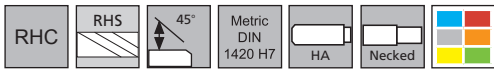
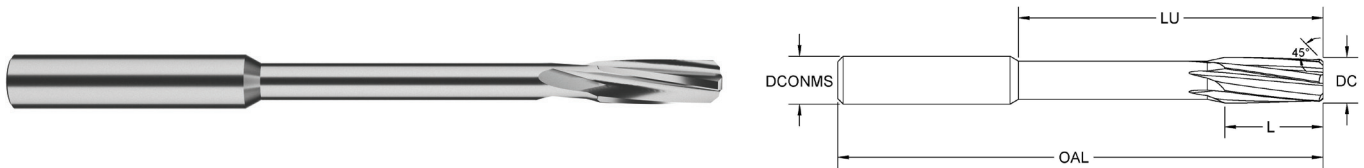


# TrueSize® NC Machine Reamer - Series 275



- 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



Inch Sizes	
DC	Tolerance
.0000 - .4375	+0.001/+0.003
DCONMS	Tolerance (h6)
.0000 - .1181	+0/-0.0024
.1182 - .2362	+0/-0.0031
.2363 - .3937	+0/-0.0035
.3938 - .5512	+0/-0.0043

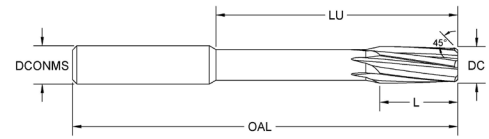
Metric (mm) Sizes	
DC	Tolerance
1.00 - 12.00	DIN 1420 H7
DCONMS	Tolerance (h6)
0.00 - 3.00	+0/-0.006
3.01 - 6.00	+0/-0.008
6.01 - 10.00	+0/-0.009
10.01 - 14.00	+0/-0.011

DIN 1420 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
.0000 - .0970	21% - 23% of DC
.0971 - .1360	.015 - 23% of DC
.1361 - .3750	.020 - .040
.3751 - .4724	.030 - .050

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
		Inch	Wire	mm	Decimal					
275M0100	27530			1.00	0.0394	3	50	6	22	4
275M0150	27531			1.50	0.0590	3	50	9	22	4
27506200	27532				0.0620	3	50	9	22	4
27506250	27533	1/16			0.0625	3	50	9	22	4
27506350	27534		52		0.0635	3	50	9	22	4
275M0200	27535			2.00	0.0787	3	50	12	22	4
27509350	27536		42		0.0935	3	50	12	22	4
27509370	27537	3/32			0.0937	3	50	12	22	4
275M0250	27538			2.50	0.0984	3	50	12	22	4



## TrueSize® NC Machine Reamer - Series 275

Tool No.	EDP	DC				DCONMS	OAL	L	LU	NOF
		Inch	Wire	mm	Decimal					
275M0300	27539			3.00	0.1181	4	66	12	38	4
27512450	27540	1/8 DP2			0.1245	4	66	12	38	4
27512500	27541	1/8			0.1250	4	66	12	38	4
27512550	27542				0.1255	4	66	12	38	4
27512600	27543	1/8 OS			0.1260	4	66	12	38	4
27512850	27544		30		0.1285	4	66	12	38	4
27513000	27545				0.1300	4	66	12	38	4
275M0350	27546			3.50	0.1378	4	66	12	38	4
27515620	27547	5/32			0.1562	4	66	12	38	4
275M0400	27548			4.00	0.1575	6	76	12	40	4
275M0450	27549			4.50	0.1772	6	76	12	40	4
27518150	27550				0.1815	6	76	12	40	4
27518700	27551	3/16 DP2			0.1870	6	76	12	40	4
27518750	27552	3/16			0.1875	6	76	12	40	4
27518800	27553				0.1880	6	76	12	40	4
275M0500	27554			5.00	0.1969	6	76	12	40	4
275M0550	27555			5.50	0.2165	6	76	12	40	4
27521870	27556	7/32			0.2187	6	76	12	40	4
275M0600	27557			6.00	0.2362	8	101	12	65	4
27524950	27558	1/4 DP2			0.2495	8	101	16	65	4
27525000	27559	1/4			0.2500	8	101	16	65	4
27525050	27560				0.2505	8	101	16	65	4
27525100	27561	1/4 OS			0.2510	8	101	16	65	4
275M0650	27562			6.50	0.2559	8	101	16	65	6
275M0700	27563			7.00	0.2756	8	101	16	65	6
27528120	27564	9/32			0.2812	8	101	16	65	6
275M0750	27566			7.50	0.2953	8	101	16	65	6
27531250	27567	5/16			0.3125	8	101	16	65	6
275M0800	27568			8.00	0.3150	10	103	16	63	6
275M0850	27569			8.50	0.3346	10	103	19	63	6
275M0900	27570			9.00	0.3543	10	103	19	63	6
275M0950	27571			9.50	0.3740	10	103	19	63	6
27537450	27572	3/8 DP2			0.3745	10	103	19	63	6
27537500	27573	3/8			0.3750	10	103	19	63	6
27537600	27574	3/8 OS			0.3760	10	103	19	63	6
275M1000	27575			10.00	0.3937	12	120	19	75	6
275M1050	27576			10.50	0.4134	12	120	19	75	6
275M1100	27577			11.00	0.4331	12	120	19	75	6
27543750	27578	7/16			0.4375	12	120	19	75	6
275M1150	27579			11.50	0.4527	12	120	19	75	6
275M1200	27581			12.00	0.4724	14	125	19	80	6

