

LEXINGTON

CUTTER, INC.

PRECISION CHUCKING REAMERS with h6 SHANK TOLERANCE

- ❖ Specifically Designed for Today's High Performance Applications
- ❖ Inherently Accurate for Use in Precision Holders such as Shrink Fit, Hydraulic Chucks, and Superior Performance in Precision Collet Chucks
- ❖ .0002" TIR on Shank & Cutting Diameters Checked Between Centers
- ❖ Precision Design Allows Higher Speeds & Feeds and Increases Tool Life
- ❖ Overall Length Engineered for Maximum Rigidity and Repeatability
- ❖ Available in Metric and Fractional Sizes
- ❖ 24 Hours to 1 Week Delivery



CARBIDE TIPPED h6 SHANK REAMER - CENTER FED COOLANT

TYPE 3414h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR NON-FERROUS
TYPE 3424h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR CAST IRON
TYPE 3434h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.
 Material specific geometry and carbide grade for the ultimate in performance and tool life.

Full length center coolant fed hole rapidly flushes chips along the flute and out of the hole preventing recutting of chips and providing superior finishes. Precision ground axially aligned diameters for accuracy.



Tool diameter tolerance: +.0002"/-.0000"
 Shank diameter tolerance thru .3750": +.0000"/-.0003"
 over .3750": +.0000"/-.0004"

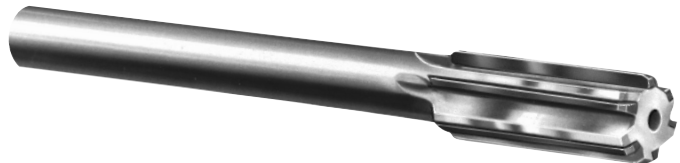
DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	OVERALL LENGTH	NON-FERR. TYPE 3414h6 EDP NO.	CAST IRON TYPE 3424h6 EDP NO.	STEEL TYPE 3434h6 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3471 - .3780	.3125	4	1 3/4	5	341412h6	342412h6	343412h6	\$253.25	\$225.95	\$216.85	\$212.45	\$207.75	\$204.10
.3781 - .4090	.3125	4	1 3/4	5	341413h6	342413h6	343413h6	253.80	226.65	217.55	213.15	208.55	204.75
.4091 - .4410	.3750	6	1 3/4	5	341414h6	342414h6	343414h6	255.90	228.60	219.45	215.20	210.40	206.85
.4411 - .4720	.3750	6	1 3/4	5	341415h6	342415h6	343415h6	257.65	230.35	221.25	216.95	212.15	208.60
.4721 - .5030	.4375	6	2	6	341416h6	342416h6	343416h6	260.00	232.75	223.65	219.30	214.60	210.90
.5031 - .5340	.4375	6	2	6	341417h6	342417h6	343417h6	264.55	237.25	228.20	223.85	219.15	215.45
.5341 - .5660	.4375	6	2	6	341418h6	342418h6	343418h6	267.60	240.30	231.20	226.85	222.20	218.45
.5661 - .5970	.4375	6	2	6	341419h6	342419h6	343419h6	272.00	244.70	235.55	231.35	226.65	222.95
.5971 - .6280	.5625	6	2 1/4	6	341420h6	342420h6	343420h6	276.15	248.85	239.75	235.40	230.70	227.10
.6281 - .6590	.5625	6	2 1/4	6	341421h6	342421h6	343421h6	299.90	272.60	263.40	259.20	254.45	250.80
.6591 - .6910	.5625	6	2 1/4	6	341422h6	342422h6	343422h6	304.85	277.60	268.45	264.20	259.40	255.80
.6911 - .7220	.5625	6	2 1/4	6	341423h6	342423h6	343423h6	315.65	288.40	279.30	274.95	270.25	266.55
.7221 - .7530	.6250	6	2 1/2	6	341424h6	342424h6	343424h6	315.65	288.40	279.30	274.95	270.25	266.55

METRIC CARBIDE TIPPED h6 SHANK REAMER - CENTER FED COOLANT

TYPE 3414h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR NON-FERROUS
TYPE 3424h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR CAST IRON
TYPE 3434h6 - STRAIGHT SHANK & FLUTES - BLIND HOLES - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes.
 Material specific geometry and carbide grade for the ultimate in performance and tool life.

