Helical Flute

20D580

Flute Overall Shank Item

Additional reamer sizes and types are available on Grainger.com.

Taper Pin Reamers

High-speed steel

Bright (uncoated) finish

Taper pin reamers enlarge, finish, or shape holes for a precise fit when installing taper pins into the hole. They have a ¼" taper to the foot and are made from high-speed steel, which offers good wear resistance in general purpose metalworking applications.

EVELAND

Helical—Reduce the size of the chips created during reaming and prevent chips from packing in the flutes. Operated with a machine such as a drill press, lathe, or screw machine.

Spiral—Pull chips out of the hole during reaming, which helps prevent damage to the reamers and workpiece. Suitable for reaming applications with blind holes and interrupted cuts. Operated with a machine such as a drill press, lathe, or screw machine.

Straight Flute

20D556

Spiral Flute

20D595

Straight—Push chips forward into the hole and are the most commonly used style of reamer. Operated with a tap wrench, adjustable wrench, or vise.

such as a drill press, lathe, or screw machine.											
For						HELICAL		STRAIGH		SPIRAL	FLUTE
Pin Size	End Dia.	Large End Dia.	Shank Dia.	Flute Length	Overall Length	Brand	ltem No.	Brand	ltem No.	Brand	ltem No.
Left	Hand Sp	piral				Drana		Drana			
<u>#0</u> #1	1/8 in 9/64 in	⁵ / ₃₂ in ¹¹ / ₆₄ in	¹¹ ⁄64 in ³ ⁄16 in	1 ¹¹ / ₁₆ in 1 ¹¹ / ₁₆ in	2 ¹⁵ ⁄16 in 2 ¹⁵ ⁄16 in	 Yankee	20D575			Yankee	20D595
#2	5⁄32 in	3⁄16 in	¹³ ⁄64 in	1 ¹ 5/16 in	3 ¹⁵ /16 in	Yankee	20D576	_	_	Yankee	20D597
#2/0 #2/0	1/8 in 7/64 in	%4 in	5/32 in	1 5⁄8 in 1 5⁄8 in	2 % in 2 % in	 Yankee	_		_	Yankee	20D611
#3	3/16 in	%4 in 7⁄32 in	5∕32 in ¹5∕64 in	2 5/4c in	3 11/16 in	rankee	20D589	_	_	Yankee	20D598
#3 #3/0	¹¹ /64 in	7⁄32 in	¹⁵ ⁄64 in	2 5/16 in 1 5/16 in	3 ¹ / ₁₆ in	Yankee	20D577		-	_	_
#3/0 #3/0	1/8 in 3/32 in	1/8 in 1/8 in	%₄ in %₄ in	1 %16 in 1 %16 in	2 5/16 in 2 5/16 in	Yankee	20D590		=	Yankee	20D612
#4	3⁄16 in	1/4 in	¹⁷ ⁄64 in	2 %16 in	4 % in	_	—	_	_	Yankee	20D599
