# **Hole Expansion Tools & Sets**



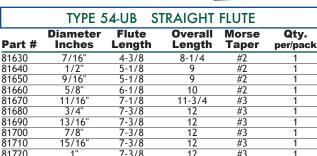
## BRIDGE REAMERS & HOLE HOG™ & STEP REAMERS

Type 54-UB -Straight Flute Type 55-UB -Spiral Flute

Bridge Reamers - Straight & Spiral Flutes - Taper Shank High-Speed Steel, Surface Treated

• These special Hi-Tungsten tool steel reamers with gold surface treated body and clearance are designed to be used with Taper shank equipment.

 They are available in both straight and spiral flute configuration and are designed for heavy-duty reaming as encountered in the fabrication of structural steel assemblies, bridge erection, and ship construction.



#### 81720 7-3/8 12 #3 7-3/8 81730 1-1/16 #3 12 7-3/8 81740 1-1/8 12 #3 81750 7-3/8 1-3/16 17 #3 7-3/8 81760 1-1/4 13 #4 7-3/8 81770 1-5/16 13

### **Type 284-UB & Sets**

# Hole Hog<sup>™</sup> 1/2" Shank 4-Flute Core Drill Super Premium, 3-Flats on Shank

- The 4-flute design eliminates the catching and hogging-in experienced with standard S&D drills when breaking through thinner materials such as truck frames.
- These core drills may replace tapered reamers in many applications.



This tool is designed exclusively for enlarging existing holes.

	TYPE	284-UB	FRACTIC	NAL	
Part #	Diameter Inches	Min. Starting Hole Size	OAL Inches	Flute Length Inches	Qty. per/pack
22030	3/8"	1/4"	4-5/16	1-7/8	1
22040	1/2"	5/16"	4-5/16	1-7/8	1
22060	9/16"	3/8"	4-5/16	1-7/8	1
22080	5/8"	25/64"	4-5/16	1-7/8	1
22100	11/16"	7/16"	4-5/16	1-7/8	1
22120	3/4"	15/32"	4-5/16	1-7/8	1

#### SETS - TYPE 284-UB

#### SP-8HH Set Contains 1ea:

Part# 38880

284-UB Core drill sizes: 3/8", 1/2", 5/8" & 3/4" 250-UB Drill sizes: 1/4", 5/16", 25/64" & 15/32"

#### SP-6HHL Set Contains 1ea:

Part# 38870

284-UB Core drill sizes: 1/2", 5/8" & 3/4" 250-UB Drill sizes: 5/16", 25/64" & 15/32"

#### SP-6HHS Set Contains 1ea:

Part# 38860

284-UB Core drill sizes: 3/8", 1/2" & 5/8" 250-UB Drill sizes: 1/4", 5/16" & 25/64"

> A selection of core drills and companion (minimum starting hole size) pilot drills in a black steel index



TYPE 55-UB SPIRAL FLUTE						
Part #	Diameter Inches	Flute Length	Overall Length	Morse Taper	Qty. per/pack	
83310	7/16"	4-3/8	8-1/4	#2	1	
83320	1/2"	5-1/8	9	#2	1	
83330	9/16"	5-1/8	9	#2	1	
83340	5/8"	6-1/8	10	#2	1	
83350	11/16"	7-1/8	11-3/4	#3	1	
83360	3/4"	7-3/8	12	#3	1	
83370	13/16"	7-3/8	12	#3	1	
83380	7/8"	7-3/8	12	#3	1	
83390	15/16"	7-3/8	12	#3	1	
83400	1"	7-3/8	12	#3	1	
83410	1-1/16"	7-3/8	12	#3	1	
83420	1-1/8"	7-3/8	12	#3	1	
83430	1-3/16"	7-3/8	12	#3	1	
83440	1-1/4"	7-3/8	13	#4	1	
83450	1-5/16"	7-3/8	13	#4	1	

### **Type 78-GR -Gold Oxide**

### Type 78-ZR -White Gold & SETS HSS Step Reamers, 3-Flats on Shank



- · Accurately starts, enlarge and deburrs in holes in material up to 1/2" thick.
- 90° notch point starts holes easily.
- · Each reamer has five hole enlargement steps.

Gold Oxide - low temperature stress relief that enhances lubricity, reduces friction and increases toughness

Zirconium Nitride - cutting machining aluminum magnesium, titanium alloys. Increased lubricity.





#### TYPE 78-GR GOLD OXIDE & TYPE 78-ZR WHITE GOLD

78-GR Gold Oxide Part #	78-ZR Zirconium Nitride Part #	Hole Sizes	Range	Shank Sizes	Step Thickness
83710	99940	5	5/16" - 9/16"	3/8"	1/2"
83720	99950	5	9/16" - 13/16"	3/8"	1/2"
83730	99960	5	13/16" - 1-1/16"	3/8"	1/2"
			SETS		

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78-GR Part #	78-ZR Part #		Hole Sizes	Range	Shank Sizes	Step Thickness	
83750	99980	3рс.	5	5/16" - 1-1/16"	3/8"	1/2"	
83760	99990	2nc	5	5/16" - 9/16"	3/8"	1/2"	





#99980

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