

Hole Expansion Tools & Sets

Black & Gold

BRIDGE REAMERS & STEP REAMERS & **VORTEX-POINT™/REAMER**

Type 54-AG -Straight Flute Type 55-AG -Spiral Flute

Bridge Reamers - Straight & Spiral Flutes - Taper Shank High-Speed Steel, Surface Treated

- These special Hi-Tungsten tool steel reamers with gold surface treated body and clearance are designed to be used with Taper shank equipment.
- They are available in both straight and spiral flute configuration and are designed for heavy-duty reaming as encountered in the fabrication of structural steel assemblies, bridge erection, and ship construction.



TYPE 54-AG STRAIGHT FLUTE					
Part #	Diameter Inches	Flute Length	Overall Length	Taper Shank	Qty. per/pack
81630	7/16"	4-3/8	8-1/4	#2	1
81640	1/2"	5-1/8	9	#2	1
81650	9/16"	5-1/8	9	#2	1
81660	5/8"	6-1/8	10	#2	1
81670	11/16"	7-1/8	11-3/4	#3	1
81680	3/4"	7-3/8	12	#3	1
81690	13/16"	7-3/8	12	#3	1
81700	7/8"	7-3/8	12	#3	1
81710	15/16"	7-3/8	12	#3	1
81720	1"	7-3/8	12	#3	1
81730	1-1/16"	7-3/8	12	#3	1
81740	1-1/8"	7-3/8	12	#3	1
81750	1-3/16"	7-3/8	12	#3	1
81760	1-1/4"	7-3/8	13	#4	1
81770	1-5/16"	7-3/8	13	#4	1

TYPE 55-AG SPIRAL FLUTE					
Part #	Diameter Inches	Flute Length	Overall Length	Taper Shank	Qty. per/pack
83310	7/16"	4-3/8	8-1/4	#2	1
83320	1/2"	5-1/8	9	#2	1
83330	9/16"	5-1/8	9	#2	1
83340	5/8"	6-1/8	10	#2	1
83350	11/16"	7-1/8	11-3/4	#3	1
83360	3/4"	7-3/8	12	#3	1
83370	13/16"	7-3/8	12	#3	1
83380	7/8"	7-3/8	12	#3	1
83390	15/16"	7-3/8	12	#3	1
83400	1"	7-3/8	12	#3	1
83410	1-1/16"	7-3/8	12	#3	1
83420	1-1/8"	7-3/8	12	#3	1
83430	1-3/16"	7-3/8	12	#3	1
83440	1-1/4"	7-3/8	13	#4	1
83450	1-5/16"	7-3/8	13	#4	1

Type 51-AGM

Car Reamers - Fast Spiral Hole Buster™ Super Premium Mechanics Length 3-Flats on Shank



- For use in enlarging previously formed or drilled holes.
- These reamers are especially designed for the reaming of structural steel plates commonly found in truck frames, rail cars, bridges, and pressure vessels.



Part #	Diameter Inches	OAL Inches	Point Diameter	Min. Starting Hole Size	Qty. per/pack
82100	3/8"	4.160	.183	3/16"	1
82120	1/2"	4.625	.245	1/4"	1
82140	5/8"	5.200	.310	5/16"	1
82170	3/4"	5.750	.370	3/8"	1

Type VT&R-8P

VORTEX-POINT™ & Car Reamers Mechanics Length

- **VORTEX-POINT™** Split-point design gives accurate starting and its self-centering eliminating the need for the use of a center punch.
- **VORTEX-POINT™** Unique tip geometry reduces heat generation & cutting tool wear increasing tool life.
- **Type 51-AGM** Mechanics Length reamers are especially designed for the reaming of structural steel plates commonly found in truck frames, rail cars, bridges, and pressure vessels.



SET

8 Pc. Ultra Dex

Part #	3/16", 1/4", 5/16", 3/8" + 3/8", 1/2", 5/8", 3/4"	Qty of ea.
82340	VORTEX-POINT™ + Fast Spiral Car Reamer Type 175-VT & 51-UBM	1

Type 78-GR -Gold Oxide

Type 78-ZR -White Gold & SETS HSS Step Reamers, 3-Flats on Shank



- Accurately starts, enlarge and deburrs in holes in material up to 1/2" thick.
- 90° notch point starts holes easily.
- Each reamer has five hole enlargement steps.

Gold Oxide - low temperature stress relief that enhances lubricity, reduces friction and increases toughness.

Zirconium Nitride - cutting machining aluminum magnesium, titanium alloys. Increased lubricity.



TYPE 78-GR GOLD OXIDE & TYPE 78-ZR WHITE GOLD

78-GR Gold Oxide Part #	78-ZR Zirconium Nitride Part #	Hole Sizes	Range	Shank Sizes	Step Thickness
83710	99940	5	5/16" - 9/16"	3/8"	1/2"
83720	99950	5	9/16" - 13/16"	3/8"	1/2"
83730	99960	5	13/16" - 1-1/16"	3/8"	1/2"

SETS

78-GR Part #	78-ZR Part #	Hole Sizes	Range	Shank Sizes	Step Thickness
83750	99980	3pc. 5	5/16" - 1-1/16"	3/8"	1/2"
83760	99990	2pc. 5	5/16" - 13/16"	3/8"	1/2"



#83750



#99980

Proudly Manufactured in the U.S.A

• America's Finest High Speed Steel Cutting Tools™ • Call Toll Free

1.800.328.4655

Specialty Tools - Morse Taper Reamers & Step Reamers