



Reynolda Manufacturing Solutions
1200 Flint Hill Road
East Bend, NC 27018
Watts: (800)-888-6308
Fax: (336)699-2150
www.Reynolda.com

This information is only an illustration on insert tooling and how it can save you money and create more time for your machine to run.

Based on the following information, here is how much time and money can be saved using insert form tools.

Your Shop Rate: \$60
Cycle Time: 3.5 seconds

Total Standard Form Tool Costs	Total Insert Tooling Cost
Dovetail: \$170 x 2: 340	Insert Holder: \$300
Resharpen: 40 times at 15 min.: \$597	40 Inserts \$20 each: \$800
Lost Time: 1200 Minutes or 72,000 seconds	Resharpen: No Cost
Cost for Lost Time: \$1200	Lost Time: 60 Minutes or 3600 seconds
Total parts not produced: 20,571	Cost: \$60
Your Tools Real Cost: \$2137	Total parts not produced: 1028
	Insert Tooling Real Cost: \$960

RMS

REYNOLDA MANUFACTURING SOLUTIONS

PO Box 455

Lewisville, NC 27023

Watts: (800) 888-6308

Fax: (336) 699-2150

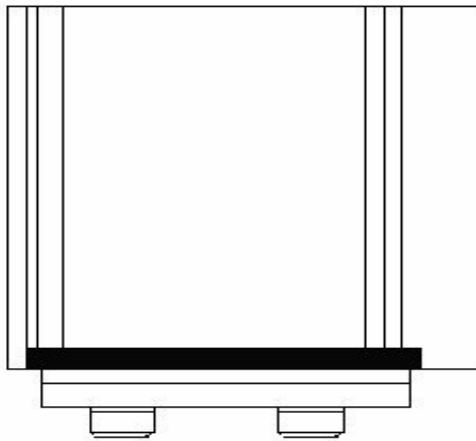
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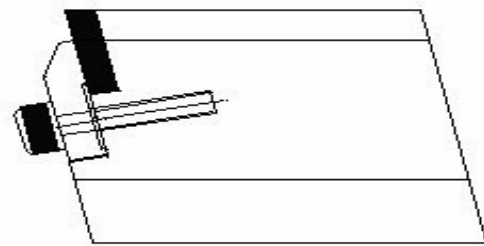
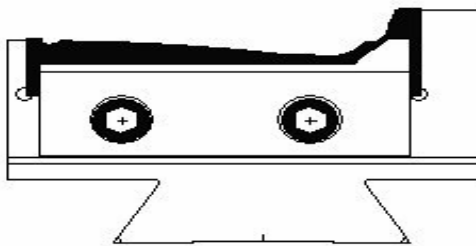
Quick Change Insert Tooling

Are you wasting timing sharpening tools, setting up tooling for long run jobs? Do you have a family of parts that could be set-up more efficiently?

Let Reynolda take a look and help you out.



*Insert technology made simple.
The way it should be!!*



Fax or email your part print to Reynolda today and we can get to work saving you money!



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How to Pick Your Tool Steel

Reynolda Cutting Tools manufactures its cutting tools in a variety of high-speed steels and carbides. To make your selection process easier, the following information will give you a good idea of what is available and its applications.

Properties of tool steels

There are three basic properties to high-speed steel:

1. **Hardness:** The resistance to deforming and flattening
2. **Toughness:** The resistance to breakage and chipping
3. **Wear resistance:** The resistance to abrasion & erosion

M-2 High Speed Steel

Hardness 64-66

The least wear resistance and a high toughness. Low hardness. We do not recommend this material for any applications. M-42 is a better material and its tool life will offset the cost difference.

M-42 High Speed Steel:

Hardness 65-67

Low wear resistance and toughness but a high hardness. Recommended as a substitute for M-2 material. Great for short run jobs or if you are cutting a soft material like brass.

