



**PACREAMER**  
PRECISE • ACCURATE • CONCENTRIC

**NEXT GENERATION REAMER**



# ONE SOURCE HOLEMAKING

ECO Drills & PAC Reamers working together  
are ideal for close tolerance, round-hole  
applications that require a micro-finish.

Order the perfect pair today.







## FEATURES & BENEFITS

### 1. Coolant Supply

Optional coolant through feature for blind & deep hole applications

### 2. Self-Locating

Proprietary design ensures straightness and locates true position without reliance upon the pre-drilled hole quality

### 3. Burnishing

Eliminates vibration while burnishing to achieve mirror-like surface finishes

## UPGRADE YOUR TRADITIONAL CHUCKING REAMER

PAC Reamer's unique design prevents it from wandering via untrue holes. No longer do you need to qualify a drilled hole's straightness to ensure proper straightness and position are achieved.

- Reamer accuracy with perfect position & straightness
- Better internal surface finish vs. standard chucking reamers
- Ideal for precision hole finishing applications like dowel pin-holes
- Custom diameter & length configurations available with lightning service
- Fast regrind & recoating service available

# ELIMINATE AN ENTIRE STEP

### OLD WAY

1. Drill Hole
2. Circular interpolate hole with end mill
3. Ream hole with chuck reamer

### NEW WAY

1. Drill Hole (0.02-0.03" smaller)
  2. Ream hole with PAC Reamer
- Use our pre-sized ECO drills for perfect pairing.

## PACREAMER



# ULTIMATE PERFORMANCE

Premium High Performance Carbide Reamers



## Series 4050 PAC | 1FL | Solid Carbide | Inch & Metric

Cutting Diameter mm	Diameter decimal	Shank Dia.	LOC	OAL	EDP	ECO Drill Size
3.1496	0.1240	1/8	1-3/4	3	<b>427113</b>	Use 2.5mm ECO DRILL
3.1623	0.1245	1/8	1-3/4	3	<b>427115</b>	Use 2.5mm ECO DRILL
3.1750	0.1250	1/8	1-3/4	3	<b>427118</b>	Use 2.5mm ECO DRILL
3.1877	0.1255	1/8	1-3/4	3	<b>427122</b>	Use 2.5mm ECO DRILL
3.2004	0.1260	1/8	1-3/4	3	<b>427123</b>	Use 2.5mm ECO DRILL
