

STANDARD LENGTH STUB SCREW MACHINE REAMERS

Left Hand Spiral with Right Hand Cut	SSLR
Right Hand Spiral with Right Hand Cut	SSRR
Straight Flute with Right Hand Cut	SSSR
Left Hand Spiral with Left Hand Cut	SSLL
Right Hand Spiral with Left Hand Cut	SSRL
Straight Flute with Left Hand Cut	SSSL



Schedule K2

These abbreviated versions of the chucking reamer are ideal for applications where the holes are shallow. Originally designed for use in screw machines, these tools can be used in a wide variety of machining applications. Pinholes in the shank allow for use in floating holders. Gammons Stub Screw Machine Reamers are available in a wide variety of diameters, cuts and flute spirals. They are also available in 3 or 4 flute styles or as semi-finished blanks.



Order specific style using the four letter part number code listed above followed by the number of flutes.

Part Number	Blank	Diameter Range	Overall Length	Flute Length	Shank Length	Shank Diameter	Hole Diameter	Number of Flutes
****300	3/0	.0301 - .0599	1.75	0.50	1.00	0.125	0.063	4
****200	2/0	.0600 - .0660	1.75	0.50	1.00	0.125	0.063	4
****000	0	.0661 - .0740	1.75	0.50	1.00	0.125	0.063	4
****001	1	.0741 - .0840	1.75	0.50	1.00	0.125	0.063	4
****002	2	.0841 - .0960	1.75	0.50	1.00	0.125	0.063	4
****003	3	.0961 - .1260	2.00	0.75	1.00	0.125	0.063	4
****004	4	.1261 - .1580	2.25	1.00	1.00	0.250	0.094	4
****005	5	.1581 - .1880	2.25	1.00	1.00	0.250	0.094	4
****006	6	.1881 - .2190	2.25	1.00	1.00	0.250	0.094	3, 4 or 6
****007	7	.2191 - .2510	2.25	1.00	1.00	0.250	0.094	3, 4 or 6
****008	8	.2511 - .2820	2.25	1.00	1.00	0.375	0.125	3, 4 or 6
****009	9	.2821 - .3130	2.25	1.00	1.00	0.375	0.125	3, 4 or 6
****010	10	.3131 - .3440	2.50	1.25	1.00	0.375	0.125	3, 4 or 6
****011	11	.3441 - .3760	2.50	1.25	1.00	0.375	0.125	3, 4 or 6
****012	12	.3761 - .4070	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****013	13	.4071 - .4390	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****014	14	.4391 - .4700	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****015	15	.4701 - .5050	2.50	1.25	1.00	0.500	0.188	3, 4 or 6
****016	16	.5051 - .5670	3.00	1.50	1.25	0.625	0.250	3, 4 or 6
****017	17	.5671 - .6280	3.00	1.50	1.25	0.625	0.250	3, 4 or 6
****018	18	.6281 - .6920	3.00	1.50	1.25	0.625	0.250	3, 4 or 8
****019	19	.6921 - .7550	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****020	20	.7551 - .8170	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****021	21	.8171 - .8800	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****022	22	.8801 - .9420	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****023	23	.9421 - 1.010	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****024	24	1.011 - 1.047	3.00	1.50	1.25	0.750	0.313	3, 4 or 8
****025	25	1.048 - 1.110	3.00	1.50	1.25	0.750	0.313	4 or 8
****026	26	1.111 - 1.235	3.00	1.50	1.25	0.750	0.313	4 or 8
****027	27	1.236 - 1.360	3.00	1.50	1.25	0.750	0.313	4 or 8
****028	28	1.361 - 1.550	3.00	1.50	1.25	0.750	0.313	4 or 8

Flute diameters are held to a tolerance of $\pm .0002$ "/ $-.0000$ " unless otherwise requested.
 Also furnished as specials with end teeth, steps or pilots.
 Available in premium high speed steel or carbide. All surface treatments are available upon request.

All sizes between ****006 and ****024 may be special ordered in three and four flute style.
 All sizes between ****025 and ****028 may be special ordered in four flute style.