.0272			
86000	0.70	.0276			
86000	0.71	.0280		70	
86000	0.72	.0283			
86000	0.73	.0287			
86000	0.74	.0291		69	
86000	0.75	.0295			
86000	0.76	.0299			
86000	0.77	.0303			
86000	0.78	.0307			
86000	0.79	.0311	1/32	68	
86000	0.80	.0315			
86000	0.81	.0319		67	
86000	0.82	.0323			
86000	0.83	.0327			
86000	0.84	.0331		66	
86000	0.85	.0335			
86000	0.86	.0339			
86000	0.87	.0343			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	0.88	.0346			
86000	0.89	.0350		65	
86000	0.90	.0354			
86000	0.91	.0358		64	
86000	0.92	.0362			
86000	0.93	.0366			
86000	0.94	.0370		63	
86000	0.95	.0374			
86000	0.96	.0378		62	
86000	0.97	.0382			
86000	0.98	.0386			
86000	0.99	.0390		61	
86000	1.00	.0394			
86000	1.01	.0398		60	
86000	1.02	.0402			
86000	1.03	.0406			
86000	1.04	.0409		59	
86000	1.05	.0413			
86000	1.06	.0417			
86000	1.07	.0421		58	
86000	1.08	.0425			
86000	1.09	.0429		57	
86000	1.10	.0433			
86000	1.11	.0437			
86000	1.12	.0441			
86000	1.13	.0445			
86000	1.14	.0449			
86000	1.15	.0453			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	1.16	.0457			
86000	1.17	.0461			
86000	1.18	.0465		56	
86000	1.19	.0469	3/64		
86000	1.20	.0472			
86000	1.21	.0476			
86000	1.22	.0480			
86000	1.23	.0484			
86000	1.24	.0488			
86000	1.25	.0492			
86000	1.26	.0496			
86000	1.27	.0500			
86000	1.28	.0504			
86000	1.29	.0508			
86000	1.30	.0512			
86000	1.31	.0516			
86000	1.32	.0520		55	
86000	1.33	.0524			
86000	1.34	.0528			
86000	1.35	.0531			
86000	1.36	.0535			
86000	1.37	.0539			
86000	1.38	.0543			
86000	1.39	.0547			
86000	1.40	.0551		54	
86000	1.41	.0555			
86000	1.42	.0559			
86000	1.43	.0563			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	1.44	.0567			
86000	1.45	.0571			
86000	1.46	.0575			
86000	1.47	.0579			
86000	1.48	.0583			
86000	1.49	.0587			
86000	1.50	.0590			
86000	1.51	.0594		53	
86000	1.52	.0598			
86000	1.53	.0602			
86000	1.54	.0606			
86000	1.55	.0610			
86000	1.56	.0614			
86000	1.57	.0618			
86000	1.58	.0622			
86000	1.59	.0626	1/16		
86000	1.60	.0630			
86000	1.61	.0634		52	
86000	1.62	.0638			
86000	1.63	.0642			
86000	1.64	.0646			
86000	1.65	.0650			
86000	1.66	.0654			
86000	1.67	.0657			
86000	1.68	.0661			
86000	1.69	.0665			
86000	1.70	.0669		51	
86000	1.71	.0673			

