

JGS Tool Standards

All JGS chamber reamers are made to minimum diameter dimensions unless otherwise stated on the print. All length tolerances are +.0050 and all angle dimensions are +/- 15 minutes. Below are our standard sizes:

<u>ITEM CODE</u>	<u>DESCRIPTION</u>	<u>DIAMETER TOLERANCE</u>
<u>CARBIDE:</u>		
CF	Carbide Match Grade Finisher	+.0005
CMF	Carbide Match Grade Solid Pilot Finisher	+.0005
CPF (formerly CF*)	Carbide Production Grade Finisher	+.001/.0015
CEF	Carbide Production Grade Solid Pilot Finisher	+.001/.0015
CR	Carbide Roughing Reamer	-.0095/.010
CRS	Carbide Roughing Reamer (Small Caliber/Rimfire)	-.0035/.004
CS	Carbide Semi-finisher Reamer	-.0035/.004
CZ	Carbide Resizing Reamer	-.004 on body, neck (usually -.012 for sizing)
CD	Carbide Straight Flute Core Drill Reamer	-.0095/.010
CDS	Carbide Spiral Flute Core Drill Reamer	-.0095/.010
<u>HIGH SPEED STEEL:</u>		
HF	HSS Match Grade Finisher	+.0005
HMF	HSS Match Grade Solid Pilot Finisher	+.0005
HPF (formerly HF*)	HSS Production Grade Finisher	+.001/.0015
HS	HSS Semi-finisher Reamer	-.0035/.004
HR	HSS Roughing Reamer	-.0095/.010
HRS	HSS Roughing Reamer (Small Caliber/Rimfire)	-.0035/.004
HZ	HSS Resizing Reamer	-.004 on body; neck usually -.012 for sizing
HD	HSS Straight Flute Core Drill Reamer	-.0095/.010
HDS	HSS Spiral Flute Core Drill Reamer	-.0095/.010
<u>HEADSPACE GAUGES:</u>		<u>LENGTH TOLERANCE</u>
GO	GO Headspace Gauge	+.0005
GN	NO-GO Headspace Gauge	-.0005
GF	Field Headspace Gauge	-.0005
<u>BUSHINGS:</u>		
Standard or Oil Grooved Bushings		Made in .0002 increments