Full length center coolant fed hole rapidly flushes chips along the flute and out of the hole preventing recutting of chips and providing superior finishes. Precision ground axially aligned diameters for accuracy.



Tool diameter tolerance: +.0051mm/-.0000mm.
 Shank diameter tolerance thru 10mm: +.0000mm/-.0076mm.
 over 10mm: +.0000mm/-.0102mm.

METRIC SIZE RANGE (mm)	SHANK DIAMETER (mm)	NO. OF FLUTES	FLUTE LENGTH (mm)	OVERALL LENGTH (mm)	NON-FERR. TYPE 3414h6 EDP NO.	CAST IRON TYPE 3424h6 EDP NO.	STEEL TYPE 3434h6 EDP NO.	PRICE EACH - FINISHED TO METRIC SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
8.815 - 9.601	8	4	45	127	3414095h6	3424095h6	3434095h6	\$257.80	\$230.60	\$221.50	\$217.00	\$212.45	\$208.65
9.602 - 10.389	8	4	45	127	3414100h6	3424100h6	3434100h6	258.35	231.35	222.20	217.70	213.15	209.30
10.390 - 11.201	10	6	45	127	3414110h6	3424110h6	3434110h6	260.40	233.30	224.20	219.75	215.20	211.40
11.202 - 12.000	10	6	45	127	3414120h6	3424120h6	3434120h6	262.20	235.05	225.95	221.50	216.95	213.15
12.001 - 12.875	10	6	51	153	3414125h6	3424125h6	3434125h6	264.55	237.50	228.25	223.85	219.30	215.45
12.876 - 13.565	12	6	51	153	3414135h6	3424135h6	3434135h6	269.15	242.05	232.80	228.40	223.85	220.00
13.566 - 14.376	12	6	51	153	3414140h6	3424140h6	3434140h6	272.15	244.95	235.90	231.40	226.85	223.00
14.377 - 15.164	12	6	51	153	3414150h6	3424150h6	3434150h6	276.55	249.40	240.30	235.90	231.35	227.50
15.165 - 16.100	14	6	57	153	3414160h6	3424160h6	3434160h6	280.70	253.60	244.35	239.95	235.40	231.65
16.101 - 16.740	14	6	57	153	3414165h6	3424165h6	3434165h6	309.40	282.30	273.20	268.75	264.20	260.35
16.741 - 17.551	14	6	57	153	3414175h6	3424175h6	3434175h6	309.40	282.30	273.20	268.75	264.20	260.35
17.552 - 18.340	14	6	57	153	3414180h6	3424180h6	3434180h6	320.20	293.15	283.90	279.50	274.95	271.10
18.341 - 19.250	16	6	64	153	3414190h6	3424190h6	3434190h6	320.20	293.15	283.90	279.50	274.95	271.10

LEXINGTON CUTTER, INC. • sales@lexingtoncutter.com • Phone 800-882-2627 • Fax 800-882-3637

CARBIDE TIPPED h6 SHANK REAMER - FLUTE FED COOLANT

TYPE 3416h6- STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR NON-FERROUS

TYPE 3426h6 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR CAST IRON

TYPE 3435h6 - STRAIGHT SHANK & FLUTES - THROUGH HOLES - FOR STEEL

Flute long carbide tips brazed to one piece hardened alloy steel bodies. Straight polished flutes. Material specific geometry and carbide grade for the ultimate in performance and tool life.

Coolant fed hole in each flute rapidly flushes chips forward ahead of the reamer to help break chips and provide superior finishes. Precision ground axially aligned diameters for accuracy.



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Shank diameter tolerance thru .3750": +.0000"/-.0003"
over .3750": +.0000"/-.0004"

