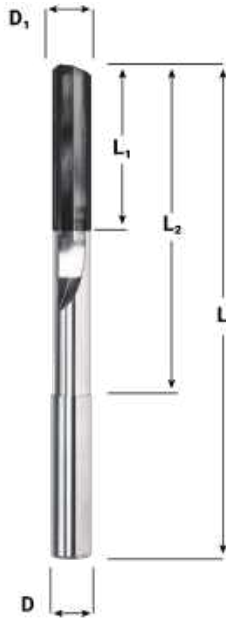


# ULTIMATE PERFORMANCE

Self-Locating Carbide Reamers For Ferrous Materials



FEATURES/DESCRIPTION	APPLICATION	FEATURES
<p><b>PACREAMER</b></p> <p><b>Self-Centering Reamer</b></p> <ul style="list-style-type: none"> <li>Precise - Accurate - Concentric</li> <li>Micrograin carbide substrate for wear resistance</li> <li>Burnishing pad for mirror-like finishes</li> <li>Proprietary geometry ensures perfect straightness</li> <li>Available in stocked sizes for press and slip fit applications</li> <li>&gt;0.6240 has reduced shank</li> </ul>		<ul style="list-style-type: none"> <li>CARBIDE</li> <li>1FL</li> <li>0°</li> <li>h6</li> <li>P370</li> <li>AlTiN</li> </ul>

STEEL			STAINLESS		CAST IRON		NON-FERROUS		HSSA		HARDENED STEEL	
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2
●	●	○	○	○	●	●					○	

● Best ○ Good

**Series 4050 PAC | 1FL | Solid Carbide | Inch & Metric | Reamer**

Diameter(D <sub>1</sub> )		Flute Length(L <sub>1</sub> )	LBS(L <sub>2</sub> )	OAL(L)	Shank(D)	PAC Drill Size	EDP
mm	in						
3.1496	0.1240	1	2	3	1/8	2.5mm	427113
3.1623	0.1245	1	2	3	1/8	2.5mm	427115
3.1750	0.1250	1	2	3	1/8	2.5mm	427118
3.1877	0.1255	1	2	3	1/8	2.5mm	427122
3.2004	0.1260	1	2	3	1/8	2.5mm	427123
4.7371	0.1865	1-1/2	3	4	3/16	4.0mm	427126
4.7498	0.1870	1-1/2	3	4	3/16	4.0mm	427127
4.7625	0.1875	1-1/2	3	4	3/16	4.0mm	427130
4.7752	0.1880	1-1/2	3	4	3/16	4.0mm	427131
4.7879	0.1885	1-1/2	3	4	3/16	4.0mm	427134
5.9750	0.2352	38mm	-	101mm	6mm	5.5mm	427136
5.9870	0.2357	38mm	-	101mm	6mm	5.5mm	427137
6.0000	0.2362	38mm	-	101mm	6mm	5.5mm	427141
6.0130	0.2367	38mm	-	101mm	6mm	5.5mm	427142
6.0250	0.2372	38mm	-	101mm	6mm	5.5mm	427145
6.3246	0.2490	1-1/2	3	4	1/4	6.0mm	427147
6.3373	0.2495	1-1/2	3	4	1/4	6.0mm	427151
6.3500	0.2500	1-1/2	3	4	1/4	6.0mm	427154
6.3627	0.2505	1-1/2	3	4	1/4	6.0mm	427157
6.3754	0.2510	1-1/2	3	4	1/4	6.0mm	427161
7.9121	0.3115	1-1/2	3	4	5/16	7.5mm	427163
7.9121	0.3115	2	4	6	5/16	7.5mm	427164
7.9248	0.3120	1-1/2	3	4	5/16	7.5mm	427168
7.9248	0.3120	2	4	6	5/16	7.5mm	427170
7.9375	0.3125	1-1/2	3	4	5/16	7.5mm	427173
7.9375	0.3125	2	4	6	5/16	7.5mm	427177
7.9502	0.3130	1-1/2	3	4	5/16	7.5mm	427178
7.9502	0.3130	2	4	6	5/16	7.5mm	427179
7.9629	0.3135	1-1/2	3	4	5/16	7.5mm	427181
7.9629	0.3135	2	4	6	5/16	7.5mm	427182
7.9750	0.3140	38mm	-	101mm	8mm	7.5mm	427185
7.9750	0.3140	50mm	-	152mm	8mm	7.5mm	427188
7.9870	0.3144	38mm	-	101mm	8mm	7.5mm	427192
7.9870	0.3144	50mm	-	152mm	8mm	7.5mm	427196
8.0000	0.3150	38mm	-	101mm	8mm	7.5mm	427198
8.0000	0.3150	50mm	-	152mm	8mm	7.5mm	427199
8.0130	0.3155	38mm	-	101mm	8mm	7.5mm	427202
8.0130	0.3155	50mm	-	152mm	8mm	7.5mm	427204
8.0250	0.3159	38mm	-	101mm	8mm	7.5mm	427206
8.0250	0.3159	50mm	-	152mm	8mm	7.5mm	427207
9.4996	0.3740	1-1/2	3	4	3/8	9.0mm	427210
9.4996	0.3740	2	4	6	3/8	9.0mm	427214
9.5123	0.3745	1-1/2	3	4	3/8	9.0mm	427215
9.5123	0.3745	2	4	6	3/8	9.0mm	427219
9.5250	0.3750	1-1/2	3	4	3/8	9.0mm	427222