#4 #4/0	¹³ ⁄64 in 1⁄16 in	1⁄4 in 7⁄64 in	¹⁷ ⁄64 in 1⁄8 in	2 %16 in 1 5⁄16 in	4 5/8 in 2 5/16 in	Yankee	20D578		_	 Yankee	20D613
#5	1/4 in	¹⁹ /64 in	5⁄16 in	2 ¹³ /16 in	4 5/16 in					Yankee	20D613 20D601
#5	¹⁵ ⁄64 in	¹⁹ ⁄64 IN	5⁄16 in	2 ¹³ /16 IN	4 %16 IN	Yankee	20D579		—	_	_
#6 #6	1/4 in 17/64 in	¹¹ / ₃₂ in ¹¹ / ₃₂ in	²³ ⁄ ₆₄ in ²³ ⁄ ₆₄ in	3 5/8 in 3 5/8 in	5 1/16 IN	Yankee	20D580			Yankee	20D602
#6/0	1⁄16 in	5⁄64 in	3∕32 IN	19/16 IN	1 ¹⁵ ⁄16 in			—	_	Yankee	20D615
#7	5⁄16 in	$\frac{27}{64}$ in	13/32 in	4 1/16 IN	6 5⁄16 in			—	_	Yankee	20D603
#7 #8	²¹ / ₆₄ in 3/8 in	²⁷ / ₆₄ in 1/2 in	¹³ / ₃₂ in 7/16 in	4 ⁷ / ₁₆ in 5 ³ / ₁₆ in	6 5/16 in 7 3/16 in	Yankee	20D581			Yankee	20D604
#8	²⁵ ⁄64 IN	1/2 in	7/16 in	5 3/16 in	7 3/16 in	Yankee	20D582	-	_	_	—
#9 #9	1/4 in	41/64 in	%16 in	6 5⁄8 in 6 5⁄8 in	8 5/16 in 8 5/16 in		20D583	-	_	Yankee	20D605
#9	¹⁵ ⁄32 in 9⁄16 in	41/64 in 23/32 in	%in 16 9∕16 9∕16 9∕16	6 ¹³ / ₁₆ in	9 5/16 in	Yankee	200303	=		Yankee	20D606
#11	¹¹ /16 in	7/8 in	3⁄4 in	8 ¼ in	11 ¼ in	—	-	—	_	Yankee	20D607
#13	1 in t Hand S	1 ¼ in	1 1/16 in	12 in	16 in		-	-	-	Yankee	20D609
#0	1% in	5/32 in	¹¹ ⁄64 in	1 ¹¹ /16 in	2 ¹⁵ ⁄16 in	_	-	Yankee	20D553	_	-
#1	1⁄8 in	11/64 in	3∕16 in	1 ¹ / ₁₆ in	2 15/16 in	—	-	_	_	Cleveland	445N25
#1 #2	%₄ in ⅔⁄16 in	¹¹ ⁄64 in ³ ⁄16 in	³ ⁄16 in ¹³ ⁄64 in	1 ¹¹ / ₁₆ in 1 ¹⁵ / ₁₆ in	2 ¹⁵ / ₁₆ in 3 ³ / ₁₆ in			Yankee	20D554	Cleveland	445N26
#2	5∕32 in	3∕16 in	¹³ ⁄64 in	1 ¹⁵ / ₁₆ in	3 3/16 in	Cleveland	445M93	_	_		
#2	5∕32 in	3∕16 in	¹³ ⁄64 in	1 15/16 in	3 19/16 IN	—	-	Yankee	20D555	—	_
#2/0 #3	⁷ ⁄64 in 3⁄16 in	%₄ in 7⁄32 in	⁵ ⁄32 in ¹⁵ ⁄64 in	1 5⁄8 in 2 5⁄16 in	2 % in 3 11/16 in			Yankee	20D568	Cleveland	445N27
#3	3⁄32 in	1⁄8 in	%4 in	1 5⁄16 in	2 ½16 IN	—	_	Cleveland			
#3 #3	¹¹ / ₆₄ in	7/32 in	15/64 in	2 5/16 in 2 5/16 in	3 ¹¹ / ₁₆ in	 Cleveland		Cleveland	445N11 20D556	_	_
#3/0	¹¹ ⁄ ₆₄ in ³ ⁄ ₃₂ in	7⁄32 in 1∕8 in	¹⁵ ⁄64 in %4 in	1 5/16 IN	3 ¹ / ₁₆ in 2 ⁵ / ₁₆ in		44311194	Yankee	20D550		
#4	3⁄16 in	1⁄4 in	17/64 in	2 9/4c in	4 1/16 in	—	-		_	Cleveland	445N28
