

REAMING



COMPLETE REAMING SOLUTIONS

The UK's most comprehensive range of Reamers
from Drill Service (Horley) Ltd



www.drill-service.co.uk Tel: 01293 774911 email: sales@drill-service.co.uk

What Reamer do you need?



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HSS Hand and Machine Reamers



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HSCO Machine Reamers



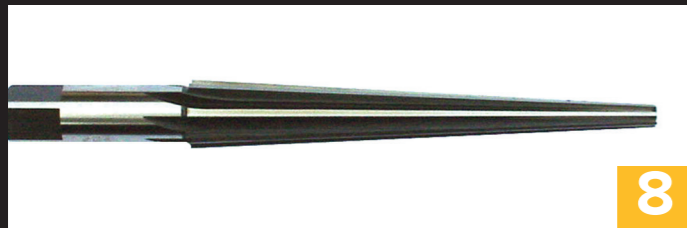
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Carbide Machine Reamers



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Carbide Tipped Machine Reamers



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Tapered Hand and Machine Reamers



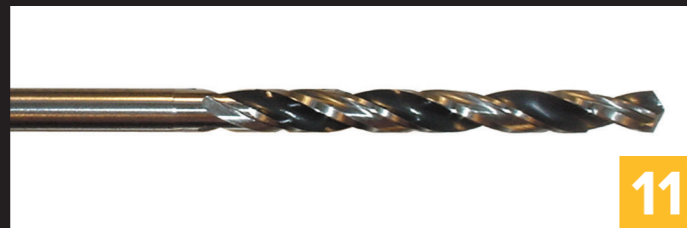
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Bespoke Special Reamers



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Diatool Reamers



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Drill Reamers

About Drill Service

Drill Service is a family owned business that provides a vast range of cutting tools

- Drills
- Centre Drills and Spotting Drills
- Reamers
- Milling Cutters
- Threading Tools
- Deburring Tools
- Burrs and Points
- Countersinks and Counterbores
- Bespoke Tooling
- Small Hole Drilling

We have been producing Reamers in our workshop since 1961. Our team of engineers has a great depth of experience in all aspects of reaming whilst our sales team can offer expert technical advice on choice of reamer. Many different ranges of reamers are available and we can help you with them all.

We stock an extensive range of standard sizes but also can resize to your specification on a quick turnaround. We quote 3 to 4 days on resizing but if you are in a hole and want it quicker please ask as we will always endeavour to accommodate you.

Reaming Tips

1. Reamer Cutting too small?

Try Pre-drilling slightly smaller or using thicker cutting oil or paste

2. Reamer Cutting too Big?

Try pre-drilling slightly bigger or using thinner cutting oil or soluble oil

3. Pre Reaming Bore

Generally a hole should be pre-drilled @ 0.2-0.5mm undersize as bore size increases but minimum 0.2-0.3mm to avoid cutting too tight

4. Truing up a bore or flat bottoming a hole

Try an End Cutting Reamer with a smaller lead.



HSS Hand and Machine Reamers

The full range of general purpose HSS Hand and Machine Reamers

RHAND



SIZE 1.00mm to 50.80mm

Left hand spiral flute general purpose hand reamer. Suitable for steel aluminium and copper alloys.

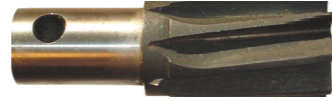
RHANDEXP



SIZE 6.00mm to 100mm

Adjustable hand reamers suitable for resizing and refinishing pre drilled holes.

RST



SIZE 1.83mm to 12.83mm

Left Hand spiral stub machine Reamers with Drive hole. Stocked as blanks and then sized to the customer's requirements.

RMICRO



SIZE 0.343mm to 6.528mm

Small chucking machine reamers with 7 degree right hand spiral flutes.

R



SIZE 1.588mm to 16.00mm

Straight shank, spiral flute, parallel machine reamer for finishing existing holes in most ferrous and non ferrous materials.

RCHUCK



SIZE 1.30mm to 17.00mm

Straight shank, general purpose reamer with a long shank and short straight flutes suitable for use on steel, aluminium and copper alloys.