T-15PM High Speed Steel:

Hardness 66-68

The wear resistance is high. Grinding and sharpening is a little harder than with M-42 or Rex-76. Works well on all materials and best used on high abrasive materials. Tool life is good

Rex-76 (M48) High Speed Steel:

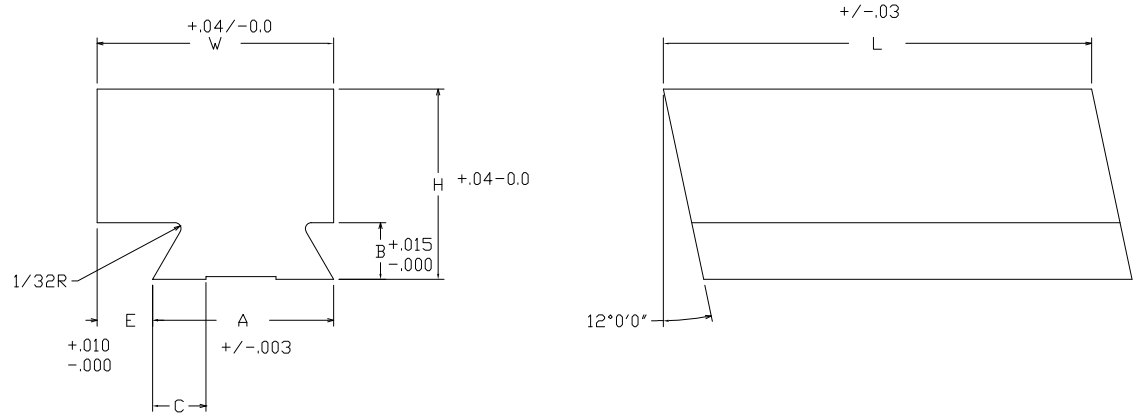
Hardness 67-69

The best of the high-speed steels on the market. Great wear resistance and high hardness. The grinding and sharpening is similar to lower hardness materials. Recommended for any long jobs and tougher materials.

Dovetail Form Tool Blanks
 M-42, T15PM & Rex-76

H.S.S.
 Hardened & Ground
 4140 Pre Heat Treated
 And Ground
 Machineable

www.Reynolda.com



.700 Dovetail Blanks Fit 3/8" Dovetail Holders

A	W	E	B	H	C	L	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price	4140 PHT Price
.700	1"	1/4	19/64	3/4	1/4	1 1/8	38-100	27.77	29.57	35.23	21.72

.951 Dovetail Blanks Fit 5/8" Dovetail Holders

A	W	E	B	H	C	L	Tap Hole	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price	4140 PHT Ground
.951	1"	1/16	19/64	1.0	9/32	2 1/4	—	58-100	38.87	43.49	51.94	25.34
.951	1"	1/16	19/64	1.0	9/32	1 1/2	1/4-28	58-100-DAV	40.61	46.21	50.43	31.67
.951	1 1/4	19/64	19/64	1.0	9/32	2 1/4	—	58-125	46.13	53.74	60.52	26.06
.951	1 1/2	9/16	19/64	1.0	9/32	2 1/4	—	58-150	51.25	59.71	67.24	28.96
.951	1 1/2	19/64	19/64	1.0	9/32	1 1/2	1/4-28	58-150-DAV	46.42	54.14	59.27	34.85
.951	2"	17/32	19/64	1.0	9/32	2 1/4	—	58-200	64.12	76.02	82.51	33.03

1.882 Dovetail Blanks Fit 1 1/4 Dovetail Holder

A	W	E	B	H	C	L	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price	4140 PHT Ground
1.882	2"	1/8	35/64	1 1/2	1/2	2 1/4	114-200	90.96	107.54	118.47	35.30
1.882	2 1/2	9/16	35/64	1 1/2	1/2	2 1/4	114-250	108.74	130.81	142.29	39.37
1.882	3"	9/16	35/64	1 1/2	1/2	2 1/4	114-300	126.56	153.37	169.51	44.35