EDP 8600					SIZE	EDP 8600					SIZE	EDP 8600					SIZE	EDP 8600					SIZE
#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire	
86000	1.72	.0677				86000	2.18	.0858				86000	2.64	.1039			37	86000	3.10	.1220			
86000	1.73	.0681				86000	2.19	.0862			44	86000	2.65	.1043				86000	3.11	.1224			
86000	1.74	.0685				86000	2.20	.0866				86000	2.66	.1047				86000	3.12	.1228			
86000	1.75	.0689				86000	2.21	.0870				86000	2.67	.1051				86000	3.13	.1232			
86000	1.76	.0693				86000	2.22	.0874				86000	2.68	.1055				86000	3.14	.1236			
86000	1.77	.0697				86000	2.23	.0878				86000	2.69	.1059				86000	3.15	.1240			
86000	1.78	.0701			50	86000	2.24	.0882				86000	2.70	.1063				86000	3.16	.1244			
86000	1.79	.0705				86000	2.25	.0886				86000	2.71	.1067			36	86000	3.17	.1248			
86000	1.80	.0709				86000	2.26	.0890			43	86000	2.72	.1071				86000	3.18	.1252	1/8		
86000	1.81	.0713				86000	2.27	.0894				86000	2.73	.1075				86000	3.19	.1256			
86000	1.82	.0717				86000	2.28	.0898				86000	2.74	.1079				86000	3.20	.1260			
86000	1.83	.0720				86000	2.29	.0902				86000	2.75	.1083				86000	3.21	.1264			
86000	1.84	.0724				86000	2.30	.0906				86000	2.76	.1087				86000	3.22	.1268			
86000	1.85	.0728				86000	2.31	.0909				86000	2.77	.1091				86000	3.23	.1272			
86000	1.86	.0732			49	86000	2.32	.0913				86000	2.78	.1094	7/64			86000	3.24	.1276			
86000	1.87	.0736				86000	2.33	.0917				86000	2.79	.1098				86000	3.25	.1280			
86000	1.88	.0740				86000	2.34	.0921				86000	2.80	.1102			35	86000	3.26	.1283			30
86000	1.89	.0744				86000	2.35	.0925				86000	2.81	.1106				86000	3.27	.1287			
86000	1.90	.0748				86000	2.36	.0929				86000	2.82	.1110			34	86000	3.28	.1291			
86000	1.91	.0752				86000	2.37	.0933				86000	2.83	.1114				86000	3.29	.1295			
86000	1.92	.0756				86000	2.38	.0937	3/32		42	86000	2.84	.1118				86000	3.30	.1299			
86000	1.93	.0760			48	86000	2.39	.0941				86000	2.85	.1122				86000	3.31	.1303			
86000	1.94	.0764				86000	2.40	.0945				86000	2.86	.1126				86000	3.32	.1308			
86000	1.95	.0768				86000	2.41	.0949				86000	2.87	.1130			33	86000	3.33	.1311			
86000	1.96	.0772				86000	2.42	.0953				86000	2.88	.1134				86000	3.34	.1315			
86000	1.97	.0776				86000	2.43	.0957				86000	2.89	.1138				86000	3.35	.1319			
86000	1.98	.0780	5/64			86000	2.44	.0961			41	86000	2.90	.1142				86000	3.36	.1323			
86000	1.99	.0783				86000	2.45	.0965				86000	2.91	.1146				86000	3.37	.1327			
86000	2.00	.0787			47	86000	2.46	.0969				86000	2.92	.1150				86000	3.38	.1331			
86000	2.01	.0791				86000	2.47	.0972				86000	2.93	.1154				86000	3.39	.1335			
86000	2.02	.0795				86000	2.48	.0976				86000	2.94	.1157				86000	3.40	.1339			
86000	2.03	.0799				86000	2.49	.0980			40	86000	2.95	.1161			32	86000	3.41	.1343			
86000	2.04	.0803				86000	2.50	.0984				86000	2.96	.1165				86000	3.42	.1346			
86000	2.05	.0807				86000	2.51	.0988				86000	2.97	.1169				86000	3.43	.1350			
86000	2.06	.0811			46	86000	2.52	.0992				86000	2.98	.1173				86000	3.44	.1354			
86000	2.07	.0815				86000	2.53	.0996			39	86000	2.99	.1177				86000	3.45	.1358			
86000	2.08	.0819			45	86000	2.54	.1000				86000	3.00	.1181				86000	3.46	.1362			29
86000	2.09	.0823				86000	2.55	.1004				86000	3.01	.1185				86000	3.47	.1366			
86000	2.10	.0827				86000	2.56	.1008				86000	3.02	.1189				86000	3.48	.1370			
86000	2.11	.0831				86000	2.57	.1012				86000	3.03	.1193				86000	3.49	.1374			
86000	2.12	.0835				86000	2.58	.1016			38	86000	3.04	.1197				86000	3.50	.1378			
86000	2.13	.0839				86000	2.59	.1020				86000	3.05	.1201			31	86000	3.51	.1382			
86000	2.14	.0843				86000	2.60	.1024				86000	3.06	.1205				86000	3.52	.1386			
86000	2.15	.0846				86000	2.61	.1028				86000	3.07	.1209				86000	3.53	.1390			
86000	2.16	.0850				86000	2.62	.1031				86000	3.08	.1213				86000	3.54	.1394			
86000	2.17	.0854				86000	2.63	.1035				86000	3.09	.1217				86000	3.55	.1398			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	3.56	.1402			
86000	3.57	.1406	9/64	28	
86000	3.58	.1409			
86000	3.59	.1413			
86000	3.60	.1417			
86000	3.61	.1421			
86000	3.62	.1425			
86000	3.63	.1429			
86000	3.64	.1433			
86000	3.65	.1437			
86000	3.66	.1441		27	
86000	3.67	.1445			
86000	3.68	.1449			
86000	3.69	.1453			
86000	3.70	.1457			
86000	3.71	.1461			
86000	3.72	.1465			
86000	3.73	.1469		26	
86000	3.74	.1472			
86000	3.75	.1476			
86000	3.76	.1480			
86000	3.77	.1484			
86000	3.78	.1488			
86000	3.79	.1492			
86000	3.80	.1496		25	
86000	3.81	.1500			
86000	3.82	.1504			
86000	3.83	.1508			
86000	3.84	.1512			
86000	3.85	.1516			
86000	3.86	.1520			
86000	3.87	.1524			
86000	3.88	.1528			
86000	3.89	.1531			
86000	3.90	.1535			
86000	3.91	.1539			
86000	3.92	.1543			
86000	3.93	.1547			
86000	3.94	.1551			
86000	3.95	.1555			
86000	3.96	.1559			
86000	3.97	.1563	5/32		
86000	3.98	.1567			
86000	3.99	.1571		22	
86000	4.00	.1575			
86000	4.01	.1579			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	4.02	.1583			
86000	4.03	.1587			
86000	4.04	.1591		21	
86000	4.05	.1594			
86000	4.06	.1598			
86000	4.07	.1602			
86000	4.08	.1606			
86000	4.09	.1610		20	
86000	4.10	.1614			
86000	4.11	.1618			
86000	4.12	.1622			
86000	4.13	.1626			
86000	4.14	.1630			
86000	4.15	.1634			
86000	4.16	.1638			
86000	4.17	.1642			
86000	4.18	.1646			
86000	4.19	.1650			
86000	4.20	.1654			
86000	4.21	.1657			
86000	4.22	.1661		19	
86000	4.23	.1665			
86000	4.24	.1669			
86000	4.25	.1673			
86000	4.26	.1677			
86000	4.27	.1681			
86000	4.28	.1685			
86000	4.29	.1689			
86000	4.30	.1693		18	
86000	4.31	.1697			
86000	4.32	.1701			
86000	4.33	.1705			
86000	4.34	.1709			
86000	4.35	.1713			
86000	4.36	.1717			
86000	4.37	.1720	11/64		
86000	4.38	.1724			
86000	4.39	.1728		17	
86000	4.40	.1732			
86000	4.41	.1736			
86000	4.42	.1740			
86000	4.43	.1744			
86000	4.44	.1748			
86000	4.45	.1752			
86000	4.46	.1756			
86000	4.47	.1760			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	4.48	.1764			
86000	4.49	.1768		16	
86000	4.50	.1772			
86000	4.51	.1776			
86000	4.52	.1780			
86000	4.53	.1783			
86000	4.54	.1787			
86000	4.55	.1791			
86000	4.56	.1795			
86000	4.57	.1799		15	
86000	4.58	.1803			
86000	4.59	.1807			
86000	4.60	.1811			
86000	4.61	.1815			
86000	4.62	.1819		14	
86000	4.63	.1823			
86000	4.64	.1827			
86000	4.65	.1831			
86000	4.66	.1835			
86000	4.67	.1839			
86000	4.68	.1843			
86000	4.69	.1846			
86000	4.70	.1850		13	
86000	4.71	.1854			
86000	4.72	.1858			
86000	4.73	.1862			
86000	4.74	.1866			
86000	4.75	.1870			
86000	4.76	.1874	3/16		
86000	4.77	.1878			
86000	4.78	.1882			
86000	4.79	.1886			
86000	4.80	.1890		12	
86000	4.81	.1984			
86000	4.82	.1898			
86000	4.83	.1902			
86000	4.84	.1906			
86000	4.85	.1909			
86000	4.86	.1913		11	
86000	4.87	.1917			
86000	4.88	.1921			
86000	4.89	.1925			
86000	4.90	.1929			
86000	4.91	.1933		10	
86000	4.92	.1937			
86000	4.93	.1941			

