



CHUCKING REAMERS • M42 COBALT STEEL • STRAIGHT SHANK

SERIES 607 • COOLANT-FED



SERIES: 607

- One Coolant Hole Per Flute
- Staggered Coolant Holes for Maximum Strength
- For Thru or Blind Holes

- M42 Cobalt High Speed Steel
- Straight Flute
- R.H. Cut

TOLERANCES

5/16" - 1/2" dia.	17/32" - 5/8" dia.	21/32" - 1" dia.
+ .0002"/-.0000"	+ .0003"/-.0000"	+ .0005"/-.0000"

SIZES
5/16"-1" INCH

DIA. INCH	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
* 5/16	0.3125	6	1-1/2	6	0.2792	607-013
* 11/32	0.3438	6	1-1/2	6	0.2792	607-015
* 3/8	0.3750	6	1-3/4	7	0.3105	607-017
* 13/32	0.4062	6	1-3/4	7	0.3105	607-019
* 7/16	0.4375	6	1-3/4	7	0.3750	607-021
* 15/32	0.4688	6	1-3/4	7	0.3750	607-023
* 1/2	0.5000	6	2	8	0.4355	607-025
* 17/32	0.5312	6	2	8	0.4355	607-027
* 9/16	0.5625	6	2	8	0.4355	607-029
* 19/32	0.5938	6	2	8	0.4355	607-031
* 5/8	0.6250	6	2-1/4	9	0.5620	607-033
* 21/32	0.6562	8	2-1/4	9	0.6520	607-035

* **Outgoing Items**

DIA. (IN.)	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
* 11/16	0.6875	8	2-1/4	9	0.5620	607-037
* 23/32	0.7188	8	2-1/4	9	0.5620	607-039
* 3/4	0.7500	8	2-1/2	9-1/2	0.6245	607-041
* 25/32	0.7812	8	2-1/2	9-1/2	0.6245	607-043
* 13/16	0.8125	8	2-1/2	9-1/2	0.6245	607-045
* 27/32	0.8438	8	2-1/2	9-1/2	0.6245	607-047
* 7/8	0.8750	8	2-5/8	10	0.7495	607-049
* 29/32	0.9062	8	2-5/8	10	0.7495	607-051
* 15/16	0.9375	8	2-5/8	10	0.7495	607-053
* 31/32	0.9688	8	2-5/8	10	0.7495	607-055
* 1	1.0000	8	2-3/4	10-1/2	0.8745	607-057

* **Outgoing Items**

CHUCKING REAMERS • SPECIAL DECIMAL SIZE • M42 COBALT STEEL • STRAIGHT SHANK

SERIES S607 • COOLANT-FED



SERIES: S607

- M42 Cobalt High Speed Steel
- Staggered Coolant Holes for Maximum Strength
- One Coolant Hole Per Flute

- Straight Flute
- For Thru or Blind Holes
- R.H. Cut

TOLERANCES

.2969"-.4999" dia.	.5001"-.6249" dia.	.6251"-.999" dia.
+ .0002"/-.0000"	+ .0003"/-.0000"	+ .0005"/-.0000"

SIZES
0.2969"-0.9999" INCH

DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
* 0.2969-0.3125	6	1-1/2	6	0.2792	S607-*-01
* 0.3126-0.3437	6	1-1/2	6	0.2792	S607-*-02
* 0.3439-0.3749	6	1-3/4	7	0.3105	S607-*-03
* 0.3751-0.4061	6	1-3/4	7	0.3105	S607-*-04
* 0.4063-0.4374	6	1-3/4	7	0.3730	S607-*-05
* 0.4376-0.4687	6	1-3/4	7	0.3750	S607-*-06
* 0.4689-0.4999	6	2	8	0.4355	S607-*-07
* 0.5001-0.5311	6	2	8	0.4355	S607-*-08
* 0.5313-0.5624	6	2	8	0.4355	S607-*-09
* 0.5626-0.5937	6	2	8	0.4355	S607-*-10
* 0.5938-0.6249	6	2-1/4	9	0.5620	S607-*-11
* 0.6251-0.6561	8	2-1/4	9	0.5620	S607-*-12

