

# NEW PRODUCTS

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# CATALOG

## INCH VERSION



Tungaloy Accelerated Lines - Leading in Innovation



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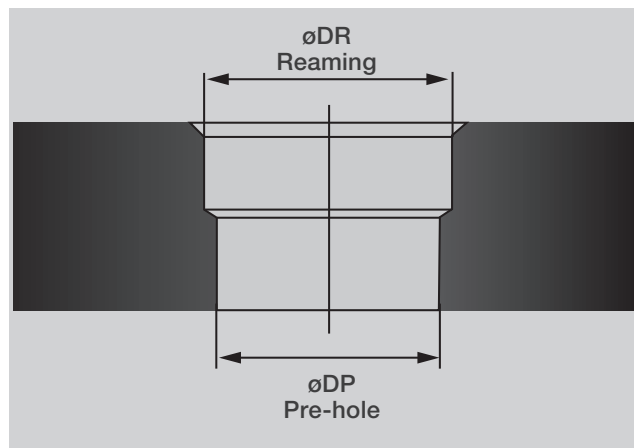
## FOR BEST PERFORMANCE

### Reaming allowance

- Reaming allowance  $\Delta$  is the stock material to be removed in the reaming process. For a successful reaming operation, reaming allowance must be determined with proper considerations. Refer to the table below for appropriate reaming allowance for various hole diameters and materials. Standard reaming allowance, unless otherwise required, will be the target diameter +0.0079" for all hole diameter ranges and materials.
- Reaming quality largely depends on the quality of the pre-hole. Pre-holes must have no diameter fluctuation and good straightness.

$\Delta$  : Reaming allowance

$$\Delta = \phi DR - \phi DP$$



Workpiece material	Hole diameter (inch)			
	0.45276 - 0.53150	0.53154 - 0.62992	0.62996 - 1.02362	1.02366 - 1.25984
Steel and cast iron	$\Delta = 0.00394 - 0.00787$	$\Delta = 0.00394 - 0.01181$	$\Delta = 0.00394 - 0.01575$	$\Delta = 0.00787 - 0.01969$
Aluminum and brass	$\Delta = 0.00591 - 0.00984$	$\Delta = 0.00787 - 0.01181$	$\Delta = 0.00787 - 0.01969$	$\Delta = 0.00787 - 0.02362$

### Recommended runout control

Runout control is important to achieve proper reaming process.

**Best:** less than 5  $\mu$

**Acceptable:** 5 - 15  $\mu$ m

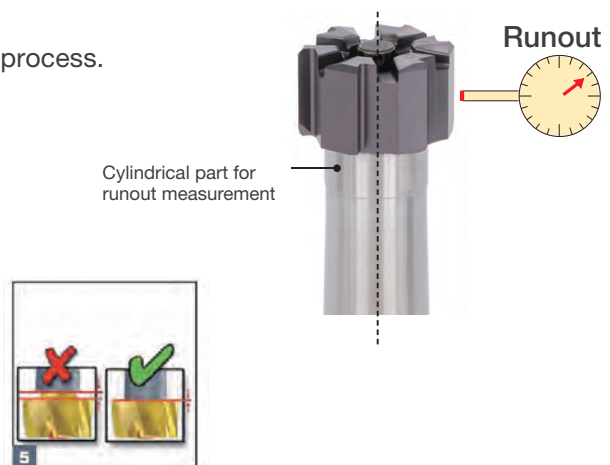
**Not acceptable:** over 15  $\mu$ m

\* If an acceptable runout is not achieved, adjust the runout as follows.

1. Make sure that there is no gap between the faces of the reaming head and the tool holder.

If there is a gap, use the key and tighten again until the gap disappears.

2. Measure the runout of the cylindrical part for runout measurement on the upper part of the tool to check the installation accuracy of the tool and the arbor. If the runout on the cylindrical surface of the tool is bad, remove the tool from the arbor, clean the tool and the arbor, then remount them and measure the runout.





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