

# CHAMPION

## Maintenance Reamers

List No. SA80

1/2" Straight Shank\* / Left Hand Helix / Right Hand Cut / Collar Stop / HSS



**Description:** Enlarge and align existing holes. Effortlessly fits into small holes.

**Application:** Used in steel erection, automotive, truck & trailer manufacturing and repair. Quickly aligns structural steel. Cuts stainless steel & tough alloys. Deburs welded & punched holes. Ideal for maintenance & repair. Reduce cutting speeds and feeds when cutting aluminum.

EDP No./ Diameter	Decimal Equivalent	No. of Flutes	Point Diameter	Flute Length	Overall Length
SA80-5/16*	.3125	4	.176	3	4-3/4
SA80-3/8*	.3750	4	.188	3	5
SA80-7/16*	.4375	4	.218	3-1/4	5-1/4
SA80-1/2	.5000	5	.230	3-15/16	5-15/16
SA80-9/16	.5625	5	.2925	3-15/16	5-15/16
SA80-5/8	.6250	5	.259	4-1/2	6-9/16
SA80-.652	.6520	5	.293	4-3/4	6-9/16
SA80-11/16	.6875	5	.3125	4-1/2	6-9/16
SA80-3/4	.7500	5	.453	4-15/16	7
SA80-.776	.7760	5	.461	5-3/16	7
SA80-13/16	.8125	5	.5155	4-15/16	7
SA80-7/8	.8750	5	.580	5-3/16	7-1/4
SA80-15/16	.9375	5	.6425	5-3/16	7-1/4
SA80-1	1.0000	5	.708	5-3/16	7-1/4
SA80-1-1/16	1.0625	5	.753	5-7/16	7-1/4
SA80-1-1/8**	1.1250	5	.810	5-7/16	7-1/4
SA80-1-1/4**	1.2500	5	.930	5-11/16	7-1/2
SA80-1-3/8**	1.3750	5	.930	5-11/16	7-1/2
SA80-1-1/2**	1.5000	5	1.185	5-11/16	7-1/2

\*Shank diameter same as reamer diameter.

\*\*3/4" flatted shank

Sizes .652 and .776 are specifically for shoulder bolts used on truck frames.



# CHAMPION

## Chucking Reamers

List No. 970

Fractional / Straight Shank / Straight Flute / HSS



**Description:** For close tolerance machine reaming of a wide range of materials.

**Application:** Used in turret lathes and drill presses as well as other standing machinery.

EDP No. / Diameter	Decimal Equiv	Flute Length	Overall Length
970-3/64	.0469	1/2	2-1/2
970-1/16	.0625	1/2	2-1/2
970-5/64	.0781	3/4	3
970-3/32	.0938	3/4	3
970-7/64	.1094	7/8	3-1/2
970-1/8	.1250	7/8	3-1/2
970-9/64	.1406	1	4
970-5/32	.1562	1	4
970-11/64	.1719	1-1/8	4-1/2

EDP No. / Diameter	Decimal Equiv	Flute Length	Overall Length
970-3/16	.1875	1-1/8	4-1/2
970-13/64	.2031	1-1/4	5
970-7/32	.2188	1-1/4	5
970-15/64	.2344	1-1/2	6
970-1/4	.2500	1-1/2	6
970-17/64	.2656	1-1/2	6
970-9/32	.2812	1-1/2	6
970-19/64	.2969	1-1/2	6
970-5/16	.3125	1-1/2	6



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
970-21/64	.3281	1-1/2	6
970-11/32	.3438	1-1/2	6
970-23/64	.3594	1-3/4	7
970-3/8	.3750	1-3/4	7
970-25/64	.3906	1-3/4	7
970-13/32	.4062	1-3/4	7
970-27/64	.4219	1-3/4	7
970-7/16	.4375	1-3/4	7
970-29/64	.4531	1-3/4	7
970-15/32	.4688	1-3/4	7
970-31/64	.4844	2	8
970-1/2	.5000	2	8
970-17/32	.5313	2	8
970-9/16	.5625	2	8
970-19/32	.5938	2	8
970-5/8	.6250	2-1/4	9
970-21/32	.6562	2-1/4	9

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
970-11/16	.6875	2-1/4	9
970-23/32	.7188	2-1/4	9
970-3/4	.7500	2-1/2	9-1/2
970-25/32	.7812	2-1/2	9-1/2
970-13/16	.8125	2-1/2	9-1/2
970-27/32	.8438	2-1/2	9-1/2
970-7/8	.8750	2-5/8	10
970-29/32	.9062	2-5/8	10
970-15/16	.9375	2-5/8	10
970-31/32	.9688	2-5/8	10
970-1	1.0000	2-3/4	10-1/2
970-1-1/16	1.0625	2-3/4	10-1/2
970-1-1/8	1.1250	2-7/8	11
970-1-3/16	1.1875	2-7/8	11
970-1-1/4	1.2500	3	11-1/2
970-1-3/8	1.3750	3-1/4	12
970-1-1/2	1.5000	3-1/2	12-1/2

## Chucking Reamers

### List No. 970L

Letter Size / Straight Shank / Straight Flute / HSS



**Description:** For close tolerance machine reaming of a wide range of materials.

**Application:** Used in turret lathes and drill presses as well as other standing machinery.

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
970L-A	.2340	6	.2265	1-1/2	6
970L-B	.2380	6	.2329	1-1/2	6
970L-C	.2420	6	.2329	1-1/2	6
970L-D	.2460	6	.2329	1-1/2	6
970L-E	.2500	6	.2405	1-1/2	6
970L-F	.2570	6	.2485	1-1/2	6
970L-G	.2610	6	.2485	1-1/2	6
970L-H	.2660	6	.2485	1-1/2	6
970L-I	.2720	6	.2485	1-1/2	6
970L-J	.2770	6	.2485	1-1/2	6
970L-K	.2810	6	.2485	1-1/2	6
970L-L	.2900	6	.2792	1-1/2	6
970L-M	.2950	6	.2792	1-1/2	6

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
970L-N	.3020	6	.2792	1-1/2	6
970L-O	.3160	6	.2792	1-1/2	6
970L-P	.3230	6	.2792	1-1/2	6
970L-Q	.3320	6	.2792	1-1/2	6
970L-R	.3390	6	.2792	1-1/2	6
970L-S	.3480	6	.3105	1-3/4	6
970L-T	.3580	6	.3105	1-3/4	7
970L-U	.3680	6	.3105	1-3/4	7
970L-V	.3770	6	.3105	1-3/4	7
970L-W	.3860	6	.3105	1-3/4	7
970L-X	.3970	6	.3105	1-3/4	7
970L-Y	.4040	6	.3105	1-3/4	7
970L-Z	.4130	6	.3730	1-3/4	7