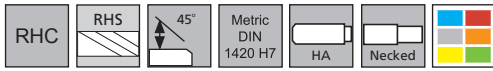
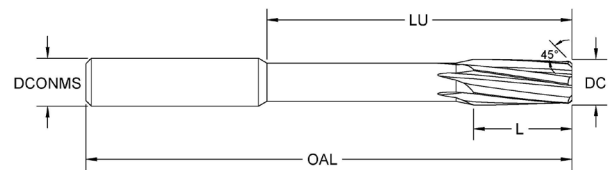


TrueSize® NC Machine Reamer - Series 275



- Solid Carbide
- Recommended for CNC reaming applications
- Common metric shanks for high-accuracy clamping
- Extended reach for increased hole depths
- RH Spiral / RH Cut design for both blind and through hole applications
- Suited for most materials



Metric (mm) Sizes	
DC	Tolerance
1.00 - 12.00	DIN 1420 H7
DCONMS	Tolerance (h6)
0.00 - 3.00	+0/-0.006
3.01 - 6.00	+0/-0.008
6.01 - 10.00	+0/-0.009
10.01 - 14.00	+0/-0.011

DIN1420 H7	
DC	Tolerance
≤ 3mm	+0.0041/+0.0078
>3mm - 6mm	+0.0051/+0.0100
> 6mm - 10mm	+0.0061/+0.0120
> 10mm - 12mm	+0.0078/+0.0150

Lead Chamfer Width (45° ± 1°)	
DC	Width
0.00 - 2.45	21% - 23% of DC
2.46 - 3.45	0.38 - 23% of DC
3.46 - 9.52	0.5 - 1.02
9.53 - 12.00	0.76 - 1.27

Tool No.	EDP	DC	DCONMS	OAL	L	LU	NOF
		mm					
275M0100	27530	1.0	3.0	50.0	6.0	22.0	4
275M0150	27531	1.5	3.0	50.0	9.0	22.0	4
275M0200	27535	2.0	3.0	50.0	12.0	22.0	4
275M0250	27538	2.5	3.0	50.0	12.0	22.0	4
275M0300	27539	3.0	4.0	66.0	12.0	38.0	4
275M0350	27546	3.5	4.0	66.0	12.0	38.0	4
275M0400	27548	4.0	6.0	76.0	12.0	40.0	4
275M0450	27549	4.5	6.0	76.0	12.0	40.0	4
275M0500	27554	5.0	6.0	76.0	12.0	40.0	4
275M0550	27555	5.5	6.0	76.0	12.0	40.0	4
275M0600	27557	6.0	8.0	101.0	12.0	65.0	4
275M0650	27562	6.5	8.0	101.0	16.0	65.0	6
275M0700	27563	7.0	8.0	101.0	16.0	65.0	6
275M0750	27566	7.5	8.0	101.0	16.0	65.0	6
275M0800	27568	8.0	10.0	103.0	16.0	63.0	6
275M0850	27569	8.5	10.0	103.0	19.0	63.0	6
275M0900	27570	9.0	10.0	103.0	19.0	63.0	6
275M0950	27571	9.5	10.0	103.0	19.0	63.0	6
275M1000	27575	10.0	12.0	120.0	19.0	75.0	6
275M1050	27576	10.5	12.0	120.0	19.0	75.0	6
275M1100	27577	11.0	12.0	120.0	19.0	75.0	6
275M1150	27579	11.5	12.0	120.0	19.0	75.0	6
275M1200	27581	12.0	14.0	125.0	19.0	80.0	6

275 Series Recommended Cutting Data - Metric

Workpiece Material Group	ISO	Vc - M/Min Low - High	Drill Diameter (mm)					
			1.0 - 1.5	1.6 - 3.0	3.1 - 5.0	5.1 - 7.0	7.1 - 9.5	9.6 - 12.0
			Feed (mm/rev)					
Low Carbon Steels	P	30 - 45	0.075 - 0.200	0.200 - 0.350	0.200 - 0.400	0.250 - 0.550	0.400 - 0.700	0.400 - 0.750
Medium Carbon Steels		25 - 35	0.075 - 0.200	0.200 - 0.350	0.200 - 0.400	0.250 - 0.550	0.400 - 0.700	0.400 - 0.750
Alloy Steels		20 - 35	0.075 - 0.200	0.200 - 0.350	0.200 - 0.400	0.250 - 0.550	0.400 - 0.700	0.400 - 0.750
Die / Tool Steels		15 - 25	0.075 - 0.200	0.200 - 0.350	0.200 - 0.400	0.250 - 0.550	0.400 - 0.700	0.400 - 0.750
Free Machining Stainless Steels	M	20 - 30	0.075 - 0.200	0.205 - 0.330	0.200 - 0.400	0.280 - 0.530	0.400 - 0.700	0.400 - 0.780
Austenitic Stainless Steels		10 - 20	0.025 - 0.125	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.300 - 0.500	0.300 - 0.600
Difficult Stainless Steels		5 - 15	0.025 - 0.125	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.300 - 0.500	0.300 - 0.600
PH Stainless Steels		10 - 20	0.025 - 0.125	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.300 - 0.500	0.300 - 0.600
High Temp Alloys	S	5 - 15	0.015 - 0.075	0.100 - 0.200	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.250 - 0.450
Titanium Alloys		10 - 20	0.025 - 0.125	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.300 - 0.500	0.300 - 0.600
Gray Cast Irons	K	25 - 35	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Ductile Cast Irons		20 - 35	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Malleable Cast Irons		20 - 30	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Aluminium - ≤ 10% Si	N	75 - 105	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Aluminium - > 10% Si		60 - 90	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Copper / Brass		55 - 75	0.125 - 0.300	0.250 - 0.450	0.350 - 0.650	0.400 - 0.780	0.500 - 0.850	0.600 - 1.000
Hardened Steels 45-50 HRC	H	10 - 20	0.075 - 0.200	0.200 - 0.330	0.200 - 0.400	0.280 - 0.530	0.400 - 0.700	0.400 - 0.780
Hardened Steels 50-55 HRC		10 - 15	0.025 - 0.125	0.150 - 0.300	0.200 - 0.300	0.200 - 0.400	0.300 - 0.500	0.300 - 0.600

Stock Allowance for NC Machine Reamers - Metric	
Reamer Diameter (mm)	Total Allowance
1.0 - 1.5	0.08 - 0.15
1.5 - 3.0	0.13 - 0.23
3.0 - 6.0	0.18 - 0.30
6.0 - 12.0	0.25 - 0.38

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.