



In applications demanding precision hole tolerances, tighter diameter control and quality bore finishes, our TrueSize® reamers provide a high quality and highly cost-effective solution. Our reamers are available in a wide range of sizes and can be used to machine virtually any material, including cast iron, aluminium, stainless steel, exotic alloys, plastics and other non-ferrous materials.

(FR)

Pour les applications exigeant de la précision et une bonne tolérance de trous, un contrôle de diamètre plus strict et une finition de qualité dans le perçage, nos alésoirs TrueSize® fournissent des solutions de grande qualité et hautement rentables. Nos alésoirs sont disponibles dans une grande variété de tailles et peuvent être utilisés pour usiner pratiquement n'importe quel matériau, y compris la fonte, l'aluminium, l'acier inoxydable, les alliages exotiques, le plastique et d'autres matériaux non-ferreux.

(DE)

Für Anwendungen, bei denen Präzisionsbohrungen mit geringen Toleranzen, eine strengere Durchmesserkontrolle und eine hochwertige Oberflächengüte der Bohrungen erforderlich sind, bieten unsere TrueSize®-Reibahlen eine Lösung von hoher Qualität und zu einem sehr guten Preis-Leistungs-Verhältnis. Unsere Reibahlen sind in diversen Größen erhältlich und können zur Bearbeitung nahezu jeden Materials verwendet werden, einschließlich Gusseisen, Aluminium, rostfreiem Stahl, Sonderlegierungen, Kunststoffen und sonstigen eisenfreien Materialien.

(IT)

Nelle applicazioni che richiedono tolleranze di precisione per i fori, controllo più stretto del diametro e finiture di qualità, i nostri alesatori TrueSize® offrono una soluzione di alta qualità e altamente efficiente. I nostri alesatori sono disponibili in una vasta gamma di misure e possono essere utilizzati per la lavorazione di qualsiasi materiale, tra cui ghisa, alluminio, acciaio inossidabile, leghe esotiche, materie plastiche e altri materiali non ferrosi.

(PL)

W zastosowaniach wymagających precyzyjnych tolerancji otworów, dokładniejszej kontroli średnicy i wysokiej jakości wykończenia, nasze rozwiertaki TrueSize® zapewniają wysoką jakość i bardzo ekonomiczne rozwiązanie. Nasze rozwiertaki są dostępne w szerokiej gamie rozmiarów i mogą być stosowane do maszyn praktycznie w każdym materiale, w tym żeliwie, aluminium, stali nierdzewnej, stopach egzotycznych, tworzywach sztucznych i innych materiałach nieżelaznych.

# TrueSize®

## Reamers

Alésoirs Reibahlen Alesatori Rozwiertaki

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FORD MAX

Reamers  
Alésoirs  
Reibahlen  
Alesatori  
Rozwiertaki

# TrueSize® Solid Carbide Reamers

## Recommended Stock Allowance For Truesize® Solid Carbide Metric Reamers

Surépaisseur recommandée pour les alésosirs métriques en carbure monoblocs Truesize® · Empfohlenes Aufmaß für Truesize®-Vollhartmetall-Reibahlen  
 Sovrametallo raccomandato per alesatori metrici in metallo duro Truesize® · Zalecany naddatek dla rozwiertaków węglkowych Truesize®

Workpiece Material Group	Material Type	Reamer Diameter (mm)										
		0.35	1.00	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00	16.00
		Drill Diameter (mm)										
		0.30	0.90	1.80	2.70	3.70	4.70	5.70	7.60	9.60	11.60	15.50
Stock Allowance (mm)												
<b>P</b>	Low Carbon	0.03	0.09	0.17	0.24	0.26	0.27	0.28	0.31	0.33	0.35	0.41
	Medium Carbon	0.03	0.08	0.15	0.21	0.23	0.24	0.25	0.28	0.31	0.32	0.38
	Tool Steel	0.03	0.08	0.15	0.21	0.23	0.24	0.25	0.28	0.31	0.32	0.38
<b>M</b>	Stainless	0.03	0.08	0.15	0.21	0.23	0.24	0.25	0.28	0.31	0.32	0.38
<b>S</b>	High Temp Alloys	0.03	0.07	0.14	0.20	0.21	0.22	0.23	0.24	0.26	0.29	0.33
	Titanium Alloys	0.03	0.09	0.17	0.24	0.26	0.27	0.28	0.31	0.33	0.35	0.41
<b>K</b>	Grey Cast Iron	0.03	0.09	0.17	0.24	0.26	0.27	0.28	0.31	0.33	0.35	0.41
	Ductile Cast Iron	0.03	0.09	0.17	0.24	0.26	0.27	0.28	0.31	0.33	0.35	0.41
<b>H</b>	Hardened Steel	0.02	0.06	0.12	0.17	0.19	0.19	0.20	0.23	0.26	0.27	0.33
<b>N</b>	Aluminium Alloys	0.04	0.09	0.19	0.27	0.29	0.29	0.30	0.32	0.34	0.37	0.41
	Copper & Hard Bronze	0.04	0.09	0.19	0.27	0.29	0.29	0.30	0.33	0.36	0.38	0.43
	Brass & Soft Bronze	0.04	0.09	0.19	0.27	0.29	0.29	0.30	0.32	0.34	0.37	0.41

## Dowel Pin Chart - Metric Dowels

Tableau des goupilles - goupilles métriques · Tabelle der Spannstifte - metrische Spannstifte · Tabella spine calibrate - Spine metriche · Tabela kołków - kołki metryczne

Dowel Pin	Strong Press Fit	Reamer Required	Tight Press Fit	Reamer Required	Loose Press Fit	Reamer Required	Tight Slip Fit	Reamer Required	Loose Slip Fit	Reamer Required
Size (mm)	Reamer Ø	Tool No.	Reamer Ø	Tool No.	Reamer Ø	Tool No.	Reamer Ø	Tool No.	Reamer Ø	Tool No.
2.0	1.95	27207670	1.98	27207810	1.99	27207850	2.01	27207900	2.02	27207950
3.0	2.95	27211610	2.98	27211750	3.00	27211800	3.01	27211850	3.02	27211900
4.0	3.95	27215550	3.99	27215700	4.00	27215750	4.01	27215800	4.03	27215850
5.0	4.95	27219490	4.99	27219650	5.00	27219690	5.02	27219750	5.03	27219800
6.0	5.95	27223430	5.98	27223550	5.99	27223600	6.01	27223650	6.02	27223700
8.0	7.95	27231300	7.98	27231400	8.00	27231500	8.00	27231500	8.03	27231600
10.0	9.96	27239200	9.98	27239300	10.00	27239370	10.01	27239400	10.03	27239500
12.0	11.96	27247100	11.99	27247200	12.00	27247240	12.01	27247300	12.01	27247300

Truesize® Reamer Tolerance - DIN 1420 H7  
 Dowels are to nominal size +0.0025 / -0.0025mm

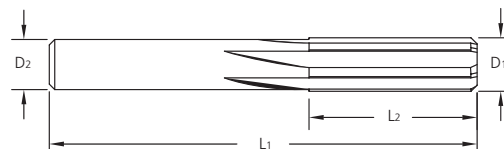
**ISO 9001:2008 Certified**  
 ISO 9001:2008 Certifié  
 Nach ISO 9001:2008 zertifiziert  
 Certificato ISO 9001: 2008  
 Certyfikat ISO 9001:2008

# TrueSize® Straight Flute Carbide Reamers Series 272



DIN 1420 H7

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
> 10.00 - 16.00	+ 0.008 / + 0.015