DECIMAL SIZE RANGE	SHANK DIAMETER	NO. OF FLUTES	FLUTE LENGTH	OVERALL LENGTH	NON-FERR. TYPE 3416h6 EDP NO.	CAST IRON TYPE 3426h6 EDP NO.	STEEL TYPE 3435h6 EDP NO.	PRICE EACH - FINISHED TO DECIMAL SIZE					
								1 PC.	2 PC.	3 PC.	4 PC.	5-7	8-14*
.3471 - .3780	.3125	4	1 3/4	5	341612h6	342612h6	343512h6	\$255.00	\$227.70	\$218.60	\$214.25	\$209.65	\$205.85
.3781 - .4090	.3125	4	1 3/4	5	341613h6	342613h6	343513h6	260.00	232.75	223.65	219.30	214.60	210.90
.4091 - .4410	.3750	6	1 3/4	5	341614h6	342614h6	343514h6	264.95	237.70	228.60	224.30	219.65	215.95
.4411 - .4720	.3750	6	1 3/4	5	341615h6	342615h6	343515h6	264.95	237.70	228.60	224.30	219.65	215.95
.4721 - .5030	.4375	6	2	6	341616h6	342616h6	343516h6	264.95	237.70	228.60	224.30	219.65	215.95
.5031 - .5340	.4375	6	2	6	341617h6	342617h6	343517h6	277.15	249.90	240.80	236.45	231.70	228.15
.5341 - .5660	.4375	6	2	6	341618h6	342618h6	343518h6	280.30	253.05	243.90	239.45	234.85	231.20
.5661 - .5970	.4375	6	2	6	341619h6	342619h6	343519h6	282.40	255.10	246.00	241.55	236.95	233.30
.5971 - .6280	.5625	6	2 1/4	6	341620h6	342620h6	343520h6	282.40	255.10	246.00	241.55	236.95	233.30
.6281 - .6590	.5625	6	2 1/4	6	341621h6	342621h6	343521h6	307.15	279.85	270.60	266.35	261.65	258.00
.6591 - .6910	.5625	6	2 1/4	6	341622h6	342622h6	343522h6	307.15	279.85	270.60	266.35	261.65	258.00
.6911 - .7220	.5625	6	2 1/4	6	341623h6	342623h6	343523h6	324.45	297.15	288.05	283.80	278.95	275.40
.7221 - .7530	.6250	6	2 1/2	6	341624h6	342624h6	343524h6	324.45	297.15	288.05	283.80	278.95	275.40

CARBIDE TIPPED h6 SHANK REAMER - FLUTE FED COOLANT

METRIC

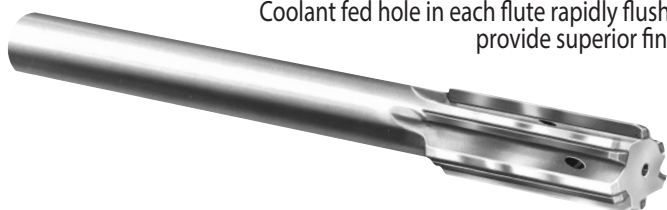
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11.202 - 12.000	10	6	45	127	3416120h6	3426120h6	3435120h6	269.50	242.50	233.30	228.85	224.30	220.50
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14.377 - 15.164	12	6	51	153	3416150h6	3426150h6	3435150h6	287.00	259.75	250.60	246.10	241.55	237.85
15.165 - 16.100	14	6	57	153	3416160h6	3426160h6	3435160h6	287.00	259.75	250.60	246.10	241.55	237.85
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17.552 - 18.340	14	6	57	153	3416180h6	3426180h6	3435180h6	329.00	301.75	292.65	288.25	283.80	279.95
18.341 - 19.250	16	6	64	153	3416190h6	3426190h6	3435190h6	329.00	301.75	292.65	288.25	283.80	279.95

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*Quantities of 15 or more: call for pricing.

Made in U.S.A.