Fits the New Britain Holder

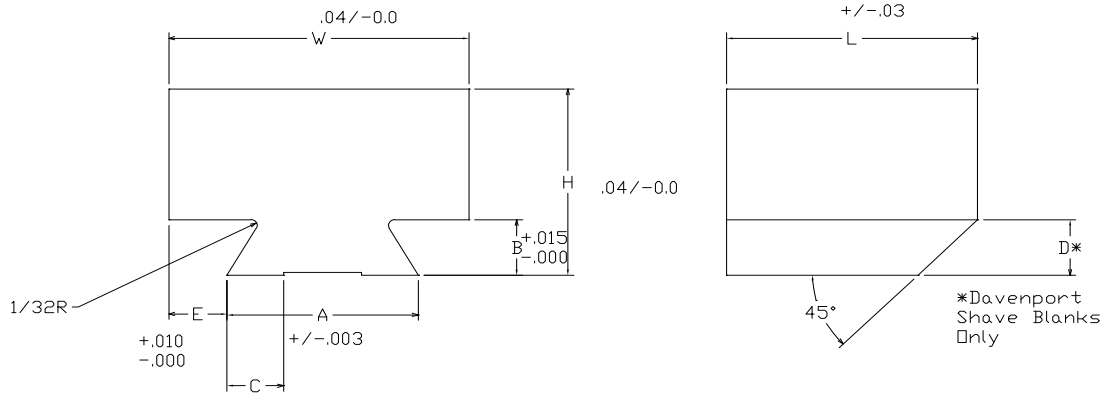
A	W	E	B	H	C	L	Catalog Number	T-15PM Price	Rex-76 Price
1.253	1 1/2	1/4	9/16	1 1/2	3/8	2 1/4	NB-150	90.51	100.63
1.253	2"	3/8	9/16	1 1/2	3/8	2 1/4	NB-200	108.97	119.97



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Dovetail Shave Tool Blanks
 M-42, T-15PM, & Rex-76
 Hardened & Ground
 4140 Material
 Soft & Ground



DOVETAIL SHAVE TOOL BLANKS, FOR 5/8" & 1/2" HOLDERS

A	W	E	B	H	C	L	Catalog Number	M-42 Price	T-15PM H.S.S. PRICE	REX-76 PRICE	4140 PHT GROUND
.714	1	9/32	13/64	3/4	9/32	1 1/4	714-100	27.58	27.17	33.29	15.84
.913	1	3/32	17/64	1	9/32	1 1/4	913-100	26.36	33.19	35.23	19.00
.913	1 1/2	19/32	17/64	1	9/32	1 1/4	913-150	33.23	36.87	44.76	22.62
.913	2	35/64	17/64	1	9/32	1 1/4	913-200	40.48	47.09	53.87	24.89

DOVETAIL SHAVE TOOL BLANKS, FOR 1" HOLDER

A	W	E	B	H	C	L	Catalog Number	M-42 Price	T-15PM H.S.S. PRICE	REX-76 PRICE	4140 PHT GROUND
1.287	1 1/2	7/32	17/64	1	3/8	1 1/2	1287-150	40.85	49.06	55.88	24.43
1.287	2	23/64	17/64	1	3/8	1 1/2	1287-200	51.04	61.07	67.71	27.60

DOVETAIL SHAVE TOOL BLANKS, FOR 1-1/4" & 1-1/2" HOLDERS

A	W	E	B	H	C	L	Catalog Number	M-42 Price	T-15PM H.S.S. Price	Rex-76 Price	4140 Pht Ground
1.554	2	11/32	17/64	1	1/2	1 3/4	1554-200	50.45	61.10	67.71	27.60
1.787	2	7/32	17/64	1	1/2	1 3/4	1787-200	53.73	64.93	71.73	28.50

* DOVETAIL SHAVE TOOL BLANKS, FOR DAVENPORT HOLDERS

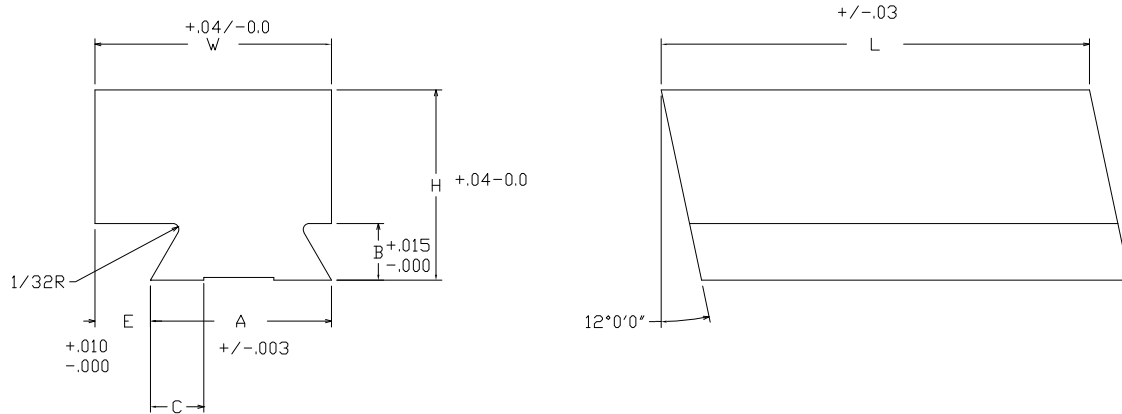
A	W	E	B	H	C	L	D	Catalog Number	M-42 Price	T-15PM H.S.S. Price	Rex-76 Price
*.951	1	1/16	19/64	29/32	9/32	1 1/4	1/4	951-100-DAV	POA	36.60	42.69
*.951	1 1/2	19/64	19/64	29/32	9/32	1 1/4	1/4	951-150-DAV	POA	40.52	46.87