* **Outgoing Items**

DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
* 0.6563-0.6874	8	2-1/4	9	0.5620	S607-*-13
* 0.6876-0.7187	8	2-1/4	9	0.5620	S607-*-14
* 0.7189-0.7499	8	2-1/2	9-1/2	0.6245	S607-*-15
* 0.7501-0.7811	8	2-1/2	9-1/2	0.6245	S607-*-16
* 0.7813-0.8124	8	2-1/2	9-1/2	0.6245	S607-*-17
* 0.8126-0.8437	8	2-1/2	9-1/2	0.6245	S607-*-18
* 0.8439-0.8749	8	2-5/8	10	0.7495	S607-*-19
* 0.8751-0.9061	8	2-5/8	10	0.7495	S607-*-20
* 0.9062-0.9374	8	2-5/8	10	0.7495	S607-*-21
* 0.9376-0.9687	8	2-5/8	10	0.7495	S607-*-22
* 0.9689-0.9999	8	2-3/4	10-1/2	0.8745	S607-*-23

* **Outgoing Items**

Note : When ordering Series S607 reamers, specify the exact decimal size required in the place where the asterisk is shown.

For example, to order a 0.6820 diameter reamer use S607-6820-13.

Additional Specifications for SERIES 607 & S607 - End Entry Feeds:

0.2969" to 0.6249" , Cupped End Coolant Entry • 0.6251" to 0.7187" , 1/8 NPT Tapped Coolant Entry • 0.7501" to 0.9999" , 1/4 NPT Tapped Coolant Entry



CHUCKING REAMERS • C-2 CARBIDE TIPPED • STRAIGHT SHANK

SERIES 606 • COOLANT-FED



SERIES: 606

SIZES
9/16"-1-1/16"
INCH

- One Coolant Hole Per Flute
- Staggered Coolant Holes for Maximum Strength

- Straight Flute
- R.H. Cut

• TOLERANCES •

9/16" - 5/8" dia.	11/16" - 1" dia.
+ .0003"/- .0000"	+ .0005"/- .0000"

DIA. (IN.)	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER	DIA. (IN.)	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
9/16	0.5625	6	2	8	7/16	606-029	13/16	0.8125	6	2-1/2	9-1/2	5/8	606-045
19/32	0.5938	6	2	8	7/16	606-031	27/32	0.8438	6	2-1/2	9-1/2	5/8	606-047
5/8	0.6250	6	2-1/4	9	9/16	606-033	7/8	0.8750	6	2-5/8	10	3/4	606-049
21/32	0.6562	6	2-1/4	9	9/16	606-035	29/32	0.9062	6	2-5/8	10	3/4	606-051
11/16	0.6875	6	2-1/4	9	9/16	606-037	15/16	0.9375	8	2-5/8	10	3/4	606-053
23/32	0.7188	6	2-1/4	9	9/16	606-039	31/32	0.9688	8	2-5/8	10	3/4	606-055
3/4	0.7500	6	2-1/2	9-1/2	5/8	606-041	1	1.0000	8	2-3/4	10-1/2	7/8	606-057
25/32	0.7812	6	2-1/2	9-1/2	5/8	606-043	1-1/16	1.0625	8	2-3/4	10-1/2	7/8	606-059

COOLANT-FED REAMERS AND T-SLOT CUTTERS

CHUCKING REAMERS • SPECIAL DECIMAL SIZE • C-2 CARBIDE TIPPED • STRAIGHT SHANK

SERIES S606 • COOLANT-FED



SERIES: S606

SIZES
0.5469"-1.0625"
INCH

- One Coolant Hole Per Flute
- Staggered Coolant Holes for Maximum Strength

- Straight Flute
- R.H. Cut

• TOLERANCES •

.5469" - .6562" dia.	.6563" - 1.0625" dia.
+ .0003"/- .0000"	+ .0005"/- .0000"

DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER	DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK DIA. (IN.)	PART NUMBER
0.5469-0.5625	6	2	8	7/16	S606-*-01	0.7813-0.8125	6	2-1/2	9-1/2	5/8	S606-*-09
0.5626-0.5938	6	2	8	7/16	S606-*-02	0.8126-0.8438	6	2-1/2	9-1/2	5/8	S606-*-10
0.5939-0.6250	6	2-1/4	9	9/16	S606-*-03	0.8439-0.8750	6	2-5/8	10	3/4	S606-*-11
0.6251-0.6562	6	2-1/4	9	9/16	S606-*-04	0.8751-0.9062	6	2-5/8	10	3/4	S606-*-12
0.6563-0.6875	6	2-1/4	9	9/16	S606-*-05	0.9063-0.9375	8	2-5/8	10	3/4	S606-*-13
0.6876-0.7188	6	2-1/4	9	9/16	S606-*-06	0.9376-0.9688	8	2-5/8	10	3/4	S606-*-14
0.7189-0.7500	6	2-1/2	9-1/2	5/8	S606-*-07	0.9689-1.0000	8	2-3/4	10-1/2	7/8	S606-*-15
0.7501-0.7812	6	2-1/2	9-1/2	5/8	S606-*-08	1.0001-1.0625	8	2-3/4	10-1/2	7/8	S606-*-16

Note : When ordering Series S606 reamers, specify the exact decimal size required in the place where the asterisk is shown.

For example, to order a 0.5470 diameter reamer use S606-5470-01.

Additional Specifications for SERIES 606 & S606 - End Entry Feeds:

0.5469" to 0.6249" , Cupped End Coolant Entry • 0.6251" to 0.7187" , 1/8 NPT Tapped Coolant Entry • 0.7501" to 1.0625" , 1/4 NPT Tapped Coolant Entry



HEAT EXCHANGER REAMERS • M42 COBALT STEEL • TAPER SHANK

SERIES 608 • COOLANT-FED



SERIES: 608

SIZES

9/16"-1-1/16"
INCH

- Staggered coolant holes for maximum strength
- Dual Coolant Entry : Removable tang end plug or side entry morse taper
- Left hand spiral flutes for ease of chip ejection & excellent finish
- Designed for deep hole applications

- M42 Cobalt High Speed
- 15° Left-Hand Spiral
- R.H.Cut
- Two coolant holes per flute

TOLERANCES

9/16" - 5/8" dia.	21/32" - 1" dia.	1-1/16" dia.
+ .0003"/-.0001"	+ .0005"/-.0000"	+ .0006"/-.0002"

DIA. (IN.)	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK	PART NUMBER	DIA. (IN.)	DECIMAL (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK	PART NUMBER
9/16	0.5625	6	6	14	3MT	608-021	13/16	0.8125	8	6	14	3MT	608-037
19/32	0.5938	6	6	14	3MT	608-023	27/32	0.8438	8	6	14	3MT	608-039
5/8	0.6250	6	6	14	3MT	608-025	7/8	0.8750	8	6	14	3MT	608-041
21/32	0.6562	8	6	14	3MT	608-027	29/32	0.9062	8	6	14	3MT	608-043
11/16	0.6875	8	6	14	3MT	608-029	15/16	0.9375	8	6	14	3MT	608-045
23/32	0.7188	8	6	14	3MT	608-031	31/32	0.9688	8	6	14	3MT	608-047
3/4	0.7500	8	6	14	3MT	608-033	1	1.0000	8	6	14	3MT	608-049
25/32	0.7812	8	6	14	3MT	608-035	1-1/16	1.0625	8	6	14	3MT	608-051

HEAT EXCHANGER REAMERS • SPECIAL DECIMAL SIZE • M42 COBALT STEEL • TAPER SHANK

SERIES S608 • COOLANT-FED



SERIES: S608

SIZES

0.5469"-1.0625"
INCH

- Dual Coolant Entry : Removable tang end plug or side entry morse taper
- Left hand spiral flutes for ease of chip ejection & excellent finish
- Designed for deep hole applications
- Staggered coolant holes for maximum strength

- M42 Cobalt High Speed
- 15° Left-Hand Spiral
- R.H.Cut
- Two coolant holes per flute

TOLERANCES

.5469"-.6562" dia.	.6563"-1.0000 dia.	1.001"-1.0625" dia.
+ .0003"/-.0001"	+ .0005"/-.0000"	+ .0006"/-.0002"

DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK	PART NUMBER	DECIMAL RANGE (IN.)	NO. OF FLUTES	FLUTE (IN.)	OAL (IN.)	SHANK	PART NUMBER
0.5469-0.5625	6	6	14	3MT	S608-*-01	0.7813-0.8125	8	6	14	3MT	S608-*-09
0.5626-0.5938	6	6	14	3MT	S608-*-02	0.8126-0.8438	8	6	14	3MT	S608-*-10
0.5939-0.6250	6	6	14	3MT	S608-*-03	0.8439-0.8750	8	6	14	3MT	S608-*-11
0.6251-0.6562	8	6	14	3MT	S608-*-04	0.8751-0.9062	8	6	14	3MT	S608-*-12
0.6563-0.6875	8	6	14	3MT	S608-*-05	0.9063-0.9375	8	6	14	3MT	S608-*-13
0.6876-0.7188	8	6	14	3MT	S608-*-06	0.9376-0.9688	8	6	14	3MT	S608-*-14
0.7189-0.7500	8	6	14	3MT	S608-*-07	0.9689-1.0000	8	6	14	3MT	S608-*-15
0.7501-0.7812	8	6	14	3MT	S608-*-08	1.0001-1.0625	8	6	14	3MT	S608-*-16

Note : When ordering Series S608 reamers, specify the exact decimal size required in the place where the asterisk is shown. For example, to order a 0.5469 diameter reamer use S608-5469-01.



T-SLOT CUTTERS • SUPER COBALT STEEL

SERIES 810



Patent No. 3,597,817

SERIES: 810

SIZES

3/8"-1-1/2"
INCH

Because of the greater speed and feed capabilities, production rates when cutting T-slots are improved from 2 to 5 times.

The coolant pressure forces chips ahead of the cutter. Since the cutter need not be backed out to remove impact chips, a T-slot can be cut in one pass.

With coolant brought right to the cutting edge, the tool is kept cool at all times, extending its life. This also lubricates the cutting edge to eliminate galling, to minimize recutting chips and to facilitate chip removal.

The final result is a T-slot with a better finish and closer tolerances, produced more quickly with less wear on the tool.

COOLANT-FED
REAMERS AND
T-SLOT CUTTERS

PART NUMBER	OLD PART NUMBER	BOLT SIZE (IN.)	DIAMETER OF CUTTER (IN.)	THICKNESS OF CUTTER (IN.)	DIAMETER OF NECK (IN.)	OVERALL LENGTH (IN.)	SHANK DIA. (IN.)	UNDERCUT LENGTH (IN.)	NO. FLUTES
* 810-001	OTC-3	3/8	25/32	21/64	13/32	3-1/4	3/4	55/64	6
* 810-002	OTC-4	1/2	31/32	25/64	17/32	3-7/16	3/4	63/64	6
* 810-003	OTC-5	5/8	1-1/4	31/64	21/32	3-15/16	1	1-9/64	6
* 810-004	OTC-6	3/4	1-15/32	5/8	25/32	4-7/16	1	1-1/2	8
* 810-005	OTC-7	1	1-27/32	53/64	1-1/32	4-13/16	1-1/4	1-43/64	8
* 810-006	OTC-8	1-1/4	2-7/32	1-3/32	1-7/32	5-3/8	1-1/4	1-31/32	8
* 810-007	OTC-9	1-1/2	2-21/32	1-11/32	1-17/32	5-29/32	1-1/4	2-1/8	10

* **Outgoing Items**

SPECIAL COOLANT-FED CUTTING TOOLS

Our experienced tooling engineers will provide quotes on special tooling per your specifications. Some of the more popular materials and special tools are listed below. Fax your special tooling requests to us at (216) 481-9966 or e-mail them to: sales@coolantfedtooling.com.

MATERIALS

- High Speed
- Cobalt
- Solid Carbide
- Carbide Tipped

SPECIAL TOOLS

- Porting Tools
- Combination Tools
- Step Drills
- Fluted Milling Tools
- Forming Tools
- Dovetail Cutters
- Conventional & Special Shanks