\*bold numbers are EDPs for ordering

INTRO

MILLING

SPECIALTY

HOLEMAKING

THREADING

INSERTS

# ULTIMATE PERFORMANCE

Self-Locating Carbide Reamers For Ferrous Materials



Series 4050 PAC | 1FL | Solid Carbide | Inch & Metric | Reamer

Diameter(D <sub>1</sub> )		Flute Length(L <sub>1</sub> )	LBS(L <sub>2</sub> )	OAL(L)	Shank(D)	PAC Drill Size	EDP
mm	in						
9.5250	0.3750	2	4	6	3/8	9.0mm	<b>427225</b>
9.5377	0.3755	1-1/2	3	4	3/8	9.0mm	<b>427226</b>
9.5377	0.3755	2	4	6	3/8	9.0mm	<b>427229</b>
9.5504	0.3760	1-1/2	3	4	3/8	9.0mm	<b>427231</b>
9.5504	0.3760	2	4	6	3/8	9.0mm	<b>427233</b>
9.9750	0.3927	50mm	-	152mm	10mm	9.5mm	<b>427235</b>
9.9870	0.3932	50mm	-	152mm	10mm	9.5mm	<b>427238</b>
10mm	0.3937	50mm	-	152mm	10mm	9.5mm	<b>427239</b>
10.0130	0.3942	50mm	-	152mm	10mm	9.5mm	<b>427242</b>
10.0250	0.3947	50mm	-	152mm	10mm	9.5mm	<b>427243</b>
11.0871	0.4365	2	4	6	7/16	10.5mm	<b>427247</b>
11.0998	0.4370	2	4	6	7/16	10.5mm	<b>427250</b>
11.1125	0.4375	2	4	6	7/16	10.5mm	<b>427252</b>
11.1252	0.4380	2	4	6	7/16	10.5mm	<b>427255</b>
11.1379	0.4385	2	4	6	7/16	10.5mm	<b>427256</b>
11.9750	0.4715	50mm	-	152mm	12mm	11.5mm	<b>427257</b>
11.9870	0.4719	50mm	-	152mm	12mm	11.5mm	<b>427258</b>
12.0000	0.4724	50mm	-	152mm	12mm	11.5mm	<b>427262</b>
12.0130	0.4730	50mm	-	152mm	12mm	11.5mm	<b>427266</b>
12.0250	0.4734	50mm	-	152mm	12mm	11.5mm	<b>427269</b>
12.6746	0.4990	2	4	6	1/2	12mm	<b>427271</b>
12.6873	0.4995	2	4	6	1/2	12mm	<b>427273</b>
12.7000	0.5000	2	4	6	1/2	12mm	<b>427275</b>
12.7127	0.5005	2	4	6	1/2	12mm	<b>427277</b>
12.7254	0.5010	2	4	6	1/2	12mm	<b>427279</b>
13.9750	0.5502	50mm	-	152mm	14mm	13.5mm	<b>427281</b>
13.9870	0.5507	50mm	-	152mm	14mm	13.5mm	<b>427285</b>
14.0000	0.5512	50mm	-	152mm	14mm	13.5mm	<b>427289</b>
14.0130	0.5517	50mm	-	152mm	14mm	13.5mm	<b>427293</b>
14.0250	0.5522	50mm	-	152mm	14mm	13.5mm	<b>427297</b>
15.8496	0.6240	2	4	6	9/16	15mm	<b>427300</b>
15.8623	0.6245	2	4	6	9/16	15mm	<b>427302</b>
15.8750	0.6250	2	4	6	9/16	15mm	<b>427305</b>
15.8877	0.6255	2	4	6	9/16	15mm	<b>427308</b>
15.9004	0.6260	2	4	6	9/16	15mm	<b>427312</b>
15.9750	0.6289	50mm	-	152mm	14mm	15.5mm	<b>427316</b>
15.9870	0.6294	50mm	-	152mm	14mm	15.5mm	<b>427320</b>
16.0000	0.6299	50mm	-	152mm	14mm	15.5mm	<b>427324</b>
16.0130	0.6304	50mm	-	152mm	14mm	15.5mm	<b>427325</b>
16.0250	0.6309	50mm	-	152mm	14mm	15.5mm	<b>427329</b>
19.0246	0.7490	2	4	6	5/8	18.5mm	<b>427333</b>
19.0373	0.7495	2	4	6	5/8	18.5mm	<b>427337</b>
19.0500	0.7500	2	4	6	5/8	18.5mm	<b>427339</b>
19.0627	0.7505	2	4	6	5/8	18.5mm	<b>427341</b>
19.0754	0.7510	2	4	6	5/8	18.5mm	<b>427344</b>