POA: Price Available on Application.



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Maxamet High Speed Steel

.951 Dovetail Blanks Fit 5/8" Dovetail Holders

A	W	E	B	H	C	L	Tap Hole	Catalog Number	Maxamet Price
.951	1"	1/16	19/64	1.0	9/32	2 1/4	—	58-100	59.73
.951	1"	1/16	19/64	1.0	9/32	1 1/2	1/4-28	58-100-DAV	57.99
.951	1 1/2	9/16	19/64	1.0	9/32	2 1/4	—	58-150	77.32
.951	1 1/2	19/64	19/64	1.0	9/32	1 1/2	1/4-28	58-150-DAV	68.16
.951	2"	17/32	19/64	1.0	9/32	2 1/4	—	58-200	94.88

1.882 Dovetail Blanks Fit 1 1/4 Dovetail Holder

A	W	E	B	H	C	L	Catalog Number	Maxamet Price
1.882	2"	1/8	35/64	1 1/2	1/2	2 1/4	114-200	135.70
1.882	2 1/2	9/16	35/64	1 1/2	1/2	2 1/4	114-250	163.30

Maxamet is a high speed steel produced by Carpenter Technologies. It is a steel that is meant to help with hard cuts where carbide tipped dovetails would normally chip or break. It has a higher hardness than Rex-76(M48). We recommend it when there will be interrupted cuts with your form.



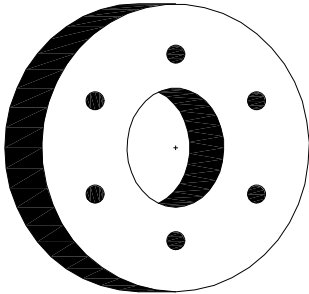
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Davenport Circular Form, Size, And Roll Blanks

DAVENPORT FORM BLANKS

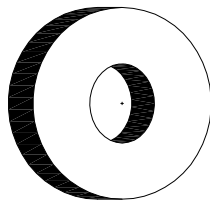


FORM

2" Diameter
 9/16" Center Hole
 (6) 9/64" Dia. Pin Holes
 Thru On 1 1/4" B.C.
 Surface ground both sides only

WIDTH	CATALOG NUMBER	M-42 PRICE	T-15 PM PRICE	REX-76 PRICE
1/4	DFB-250	27.91	33.20	34.89
5/16	DFB-313	35.92	37.34	39.21
3/8	DFB-375	37.80	41.01	42.98
7/16	DFB-438	38.73	44.70	47.27
1/2	DFB-500	42.44	49.88	52.55
9/16	DFB-562	44.82	53.55	56.36
5/8	DFB-625	48.61	57.23	60.14
3/4	DFB-750	55.71	66.12	69.75
7/8	DFB-875	61.81	73.99	78.31
1	DFB-1.000	69.40	81.48	86.41

DAVENPORT SIZE BLANKS

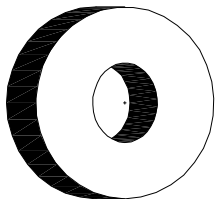


SIZE

1 5/16" Diameter
 7/16-20 L.H. Thread
 Surface ground both sides
 only

WIDTH	CATALOG NUMBER	M-42 PRICE	T-15 PM PRICE	REX-76 PRICE
1/4	DSB-250	12.61	14.60	15.88
5/16	DSB-313	14.96	17.07	18.03
3/8	DSB-375	16.05	18.65	19.72
7/16	DSB-438	17.71	20.76	21.85
1/2	DSB-500	18.86	22.84	23.99
9/16	DSB-562	20.45	24.40	25.62
5/8	DSB-625	22.61	25.99	27.76
3/4	DSB-750	25.36	30.65	32.05
7/8	DSB-875	28.15	34.82	36.32
1	DSB-1.000	31.90	37.99	40.09
1 1/8	DSB-1.125	39.71	47.08	51.35
1 1/4	DSB-1.250	42.60	52.98	55.30

DAVENPORT ROLLS



ROLL

Hardened 52100 Steel
 Ground all over
 15/16 O.D.
 .3125/.313 Honed I.D.

