



Originators and Designers of Specialty Reamers and Cutting Tools Since 1918

Helical Die Maker Reamers with Straight Shank .005



Flute
High Spiral, Left Hand

Shank
Straight

Cut
Right Hand

Material
High Speed Steel

.005" TPI - .060' TPF Schedule D2

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Fast spiral fluted reamers provide the most accurate and best-finished holes. The high helix design allows for the maximum surface contact and easier chip removal thus reducing chatter, vibration and finish scoring. GAMMONS® Die Maker Reamers come in a variety of tapers and sizes and are ideal for a wide range of machining needs. Precision design provides exceptional quality and accuracy. We have a large range of HSS tools in stock.

GAMMONS® Die Maker Reamers can also be made as specials in duplex style, extra length, end cutting, special helix angles, 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 | Small End Diameter | Large End Diameter | Flute Length | Number of Flutes | Shank Size | Overall Length |
|-------------|------|--------------------|--------------------|--------------|------------------|------------|----------------|
| DMHS5AA1 | 5AA1 | 0.045 | 0.051 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA2 | 5AA2 | 0.049 | 0.055 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA3 | 5AA3 | 0.053 | 0.059 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA4 | 5AA4 | 0.057 | 0.063 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA5 | 5AA5 | 0.061 | 0.067 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA6 | 5AA6 | 0.065 | 0.071 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA7 | 5AA7 | 0.069 | 0.075 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS5AA8 | 5AA8 | 0.073 | 0.079 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS05A1 | 5A1 | 0.077 | 0.083 | 1.13 | 2 | 0.125 | 2.13 |
| DMHS05A2 | 5A2 | 0.081 | 0.088 | 1.38 | 2 | 0.125 | 2.50 |
| DMHS05B1 | 5B1 | 0.086 | 0.093 | 1.38 | 2 | 0.125 | 2.50 |
| DMHS05B2 | 5B2 | 0.091 | 0.099 | 1.50 | 2 | 0.125 | 2.63 |
| DMHS05C1 | 5C1 | 0.097 | 0.105 | 1.50 | 2 | 0.125 | 2.63 |
| DMHS05C2 | 5C2 | 0.103 | 0.111 | 1.50 | 2 | 0.125 | 2.75 |
| DMHS05D1 | 5D1 | 0.109 | 0.117 | 1.50 | 2 | 0.125 | 2.75 |
| DMHS05E1 | 5 E1 | 0.115 | 0.123 | 1.63 | 2 | 0.125 | 2.88 |
| DMHS05F1 | 5F1 | 0.121 | 0.130 | 1.75 | 2 | 0.125 | 3.00 |
| DMHS05F2 | 5F2 | 0.127 | 0.136 | 1.75 | 2 | 0.125 | 3.00 |
| DMHS05G1 | 5G1 | 0.133 | 0.142 | 1.88 | 2 | 0.155 | 3.25 |
| DMHS05G2 | 5G2 | 0.140 | 0.149 | 1.88 | 2 | 0.155 | 3.25 |
| DMHS05H1 | 5H1 | 0.147 | 0.156 | 1.88 | 2 | 0.155 | 3.25 |
| DMHS05H2 | 5H2 | 0.154 | 0.163 | 1.88 | 2 | 0.155 | 3.25 |
| DMHS05I1 | 5I1 | 0.161 | 0.170 | 1.88 | 2 | 0.155 | 3.25 |
| DMHS05I2 | 5I2 | 0.168 | 0.177 | 1.88 | 2 | 0.188 | 3.25 |
| DMHS05J1 | 5J1 | 0.175 | 0.184 | 1.88 | 2 | 0.188 | 3.25 |



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| Part Number | Size | Small End Diameter | Large End Diameter | Flute Length | Number of Flutes | Shank Size | Overall Length |
|-------------|------|--------------------|--------------------|--------------|------------------|------------|----------------|
| DMHS05J2 | 5J2 | 0.182 | 0.193 | 2.25 | 2 | 0.188 | 3.63 |
| DMHS05K1 | 5K1 | 0.191 | 0.202 | 2.25 | 2 | 0.188 | 3.63 |
| DMHS05K2 | 5K2 | 0.200 | 0.211 | 2.25 | 2 | 0.219 | 3.63 |
| DMHS05L1 | 5L1 | 0.209 | 0.220 | 2.25 | 2 | 0.219 | 3.63 |
| DMHS05M1 | 5M1 | 0.218 | 0.231 | 2.50 | 2 | 0.219 | 4.13 |
| DMHS05M2 | 5M2 | 0.228 | 0.241 | 2.50 | 2 | 0.250 | 4.13 |
| DMHS05N1 | 5N1 | 0.238 | 0.253 | 3.00 | 2 | 0.250 | 4.75 |
| DMHS05O1 | 5O1 | 0.250 | 0.269 | 3.75 | 2 | 0.250 | 5.50 |
| DMHS05O2 | 5O2 | 0.266 | 0.285 | 3.75 | 2 | 0.281 | 5.50 |
| DMHS05PA | 5P1 | 0.282 | 0.302 | 4.00 | 2 | 0.313 | 5.75 |
| DMHS05P2 | 5P2 | 0.298 | 0.321 | 4.50 | 2 | 0.313 | 6.25 |
| DMHS05Q1 | 5Q1 | 0.317 | 0.340 | 4.50 | 2 | 0.344 | 6.25 |
| DMHS05R1 | 5R1 | 0.336 | 0.360 | 4.75 | 2 | 0.344 | 6.56 |
| DMHS05R2 | 5R2 | 0.356 | 0.380 | 4.75 | 2 | 0.375 | 6.56 |
| DMHS05S1 | 5S1 | 0.376 | 0.401 | 5.00 | 2 | 0.375 | 6.75 |
| DMHS05S2 | 5S2 | 0.397 | 0.423 | 5.25 | 2 | 0.375 | 7.00 |
| DMHS05T1 | 5T2 | 0.419 | 0.445 | 5.25 | 2 | 0.438 | 7.00 |
| DMHS05U1 | 5U1 | 0.440 | 0.469 | 5.75 | 2 | 0.438 | 7.63 |
| DMHS05U2 | 5U2 | 0.464 | 0.493 | 5.75 | 2 | 0.500 | 7.63 |
| DMHS05V1 | 5V1 | 0.488 | 0.519 | 6.25 | 4 | 0.500 | 8.38 |
| DMHS05W1 | 5W1 | 0.514 | 0.548 | 6.75 | 4 | 0.500 | 8.75 |
| DMHS05W2 | 5W2 | 0.543 | 0.577 | 6.75 | 4 | 0.563 | 8.75 |
| DMHS05X1 | 5X1 | 0.572 | 0.608 | 7.25 | 4 | 0.563 | 9.50 |
| DMHS05X2 | 5X2 | 0.603 | 0.639 | 7.25 | 4 | 0.625 | 9.50 |
| DMHS05Y1 | 5Y1 | 0.634 | 0.672 | 7.75 | 4 | 0.625 | 10.00 |
| DMHS05Y2 | 5Y2 | 0.667 | 0.708 | 8.25 | 4 | 0.688 | 10.50 |