EDP 8600					SIZE
#	mm	Decimal	inch	Wire	
86000	4.94	.1945			
86000	4.95	.1949			
86000	4.96	.1953			
86000	4.97	.1957			
86000	4.98	.1961		9	
86000	4.99	.1965			
86000	5.00	.1969			
86000	5.01	.1972			
86000	5.02	.1976			
86000	5.03	.1980			
86000	5.04	.1984			
86000	5.05	.1988		8	
86000	5.06	.1992			
86000	5.07	.1996			
86000	5.08	.2000			
86000	5.09	.2004			
86000	5.10	.2008		7	
86000	5.11	.2012			
86000	5.12	.2016			
86000	5.13	.2020			
86000	5.14	.2024			
86000	5.15	.2028			
86000	5.16	.2031	13/64		
86000	5.17	.2035			
86000	5.18	.2039		6	
86000	5.19	.2043			
86000	5.20	.2047			
86000	5.21	.2051			
86000	5.22	.2055		5	
86000	5.23	.2059			
86000	5.24	.2063			
86000	5.25	.2067			
86000	5.26	.2071			
86000	5.27	.2075			
86000	5.28	.2079			
86000	5.29	.2083			
86000	5.30	.2087			
86000	5.31	.2091		4	
86000	5.32	.2094			
86000	5.33	.2098			
86000	5.34	.2102			
86000	5.35	.2106			
86000	5.36	.2110			
86000	5.37	.2114			
86000	5.38	.2118			
86000	5.39	.2122			