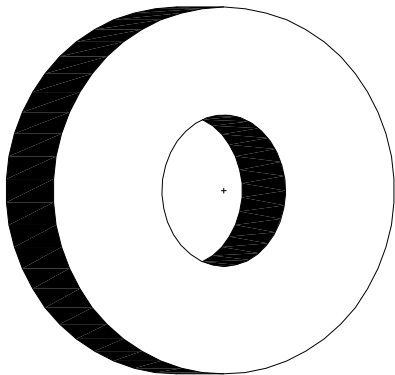
WIDTH	CATALOG NUMBER	PRICE
1/4	DR-250	15.50
5/16	DR-313	16.50
3/8	DR-375	17.00
7/16	DR-438	17.50
1/2	DR-500	18.00
5/8	DR-625	20.00
3/4	DR-750	21.50
7/8	DR-875	22.50
1	DR-1.000	24.00

**Brown & Sharpe
Circular Form
Tool Blanks**

**M-42, T-15PM
and Rex-76
Material**

Hardened and Surface
Ground Both Sides

All Blanks supplied
without pin holes. Blanks
are available
with pin holes at extra
cost.



#OOBS 1 3/4 Dia. 3/8-16 Tap Hole

Width	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price
1/4	OOBS-250	16.36	20.54	21.36
5/16	OOBS-313	19.15	23.81	25.05
3/8	OOBS-375	20.99	26.08	27.40
7/16	OOBS-438	23.38	28.85	30.78
1/2	OOBS-500	25.70	32.18	34.20
9/16	OOBS-562	27.54	34.98	36.55
5/8	OOBS-625	29.40	37.77	39.98
3/4	OOBS-750	34.47	42.82	45.22
7/8	OOBS-875	37.51	47.88	50.96
1"	OOBS-1.000	42.98	54.54	57.79
1 1/8"	OOBS-1.125	47.19	59.58	63.04
1 1/4"	OOBS-1.250	58.95	73.71	75.02
1 3/8"	OOBS-1.375	63.27	79.81	80.27
1 1/2"	OOBS-1.500	68.14	85.35	86.64

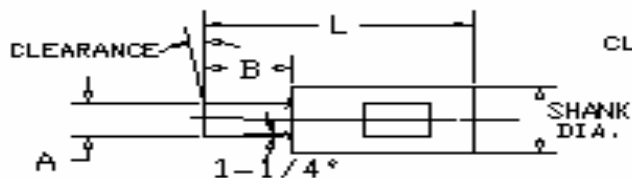
#OB&S 2 1/4" Dia. 1/2-13 Tap Hole

Width	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price
5/16	OBS-313	27.80	35.11	37.81
3/8	OBS-375	30.69	39.54	41.90
1/2	OBS-500	37.30	47.41	50.03
5/8	OBS-625	43.95	56.36	59.81
3/4	OBS-750	50.03	64.79	69.05
1"	OBS-1.000	63.22	82.17	87.00

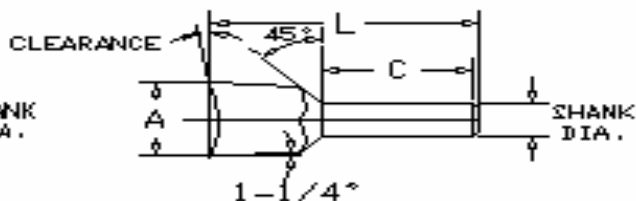
#2B&S 3" Dia. 5/8-11 Tap Hole

Width	Catalog Number	M-42 Price	T-15PM Price	Rex-76 Price
3/8	2BS-375	52.20	64.29	68.52
7/16	2BS-438	56.56	71.58	75.58
1/2	2BS-500	60.75	77.97	82.73
9/16	2BS-562	64.75	84.87	90.38
5/8	2BS-625	70.11	91.77	97.52
11/16	2BS-687	75.42	97.32	105.12
3/4	2BS-750	80.42	105.57	112.32
7/8	2BS-875	89.78	118.85	126.12
1"	2BS-1.000	100.12	132.62	140.92
1 1/8"	2BS-1.125	109.50	146.44	155.71
1 1/4"	2BS-1.250	119.81	159.23	170.01
1 3/8"	2BS-1.375	129.16	173.52	183.80
1 1/2"	2BS-1.500	139.52	187.32	198.61