4.7371	0.1865	3/16	2-3/4	4	<b>427126</b>	Use 4.0mm ECO DRILL
4.7498	0.1870	3/16	2-3/4	4	<b>427127</b>	Use 4.0mm ECO DRILL
4.7625	0.1875	3/16	2-3/4	4	<b>427130</b>	Use 4.0mm ECO DRILL
4.7752	0.1880	3/16	2-3/4	4	<b>427131</b>	Use 4.0mm ECO DRILL
4.7879	0.1885	3/16	2-3/4	4	<b>427134</b>	Use 4.0mm ECO DRILL
5.9750	0.2352	6	70	101	<b>427136</b>	Use 5.5mm ECO DRILL
5.9870	0.2357	6	70	101	<b>427137</b>	Use 5.5mm ECO DRILL
6.0000	0.2362	6	70	101	<b>427141</b>	Use 5.5mm ECO DRILL
6.0130	0.2367	6	70	101	<b>427142</b>	Use 5.5mm ECO DRILL
6.0250	0.2372	6	70	101	<b>427145</b>	Use 5.5mm ECO DRILL
6.3246	0.2490	1/4	2-3/4	4	<b>427147</b>	Use 6.0mm ECO DRILL
6.3373	0.2495	1/4	2-3/4	4	<b>427151</b>	Use 6.0mm ECO DRILL
6.3500	0.2500	1/4	2-3/4	4	<b>427154</b>	Use 6.0mm ECO DRILL
6.3627	0.2505	1/4	2-3/4	4	<b>427157</b>	Use 6.0mm ECO DRILL
6.3754	0.2510	1/4	2-3/4	4	<b>427161</b>	Use 6.0mm ECO DRILL
7.9121	0.3115	5/16	2-3/4	4	<b>427163</b>	Use 7.5mm ECO DRILL
7.9121	0.3115	5/16	3-3/4	6	<b>427164</b>	Use 7.5mm ECO DRILL
7.9248	0.3120	5/16	2-3/4	4	<b>427168</b>	Use 7.5mm ECO DRILL
7.9248	0.3120	5/16	3-3/4	6	<b>427170</b>	Use 7.5mm ECO DRILL
7.9375	0.3125	5/16	2-3/4	4	<b>427173</b>	Use 7.5mm ECO DRILL
7.9375	0.3125	5/16	3-3/4	6	<b>427177</b>	Use 7.5mm ECO DRILL
7.9502	0.3130	5/16	2-3/4	4	<b>427178</b>	Use 7.5mm ECO DRILL
7.9502	0.3130	5/16	3-3/4	6	<b>427179</b>	Use 7.5mm ECO DRILL
7.9629	0.3135	5/16	2-3/4	4	<b>427181</b>	Use 7.5mm ECO DRILL
7.9629	0.3135	5/16	3-3/4	6	<b>427182</b>	Use 7.5mm ECO DRILL
7.9750	0.3140	8	70	101	<b>427185</b>	Use 7.5mm ECO DRILL
7.9750	0.3140	8	95	152	<b>427188</b>	Use 7.5mm ECO DRILL
7.9870	0.3144	8	70	101	<b>427192</b>	Use 7.5mm ECO DRILL
7.9870	0.3144	8	95	152	<b>427196</b>	Use 7.5mm ECO DRILL
8.0000	0.3150	8	70	101	<b>427198</b>	Use 7.5mm ECO DRILL
8.0000	0.3150	8	95	152	<b>427199</b>	Use 7.5mm ECO DRILL
8.0130	0.3155	8	70	101	<b>427202</b>	Use 7.5mm ECO DRILL
8.0130	0.3155	8	95	152	<b>427204</b>	Use 7.5mm ECO DRILL
8.0250	0.3159	8	70	101	<b>427206</b>	Use 7.5mm ECO DRILL