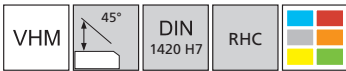


Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27201300	0.330	0.33	38.0	5.0	4
27201350	0.343	0.34	38.0	5.0	4
27201380	0.351	0.35	38.0	5.0	4
27201400	0.356	0.36	38.0	5.0	4
27201450	0.368	0.37	38.0	5.0	4
27201500	0.381	0.38	38.0	5.0	4
27201550	0.394	0.39	38.0	5.0	4
27201570	0.400	0.40	38.0	5.0	4
27201600	0.406	0.41	38.0	5.0	4
27201650	0.419	0.42	38.0	5.0	4
27201700	0.432	0.43	38.0	5.0	4
27201750	0.445	0.45	38.0	5.0	4
27201770	0.450	0.45	38.0	5.0	4
27201800	0.457	0.46	38.0	5.0	4
27201850	0.470	0.47	38.0	5.0	4
27201900	0.483	0.48	38.0	5.0	4
27201950	0.495	0.49	38.0	5.0	4
27201970	0.500	0.50	38.0	5.0	4
27202000	0.508	0.51	38.0	5.0	4
27202050	0.521	0.52	38.0	6.5	4
27202100	0.533	0.53	38.0	6.5	4
27202150	0.546	0.55	38.0	6.5	4
27202170	0.551	0.55	38.0	6.5	4
27202200	0.559	0.56	38.0	6.5	4
27202250	0.572	0.57	38.0	6.5	4
27202300	0.584	0.58	38.0	6.5	4
27202350	0.597	0.59	38.0	6.5	4
27202360	0.600	0.60	38.0	6.5	4
27202400	0.610	0.61	38.0	6.5	4
27202450	0.622	0.62	38.0	6.5	4
27202500	0.635	0.64	38.0	6.5	4
27202550	0.648	0.65	38.0	6.5	4
27202560	0.650	0.65	38.0	6.5	4
27202600	0.660	0.66	38.0	6.5	4
27202650	0.673	0.67	38.0	6.5	4
27202700	0.686	0.69	38.0	6.5	4
27202750	0.700	0.70	38.0	6.5	4
27202800	0.711	0.71	38.0	6.5	4
27202850	0.724	0.72	38.0	6.5	4
27202900	0.737	0.73	38.0	6.5	4
27202920	0.742	0.74	38.0	6.5	4
27202951	0.750	0.75	38.0	6.5	4
27203000	0.762	0.76	38.0	6.5	4
27203050	0.775	0.78	38.0	6.5	4
27203100	0.787	0.79	38.0	6.5	4
27203120	0.792	0.79	38.0	6.5	4
27203150	0.800	0.80	38.0	6.5	4

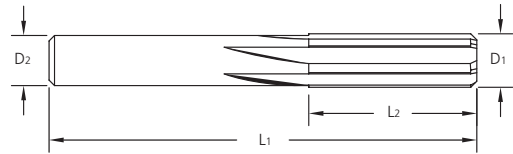
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27203200	0.813	0.81	38.0	6.5	4
27203250	0.826	0.83	38.0	6.5	4
27203300	0.838	0.84	38.0	6.5	4
27203350	0.850	0.85	38.0	6.5	4
27203400	0.864	0.86	38.0	6.5	4
27203450	0.876	0.88	38.0	6.5	4
27203500	0.889	0.89	38.0	6.5	4
27203540	0.900	0.90	38.0	6.5	4
27203600	0.914	0.91	38.0	6.5	4
27203650	0.927	0.93	38.0	6.5	4
27203700	0.940	0.94	38.0	6.5	4
27203740	0.950	0.95	38.0	6.5	4
27203800	0.965	0.97	38.0	6.5	4
27203850	0.978	0.98	38.0	6.5	4
27203900	0.991	0.99	38.0	6.5	4
27203940	1.000	1.00	38.0	6.5	4
27204000	1.016	1.02	38.0	6.5	4
27204050	1.029	1.03	38.0	9.5	4
27204100	1.041	1.04	38.0	9.5	4
27204130	1.049	1.05	38.0	9.5	4
27204150	1.054	1.06	38.0	9.5	4
27204200	1.067	1.07	38.0	9.5	4
27204250	1.080	1.08	38.0	9.5	4
27204300	1.092	1.09	38.0	9.5	4
27204330	1.100	1.10	38.0	9.5	4
27204350	1.105	1.09	38.0	9.5	4
27204400	1.118	1.09	38.0	9.5	4
27204450	1.130	1.09	38.0	9.5	4
27204500	1.143	1.09	38.0	9.5	4
27204520	1.148	1.09	38.0	9.5	4
27204550	1.156	1.09	38.0	9.5	4
27204600	1.168	1.09	38.0	9.5	4
27204650	1.181	1.09	38.0	9.5	4
27204680	1.189	1.09	38.0	9.5	4
27204700	1.194	1.09	38.0	9.5	4
27204720	1.200	1.09	38.0	9.5	4
27204750	1.207	1.09	38.0	9.5	4
27204800	1.219	1.09	38.0	9.5	4
27204850	1.232	1.09	38.0	9.5	4
27204900	1.245	1.09	38.0	9.5	4
27204920	1.250	1.09	38.0	9.5	4
27204950	1.257	1.09	38.0	9.5	4
27205000	1.270	1.09	38.0	9.5	4
27205050	1.283	1.09	38.0	9.5	4
27205100	1.295	1.09	38.0	9.5	4
27205110	1.298	1.09	38.0	9.5	4
27205150	1.308	1.09	38.0	9.5	4



# TrueSize® Straight Flute Carbide Reamers Series 272


**DIN 1420 H7**

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
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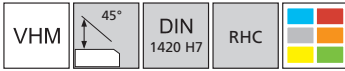


Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27205200	1.321	1.17	38.0	9.5	4
27205250	1.334	1.17	38.0	9.5	4
27205300	1.346	1.17	38.0	9.5	4
27205310	1.349	1.17	38.0	9.5	4
27205350	1.359	1.17	38.0	9.5	4
27205400	1.372	1.17	38.0	9.5	4
27205450	1.384	1.17	38.0	9.5	4
27205500	1.397	1.17	38.0	9.5	4
27205510	1.400	1.17	38.0	9.5	4
27205550	1.410	1.17	38.0	9.5	4
27205600	1.422	1.17	38.0	9.5	4
27205650	1.435	1.17	38.0	9.5	4
27205700	1.448	1.17	38.0	9.5	4
27205710	1.450	1.17	38.0	9.5	4
27205750	1.461	1.17	38.0	9.5	4
27205800	1.473	1.17	38.0	9.5	4
27205850	1.486	1.17	38.0	9.5	4
27205901	1.500	1.17	38.0	9.5	4
27205950	1.511	1.47	38.0	9.5	4
27206000	1.524	1.47	38.0	9.5	4
27206050	1.537	1.47	38.0	9.5	4
27206101	1.550	1.47	38.0	9.5	4
27206150	1.562	1.47	38.0	9.5	4
27206200	1.575	1.47	38.0	9.5	4
27206250	1.588	1.47	38.0	9.5	4
27206300	1.600	1.47	38.0	9.5	4
27206350	1.613	1.47	38.0	9.5	4
27206400	1.626	1.47	38.0	9.5	4
27206450	1.638	1.47	38.0	9.5	4
27206500	1.650	1.47	38.0	9.5	4
27206550	1.664	1.47	38.0	9.5	4
27206600	1.676	1.47	38.0	9.5	4
27206650	1.689	1.65	44.0	12.5	4
27206690	1.700	1.65	44.0	12.5	4
27206750	1.715	1.65	44.0	12.5	4
27206800	1.727	1.65	44.0	12.5	4
27206850	1.740	1.65	44.0	12.5	4
27206890	1.750	1.65	44.0	12.5	4
27206900	1.753	1.65	44.0	12.5	4
27206950	1.765	1.65	44.0	12.5	4
27207000	1.778	1.65	44.0	12.5	4
27207050	1.791	1.65	44.0	12.5	4
27207080	1.798	1.65	44.0	12.5	4
27207100	1.803	1.65	44.0	12.5	4
27207150	1.816	1.65	44.0	12.5	4
27207200	1.829	1.65	44.0	12.5	4
27207250	1.842	1.65	44.0	12.5	4

Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27207280	1.850	1.65	44.0	12.5	4
27207300	1.854	1.65	44.0	12.5	4
27207350	1.867	1.65	44.0	12.5	4
27207400	1.880	1.65	44.0	12.5	4
27207450	1.892	1.85	44.0	12.5	4
27207480	1.900	1.85	44.0	12.5	4
27207500	1.905	1.85	44.0	12.5	4
27207550	1.918	1.85	44.0	12.5	4
27207600	1.930	1.85	44.0	12.5	4
27207650	1.943	1.85	44.0	12.5	4
27207670	1.948	1.85	44.0	12.5	4
27207700	1.956	1.85	44.0	12.5	4
27207750	1.969	1.85	44.0	12.5	4
27207800	1.981	1.85	44.0	12.5	4
27207810	1.984	1.85	44.0	12.5	4
27207850	1.994	1.85	44.0	12.5	4
27207870	2.000	1.85	44.0	12.5	4
27207900	2.007	1.85	44.0	12.5	4
27207950	2.019	1.85	44.0	12.5	4
27208000	2.032	1.85	44.0	12.5	4
27208050	2.045	1.85	44.0	12.5	4
27208070	2.050	1.85	44.0	12.5	4
27208100	2.057	1.85	44.0	12.5	4
27208150	2.070	2.03	51.0	12.5	4
27208200	2.083	2.03	51.0	12.5	4
27208250	2.096	2.03	51.0	12.5	4
27208270	2.101	2.03	51.0	12.5	4
27208300	2.108	2.03	51.0	12.5	4
27208350	2.121	2.03	51.0	12.5	4
27208400	2.134	2.03	51.0	12.5	4
27208450	2.146	2.03	51.0	12.5	4
27208460	2.149	2.03	51.0	12.5	4
27208500	2.159	2.03	51.0	12.5	4
27208550	2.172	2.03	51.0	12.5	4
27208600	2.184	2.03	51.0	12.5	4
27208650	2.197	2.03	51.0	12.5	4
27208660	2.200	2.03	51.0	12.5	4
27208700	2.210	2.03	51.0	12.5	4
27208750	2.223	2.03	51.0	12.5	4
27208800	2.235	2.03	51.0	12.5	4
27208850	2.248	2.03	51.0	12.5	4
27208860	2.250	2.03	51.0	12.5	4
27208900	2.261	2.03	51.0	12.5	4
27208950	2.273	2.24	51.0	12.5	4
27209000	2.286	2.24	51.0	12.5	4
27209050	2.300	2.24	51.0	12.5	4
27209100	2.311	2.24	51.0	12.5	4

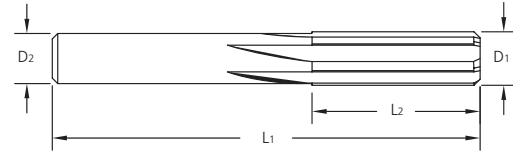


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DIN 1420 H7

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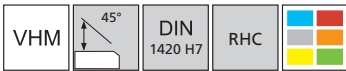


Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27209150	2.324	2.24	51.0	12.5	4
27209200	2.337	2.24	51.0	12.5	4
27209251	2.350	2.24	51.0	12.5	4
27209300	2.362	2.24	51.0	12.5	4
27209350	2.375	2.24	51.0	12.5	4
27209370	2.380	2.24	51.0	12.5	4
27209400	2.388	2.24	51.0	12.5	4
27209450	2.400	2.24	51.0	12.5	4
27209500	2.413	2.24	51.0	12.5	4
27209550	2.426	2.24	51.0	12.5	4
27209600	2.438	2.24	51.0	12.5	4
27209650	2.451	2.24	51.0	12.5	4
27209700	2.464	2.24	51.0	12.5	4
27209750	2.477	2.44	57.0	16.0	4
27209800	2.489	2.44	57.0	16.0	4
27209840	2.500	2.44	57.0	16.0	4
27209900	2.515	2.44	57.0	16.0	4
27209950	2.527	2.44	57.0	16.0	4
27210000	2.540	2.44	57.0	16.0	4
27210040	2.550	2.44	57.0	16.0	4
27210100	2.565	2.44	57.0	16.0	4
27210150	2.578	2.44	57.0	16.0	4
27210200	2.591	2.44	57.0	16.0	4
27210240	2.601	2.44	57.0	16.0	4
27210300	2.616	2.44	57.0	16.0	4
27210350	2.629	2.44	57.0	16.0	4
27210400	2.642	2.44	57.0	16.0	4
27210430	2.649	2.44	57.0	16.0	4
27210500	2.667	2.44	57.0	16.0	4
27210550	2.680	2.64	57.0	16.0	4
27210600	2.692	2.64	57.0	16.0	4
27210630	2.700	2.64	57.0	16.0	4
27210650	2.705	2.64	57.0	16.0	4
27210700	2.718	2.64	57.0	16.0	4
27210750	2.731	2.64	57.0	16.0	4
27210800	2.743	2.64	57.0	16.0	4
27210830	2.751	2.64	57.0	16.0	4
27210850	2.756	2.64	57.0	16.0	4
27210900	2.769	2.64	57.0	16.0	4
27210940	2.779	2.64	57.0	16.0	4
27210950	2.781	2.64	57.0	16.0	4
27211000	2.794	2.64	57.0	16.0	4
27211020	2.800	2.64	57.0	16.0	4
27211050	2.807	2.64	57.0	16.0	4
27211100	2.819	2.64	57.0	16.0	4
27211150	2.832	2.64	57.0	16.0	4
27211200	2.845	2.64	57.0	16.0	4

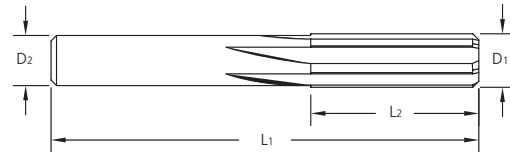
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27211220	2.850	2.64	57.0	16.0	4
27211250	2.858	2.64	57.0	16.0	4
27211300	2.870	2.64	57.0	16.0	4
27211350	2.883	2.84	57.0	16.0	4
27211400	2.896	2.84	57.0	16.0	4
27211420	2.900	2.84	57.0	16.0	4
27211450	2.908	2.84	57.0	16.0	4
27211500	2.921	2.84	57.0	16.0	4
27211550	2.934	2.84	57.0	16.0	4
27211600	2.946	2.84	57.0	16.0	4
27211610	2.949	2.84	57.0	16.0	4
27211650	2.959	2.84	57.0	16.0	4
27211700	2.972	2.84	57.0	16.0	4
27211750	2.985	2.84	57.0	16.0	4
27211810	3.000	2.84	57.0	16.0	4
27211850	3.010	2.84	57.0	16.0	4
27211900	3.023	2.84	57.0	16.0	4
27211950	3.035	2.84	57.0	16.0	4
27212000	3.048	2.84	57.0	16.0	4
27212010	3.051	2.84	57.0	16.0	4
27212050	3.061	2.84	57.0	16.0	4
27212100	3.073	2.84	57.0	16.0	4
27212150	3.086	3.05	57.0	16.0	4
27212200	3.099	3.05	57.0	16.0	4
27212250	3.112	3.05	57.0	16.0	4
27212300	3.124	3.05	57.0	16.0	4
27212350	3.137	3.05	57.0	16.0	4
27212401	3.150	3.05	57.0	16.0	4
27212450	3.162	3.05	57.0	16.0	4
27212480	3.170	3.05	57.0	16.0	4
27212500	3.175	3.05	57.0	16.0	4
27212550	3.188	3.05	57.0	16.0	4
27212600	3.200	3.05	57.0	16.0	4
27212650	3.213	3.05	57.0	16.0	4
27212700	3.226	3.05	57.0	16.0	4
27212750	3.239	3.05	57.0	16.0	4
27212800	3.251	3.05	57.0	16.0	4
27212850	3.264	3.23	63.0	19.0	4
27212900	3.277	3.23	63.0	19.0	4
27212950	3.289	3.23	63.0	19.0	4
27212990	3.300	3.23	63.0	19.0	4
27213050	3.315	3.23	63.0	19.0	4
27213100	3.327	3.23	63.0	19.0	4
27213150	3.340	3.23	63.0	19.0	4
27213190	3.350	3.23	63.0	19.0	4
27213250	3.366	3.23	63.0	19.0	4
27213300	3.378	3.23	63.0	19.0	4