Try our finish ground circular
form tools. Let us do the work
and design your circulars for
you or we will make them to
your tool drawing. Have it your
way!!!!



.315 Shank Diameter



.500 Shank Diameter Hexagon

Hex Size	A	B	C	L	Style	Cat. No.	Price
.050	.051	5/64	—	1 1/4	A	315-050H	41.22
1.5MM	.61	3/32	—	1 1/4	A	315-1.5H	41.22
1/16	.064	3/32	—	1 1/4	A	315-1/16H	41.22
5/64	.079	7/64	—	1 1/4	A	315-5/64H	41.22
2.0MM	.081	7/64	—	1 1/4	A	315-2.0H	41.22
3/32	.095	9/64	—	1 1/4	A	315-3/32H	41.22
2.5MM	.101	5/32	—	1 1/4	A	315-2.5H	41.22
7/64	.111	5/32	—	1 1/4	A	315-7/64H	41.22
3.0MM	.120	3/16	—	1 1/4	A	315-3.0H	41.22
1/8	.127	3/16	—	1 1/4	A	315-1/8H	41.22
9/64	.143	7/32	—	1 1/4	A	315-9/64H	41.22
5/32	.158	1/4	—	1 1/4	A	315-5/32H	41.22
4.0MM	.160	1/4	—	1 1/4	A	315-4.0H	41.22
3/16	.190	9/32	—	1 1/4	A	315-3/16H	41.22
5.0MM	.199	5/16	—	1 1/4	A	315-5.0H	41.22
7/32	.221	11/32	—	1 1/4	A	315-7/32H	41.22
6.0MM	.238	3/8	—	1 1/4	A	315-6.0H	41.22
1/4	.252	3/8	—	1 1/4	A	315-1/4H	41.22
9/32	.284	—	1 1/8	1 1/2	B	315-9/32	53.98
5/16	.316	—	1 1/8	1 1/2	B	315-5/16H	54.79
8.0MM	.318	—	1 1/8	1 1/2	B	315-8.0H	54.79
3/8	.378	—	1"	1 1/2	B	315-3/8H	56.10
10.MM	.397	—	1 1/8	1 1/2	B	315-10.0H	56.10

Hex Size	A	B	C	L	Style	Catalog Number	Price
3/32	.096	9/64	—	1 1/2	A	500-3/32H	48.25
2.5MM	.101	5/32	—	1 1/2	A	500-2.5H	48.25
7/64	.111	5/32	—	1 1/2	A	500-7/64H	48.25
3.0MM	.120	3/16	—	1 1/2	A	500-3.0H	48.25
1/8	.127	3/16	—	1 1/2	A	500-1/8H	48.25
9/64	.143	7/32	—	1 1/2	A	500-9/64	48.25
5/32	.158	1/4	—	1 1/2	A	500-5/32	48.25
4.0MM	.160	1/4	—	1 1/2	A	500-4.0H	48.25
3/16	.190	9/32	—	1 1/2	A	500-3/16H	48.25
5.0MM	.199	5/16	—	1 1/2	A	500-5.0H	48.25
7/32	.221	11/32	—	1 1/2	A	500-7/32	48.25
6.0MM	.238	3/8	—	1 1/2	A	500-6.0H	48.25
1/4	.252	3/8	—	1 1/2	A	500-1/4H	48.25
9/32	.284	7/16	—	1 1/2	A	500-9/32H	48.25
5/16	.316	1/2	—	1 1/2	A	500-5/16H	48.25
8.0MM	.318	1/2	—	1 1/2	A	500-8.0H	48.25
3/8	.378	9/16	—	1 1/2	A	500-3/8H	48.25
10MM	.397	9/16	—	1 1/2	A	500-10.0H	48.25
7/16	.441	—	1 3/8	2"	B	500-7/16	63.59
12.MM	.476	—	1 3/8	2"	B	500-12H	64.97
1/2	.503	—	1 3/8	2"	B	500-1/2H	64.97
14MM	.554	—	1 3/8	2"	B	500-14H	66.35
9/16	.566	—	1 3/8	2"	B	500-9/16H	67.72
5/8	.629	—	1 1/4	2"	B	500-5/8H	68.88
17MM	.673	—	1 1/8	2"	B	500-17H	69.13
11/16	.692	—	1 1/8	2"	B	500-11/16H	69.13
19M	.752	—	1 1/8	2"	B	500-19H	70.51
3/4	.754	—	1 1/8	2"	B	500-3/4H	70.51