RTS



SIZE 2.778mm to 70.00mm

Machine Reamer with Taper Shank for finishing existing holes in most ferrous and non-ferrous materials.

REL



SIZE 4.00mm to 16.00mm

Straight shank extra length machine reamer for finishing existing holes in most ferrous and non ferrous materials. Manufactured to customer's specifications.

RELTS



SIZE 4.762mm to 50.00mm

Taper shank extra length machine reamer for finishing existing holes in most ferrous and non ferrous materials. Manufactured to customer's specifications.

HSCO Machine Reamers

HSCO is ideally suited to small batch runs when Carbide cannot be economically justified. HSCO can be run at a higher speed and is more resilient to flank wear than HSS on difficult to cut materials.

RCOCHUCK



SIZE 1.00mm to 20.00mm

Straight shank, straight flute chucking style reamer to produce holes with H7 tolerance.

RCO



SIZE 0.60mm to 20.00mm

Spiral flute straight shank chucking style reamer to produce holes with H7 tolerance.

RCOQS



SIZE 3.00mm to 18.00mm

Quick spiral reamers chucking style. H7 tolerance.

RCOTS



SIZE 5.00mm to 40.00mm

Taper shank reamers chucking style. H7 tolerance.

RCOEL



SIZE 1.50mm to 12.00mm

Extra Length reamers chucking style. H7 tolerance

All Reamers can be purchased on our website

www.drill-service.co.uk

where prices and stock levels are current.



Carbide Machine Reamers

Carbide Reamers allow higher cutting speeds and are more resistant to wear - reducing costs. Carbide Reamers will consistently and accurately produce sized holes reducing tool change time and frequency resulting in longer tool life.

RC1200



SIZE 1.850mm to 13.200mm

Straight Flute for general use.

RC1200L



SIZE 1.850mm to 13.200mm

Left hand spiral. Gives better finish on hard materials, including heat treated steels and chilled castings. Use for holes with interruptions such as key ways, perforations, etc. Chip will clog on blind holes.

RC1200R



SIZE 2.351mm to 13.200mm

Right hand spiral for use on ductile and abrasive materials and blind holes. Do not use on holes with interruptions unless the material is very soft.

RC1300



SIZE 2.500mm to 13.200mm

Extra Length Straight Flute for general use.

RC1300L



SIZE 2.500mm to 13.200mm

Extra Length Left hand spiral. Gives better finish on hard materials, including heat treated steels and chilled castings. Use for holes with interruptions such as keyways, perforations, etc. Chip will clog on blind holes.

RC1300R



SIZE 2.500mm to 13.200mm

Extra Length Right hand spiral for use on ductile and abrasive materials and blind holes. Do not use on holes with interruptions unless the material is very soft.

RCMICRO



SIZE 0.200mm to 0.595mm in 0.005mm increments.

Miniature Reamers on a 3.00mm reinforced shank to provide greater stability.

RC



SIZE 0.40mm to 16.00mm

Straight flute for general use.

RCL



SIZE 0.60mm to 20.00mm. Reamers over 12.00mm diameter have a brazed carbide head.

Left hand spiral flute, right hand cut. These reamers have unequal flute spacing.

RCRTC



SIZE 3.90mm to 12.00mm

Right hand spiral reamers with one central coolant hole. This projects the lubricant directly into the hole and helps chip removal.

RCLTC



SIZE 3.90mm to 12.00mm

Left hand spiral through coolant reamer with three 'Y' feed coolant holes that allow the coolant to reach the cutting edges easily. The swarf is cleared forward to prevent the risk of scratching the hole bored.

RCEL



SIZE 2.00mm to 12.00mm

Extra Long Chucking Reamers.

RCSL



SIZE 10.00mm to 20.00mm

Super long Reamers with a brazed carbide head.

Carbide Tipped Machine Reamers

Toughened steel over full length with carbide tips. Some standard sizes kept in stock but blanks held for customers requirements and sized on quick deliveries.

RCTST



SIZE 1.00mm to 50.80mm

Straight flute, straight shank reamers with drive hole. Stocked as blanks and sized to customer requirements with quick deliveries.

LONG TIPPED: Straight flute for deep-hole reaming and long runs.

