

# Technical Details



## Stock Removal

Sufficient amount of stock should be left in the work area to permit the reamer to cut rather than to burnish or glaze.

The amount of stock removal for machine reaming:

Reamer Diameter	Suggested Stock Removal
.2500"	.008" - .010"
.2501" - .5000"	.012" - .015"
.5001" - 1.0000"	.017" - .020"
1.001" - 1.5000"	.020" - .025"

The use of coolants will help produce a superior finish when reaming.

**Not Recommended for Composites, Plastics, or Graphite.** The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process, then cautiously progress incrementally to achieve optimum performance.

## Reamer Alignment

For optimum results, it is recommended to hold these tools in floating reamer holders. Since the objective of the reamers is to machine holes to tight tolerances, it is essential the reamers follow the existing hole and don't run out. The floating holders will allow the reamer to 'float' slightly so as it enters the hole it can adjust to the center of the hole. This will also distribute the cut depth evenly around the cutting flutes resulting in minimum cutting forces and increased tool life.