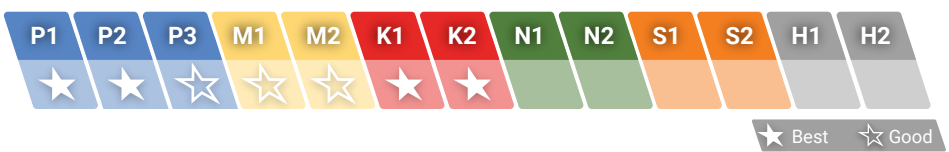
### PACREAMER

#### More About the Series 4050

**Precise. Accurate. Concentric.** The PAC reamer design is self-locating, thereby able to provide straightness and true position for dowel pin holes

Ideally coupled with the ECO drill series.

Diameter Tolerance: +0 /- .0002"



# ULTIMATE PERFORMANCE

Premium High Performance Carbide Reamers



## Series 4050 PAC | 1FL | Solid Carbide | Inch & Metric

Cutting mm	Diameter decimal	Shank Dia.	LOC	OAL	EDP	ECO Drill Size
8.0250	0.3159	8	95	152	<b>427207</b>	Use 7.5mm ECO DRILL
9.4996	0.3740	3/8	2-3/4	4	<b>427210</b>	Use 9.0mm ECO DRILL
9.4996	0.3740	3/8	3-3/4	6	<b>427214</b>	Use 9.0mm ECO DRILL
9.5123	0.3745	3/8	2-3/4	4	<b>427215</b>	Use 9.0mm ECO DRILL
9.5123	0.3745	3/8	3-3/4	6	<b>427219</b>	Use 9.0mm ECO DRILL
9.5250	0.3750	3/8	2-3/4	4	<b>427222</b>	Use 9.0mm ECO DRILL
9.5250	0.3750	3/8	3-3/4	6	<b>427225</b>	Use 9.0mm ECO DRILL
9.5377	0.3755	3/8	2-3/4	4	<b>427226</b>	Use 9.0mm ECO DRILL
9.5377	0.3755	3/8	3-3/4	6	<b>427229</b>	Use 9.0mm ECO DRILL
9.5504	0.3760	3/8	2-3/4	4	<b>427231</b>	Use 9.0mm ECO DRILL
9.5504	0.3760	3/8	3-3/4	6	<b>427233</b>	Use 9.0mm ECO DRILL
9.9750	0.3927	10	95	152	<b>427235</b>	Use 9.5mm ECO DRILL
9.9870	0.3932	10	95	152	<b>427238</b>	Use 9.5mm ECO DRILL
10.0000	0.3937	10	95	152	<b>427239</b>	Use 9.5mm ECO DRILL
10.0130	0.3942	10	95	152	<b>427242</b>	Use 9.5mm ECO DRILL
10.0250	0.3947	10	95	152	<b>427243</b>	Use 9.5mm ECO DRILL
11.0871	0.4365	7/16	3-3/4	6	<b>427247</b>	Use 10.5mm ECO DRILL
11.0998	0.4370	7/16	3-3/4	6	<b>427250</b>	Use 10.5mm ECO DRILL
11.1125	0.4375	7/16	3-3/4	6	<b>427252</b>	Use 10.5mm ECO DRILL
11.1252	0.4380	7/16	3-3/4	6	<b>427255</b>	Use 10.5mm ECO DRILL
11.1379	0.4385	7/16	3-3/4	6	<b>427256</b>	Use 10.5mm ECO DRILL
11.9750	0.4715	12	95	152	<b>427257</b>	Use 11.5mm ECO DRILL
11.9870	0.4719	12	95	152	<b>427258</b>	Use 11.5mm ECO DRILL
12.0000	0.4724	12	95	152	<b>427262</b>	Use 11.5mm ECO DRILL
12.0130	0.4730	12	95	152	<b>427266</b>	Use 11.5mm ECO DRILL
12.0250	0.4734	12	95	152	<b>427269</b>	Use 11.5mm ECO DRILL
12.6746	0.4990	1/2	3-3/4	6	<b>427271</b>	Use 12mm ECO DRILL
12.6873	0.4995	1/2	3-3/4	6	<b>427273</b>	Use 12mm ECO DRILL
12.7000	0.5000	1/2	3-3/4	6	<b>427275</b>	Use 12mm ECO DRILL
12.7127	0.5005	1/2	3-3/4	6	<b>427277</b>	Use 12mm ECO DRILL
12.7254	0.5010	1/2	3-3/4	6	<b>427279</b>	Use 12mm ECO DRILL
13.9750	0.5502	14	95	152	<b>427281</b>	Use 13.5mm ECO DRILL
13.9870	0.5507	14	95	152	<b>427285</b>	Use 13.5mm ECO DRILL
14.0000	0.5512	14	95	152	<b>427289</b>	Use 13.5mm ECO DRILL
14.0130	0.5517	14	95	152	<b>427293</b>	Use 13.5mm ECO DRILL
14.0250	0.5522	14	95	152	<b>427297</b>	Use 13.5mm ECO DRILL
15.8496	0.6240	5/8	3-3/4	6	<b>427300</b>	Use 15mm ECO DRILL
15.8623	0.6245	5/8	3-3/4	6	<b>427302</b>	Use 15mm ECO DRILL
15.8750	0.6250	5/8	3-3/4	6	<b>427305</b>	Use 15mm ECO DRILL
15.8877	0.6255	5/8	3-3/4	6	<b>427308</b>	Use 15mm ECO DRILL

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**Precise. Accurate. Concentric.** The PAC reamer design is self-locating, thereby able to provide straightness and true position for dowel pin holes

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Diameter Tolerance: +0/- .0002"



