



Originators and Designers of Specialty Reamers and Cutting Tools Since 1918

## Helical Chucking Reamers with Straight Shank



**Flute**  
High Spiral, Left Hand

**Shank**  
Straight

**Cut**  
Right Hand

**Material**  
High Speed Steel

### Schedule G1

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Designed for general purpose machining, left hand spiral chucking reamers work best on through-hole or limited stock removal applications. The high helix design of our chucking reamers reduces chatter and vibration and provides for easier chip removal. Precision design provides for exceptional quality and accuracy in most materials. Ideal for use in lathes, drill presses, milling machines and machining & turning centers.

Chucking reamers are furnished as Left Hand Spiral, Right Hand Cut. Also available in Right Hand Spiral or Straight Flute. Flute Diameters are held to a tolerance of  $\pm .0002$ " /  $-.0000$ " unless otherwise specified.

Helical Chucking Reamers can also be made as specials in extra length, larger diameters, special helix angles, end cutting, with chip breakers or in premium high-speed steel or carbide.

All surface treatments available upon request. Return to GAMMONS® for resharpener

Part Number	Size Range	Flute Length	Number of Flutes	Shank Size	Overall Length
CRLS0006	.0469 - .0625	0.500	4	0.125	2.5
CRLS0007	.0626 - .0781	0.750	4	0.125	3.0
CRLS0009	.0782 - .0938	0.750	4	0.125	3.0
CRLS0010	.0939 - .1094	0.880	4	0.125	3.5
CRLS0012	.1095 - .1250	0.880	4	0.125	3.5
CRLS0014	.1251 - .1406	1.000	4	0.125	4.5
CRLS0015	.1407 - .1563	1.000	4	0.125	4.0
CRLS0017	.1564 - .1719	1.130	6	0.125	4.5
CRLS0018	.1720 - .1875	1.130	6	0.156	4.5
CRLS0020	.1876 - .2031	1.250	6	0.156	5.0
CRLS0021	.2032 - .2188	1.250	6	0.188	5.0
CRLS0023	.2189 - .2344	1.500	6	0.188	6.0
CRLS0025	.2345 - .2500	1.500	6	0.219	6.0
CRLS0026	.2501 - .2656	1.500	6	0.219	6.0
CRLS0028	.2657 - .2813	1.500	6	0.250	6.0
CRLS0029	.2814 - .2969	1.500	6	0.250	6.0
CRLS0031	.2970 - .3125	1.500	6	0.250	6.0
CRLS0032	.3126 - .3281	1.500	6	0.250	6.0
CRLS0034	.3282 - .3438	1.500	6	0.313	6.0
CRLS0035	.3438 - .3594	1.750	6	0.313	7.0
CRLS0037	.3595 - .3750	1.750	6	0.313	7.0
CRLS0039	.3751 - .3906	1.750	6	0.313	7.0
CRLS0040	.3907 - .4063	1.750	6	0.375	7.0
CRLS0042	.4064 - .4219	1.750	6	0.375	7.0
CRLS0043	.4220 - .4375	1.750	6	0.375	7.0
CRLS0045	.4376 - .4531	1.750	6	0.375	7.0



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Part Number	Size Range	Flute Length	Number of Flutes	Shank Size	Overall Length
CRLS0046	.4532 - .4688	1.750	6	0.438	7.0
CRLS0048	.4689 - .4844	2.000	6	0.438	8.0
CRLS0050	.4845 - .5000	2.000	6	0.438	8.0
CRLS0053	.5001 - .5313	2.000	6	0.438	8.0
CRLS0056	.5314 - .5625	2.000	6	0.500	8.0
CRLS0059	.5626 - .5938	2.000	6	0.500	8.0
CRLS0062	.5939 - .6250	2.250	8	0.563	9.0
CRLS0065	.6251 - .6563	2.250	8	0.563	9.0
CRLS0068	.6564 - .6875	2.250	8	0.625	9.0
CRLS0071	.6876 - .7188	2.250	8	0.625	9.0
CRLS0075	.7189 - .7500	2.500	8	0.688	9.5
CRLS0078	.7501 - .7813	2.500	8	0.688	9.5
CRLS0081	.7814 - .8125	2.500	8	0.750	9.5
CRLS0084	.8126 - .8438	2.500	8	0.750	9.5
CRLS0087	.8439 - .8750	2.630	8	0.750	10.0
CRLS0090	.8751 - .9063	2.630	8	0.750	10.0
CRLS0093	.9064 - .9375	2.630	8	0.875	10.0
CRLS0096	.9376 - .9688	2.630	8	0.875	10.0
CRLS0100	.9689 - 1.0000	2.750	8	0.875	10.5
CRLS0106	1.0001 - 1.0625	2.750	10	0.875	10.5
CRLS0112	1.0626 - 1.1250	2.880	10	1.000	11.0
CRLS0118	1.1251 - 1.1875	2.880	10	1.000	11.0
CRLS0125	1.1876 - 1.2500	3.000	10	1.125	11.5
CRLS0131	1.2501 - 1.3125	3.000	10	1.125	11.5
CRLS0150	1.4376 - 1.5000	3.500	10	1.375	12.5
CRLS0156	1.5001 - 1.5625	3.500	10	1.375	12.5
CRLS0162	1.5626 - 1.6250	3.750	10	1.375	13.0
CRLS0168	1.6251 - 1.6875	3.750	12	1.375	13.0
CRLS0175	1.6876 - 1.7500	4.000	12	1.500	13.5
CRLS0181	1.7501 - 1.8125	4.000	12	1.500	13.5
CRLS0187	1.8126 - 1.8750	4.250	12	1.500	14.0
CRLS0193	1.8751 - 1.9375	4.250	12	1.500	14.0
CRLS0200	1.9376 - 2.0000	4.250	12	1.500	14.0