#4 #4	¹³ ⁄ ₆₄ in ¹³ ⁄ ₆₄ in	1/4 in 1/4 in	¹⁷ ⁄ ₆₄ in ¹⁷ ⁄ ₆₄ in	2 %16 in 2 %16 in	4 5/8 in 4 1/16 in	 Claveland		Yankee Cleveland	20D557		
#4/0	5/64 in	7/64 in	1/8 in	1 5/16 in	2 5/16 in	Cleveland			4451112	_	_
#5	1⁄4 in	19⁄64 in	5∕16 in	2 ¹³ / ₁₆ in	4 5⁄16 in	_	_	_	_	Cleveland	445N29
#5 #5	¹⁵ ⁄64 in ¹⁵ ⁄64 in	¹⁹ ⁄64 in ¹⁹ ⁄64 in	⁵⁄16 in ⁵⁄16 in	2 ¹³ / ₁₆ in 2 ¹³ / ₁₆ in	4 5/16 in 4 5/16 in	Cleveland	445196	Cleveland	20D558 445N13		
#5/0	1⁄16 in	3∕32 in	7⁄64 in	1 3/16 in	2 3/16 in	Cleveland	445M87	Yankee	20D571	_	_
#6	1/4 in	11/32 in	23/64 in	3 11/16 in	5 1/16 in		-		_	Cleveland	445N30
#6 #6	¹⁷ ⁄ ₆₄ in ¹⁷ ⁄ ₆₄ in	¹¹ / ₃₂ in ¹¹ / ₃₂ in	²³ ⁄ ₆₄ in ²³ ⁄ ₆₄ in	3 ¹ / ₁₆ in 3 ⁵ / ₈ in	5 ⁷ ⁄ ₁₆ in 5 ⁷ ⁄ ₁₆ in	Cieveland	445197	Cleveland Yankee	20D559		
#6/0	3⁄64 in	5⁄64 in	3⁄32 in	¹⁵ /16 in	1 ¹⁵ /16 in	—	—	Yankee	20D572	—	_
#7 #7	⁵ /16 in ²¹ /64 in	²⁷ / ₆₄ in ²⁷ / ₆₄ in	¹³ / ₃₂ in ¹³ / ₃₂ in	4 ⁷ ⁄ ₁₆ in 4 ⁷ ⁄ ₁₆ in	6 ⁵ ⁄16 in 6 ⁵ ⁄16 in		_	 Cleveland	446N16	Cleveland	445N31
#7	21/64 in	27/64 in	13/32 in	4 7/16 in	6 5/16 in	Cleveland	445M98	Yankee			
#7/0	3⁄64 in	1⁄16 in	5⁄64 in	13/16 in	1 ¹³ /16 in	Cleveland			20D573	. —	
#8 #8	3/8 in 25/64 in	1/2 in 1/2 in	7∕16 in 7∕16 in	5 ¾16 in 5 ¾16 in	7 ⅔16 in 7 ⅔16 in			Cleveland		Cleveland	445N32
#8	25/64 in	1/2 in	7∕16 in	5 3/16 in	7 3⁄16 in	Cleveland	445M99	Yankee	20D561	_	_
#9	1⁄4 in	⁴¹ /64 in	%16 in	6 1⁄16 in	8 5⁄16 in	_	—	-	_	Cleveland	445N33
#9 #9	¹⁵ / ₃₂ in ¹⁵ / ₃₂ in	41/64 in 41/64 in	9⁄16 in 9⁄16 in	6 1⁄16 in 6 5⁄8 in	8 5⁄16 in 8 5⁄16 in	ueveland	4451001	Cleveland Yankee	445N17 20D562		
#10	16 in%	²³ /32 in	5⁄8 in	6 ¹³ /16 in	9 5⁄16 in			_	-	Cleveland	445N34
#10 #10	³⁷ ⁄ ₆₄ in ³⁷ ⁄ ₆₄ in	²³ /32 in	5% in 5% in	6 13/16 in	9 5⁄16 in	Cleveland	445N02	Yankee Cleveland	20D563		_
#10	⁴⁵ /64 in	²³ /32 in 7/8 in	3/4 in	6 ¹³ / ₁₆ in 8 ¹ / ₄ in	9 5/16 in 11 1/4 in			Yankee	20D564		
#12	⁵³ ⁄64 in	1 3⁄64 in	3⁄4 in	10 in	13 7/8 in	—	-	Yankee	20D565	_	-
2 in 3 in	^{9∕16} in ^{49∕64} in	47/64 in 63/64 in	5% in ⅔ in	3 ½ in 4 ¼ in	6 in 7 ¼ in			Yankee Yankee	20D537 20D538		
0 111	704 111	704 111	70 111	7 /4 111	1 74 111		-	IUINCC	202000	_	-