FEEDS & SPEEDS CHARTS FOR h6 REAMERS - CARBIDE TIPPED

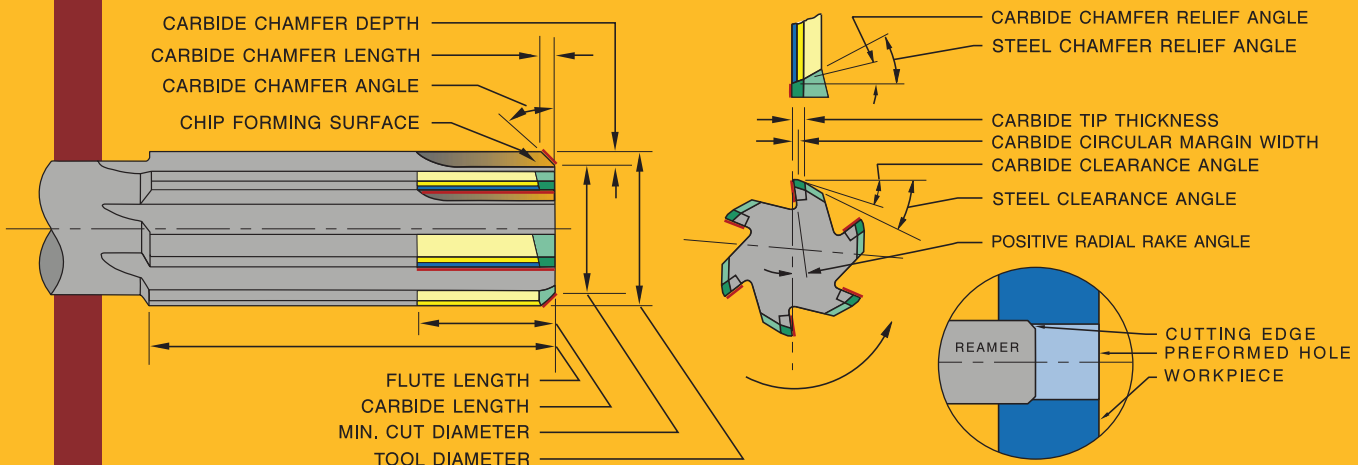
Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will affect the performance significantly. Please read machine operators instructions and use all shields and safety glasses before performing these operations.

$$RPM = SFPM * 3.82 / \text{Cutter Diameter}$$

CLASSIFICATION	MATERIAL	BRINELL	SPEED IN SFPM					
			COOLANT FED (C.F.)	1/4	3/8	1/2	5/8	3/4
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	200 - 300	.008	.010	.013	.015	.017
	MAGNESIUM ALLOY	50 - 90*	150 - 250	.012	.015	.018	.019	.020
	LEAD ALLOY	10 - 20*	200 - 300	.008	.010	.016	.017	.018
	NON-METAL AND PLASTIC	-	125 - 300	.006	.008	.009	.010	.014
	ZINC ALLOY - DIE CAST	80 - 100	170 - 240	.009	.011	.013	.014	.016
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	70 - 105	.008	.013	.015	.016	.018
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	125 - 300	.010	.014	.020	.022	.024
	NICKEL SILVER	10 - 100Rb	70 - 190	.007	.010	.012	.013	.014
	COPPER ALLOY - TOUGH	40 - 200*	70 - 105	.008	.010	.013	.014	.016
CAST IRON	DUCTILE CAST IRON - AUSTENITIC	120 - 275	65 - 100	.008	.009	.011	.014	.016
	DUCTILE CAST IRON - FERRITIC	140 - 270	70 - 105	.007	.010	.012	.015	.017
	DUCTILE CAST IRON - MARTENSITIC	270 - 400	50 - 85	.008	.009	.010	.011	.013
	GRAY - PEARLITIC	220 - 320	55 - 100	.008	.010	.012	.014	.015
	GRAY - FERRITIC	120 - 220	95 - 190	.010	.013	.014	.017	.020
	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	65 - 100	.008	.010	.012	.014	.015
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	100 - 150	.012	.014	.016	.018	.020
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 375	40 - 110	.009	.011	.013	.015	.017
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	90 - 135	.010	.012	.018	.020	.022
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 375	65 - 100	.012	.015	.018	.022	.024
	STAINLESS STEEL - 400 SERIES	135 - 325	50 - 100	.007	.007	.008	.009	.009
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	90 - 135	.008	.009	.010	.011	.012
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 400	50 - 100	.007	.008	.009	.011	.012
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	20 - 115	.006	.007	.007	.008	.008
	STAINLESS STEEL - 300 SERIES	135 - 375	60 - 90	.006	.007	.008	.008	.009
	STAINLESS STEEL - PH SERIES	150 - 440	50 - 90	.006	.006	.007	.008	.009
	TITANIUM ALLOY	110 - 380	40 - 60	.008	.010	.013	.014	.014

*500 kg

Precision Design For Use in Hydraulic Chucks, Shrink Fit Holders, and Precision Collet Chucks



Collet and holder pictures courtesy of Haimer USA

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Made in U.S.A.

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