Total Stock Allowance by Reamer Diameter

Material	Grades	≤1/64 (.0156)	1/32 (.0312)	1/16 (.0625)	1/8 (.1250)	1/4 (.2500)	3/8 (.3750)	1/2 (.5000)	5/8 (.6250)	3/4 (.7500)	7/8 (.875)	1+ (1.000)+
P - Steels												
High Strength Tool Steel	A2, D2, P20, H11, H13, S2, 01	.0010	.0020	.0040	.0070	.0080	.0100	.0110	.0130	.0140	.0150	.0160
Low Carbon	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	.0010	.0030	.0060	.0100	.0110	.0130	.0140	.0160	.0170	.0180	.0190
Medium Carbon	1040-1095, 1140-1151, 1330-1345, 1520-1572, 4023-4063, 4120-4161, 4330-4340, 4620-4640, 8620-8660, 8740-8750, 6150, 51000, 52100	.0010	.0030	.0050	.0090	.0100	.0120	.0130	.0150	.0170	.0180	.0190
M - Stainless Steels												
Austenitic	301-304L, 310, 316L, 321, 347	.0010	.0020	.0050	.0090	.0100	.0120	.0130	.0150	.0160	.0170	.0180
Martensitic	403, 410, 416, 420, 430, 431, 440	.0010	.0020	.0050	.0090	.0100	.0120	.0130	.0150	.0160	.0170	.0180
Precipitation Hardening	12/8, 15/5, 17/4, AM-350/355/363, PH13-8MO, PH14-8/MO	.0010	.0020	.0050	.0090	.0100	.0120	.0130	.0150	.0160	.0170	.0180
K - Cast Irons												
Ductile	A536, J434, 60-40-18	.0020	.0060	.0100	.0110	.0130	.0140	.0150	.0150	.0170	.0180	.0190
Gray	A48, A436, A319, Class 20, G4000	.0010-.0015	.0015- .0025	.0020-.0030	.0025-.0040	.0060-.0080	.0080-.0100	.0100-.0140	.0120-.0180	.0150-.0200	.0160-.0220	.0200-.0300
Malleable	A220, A602, J158	.0020	.0030	.0060	.0100	.0110	.0130	.0140	.0160	.0180	.0190	.0200
N - Non-Ferrous												
Aluminum Alloys	2014, 2024, 6061, 7075	.0010	.0030	.0060	.0110	.0120	.0150	.0160	.0180	.0200	.0210	.0220
Aluminum High Silicon	A380, A390	.0010-.0020	.0040	.0050	.0050-.0060	.0060-.0100	.0080-.0140	.0120-.0180	.0140-.0200	.0160-.0220	.0160-.0220	.0180-.0280
Brass/Bronze	Aluminum Bronze, Low Silicon Bronze	.0010	.0030	.0060	.0110	.0120	.0130	.0150	.0160	.0180	.0190	.0200
Composites	Plastics	.0020	.0020-.0030	.0030-.0050	.0040-.0070	.0050-.0100	.0070-.0150	.0100-.0200	.0120-.0220	.0140-.0240	.0160-.0260	.0180-.0300
Magnesium		.0010	.0020	.0030	.0040	.0080-.0100	.0100-.0120	.0140-.0180	.0150-.0200	.0160-.0220	.0180-.0280	.0200-.0300
S - High Temp Alloys												
Cobalt Base	Stellite, HS-21, Haynes 25/188, X40, L605	<.0010	.0010	.0015	.0010-.0020	.0040-.0060	.0050-.0070	.0080-.0100	.0090-.0120	.0100-.0150	.0110-.0170	.0120-.0200
Iron Base	Incoloy 800-802, Multmet N-155, Timkin 16-25-6, Carpenter 22-b3	.0010	.0030	.0050	.0100	.0110	.0130	.0140	.0150	.0160	.0170	.0180
Nickel Base	Inconel 625/718, Inco 700, 713C, 718, Monel 400-401, 404, K401, Rene, Rene 41 & 95 Hastelloy, Waspoloy, Udimet 500 & 700	.0010	.0030	.0050	.0100	.0110	.0130	.0140	.0150	.0160	.0170	.0180
Titanium	Commercially Pure, 6Al-4V ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si, Ti-8Al-1Mo, Ti-8Al-4Mo	.0010	.0030	.0050	.0100	.0110	.0130	.0140	.0150	.0160	.0170	.0180

NOTE: Speeds and Feeds listed are estimated and will vary by application.