# TrueSize® Straight Flute Carbide Reamers Series 272


**DIN 1420 H7**

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
> 10.00 - 16.00	+ 0.008 / + 0.015



Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27213350	3.391	3.23	63.0	19.0	4
27213390	3.401	3.23	63.0	19.0	4
27213450	3.416	3.23	63.0	19.0	4
27213500	3.429	3.23	63.0	19.0	4
27213550	3.442	3.23	63.0	19.0	4
27213580	3.449	3.23	63.0	19.0	4
27213600	3.454	3.23	63.0	19.0	4
27213650	3.467	3.43	63.0	19.0	4
27213700	3.480	3.43	63.0	19.0	4
27213750	3.493	3.43	63.0	19.0	4
27213780	3.500	3.43	63.0	19.0	4
27213800	3.505	3.43	63.0	19.0	4
27213850	3.518	3.43	63.0	19.0	4
27213900	3.531	3.43	63.0	19.0	4
27213950	3.543	3.43	63.0	19.0	4
27213980	3.551	3.43	63.0	19.0	4
27214000	3.556	3.43	63.0	19.0	4
27214060	3.571	3.43	63.0	19.0	4
27214100	3.581	3.43	63.0	19.0	4
27214150	3.594	3.43	63.0	19.0	4
27214170	3.599	3.43	63.0	19.0	4
27214200	3.607	3.43	63.0	19.0	4
27214250	3.620	3.43	63.0	19.0	4
27214300	3.632	3.43	63.0	19.0	4
27214350	3.645	3.43	63.0	19.0	4
27214370	3.650	3.43	63.0	19.0	4
27214400	3.658	3.43	63.0	19.0	4
27214450	3.670	3.63	63.0	19.0	4
27214500	3.683	3.63	63.0	19.0	4
27214550	3.696	3.63	63.0	19.0	4
27214570	3.701	3.63	63.0	19.0	4
27214600	3.708	3.63	63.0	19.0	4
27214650	3.721	3.63	63.0	19.0	4
27214700	3.734	3.63	63.0	19.0	4
27214750	3.747	3.63	63.0	19.0	4
27214760	3.750	3.63	63.0	19.0	4
27214800	3.759	3.63	63.0	19.0	4
27214850	3.772	3.63	63.0	19.0	4
27214900	3.785	3.63	63.0	19.0	4
27214960	3.800	3.63	63.0	19.0	4
27215000	3.810	3.63	63.0	19.0	4
27215050	3.823	3.63	63.0	19.0	4
27215100	3.835	3.63	63.0	19.0	4
27215160	3.851	3.63	63.0	19.0	4
27215200	3.861	3.63	63.0	19.0	4
27215250	3.874	3.84	63.0	19.0	4
27215300	3.886	3.84	63.0	19.0	4

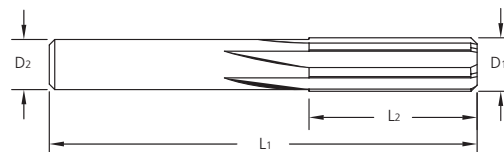
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27215351	3.900	3.84	63.0	19.0	4
27215400	3.912	3.84	63.0	19.0	4
27215450	3.924	3.84	63.0	19.0	4
27215500	3.937	3.84	63.0	19.0	4
27215550	3.950	3.84	63.0	19.0	4
27215600	3.962	3.84	63.0	19.0	4
27215620	3.967	3.84	63.0	19.0	4
27215650	3.975	3.84	63.0	19.0	4
27215700	3.988	3.84	63.0	19.0	4
27215750	4.000	3.84	63.0	19.0	4
27215800	4.013	3.84	63.0	19.0	4
27215850	4.026	3.84	63.0	19.0	4
27215900	4.039	3.84	63.0	19.0	4
27215940	4.049	4.01	70.0	22.0	4
27216000	4.064	4.01	70.0	22.0	4
27216050	4.077	4.01	70.0	22.0	4
27216100	4.089	4.01	70.0	22.0	4
27216140	4.100	4.01	70.0	22.0	4
27216200	4.115	4.01	70.0	22.0	4
27216250	4.128	4.01	70.0	22.0	4
27216300	4.140	4.01	70.0	22.0	4
27216340	4.150	4.01	70.0	22.0	4
27216400	4.166	4.01	70.0	22.0	4
27216450	4.178	4.01	70.0	22.0	4
27216500	4.191	4.01	70.0	22.0	4
27216540	4.201	4.01	70.0	22.0	4
27216600	4.216	4.01	70.0	22.0	4
27216650	4.229	4.01	70.0	22.0	4
27216700	4.242	4.01	70.0	22.0	4
27216730	4.249	4.22	70.0	22.0	4
27216800	4.267	4.22	70.0	22.0	4
27216850	4.280	4.22	70.0	22.0	4
27216900	4.293	4.22	70.0	22.0	4
27216930	4.300	4.22	70.0	22.0	4
27216950	4.305	4.22	70.0	22.0	4
27217000	4.318	4.22	70.0	22.0	4
27217050	4.331	4.22	70.0	22.0	4
27217100	4.343	4.22	70.0	22.0	4
27217130	4.351	4.22	70.0	22.0	4
27217150	4.356	4.22	70.0	22.0	4
27217190	4.366	4.22	70.0	22.0	4
27217200	4.369	4.22	70.0	22.0	4
27217250	4.382	4.22	70.0	22.0	4
27217300	4.394	4.22	70.0	22.0	4
27217320	4.399	4.22	70.0	22.0	4
27217350	4.407	4.22	70.0	22.0	4
27217400	4.420	4.22	70.0	22.0	4

# TrueSize® Straight Flute Carbide Reamers Series 272



DIN 1420 H7

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
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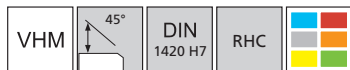


Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27217450	4.432	4.22	70.0	22.0	4
27217500	4.445	4.22	70.0	22.0	4
27217520	4.450	4.42	70.0	22.0	4
27217550	4.458	4.42	70.0	22.0	4
27217600	4.470	4.42	70.0	22.0	4
27217650	4.483	4.42	70.0	22.0	4
27217700	4.496	4.42	70.0	22.0	4
27217720	4.501	4.42	70.0	22.0	4
27217750	4.509	4.42	70.0	22.0	4
27217800	4.521	4.42	70.0	22.0	4
27217850	4.534	4.42	70.0	22.0	4
27217900	4.547	4.42	70.0	22.0	4
27217910	4.549	4.42	70.0	22.0	4
27217950	4.559	4.42	70.0	22.0	4
27218000	4.572	4.42	70.0	22.0	4
27218050	4.585	4.42	70.0	22.0	4
27218100	4.597	4.42	70.0	22.0	4
27218110	4.600	4.42	70.0	22.0	4
27218150	4.610	4.42	70.0	22.0	4
27218200	4.623	4.42	70.0	22.0	4
27218250	4.636	4.42	70.0	22.0	4
27218300	4.648	4.42	70.0	22.0	4
27218310	4.651	4.62	70.0	22.0	4
27218350	4.661	4.62	70.0	22.0	4
27218400	4.674	4.62	70.0	22.0	4
27218450	4.686	4.62	70.0	22.0	4
27218500	4.700	4.62	70.0	22.0	4
27218550	4.712	4.62	70.0	22.0	4
27218600	4.724	4.62	70.0	22.0	4
27218650	4.737	4.62	70.0	22.0	4
27218701	4.750	4.62	70.0	22.0	4
27218740	4.760	4.62	70.0	22.0	4
27218800	4.775	4.62	70.0	22.0	4
27218850	4.788	4.62	70.0	22.0	4
27218890	4.798	4.62	70.0	22.0	4
27218900	4.800	4.62	70.0	22.0	4
27218950	4.813	4.62	70.0	22.0	4
27219000	4.826	4.62	70.0	22.0	4
27219050	4.839	4.62	70.0	22.0	4
27219090	4.849	4.62	70.0	22.0	4
27219150	4.864	4.83	76.0	25.0	4
27219200	4.877	4.83	76.0	25.0	4
27219250	4.890	4.83	76.0	25.0	4
27219290	4.900	4.83	76.0	25.0	4
27219350	4.915	4.83	76.0	25.0	4
27219400	4.928	4.83	76.0	25.0	4
27219450	4.940	4.83	76.0	25.0	4

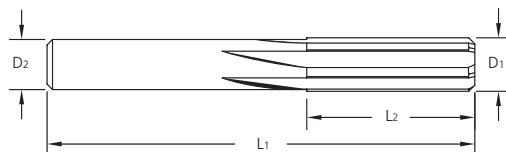
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27219490	4.950	4.83	76.0	25.0	4
27219550	4.966	4.83	76.0	25.0	4
27219600	4.978	4.83	76.0	25.0	4
27219650	4.991	4.83	76.0	25.0	4
27219690	5.001	4.83	76.0	25.0	4
27219750	5.017	4.83	76.0	25.0	4
27219800	5.029	4.83	76.0	25.0	4
27219850	5.042	4.83	76.0	25.0	4
27219880	5.050	4.83	76.0	25.0	4
27219950	5.067	5.03	76.0	25.0	4
27220000	5.080	5.03	76.0	25.0	4
27220050	5.093	5.03	76.0	25.0	4
27220080	5.100	5.03	76.0	25.0	4
27220100	5.105	5.03	76.0	25.0	4
27220150	5.118	5.03	76.0	25.0	4
27220200	5.131	5.03	76.0	25.0	4
27220250	5.144	5.03	76.0	25.0	4
27220280	5.151	5.03	76.0	25.0	4
27220310	5.159	5.03	76.0	25.0	4
27220350	5.169	5.03	76.0	25.0	4
27220400	5.182	5.03	76.0	25.0	4
27220450	5.194	5.03	76.0	25.0	4
27220470	5.199	5.03	76.0	25.0	4
27220500	5.207	5.03	76.0	25.0	4
27220550	5.220	5.03	76.0	25.0	4
27220600	5.232	5.03	76.0	25.0	4
27220650	5.245	5.21	76.0	25.0	4
27220670	5.250	5.21	76.0	25.0	4
27220700	5.258	5.21	76.0	25.0	4
27220750	5.271	5.21	76.0	25.0	4
27220800	5.283	5.21	76.0	25.0	4
27220850	5.296	5.21	76.0	25.0	4
27220870	5.301	5.21	76.0	25.0	4
27220900	5.309	5.21	76.0	25.0	4
27220950	5.321	5.21	76.0	25.0	4
27221000	5.334	5.21	76.0	25.0	4
27221050	5.347	5.21	76.0	25.0	4
27221060	5.349	5.21	76.0	25.0	4
27221100	5.359	5.21	76.0	25.0	4
27221150	5.372	5.21	76.0	25.0	4
27221200	5.385	5.21	76.0	25.0	4
27221250	5.398	5.21	76.0	25.0	4
27221260	5.400	5.21	76.0	25.0	4
27221300	5.410	5.21	76.0	25.0	4
27221350	5.423	5.21	76.0	25.0	4
27221400	5.436	5.21	76.0	25.0	4
27221450	5.448	5.21	76.0	25.0	4



# TrueSize® Straight Flute Carbide Reamers Series 272


**DIN 1420 H7**

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
> 10.00 - 16.00	+ 0.008 / + 0.015



Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27221460	5.451	5.41	76.0	25.0	4
27221500	5.461	5.41	76.0	25.0	4
27221550	5.474	5.41	76.0	25.0	4
27221600	5.486	5.41	76.0	25.0	4
27221651	5.500	5.41	76.0	25.0	4
27221700	5.512	5.41	76.0	25.0	4
27221750	5.525	5.41	76.0	25.0	4
27221800	5.537	5.41	76.0	25.0	4
27221851	5.550	5.41	76.0	25.0	4
27221900	5.563	5.41	76.0	25.0	4
27221950	5.575	5.41	76.0	25.0	4
27222000	5.588	5.41	76.0	25.0	4
27222050	5.601	5.41	76.0	25.0	4
27222100	5.613	5.41	76.0	25.0	4
27222150	5.626	5.41	76.0	25.0	4
27222200	5.639	5.41	76.0	25.0	4
27222240	5.649	5.61	76.0	25.0	4
27222250	5.652	5.61	76.0	25.0	4
27222300	5.664	5.61	76.0	25.0	4
27222350	5.677	5.61	76.0	25.0	4
27222400	5.690	5.61	76.0	25.0	4
27222440	5.700	5.61	76.0	25.0	4
27222500	5.715	5.61	76.0	25.0	4
27222550	5.728	5.61	76.0	25.0	4
27222600	5.740	5.61	76.0	25.0	4
27222640	5.751	5.61	76.0	25.0	4
27222700	5.766	5.61	76.0	25.0	4
27222750	5.779	5.61	76.0	25.0	4
27222800	5.791	5.61	76.0	25.0	4
27222830	5.799	5.61	76.0	25.0	4
27222850	5.804	5.61	76.0	25.0	4
27222900	5.817	5.61	76.0	25.0	4
27222950	5.829	5.61	76.0	25.0	4
27223000	5.842	5.61	76.0	25.0	4
27223030	5.850	5.82	76.0	25.0	4
27223050	5.855	5.82	76.0	25.0	4
27223100	5.867	5.82	76.0	25.0	4
27223150	5.880	5.82	76.0	25.0	4
27223200	5.893	5.82	76.0	25.0	4
27223230	5.900	5.82	76.0	25.0	4
27223250	5.906	5.82	76.0	25.0	4
27223300	5.918	5.82	76.0	25.0	4
27223350	5.931	5.82	76.0	25.0	4
27223400	5.944	5.82	76.0	25.0	4
27223430	5.951	5.82	76.0	25.0	4
27223450	5.956	5.82	76.0	25.0	4
27223500	5.969	5.82	76.0	25.0	4

Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27223550	5.982	5.82	76.0	25.0	4
27223600	5.994	5.82	76.0	25.0	4
27223620	5.999	5.82	76.0	25.0	4
27223650	6.007	5.82	76.0	25.0	4
27223700	6.020	5.82	76.0	25.0	4
27223750	6.033	5.99	76.0	25.0	4
27223800	6.045	5.99	76.0	25.0	4
27223820	6.050	5.99	76.0	25.0	4
27223850	6.058	5.99	76.0	25.0	4
27223900	6.071	5.99	76.0	25.0	4
27223950	6.083	5.99	76.0	25.0	4
27224000	6.096	5.99	76.0	25.0	4
27224020	6.101	5.99	76.0	25.0	4
27224050	6.109	5.99	76.0	25.0	4
27224100	6.121	5.99	76.0	25.0	4
27224150	6.134	5.99	76.0	25.0	4
27224210	6.149	5.99	76.0	25.0	4
27224250	6.160	5.99	76.0	25.0	4
27224300	6.172	5.99	76.0	25.0	4
27224350	6.185	5.99	76.0	25.0	4
27224410	6.200	5.99	76.0	25.0	4
27224450	6.210	5.99	76.0	25.0	4
27224500	6.223	5.99	76.0	25.0	4
27224550	6.236	6.20	76.0	25.0	4
27224610	6.251	6.20	76.0	25.0	4
27224650	6.261	6.20	76.0	25.0	4
27224700	6.274	6.20	76.0	25.0	4
27224750	6.287	6.20	76.0	25.0	4
27224801	6.300	6.20	76.0	25.0	4
27224850	6.312	6.20	76.0	25.0	4
27224900	6.325	6.20	76.0	25.0	4
27224950	6.337	6.20	76.0	25.0	4
27224980	6.345	6.20	76.0	25.0	4
27225001	6.350	6.20	76.0	25.0	4
27225050	6.363	6.20	76.0	25.0	4
27225100	6.375	6.20	76.0	25.0	4
27225150	6.388	6.20	76.0	25.0	4
27225190	6.398	6.20	76.0	25.0	4
27225200	6.401	6.20	76.0	25.0	4
27225250	6.414	6.20	76.0	25.0	4
27225300	6.426	6.20	76.0	25.0	4
27225390	6.449	6.40	83.0	28.0	6
27225500	6.477	6.40	83.0	28.0	6
27225590	6.500	6.40	83.0	28.0	6
27225700	6.528	6.40	83.0	28.0	6
27225800	6.553	6.40	83.0	28.0	6
27225900	6.579	6.40	83.0	28.0	6

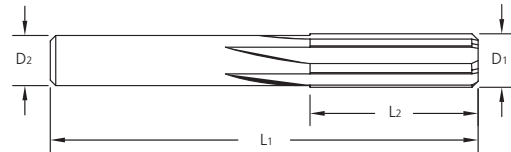


# TrueSize® Straight Flute Carbide Reamers Series 272



DIN 1420 H7

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
> 10.00 - 16.00	+ 0.008 / + 0.015

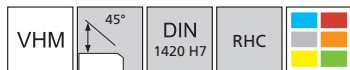


Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27226000	6.604	6.40	83.0	28.0	6
27226100	6.629	6.40	83.0	28.0	6
27226200	6.655	6.40	83.0	28.0	6
27226300	6.680	6.40	83.0	28.0	6
27226400	6.706	6.40	83.0	28.0	6
27226500	6.731	6.40	83.0	28.0	6
27226560	6.746	6.40	83.0	28.0	6
27226600	6.756	6.40	83.0	28.0	6
27226700	6.782	6.40	83.0	28.0	6
27226800	6.807	6.40	83.0	28.0	6
27226900	6.833	6.40	83.0	28.0	6
27227000	6.858	6.40	83.0	28.0	6
27227100	6.883	6.40	83.0	28.0	6
27227200	6.909	6.86	83.0	28.0	6
27227300	6.934	6.86	83.0	28.0	6
27227400	6.960	6.86	83.0	28.0	6
27227500	6.985	6.86	83.0	28.0	6
27227560	7.000	6.86	83.0	28.0	6
27227600	7.010	6.86	83.0	28.0	6
27227700	7.036	6.86	83.0	28.0	6
27227800	7.061	6.86	83.0	28.0	6
27227900	7.087	6.86	83.0	28.0	6
27228000	7.112	6.86	83.0	28.0	6
27228100	7.137	6.86	83.0	28.0	6
27228120	7.142	6.86	83.0	28.0	6
27228200	7.163	6.86	83.0	28.0	6
27228300	7.188	6.86	83.0	28.0	6
27228400	7.214	6.86	83.0	28.0	6
27228500	7.239	6.86	83.0	28.0	6
27228600	7.264	6.86	83.0	28.0	6
27228700	7.290	7.24	83.0	28.0	6
27228800	7.315	7.24	83.0	28.0	6
27228900	7.341	7.24	83.0	28.0	6
27229000	7.366	7.24	83.0	28.0	6
27229100	7.391	7.24	83.0	28.0	6
27229200	7.417	7.24	83.0	28.0	6
27229300	7.442	7.24	83.0	28.0	6
27229400	7.468	7.24	83.0	28.0	6
27229500	7.493	7.24	83.0	28.0	6
27229530	7.501	7.24	83.0	28.0	6
27229600	7.518	7.24	83.0	28.0	6
27229680	7.539	7.24	83.0	28.0	6
27229700	7.544	7.24	83.0	28.0	6
27229800	7.569	7.24	83.0	28.0	6
27229900	7.595	7.24	83.0	28.0	6
27230000	7.620	7.24	83.0	28.0	6
27230100	7.645	7.24	83.0	28.0	6

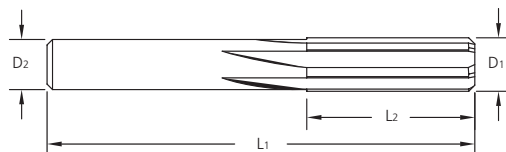
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27230200	7.671	7.24	83.0	28.0	6
27230300	7.696	7.65	83.0	28.0	6
27230400	7.722	7.65	83.0	28.0	6
27230500	7.747	7.65	83.0	28.0	6
27230600	7.772	7.65	83.0	28.0	6
27230700	7.798	7.65	83.0	28.0	6
27230800	7.823	7.65	83.0	28.0	6
27230900	7.849	7.65	83.0	28.0	6
27231000	7.874	7.65	83.0	28.0	6
27231050	7.887	7.65	83.0	28.0	6
27231100	7.899	7.65	83.0	28.0	6
27231150	7.912	7.65	83.0	28.0	6
27231200	7.925	7.65	83.0	28.0	6
27231230	7.932	7.65	83.0	28.0	6
27231250	7.938	7.65	83.0	28.0	6
27231300	7.950	7.65	83.0	28.0	6
27231350	7.963	7.65	83.0	28.0	6
27231400	7.976	7.65	83.0	28.0	6
27231500	8.000	7.65	83.0	28.0	6
27231600	8.026	7.65	83.0	28.0	6
27231700	8.052	7.65	83.0	28.0	6
27231800	8.077	7.65	83.0	28.0	6
27231900	8.103	8.05	89.0	32.0	6
27232000	8.128	8.05	89.0	32.0	6
27232100	8.153	8.05	89.0	32.0	6
27232200	8.179	8.05	89.0	32.0	6
27232300	8.204	8.05	89.0	32.0	6
27232400	8.230	8.05	89.0	32.0	6
27232500	8.255	8.05	89.0	32.0	6
27232600	8.280	8.05	89.0	32.0	6
27232700	8.306	8.05	89.0	32.0	6
27232800	8.331	8.05	89.0	32.0	6
27232900	8.357	8.05	89.0	32.0	6
27233000	8.382	8.05	89.0	32.0	6
27233100	8.407	8.05	89.0	32.0	6
27233200	8.433	8.05	89.0	32.0	6
27233300	8.458	8.05	89.0	32.0	6
27233400	8.484	8.43	89.0	32.0	6
27233460	8.499	8.43	89.0	32.0	6
27233500	8.509	8.43	89.0	32.0	6
27233600	8.534	8.43	89.0	32.0	6
27233700	8.560	8.43	89.0	32.0	6
27233800	8.585	8.43	89.0	32.0	6
27233900	8.611	8.43	89.0	32.0	6
27234000	8.636	8.43	89.0	32.0	6
27234100	8.661	8.43	89.0	32.0	6
27234200	8.687	8.43	89.0	32.0	6