High-Speed Steel Bridge Reamers

Bridge reamers install into compatible power tools to enlarge, debur, and finish holes in structural materials to a specific size. They have tapered flutes that ease their entry into rough-cut or misaligned holes. Designed for reaming difficult-to-machine materials such as iron and structural steel in applications where extreme precision is not required. Also commonly used to ream rivet holes in parts for automobile. bridges, rail cars, ships, and pressure vessels.

HEX NUT SHANK

Hex nut keeps the reamer securely in place in tools that have a square drive. Typically used to ensure the reamer won't come loose when it's used in a power tool that is being operated at a high location. **Hex nut shank with safety magnet** also have a magnet on the shank and provide a stronger hold than reamers that are secured with only a hex nut.

MORSE TAPER SHANK

Can be directly inserted into the spindle of a compatible tool or into an adapter such as a Morse taper sleeve or socket. This maximizes efficiency when installing and removing the reamers. Reamers provide accurate centering, and their self-locking taper shank is held in place by the friction between the shank and the toolholder.

STRAIGHT SHANK

Straight shank reamers with safety collars prevent the reamer from going too deep into the workpiece. Straight shank reamers with three flats are used in pneumatic or electric power tools.

Size -	Decimal	Length	Length	Dia.	No.
	ut Shank,			D10.	NU.
	- 0.5625	5 1/8 in	6 % in	1 ½16 in	13H855
			6 % in		
11/ in	- 0.6875	4 ½ in			13H856
19/16 III	- 0.6875	7 ½ in	9 ¼ in		13H857
19/16 IN	- 0.8125	5 in	7 in	1 ¼ in	13H858
¹³ /16 IN	- 0.8125	7 ¾ in	9 ¾ in	1 ¼ in	13H859
¹⁵ /16 in	- 0.9375	5 in	7 in		13H860
	- 0.9375	7 ¾ in	9 ¾ in		13H861
1 ¼16 ir	ı - 1.0625	7 ¾ in	9 ¾ in	1 5⁄8 in	13H863
Hex N	ut Shank	with Saf	iety		
Magn	et, Black	Oxide	-		
5% in	- 0.625	4 1/2 in	6 in	1 1/16 in	12G353
11/16 in	- 0.6875	4 ½ in	6 3/8 in	1 1/16 in	12G354
	ı - 0.75	5 in	7 in	1 ¼ in	12G355
	- 0.8125	5 in	7 in		12G356
	- 0.875	5 in	7 in		12G357
154c in	- 0.9375	5 in	7 in		12G358
1 in	· 1.0000	5 in	7 in		12G359
1 1/16 If	1 - 1.0625	5 in	7 in		12G360