RCTSFR



SIZE 6.00mm to 31.750mm

Straight Shank

RCTTFR



SIZE 6.00mm to 50.876mm

Taper Shank

RCTSLSR



SIZE 5.616mm to 38.176mm

Left hand spiral flutes for a better finish on heat treated steels and chilled castings and other hard materials. Better for interrupted cuts for use on through holes only.

RCTSFTC



SIZE 6.048mm to 28.651mm

Straight flute through coolant reamers

RCTRTC



SIZE 6.048mm to 19.126mm

Right hand spiral through coolant reamer.

THROUGH COOLANT: Will prolong the life of the cutting edge and assist in swarf evacuation.

RCTSRSR



SIZE 5.616mm to 38.176mm

Right hand spiral flute reamers for use on ductile and abrasive materials and for blind holes

THE EXPANDING REAMER can be resized to remove wear. The screw-in plug expands the reamer, the tool should be resized by grinding after expanding. This allows the extended use on abrasive materials that wear the lands causing undersize holes.

RCTESR



SIZE 7.216mm to 38.100mm

Straight Shank

RCTETR



SIZE 8.816mm to 38.100mm

Taper Shank

Taper Pin Reamers

For reaming standard taper pin holes with a taper of 1:50 metric and 1:48 imperial

RTPHAND



SIZE 0.90mm to 56.900

HSS for hand use with square drive.

RTP



SIZE 0.635mm to 39.167mm

HSS Straight shank. Left hand quick spiral designed for machine use. The quick spiral gives sensitivity to machine cut and prevents breakages from swarf clogging.

RTHAND



SIZE 10 x 25 to 23 x 45

Hss Straight flute 1 in 10 taper reamer with square drive for hand use.

RTPTS



SIZE 3.251mm to 39.167mm

HSS Taper shank. Left hand quick spiral designed for machine use. The quick spiral gives sensitivity to machine cut and prevents breakages from swarf clogging.

Centre Reamers

Three flute centre reamers used for cleaning up centres and correcting centres in HSS tools prior to regrinding.

RCOCTR



SIZE 6.35mm to 25.4mm

HSCO Available in 60 and 90 degrees.

RCCTR



SIZE 4.00mm to 20.00mm

Carbide centre reamers can be used after hardening prior to grinding.

Socket Reamers for Reaming Morse Tapers

QUICK SPIRAL SOCKET: HSS Quick Spiral socket machine reamers for stock removal. The quick spiral design gives long cutting edges requiring axial cutting pressure rather than torque. This gives the machine operator feel and prevents reamer breakage from excess torque and clogging.

RSOCK



SIZE 6.358mm to 64.900mm

Straight shank

RSOCKTS



SIZE 6.358mm to 64.900mm

Taper shank

DUPLEX: HSS Duplex form finishing reamers combine one straight flute with spiral flutes. This provides excellent bore quality, (roundness and surface finish), with chatter free operation without rifling, obviating the need for a subsequent grinding operation. The Duplex form reamer is best used for finishing and repair.

RSOCKD



SIZE 6.358mm to 64.900mm

Straight shank

RSOCKTSD



SIZE 6.358mm to 64.900mm

Taper shank

Miscellaneous Reamers

SPRUE: HSS Sprue bush reamers are designed for the purpose of reaming sprue bushes for plastic moulds. Available in 1,2,3,4 degree inclusive angles. 3.175mm to 12.700mm

RSPRUE



Straight shank quick spiral

RSPRUED



Straight shank Duplex type

RTTS



SIZE 5,6,8,9,10 degree tapers inclusive

Hss Taper shank Angle reamer.

RBS



SIZE 4.064mm to 46.759mm

Brown and Sharpe Taper Reamers, also referred to as Aircraft Taper Reamers, are used to finish Brown and Sharpe Taper Sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as drill presses, milling machines and machining centers.

RJARNO



SIZE 2.540mm to 65.000mm

Helical Jarno Taper Reamers are used to finish Jarno Taper sleeves. These sleeves are used to hold cutting tools or holders in the spindles of machines such as drill presses or milling machines.

RPIPE



SIZE 1/16 to 2.1/2

HSS Taper shank for pre reaming holes for tapered threads. Left hand quick spiral designed for machine use. The quick spiral gives sensitivity to machine cut and prevents breakages from swarf clogging.

