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
## 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

**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 for finishing existing holes in most ferrous and non ferrous materials. Manufactured to customer’s specifications.

**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 keyways, 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.

#### RCRTC
- **SIZE**: 3.900mm to 12.000mm
- 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.

### 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.

#### 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.

#### 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.

#### RCTSFR
- **SIZE**: 6.00mm to 31.750mm
- Long Tipped: Straight flute for deep-hole reaming and long runs.

#### RCTTFR
- **SIZE**: 6.00mm to 50.876mm
- Taper Shank

#### RCTLSFR
- **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
- Thorough Coolant: Will prolong the life of the cutting edge and assist in swarf evacuation.

#### RCTRCC
- **SIZE**: 6.048mm to 19.126mm
- Right hand spiral through coolant reamer.
**Taper Pin Reamers**

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

**RTP**
- **SIZE 0.90mm to 56.900**
  - HSS for hand use with square drive.

**RTC**
- **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.

**RTH**
- **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.

**RTPS**
- **SIZE 0.850mm to 11.900**

**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.

**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 form excess torque and clogging.

**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.

**Centre Reamers**

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

**Socket Reamers**

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

**Foam Centre Reamers**

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

**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 form excess torque and clogging.

**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.

**Centre Reamers**

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

**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 form excess torque and clogging.

**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.

**Centre Reamers**

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

**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 form excess torque and clogging.

**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.
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

RSRPRUE
Straight shank quick spiral

RSRPRUED
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 Jarino Taper Reamers are used to finish Jarino 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, Cernit, PCD, & all the latest coatings
- Repair service: Retip - Regrind - Recoeat
- 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 and stopped 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

<table>
<thead>
<tr>
<th>Part no.</th>
<th>Diameter</th>
<th>Flute Length MM</th>
<th>OAL MM</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>DR-1/8</td>
<td>1/8</td>
<td>36</td>
<td>65</td>
<td>£43.55</td>
</tr>
<tr>
<td>DR-12B</td>
<td>0.128H</td>
<td>50.8</td>
<td>82.6</td>
<td>£61.34</td>
</tr>
<tr>
<td>DR-5/32</td>
<td>5/32</td>
<td>43</td>
<td>75</td>
<td>£42.90</td>
</tr>
<tr>
<td>DR-15#</td>
<td>0.159H</td>
<td>50.8</td>
<td>82.6</td>
<td>£81.55</td>
</tr>
<tr>
<td>DR-167</td>
<td>0.161H</td>
<td>52</td>
<td>82.6</td>
<td>£61.73</td>
</tr>
<tr>
<td>DR-3/16</td>
<td>3/16</td>
<td>50.8</td>
<td>85</td>
<td>£39.60</td>
</tr>
<tr>
<td>DR-150</td>
<td>0.190H</td>
<td>50.8</td>
<td>82.6</td>
<td>£21.33</td>
</tr>
<tr>
<td>DR-1/4</td>
<td>1/4</td>
<td>55</td>
<td>101</td>
<td>£21.65</td>
</tr>
<tr>
<td>DR-4X66</td>
<td>1/4</td>
<td>95</td>
<td>152</td>
<td>£50.27</td>
</tr>
</tbody>
</table>
35,000 STOCKED TOOLS

www.drill-service.co.uk
Drill Service (Horley) Ltd Albert Road Horley Surrey RH6 7HR
Tel: 01293 774911 email: sales@drill-service.co.uk

FEB 2016