	1 - 1.125	5 in	7 in	1 5% in	12G361
	in - 1.25	5 in	7 in		12G363
	in - 1.5	7 ¾ in	10 in	2 in	12G367
Morse	e Taper Sh	ank, Bla	ack Oxid	e	
	- 0.375	2 ¾ in	5 11/16 in	MT1	13H785
5% in	- 0.625	4 ½ in	8 1/16 in	MT2	13H791
¹³ /16 in	- 0.8125	5 in	9 ½ in	MT3	13H797
1 ½16 ir	1 - 1.0625	5 in	9 ½ in	MT3	13H806
	1 - 1.125	5 in	9 ½ in	MT3	13H808
	1 - 1.0625	7 3/8 in	12 in	MT3	13H807
	1 - 1.125	7 % in	12 in	MT3	13H809
	1 - 1.375	7 % in	13 in	MT4	13H812
	in - 1.5	7 3/8 in	13 in	MT4	13H813
	pht with Sa				
	- 0.1875	1 3/8 in	3 ½ in	1/4 in	13H830
	- 0.2812	1 % in	4 in	1/4 in	13H833
3% in	- 0.375	2 % in	5 in	⅔ in	13H836
7∕16 in	- 0.4375	3 1⁄8 in	5 ¼ in	7∕16 in	13H837
1/2 i	n - 0.5	3 13/16 in	5 15/16 in	1⁄2 in	13H838
9⁄16 in	- 0.5625	4 1/8 in	6 ¼ in	1⁄2 in	13H839
	- 0.625	4 7/16 in	6 %16 in	1/2 in	13H840
	- 0.6875	4 % in	7 in	1/2 in	13H841
	1 - 0.75	4 % in	7 in	1/2 in	13H842
	- 0.8125	5 1/8 in	7 ¼ in	1/2 in	13H843
	- 0.875	5 1/8 in	7 1/4 in	1/2 in	13H844
78 III 154 - in	- 0.9375	5 1/8 in	7 1/4 in		
				1/2 in	13H845
	· 1.0000	5 1/8 in	7 ¼ in	1/2 in	13H846
	1 - 1.0625	5 1/8 in	7 ¼ in	1/2 in	13H847
1 ½ i	1 - 1.125	5 1/8 in	7 ¼ in	1/2 in	13H848
	ı - 1.1875	5 1⁄8 in	7 ¼ in	1⁄2 in	13H849
	in - 1.25	5 ¾ in	7 ½ in	1⁄2 in	13H850
1 ⁵ ⁄16 ir	ı - 1.3125	5 ¾ in	7 ½ in	1/2 in	13H851
	n - 1.375	5 ¾ in	7 ½ in	1⁄2 in	13H852
	in - 1.5	5 3/8 in	7 ½ in	1/2 in	13H853
	ht with T				
	- 0.375	2 1/2 in	4 5% in	3/8 in	13H816
7/4e in	- 0.4375	3 1/4 in	5 % in	7/16 in	13H817
	n - 0.5	3 3/4 in	5 % in	1/2 in	13H818
721	11 - U.J	0 74 11	J 78 III	72 11	101010

98 III = 0.37 J	Z 72 III	4 98 111	98 III	130010
7⁄16 in - 0.4375	3 ¼ in	5 ¾ in	7∕16 in	13H817
1⁄2 in - 0.5	3 ¾ in	5 % in	1⁄2 in	13H818
9/16 in - 0.5625	3 ¾ in	5 1 in	1⁄2 in	13H819
5% in - 0.625	4 ¼ in	6 ¾ in	1⁄2 in	13H820
21/32 in - 0.6562	4 ¼ in	6 ¾ in	1⁄2 in	13H821
11/16 in - 0.6875	4 ¼ in	6 ¾ in	1⁄2 in	13H822
3⁄4 in - 0.75	4 ½ in	6 ¾ in	1⁄2 in	13H823
¹³ / ₁₆ in - 0.8125	4 ½ in	6 % in	1⁄2 in	13H825
⅔ in - 0.875	4 ½ in	6 ¾ in	1⁄2 in	13H826
¹⁵ / ₁₆ in - 0.9375	4 ½ in	6 ¾ in	1⁄2 in	13H827
1 in - 1.0000	4 ½ in	6 % in	1⁄2 in	13H828
1 1/16 in - 1.0625	4 ½ in	6 % in	1⁄2 in	13H829

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