RBPTS



SIZE 1:6, 1:8, 1:10

HSS Ball pin reamer with Taper Shank. For the manufacture of automotive steering joints.

RBRTS



SIZE 6.40 to 40.00

Taper shank bridge reamer, left hand spiral flute, right hand cutting with large tapered lead-in. A robust tool with the front portion only tapered (at approx 1:10) and the remainder parallel. Suitable for opening out existing.

RDIE



SIZE 1/2 degree included or 0.0087 per inch and 0.005 per inch for laminated dies.

HSS high spiral taper pin reamer designed for machine use. This reamer is available from stock in three taper angles: 3/4 degree included or 0.013 per inch for piercing dies.

RCAR



SIZE 5.900mm to 33.338mm

1:10 HSS 5 flute taper reamers are suitable for opening up existing holes and hole alignment, particularly in sheet metal.

RLUER



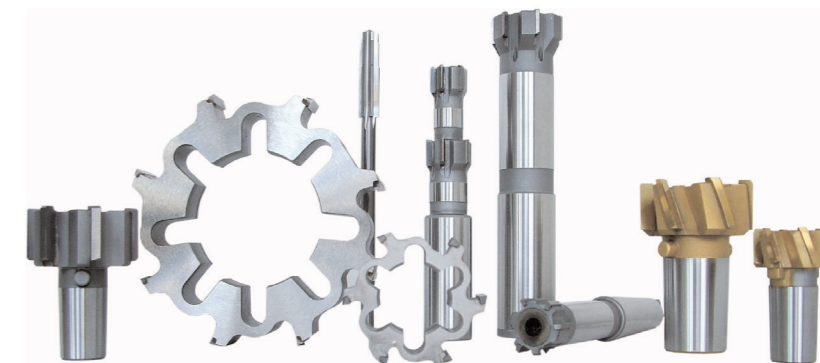
SIZE 6%

Tapered Carbide Reamer for medical applications.

Diatool Reamers

For High Performance Reaming

- Diatool for standard & special reamers
- Solid and expandable
- Diameter range: Ø 5,600 –150,000 mm
- In Carbide, Cermet, PCD, & all the latest coatings
- Repair service: Retip - Regrind - Recoat
- Express orders on request



Bespoke Special Reamers

We have been producing Reamers in our workshop since 1961.

Our team of engineers has a great depth of experience in all aspects of reaming whilst our sales team can offer technical advice. Our in house team of grinders can modify standard tooling or manufacture standard or non standard tooling to a customers specification in HSS, HSCO, Carbide or Carbide Tipped. Whether it is parallel or tapered reamers in stub length to extra length or stepped and piloted reamers for multi diameter holes and aircraft applications. All Reamers available with the latest coatings. We also have access to a worldwide network of Suppliers who can manufacture Reamers outside of our range.



Drill Reamers

DRILL REAMERS: Drill Reamers cut the cost by Drilling and reaming in one operation. Useful for holding tighter tolerances and obtaining a better finish than a standard drill.

DR



SIZE 3.175mm to 12.700mm

Straight shank

DRCSF



SIZE 3.175mm to 9.525mm

for Composites and Sandwiches

DRTS



SIZE 4.762mm to 25.400mm

Taper shank

Available in HSS, HSCO and Carbide and with the latest coatings as required. Available with Straight or taper shank.

We stock the common aircraft sizes as standard but please enquire for other sizes.

Drill Reamers have 2 Drill Flutes and 4 or 6 Reaming Flutes. 118 degree point angle.

Part no.	Diameter	Flute Length MM	OAL MM	Price
DR-1/8	1/8	36	65	£43.55
DR-128	0.128IN	50.8	82.6	£61.34
DR-5/32	5/32	43	75	£42.90
DR-159	0.159IN	50.8	82.6	£61.55
DR-187	0.187IN	52	82.6	£61.73
DR-3/16	3/16	50.8	86	£39.60
DR-190	0.190IN	50.8	82.6	£21.33
DR-1/4	1/4	65	101	£21.65
DR-1/4X6	1/4	95	152	£55.27



35,000 STOCKED TOOLS



www.drill-service.co.uk

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