EDP 8600					SIZE	EDP 8600					SIZE	EDP 8600					SIZE	EDP 8600					SIZE
#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire		#	mm	Decimal	inch	Wire	
86000	5.40	.2126				86000	5.65	.2224				86000	5.90	.2323				86000	6.15	.2421			C
86000	5.41	.2130		3		86000	5.66	.2228				86000	5.91	.2327				86000	6.16	.2425			
86000	5.42	.2134				86000	5.67	.2232				86000	5.92	.2331				86000	6.17	.2429			
86000	5.43	.2138				86000	5.68	.2236				86000	5.93	.2335				86000	6.18	.2433			
86000	5.44	.2142				86000	5.69	.2240				86000	5.94	.2339		A		86000	6.19	.2437			
86000	5.45	.2146				86000	5.70	.2244				86000	5.95	.2343	15/64			86000	6.20	.2441			
86000	5.46	.2150				86000	5.71	.2248				86000	5.96	.2347				86000	6.21	.2445			
86000	5.47	.2154				86000	5.72	.2252				86000	5.97	.2350				86000	6.22	.2449			
86000	5.48	.2158				86000	5.73	.2256				86000	5.98	.2354				86000	6.23	.2453			
86000	5.49	.2161				86000	5.74	.2260				86000	5.99	.2358				86000	6.24	.2457			
86000	5.50	.2165				86000	5.75	.2264				86000	6.00	.2362				86000	6.25	.2461		D	
86000	5.51	.2169				86000	5.76	.2268				86000	6.01	.2366				86000	6.26	.2465			
86000	5.52	.2173				86000	5.77	.2272				86000	6.02	.2370				86000	6.27	.2468			
86000	5.53	.2177				86000	5.78	.2276				86000	6.03	.2374				86000	6.28	.2472			
86000	5.54	.2181				86000	5.79	.2280		1		86000	6.04	.2378				86000	6.29	.2476			
86000	5.55	.2185				86000	5.80	.2284				86000	6.05	.2382		B		86000	6.30	.2480			
86000	5.56	.2189	7/32			86000	5.81	.2288				86000	6.06	.2386				86000	6.31	.2484			
86000	5.57	.2193				86000	5.82	.2291				86000	6.07	.2390				86000	6.32	.2488			
86000	5.58	.2197				86000	5.83	.2295				86000	6.08	.2394				86000	6.33	.2492			
86000	5.59	.2201				86000	5.84	.2299				86000	6.09	.2398				86000	6.34	.2496			
86000	5.60	.2205				86000	5.85	.2303				86000	6.10	.2402				86000	6.35	.2500	1/4	E	
86000	5.61	.2209		2		86000	5.86	.2307				86000	6.11	.2406				86000	6.36	.2504			
86000	5.62	.2213				86000	5.87	.2311				86000	6.12	.2410				86000	6.37	.2508			
86000	5.63	.2217				86000	5.88	.2315				86000	6.13	.2413				86000	6.38	.2512			
86000	5.64	.2220				86000	5.89	.2319				86000	6.14	.2417				86000	6.39	.2517			

SPECIAL REAMERS

Please fill out the following form :

1 HOLE

☐ Blind

☐ Through

Number of holes _____

2 UTILIZATION

☐ Hand

☐ Machine

Straight shank

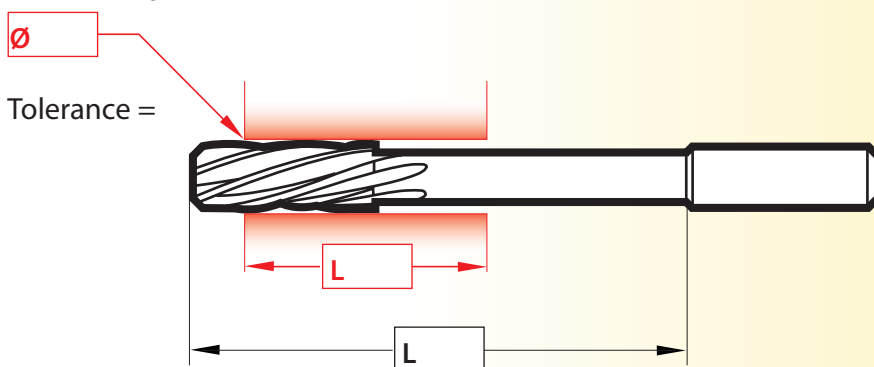
Morse taper shank

3 CONDITIONS

Material to bore

Material hardness

Drilling Ø



Name and address