# ULTIMATE PERFORMANCE

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Cutting Diameter mm	Cutting Diameter decimal	Shank Dia.	LOC	OAL	EDP	ECO Drill Size
15.9004	0.6260	5/8	3-3/4	6	<b>427312</b>	Use 15mm ECO DRILL
15.9750	0.6289	16	95	152	<b>427316</b>	Use 15.5mm ECO DRILL
15.9870	0.6294	16	95	152	<b>427320</b>	Use 15.5mm ECO DRILL
16.0000	0.6299	16	95	152	<b>427324</b>	Use 15.5mm ECO DRILL
16.0130	0.6304	16	95	152	<b>427325</b>	Use 15.5mm ECO DRILL
16.0250	0.6309	16	95	152	<b>427329</b>	Use 15.5mm ECO DRILL
19.0246	0.7490	3/4	3-3/4	6	<b>427333</b>	Use 18.5mm ECO DRILL
19.0373	0.7495	3/4	3-3/4	6	<b>427337</b>	Use 18.5mm ECO DRILL
19.0500	0.7500	3/4	3-3/4	6	<b>427339</b>	Use 18.5mm ECO DRILL
19.0627	0.7505	3/4	3-3/4	6	<b>427341</b>	Use 18.5mm ECO DRILL
19.0754	0.7510	3/4	3-3/4	6	<b>427344</b>	Use 18.5mm ECO DRILL

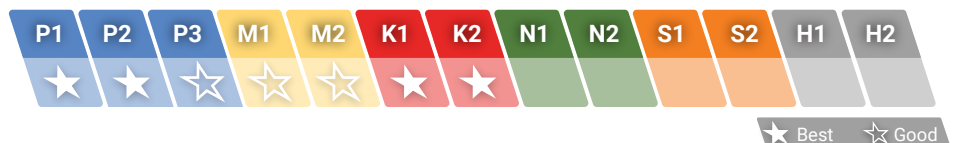
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# SPEED & FEED GUIDE

Optimum Performance

**PACREAMER**

Work Material	P						M				K				N	
	Carbon Steel		Alloy Steel		Tool Steel		300 & 400 SS		PH SS		Gray		Ductile		> 10% Si	
SFM	220 - 350		210 - 315		205 - 295		130 - 200		120 - 190		300 - 455		170 - 300		330 - 385	
Reamer Dia.	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR
	mm	inch														
1/8	7334	0.0013	6723	0.0013	6418	0.0013	4890	0.0013	4584	0.0013	8404	0.0013	7182	0.0013	10085	0.0013
4	5822	0.0016	5337	0.0016	5094	0.0016	3881	0.0016	3639	0.0016	6671	0.0016	5700	0.0016	8005	0.0016
3/16	4890	0.0019	4482	0.0019	4278	0.0019	3260	0.0019	3056	0.0019	5603	0.0019	4788	0.0019	6723	0.0019
6	3881	0.0024	3558	0.0024	3396	0.0024	2587	0.0024	2426	0.0024	4447	0.0024	3800	0.0024	5337	0.0024
1/4	3667	0.0025	3362	0.0025	3209	0.0025	2445	0.0025	2292	0.0025	4202	0.0025	3591	0.0025	5042	0.0025
8	2911	0.0031	2668	0.0031	2547	0.0031	1941	0.0031	1819	0.0031	3335	0.0031	2850	0.0031	4002	0.0031
3/8	2445	0.0038	2241	0.0038	2139	0.0038	1630	0.0038	1528	0.0038	2801	0.0038	2394	0.0038	3362	0.0038
10	2329	0.0039	2135	0.0039	2038	0.0039	1552	0.0039	1455	0.0039	2668	0.0039	2280	0.0039	3202	0.0039
7/16	2096	0.0044	1921	0.0044	1834	0.0044	1397	0.0044	1310	0.0044	2401	0.0044	2052	0.0044	2881	0.0044
12	1941	0.0047	1779	0.0047	1698	0.0047	1294	0.0047	1213	0.0047	2224	0.0047	1900	0.0047	2668	0.0047
1/2	1834	0.0050	1681	0.0050	1604	0.0050	1222	0.0050	1146	0.0050	2101	0.0050	1795	0.0050	2521	0.0050
14	1663	0.0055	1525	0.0055	1455	0.0055	1109	0.0055	1040	0.0055	1906	0.0055	1629	0.0055	2287	0.0055
5/8	1467	0.0063	1345	0.0063	1284	0.0063	978	0.0063	917	0.0063	1681	0.0063	1436	0.0063	2017	0.0063



**UPGRADE YOUR TRADITIONAL REAMER**



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## CUSTOM COMES STANDARD

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Chesterfield, IN 46017

### MICHIGAN

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Grand Rapids, MI 49512

### MASSACHUSETTS

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Springfield, MA 01104