REAMER GUIDE

BASIC TECHNICAL INFORMATION FOR REAMERS

HANNIBAL PRE-REAM DRILL SIZE CHART

REAMER DIAMETER FRACTION - DECIMAL (NOMINAL)	HOLE SIZE TO LEAVE 2%	DRILL SIZE TO LEAVE 2%	HOLE SIZE TO LEAVE 3%	DRILL SIZE TO LEAVE 3%
1/8 - .1250	.1225	31	.1213	3.0mm
9/64 - .1406	.1378	29	.1364	3.4mm
5/32 - .1562	.1532	24	.1516	25
11/64 - .1719	.1685	19	.1667	4.2mm
3/16 - .1875	.1838	14	.1819	15
13/64 - .2031	.1990	5.0mm	.1970	9
7/32 - .2188	.2144	5.4mm	.2122	4
15/64 - .2344	.2297	1	.2274	5.7mm
1/4 - .2500	.2450	C	.2425	6.1mm
17/64 - .2656	.2600	6.5mm	.2576	F
9/32 - .2812	.2756	I	.2728	6.9mm
19/64 - .2969	.2910	7.3mm	.2880	7.25mm
5/16 - .3125	.3063	7.75mm	.3031	N
21/64 - .3281	.3215	8.1mm	.3183	O
11/32 - .3438	.3370	8.5mm	.3335	8.4mm
23/64 - .3594	.3522	S	.3486	8.8mm
3/8 - .3750	.3675	9.25mm	.3638	23/64
25/64 - .3906	.3828	9.6mm	.3789	V
13/32 - .4062	.3982	10.0mm	.3941	25/64
27/64 - .4219	.4135	10.4mm	.4092	13/32
7/16 - .4375	.4288	10.8mm	.4244	27/64
29/64 - .4531	.4440	11.2mm	.4395	7/16
15/32 - .4688	.4594	11.6mm	.4547	29/64
31/64 - .4844	.4747	12.0mm	.4699	15/32
1/2 - .5000	.4900	31/64	.4850	12.2mm
33/64 - .5156	.5053	1/2	.5000	12.6mm
17/32 - .5312	.5206	33/64	.5153	13.0mm
35/64 - .5469	.5360	17/32	.5305	13.4mm
9/16 - .5625	.5513	35/64	.5456	13.8mm
37/64 - .5781	.5665	9/16	.5608	14.2mm
19/32 - .5938	.5820	37/64	.5760	14.5mm
39/64 - .6094	.5972	19/32	.5911	14.9mm
5/8 - .6250	.6125	39/64	.6063	15.3mm
41/64 - .6406	.6278	5/8	.6214	15.7mm
21/32 - .6562	.6431	41/64	.6365	16.1mm
43/64 - .6719	.6585	21/32	.6517	16.5mm
11/16 - .6875	.6738	17.0mm	.6669	16.8mm
45/64 - .7031	.6890	11/16	.6820	17.2mm
23/32 - .7188	.7044	45/64	.6972	17.6mm
47/64 - .7344	.7197	18.2mm	.7124	18.0mm
3/4 - .7500	.7350	18.5mm	.7275	18.3mm
49/64 - .7656	.7502	18.9mm	.7426	18.8mm
25/32 - .7812	.7656	19.3mm	.7578	3/4
51/64 - .7969	.7810	19.7mm	.7730	49/64
13/16 - .8125	.7963	20.1mm	.7881	25/32
53/64 - .8281	.8115	20.5mm	.8034	51/64
27/32 - .8438	.8270	20.8mm	.8185	13/16
55/64 - .8594	.8422	21.25mm	.8336	53/64
7/8 - .8750	.8575	21.6mm	.8488	27/32
57/64 - .8906	.8728	22.0mm	.8639	55/64
29/32 - .9062	.8881	22.5mm	.8790	7/8
59/64 - .9219	.9035	22.8mm	.8942	57/64
15/16 - .9375	.9188	23.25mm	.9094	29/32
61/64 - .9531	.9340	23.5mm	.9245	59/64
31/32 - .9688	.9494	24.0mm	.9397	15/16
63/64 - .9844	.9647	24.4mm	.9549	61/64
1 - 1.0000	.9800	24.75mm	.9700	31/32

This chart allows for drill oversize based on study done by the United States Cutting Tool Institute