## 275 Series Recommended Cutting Data - Inch

Workpiece Material Group	ISO	Vc - SFM Low - High	Tool Diameter (Inch)					
			.039 - .062	.063 - .124	.125 - .188	.189 - .281	.282 - .375	.376 - .472
			Feed (in/rev)					
Low Carbon Steels	P	100 - 140	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Medium Carbon Steels		80 - 120	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Alloy Steels		70 - 110	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Die / Tool Steels		50 - 90	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Free Machining Stainless Steels	M	60 - 100	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Austenitic Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Difficult Stainless Steels		20 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
PH Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
High Temp Alloys	S	20 - 50	.0005 - .003	.004 - .008	.006 - .012	.008 - .012	.008 - .016	.010 - .018
Titanium Alloys		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Gray Cast Irons	K	80 - 120	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Ductile Cast Irons		70 - 110	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Malleable Cast Irons		60 - 100	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminum - ≤ 10% Si	N	250 - 350	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminium - > 10% Si		200 - 300	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Copper / Brass		180 - 250	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Hardened Steels 45-50 HRC	H	40 - 70	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Hardened Steels 50-55 HRC		30 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024

Stock Allowance for NC Machine Reamers - Inch	
Reamer Diameter (Inch)	Total Allowance
.039 - .062	.003 - .006
.062 - .125	.005 - .009
.125 - .250	.007 - .012
.250 - .472	.010 - .015

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

## 275 Series Recommended Cutting Data - Metric

Workpiece Material Group	I S O	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	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Medium Carbon Steels		25 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Alloy Steels		20 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Die / Tool Steels		15 - 25	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Free Machining Stainless Steels	M	20 - 30	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Austenitic Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Difficult Stainless Steels		5 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
PH Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
High Temp Alloys	S	5 - 15	.015 - 0.75	.100 - .205	.105 - .305	.205 - .305	.205 - .405	.255 - .455
Titanium Alloys		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Gray Cast Irons	K	25 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Ductile Cast Irons		20 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Malleable Cast Irons		20 - 30	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminum - ≤ 10% Si	N	75 - 105	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminium - > 10% Si		60 - 90	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Copper / Brass		55 - 75	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Hardened Steels 45-50 HRC	H	10 - 20	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Hardened Steels 50-55 HRC		10 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610

Stock Allowance for NC Machine Reamers - Metric	
Reamer Diameter (mm)	Total Allowance
1.0 - 1.5	.08 - .15
1.5 - 3.0	.13 - .23
3.0 - 6.0	.18 - .30
6.0 - 12.0	.25 - .38

**If you don't see  
the size you need -  
Contact Customer  
Service for  
assistance.**

**Safety Note**  
Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.

**WARNING:** This product can expose you to chemicals including cobalt which is known to the State of California to cause cancer. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

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