# TrueSize® Straight Flute Carbide Reamers Series 272


**DIN 1420 H7**

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≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
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Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27234300	8.712	8.43	89.0	32.0	6
27234370	8.730	8.43	89.0	32.0	6
27234400	8.738	8.43	89.0	32.0	6
27234500	8.763	8.43	89.0	32.0	6
27234600	8.788	8.43	89.0	32.0	6
27234700	8.814	8.43	89.0	32.0	6
27234800	8.839	8.43	89.0	32.0	6
27234900	8.865	8.43	89.0	32.0	6
27235000	8.890	8.84	89.0	32.0	6
27235100	8.915	8.84	89.0	32.0	6
27235200	8.941	8.84	89.0	32.0	6
27235300	8.966	8.84	89.0	32.0	6
27235400	8.992	8.84	89.0	32.0	6
27235430	8.999	8.84	89.0	32.0	6
27235500	9.017	8.84	89.0	32.0	6
27235600	9.042	8.84	89.0	32.0	6
27235700	9.068	8.84	89.0	32.0	6
27235800	9.093	8.84	89.0	32.0	6
27235900	9.119	8.84	89.0	32.0	6
27235940	9.129	8.84	89.0	32.0	6
27236000	9.144	8.84	89.0	32.0	6
27236100	9.169	8.84	89.0	32.0	6
27236200	9.195	8.84	89.0	32.0	6
27236300	9.220	8.84	89.0	32.0	6
27236400	9.246	8.84	89.0	32.0	6
27236500	9.271	9.22	89.0	32.0	6
27236600	9.296	9.22	89.0	32.0	6
27236700	9.322	9.22	89.0	32.0	6
27236800	9.347	9.22	89.0	32.0	6
27236900	9.373	9.22	89.0	32.0	6
27237000	9.398	9.22	89.0	32.0	6
27237100	9.423	9.22	89.0	32.0	6
27237200	9.449	9.22	89.0	32.0	6
27237300	9.474	9.22	89.0	32.0	6
27237400	9.500	9.22	89.0	32.0	6
27237450	9.512	9.22	89.0	32.0	6
27237480	9.520	9.22	89.0	32.0	6
27237500	9.525	9.22	89.0	32.0	6
27237600	9.550	9.22	89.0	32.0	6
27237700	9.576	9.22	89.0	32.0	6
27237800	9.601	9.22	89.0	32.0	6
27237900	9.627	9.22	89.0	32.0	6
27238000	9.652	9.22	89.0	32.0	6
27238100	9.677	9.22	89.0	32.0	6
27238200	9.703	9.22	89.0	32.0	6
27238300	9.728	9.22	89.0	32.0	6
27238400	9.754	9.22	89.0	32.0	6

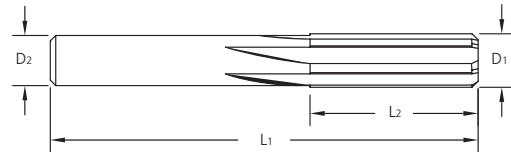
Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27238500	9.779	9.22	89.0	32.0	6
27238600	9.804	9.22	89.0	32.0	6
27238700	9.830	9.65	89.0	32.0	6
27238800	9.855	9.65	89.0	32.0	6
27238900	9.881	9.65	89.0	32.0	6
27239000	9.906	9.65	89.0	32.0	6
27239060	9.921	9.65	89.0	32.0	6
27239100	9.931	9.65	89.0	32.0	6
27239200	9.957	9.65	89.0	32.0	6
27239300	9.982	9.65	89.0	32.0	6
27239370	10.000	9.65	89.0	32.0	6
27239400	10.008	9.65	89.0	32.0	6
27239500	10.033	9.65	89.0	32.0	6
27239600	10.058	9.65	89.0	32.0	6
27239700	10.084	9.65	89.0	32.0	6
27239800	10.109	9.65	89.0	32.0	6
27239900	10.135	9.65	89.0	32.0	6
27240000	10.160	9.65	89.0	32.0	6
27240100	10.185	9.65	89.0	32.0	6
27240200	10.211	9.65	89.0	32.0	6
27240300	10.236	9.65	89.0	32.0	6
27240400	10.262	9.65	89.0	32.0	6
27240500	10.287	9.65	89.0	32.0	6
27240600	10.312	9.65	89.0	32.0	6
27240620	10.317	9.65	89.0	32.0	6
27240700	10.338	9.65	89.0	32.0	6
27240800	10.363	9.65	89.0	32.0	6
27240900	10.389	9.65	89.0	32.0	6
27241000	10.414	9.65	89.0	32.0	6
27241100	10.439	9.65	89.0	32.0	6
27241200	10.465	9.65	89.0	32.0	6
27241300	10.490	9.65	89.0	32.0	6
27241340	10.500	9.65	89.0	32.0	6
27241400	10.516	9.65	89.0	32.0	6
27241500	10.541	9.65	89.0	32.0	6
27241600	10.566	10.41	95.0	35.0	6
27241700	10.592	10.41	95.0	35.0	6
27241800	10.617	10.41	95.0	35.0	6
27241900	10.643	10.41	95.0	35.0	6
27242000	10.668	10.41	95.0	35.0	6
27242100	10.693	10.41	95.0	35.0	6
27242200	10.719	10.41	95.0	35.0	6
27242300	10.744	10.41	95.0	35.0	6
27242400	10.770	10.41	95.0	35.0	6
27242500	10.795	10.41	95.0	35.0	6
27242600	10.820	10.41	95.0	35.0	6
27242700	10.846	10.41	95.0	35.0	6

# TrueSize® Straight Flute Carbide Reamers Series 272



DIN 1420 H7

D <sup>1</sup> (mm)	Tolerance (mm)
≤ 3.00	+ 0.004 / + 0.008
> 3.00 - 6.00	+ 0.005 / + 0.010
> 6.00 - 10.00	+ 0.006 / + 0.012
> 10.00 - 16.00	+ 0.008 / + 0.015



Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27242800	10.871	10.41	95.0	35.0	6
27242900	10.897	10.41	95.0	35.0	6
27243000	10.922	10.41	95.0	35.0	6
27243100	10.947	10.41	95.0	35.0	6
27243200	10.973	10.41	95.0	35.0	6
27243310	11.000	10.41	95.0	35.0	6
27243400	11.024	10.41	95.0	35.0	6
27243500	11.049	10.41	95.0	35.0	6
27243600	11.074	10.41	95.0	35.0	6
27243700	11.100	10.41	95.0	35.0	6
27243740	11.110	10.41	95.0	35.0	6
27243800	11.125	10.41	95.0	35.0	6
27243850	11.138	10.41	95.0	35.0	6
27243900	11.151	10.41	95.0	35.0	6
27244000	11.176	10.41	95.0	35.0	6
27244100	11.201	10.41	95.0	35.0	6
27244200	11.227	10.41	95.0	35.0	6
27244300	11.252	10.41	95.0	35.0	6
27244400	11.278	10.41	95.0	35.0	6
27244500	11.303	10.41	95.0	35.0	6
27244600	11.328	11.18	95.0	35.0	6
27244700	11.354	11.18	95.0	35.0	6
27244800	11.379	11.18	95.0	35.0	6
27244900	11.405	11.18	95.0	35.0	6
27245000	11.430	11.18	95.0	35.0	6
27245100	11.455	11.18	95.0	35.0	6
27245200	11.481	11.18	95.0	35.0	6
27245270	11.499	11.18	95.0	35.0	6
27245310	11.509	11.18	95.0	35.0	6
27245400	11.532	11.18	95.0	35.0	6
27245500	11.557	11.18	95.0	35.0	6
27245600	11.582	11.18	95.0	35.0	6
27245700	11.608	11.18	95.0	35.0	6
27245800	11.633	11.18	95.0	35.0	6
27245900	11.659	11.18	95.0	35.0	6
27246000	11.684	11.18	95.0	35.0	6
27246100	11.709	11.18	95.0	35.0	6
27246200	11.735	11.18	95.0	35.0	6
27246300	11.760	11.18	95.0	35.0	6
27246400	11.786	11.18	95.0	35.0	6
27246500	11.811	11.18	95.0	35.0	6
27246600	11.836	11.18	95.0	35.0	6
27246700	11.862	11.18	95.0	35.0	6
27246800	11.887	11.18	95.0	35.0	6
27246880	11.908	11.18	95.0	35.0	6
27246900	11.913	11.18	95.0	35.0	6
27247000	11.938	11.18	95.0	35.0	6

Tool No.	Tool Dimensions				
	Ø D1	Ø D2	L1	L2	Z
27247100	11.963	11.18	95.0	35.0	6
27247200	11.989	11.18	95.0	35.0	6
27247240	11.999	11.18	95.0	35.0	6
27247300	12.014	11.18	95.0	35.0	6
27247400	12.040	11.18	95.0	35.0	6
27247500	12.065	11.18	95.0	35.0	6
27247600	12.090	11.94	102.0	38.0	6
27247700	12.116	11.94	102.0	38.0	6
27247800	12.141	11.94	102.0	38.0	6
27247900	12.167	11.94	102.0	38.0	6
27248000	12.192	11.94	102.0	38.0	6
27248100	12.217	11.94	102.0	38.0	6
27248200	12.243	11.94	102.0	38.0	6
27248300	12.268	11.94	102.0	38.0	6
27248400	12.294	11.94	102.0	38.0	6
27248440	12.304	11.94	102.0	38.0	6
27248500	12.319	11.94	102.0	38.0	6
27248600	12.344	11.94	102.0	38.0	6
27248700	12.370	11.94	102.0	38.0	6
27248800	12.395	11.94	102.0	38.0	6
27248900	12.421	11.94	102.0	38.0	6
27249000	12.446	11.94	102.0	38.0	6
27249100	12.471	11.94	102.0	38.0	6
27249200	12.497	11.94	102.0	38.0	6
27249300	12.522	11.94	102.0	38.0	6
27249400	12.548	11.94	102.0	38.0	6
27249500	12.573	11.94	102.0	38.0	6
27249600	12.598	11.94	102.0	38.0	6
27249700	12.624	11.94	102.0	38.0	6
27249800	12.649	11.94	102.0	38.0	6
27249900	12.675	11.94	102.0	38.0	6
27249950	12.687	11.94	102.0	38.0	6
27249990	12.697	11.94	102.0	38.0	6
27250000	12.700	11.94	102.0	38.0	6
27250100	12.725	11.94	102.0	38.0	6
27251180	13.000	12.83	102.0	38.0	6
27251560	13.096	12.83	102.0	38.0	6
27253120	13.492	12.83	102.0	38.0	6
27254690	13.891	13.59	102.0	38.0	6
27255120	14.000	13.59	102.0	38.0	6
27256250	14.288	13.59	102.0	38.0	6
27257810	14.684	14.35	102.0	44.0	6
27259050	14.999	14.35	102.0	44.0	6
27259380	15.083	14.35	102.0	44.0	6
27260940	15.479	15.11	102.0	44.0	6
27262500	15.875	15.11	102.0	44.0	6
27262990	15.999	15.11	102.0	44.0	6



## TrueSize® Solid Carbide Reamers Recommended cutting data

Conditions de coupe recommandées | Empfohlene Schnittdaten | Dati di taglio Raccomandati | Zalecane dane o Cięciu (Zalecane parametry skrawania)

Workpiece Material Group		Material Type	Vc (m/min)	Feed Type (Refer To Chart)
Steels	P	Low Carbon	60 - 90	M - H
		Medium Carbon	40 - 60	M
		Alloy Steels	20 - 40	L
		Mould/Tool Steel	20 - 40	L
Stainless Steels	M	Free Machining	45 - 75	M
		Austenitic	45 - 75	M
		Ferritic	25 - 40	M
		Martensitic	25 - 40	M
		PH Stainless	20 - 30	L - M
Special Alloys	S	High Temp Alloys (Ni)	15 - 20	L
		High Temp Alloys (Co)	10 - 15	L
		Titanium Alloys	10 - 15	L - M
Cast Irons	K	Grey Cast Iron	25 - 45	L - M
		Ductile Cast Iron	40 - 60	M
		Malleable Iron	40 - 60	M
Hardened Steels	H	< 25 HRc	60 - 90	M - H
		25 - 32 HRc	40 - 60	M
		32 - 43 HRc	15 - 40	L
		43 - 52 HRc	10 - 15	L
		> 52 HRc	5 - 10	L
Non Ferrous	N	Aluminium Alloys	150 - 300	M - H
		Copper & Hard Bronze	30 - 45	L
		Brass & Soft Bronze	50 - 80	M

$$\text{RPM} = \text{Vc (m/min)} \times 318.0 \div \text{Reamer } \varnothing$$

### Series 272 - Recommended cutting data

Conditions de coupe recommandées | Empfohlene Schnittdaten | Dati di taglio Raccomandati | Zalecane dane o Cięciu (Zalecane parametry skrawania)

Nominal Reamer Diameter $\varnothing D^1$	Feed (mm/rev)		
	L	M	H
0.3mm - 1.6mm	0.01 - 0.03	0.02 - 0.05	0.03 - 0.08
1.6mm - 3.0mm	0.03 - 0.05	0.05 - 0.10	0.08 - 0.15
3.0mm - 6.0mm	0.05 - 0.10	0.10 - 0.15	0.15 - 0.25
6.0mm - 12.0mm	0.10 - 0.15	0.15 - 0.25	0.25 - 0.35
12.0mm - 16.0mm	0.15 - 0.25	0.25 - 0.50	0.35 - 0.75

Feedrate Formula For Metric Reamers - Feed = RPM x mm/rev

### TrueSize® Reamer Tolerances

Résistances des alésoirs | Reibahlen – Toleranzen | Tolleranze degli alesatori | Tolerancja rozwiertaków

Tool Dimensions	Diameter (mm)	Tolerance (mm)
D <sup>1</sup>	0.330 - 16.000	DIN 1420 H7 (See Below)
D <sup>2</sup>	0.330 - 16.000	+ 0.00 / - 0.03
L <sup>1</sup>	0.330 - 16.000	+ /- 1.5
L <sup>2</sup>	0.330 - 16.000	+ /- 1.5