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**Series 4050**

**PAC Reamers | 1 FL | Inch & Metric | Solid**

Work Material	P						M				K				N	
	Carbon Steel		Alloy Steel		Tool Steel		300 & 400 SS		PH SS		Gray		Ductile		> 10% Si	
SFM	220 - 350		210 - 315		205 - 295		130 - 200		120 - 190		300 - 455		170 - 300		330 - 385	
Drill Dia.	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR
	mm	inch														
1/8	7334	0.0013	6723	0.0013	6418	0.0013	4890	0.0013	4584	0.0013	8404	0.0013	7182	0.0013	10085	0.0013
4	5822	0.0016	5337	0.0016	5094	0.0016	3881	0.0016	3639	0.0016	6671	0.0016	5700	0.0016	8005	0.0016
3/16	4890	0.0019	4482	0.0019	4278	0.0019	3260	0.0019	3056	0.0019	5603	0.0019	4788	0.0019	6723	0.0019
6	3881	0.0024	3558	0.0024	3396	0.0024	2587	0.0024	2426	0.0024	4447	0.0024	3800	0.0024	5337	0.0024
1/4	3667	0.0025	3362	0.0025	3209	0.0025	2445	0.0025	2292	0.0025	4202	0.0025	3591	0.0025	5042	0.0025
8	2911	0.0031	2668	0.0031	2547	0.0031	1941	0.0031	1819	0.0031	3335	0.0031	2850	0.0031	4002	0.0031
3/8	2445	0.0038	2241	0.0038	2139	0.0038	1630	0.0038	1528	0.0038	2801	0.0038	2394	0.0038	3362	0.0038
10	2329	0.0039	2135	0.0039	2038	0.0039	1552	0.0039	1455	0.0039	2668	0.0039	2280	0.0039	3202	0.0039
7/16	2096	0.0044	1921	0.0044	1834	0.0044	1397	0.0044	1310	0.0044	2401	0.0044	2052	0.0044	2881	0.0044
12	1941	0.0047	1779	0.0047	1698	0.0047	1294	0.0047	1213	0.0047	2224	0.0047	1900	0.0047	2668	0.0047
1/2	1834	0.0050	1681	0.0050	1604	0.0050	1222	0.0050	1146	0.0050	2101	0.0050	1795	0.0050	2521	0.0050
14	1663	0.0055	1525	0.0055	1455	0.0055	1109	0.0055	1040	0.0055	1906	0.0055	1629	0.0055	2287	0.0055
5/8	1467	0.0063	1345	0.0063	1284	0.0063	978	0.0063	917	0.0063	1681	0.0063	1436	0.0063	2017	0.0063