



Drill-Reamers

Severance Drill-Reamers are designed to drill and ream in one pass. The maximum length of holes recommended for standard drill-reamers is twice their respective diameters. Drill-Reamers of special design can be made for holes of greater length. For best results, drilling should be completed before starting to ream.

Severance Drill-Reamers are well suited for use with jigs and require only one size jig bushing.

High Speed Steel

Drill Reamer Size	Suggested Ream Length	Overall Length	Approx. Drill Length	Drill Dia. -.001 +.000	Severance Tool Name	EDP Order Number
3/16"	0.560	3-1/2"	0.20	.182	DR-3/16	26480
1/4"	0.750	4"	0.30	.242	DR-1/4	26503
5/16"	0.940	4-1/2"	0.40	.302	DR-5/16	26519
3/8"	1.130	5"	0.40	.368	DR-3/8	26534
1/2"	1.500	6"	0.60	.492	DR-1/2	26548



Ball Seat Reamers

Six-Flute Chatterless™ Design

Sizes – Tolerances – Radius size (1/2 tool diameter) is held to a plus or minus .0005". Variations from this tolerance, and other sizes at a nominal extra charge.

Uses – Severance Chatterless™ Ball Seat and Cavity Reamers are being used with outstanding success on steering gear, ball pin sockets, fuel injector plungers, valve push rod caps, gear shift lever seats, molds, etc.

High Speed Steel

Cutting Dia.	Ball Seat Radius	Overall Length	Shank Dia.	Shank Length	Severance Tool Name	EDP Order Number
1/4"	.1247/.1253	1-7/16"	3/16"	3/4"	BS-1/4	26030
3/8"	.1872/.1877	1-11/16"	1/4"	7/8"	BS-3/8	26031
1/2"	.2497/.2503	1-15/16"	3/8"	1-1/8"	BS-1/2	26032
5/8"	.3122/.3127	2-3/16"	3/8"	1-1/8"	BS-5/8	26033
3/4"	.3747/.3753	2-1/2"	1/2"	1-5/16"	BS-3/4	26034
7/8"	.4372/.4377	2-5/8"	1/2"	1-5/16"	BS-7/8	26035
1"	.4997/.5003	2-5/8"	1/2"	1-5/16"	BS-1	26036
1-1/4"	.6247/.6253	3"	3/4"	1-5/8"	BS-1-1/4	26037
1-1/2"	.7497/.7503	3-1/4"	3/4"	1-5/8"	BS-1-1/2	26038

Special Ball Seat Reamer

Special ball seat reamer for use on valve seats for a automotive valve lifter application.



REF. # 55350