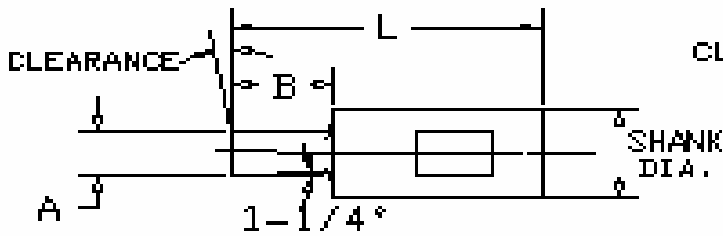
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SPECIAL HEX SIZES**



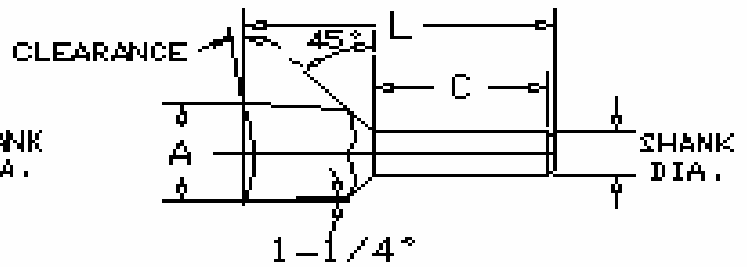
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Square Broaches
 M-2 Hardened
 & Ground
 .315 Shank Diameter
 .500 Shank Diameter



Style "A"



Style "B"

.315 Shank Diameter Square Broaches

.500 Shank Diameter Hexagon

Square Size	A	B	C	L	Style	Cat. No.	Price
3/32	.095	9/64	—	1 1/4	A	315-3/32S	40.84
1/8	.127	3/16	—	1 1/4	A	315-1/8S	40.84
5/32	.158	1/4	—	1 1/4	A	315-5/32S	40.84
3/16	.190	9/32	—	1 1/4	A	315-3/16S	40.84
7/32	.221	11/32	—	1 1/4	A	315-7/32S	40.84
1/4	.252	—	1 1/8	1 1/2	B	315-1/4S	53.48
9/32	.284	—	1 1/8	1 1/2	B	315-9/32S	54.79
5/16	.316	—	1"	1 1/2	B	315-5/16S	56.10
11/32	.347	—	1"	1 1/2	B	315-11/32S	57.42
3/8	.378	—	1"	1 1/2	B	315-3/8S	58.74

Square Size	A	B	C	L	Style	Catalog Number	Price
3/32	.096	9/64	—	1 1/2	A	500-3/32S	48.26
1/8	.127	3/16	—	1 1/2	A	500-1/8S	48.26
5/32	.158	1/4	—	1 1/2	A	500-5/32S	48.26
3/16	.190	9/32	—	1 1/2	A	500-3/16S	48.26
7/32	.221	11/32	—	1 1/2	A	500-7/32S	48.26
1/4	.252	3/8	—	1 1/2	A	500-1/4S	48.26
9/32	.284	7/16	—	1 1/2	A	500-9/32S	48.26
5/16	.316	1/2	—	1 1/2	A	500-5/16S	48.26
11/32	.347	9/16	—	1 1/2	A	500-11/32S	48.26
3/8	.378	—	1 1/2	2"	B	500-3/8S	64.97
7/16	.441	—	1 1/2	2"	B	500-7/16S	66.34
1/2	.503	—	1 3/8	2"	B	500-1/2S	67.72
9/16	.566	—	1 1/4	2"	B	500-9/16S	69.13
5/8	.629	—	1 1/8	2"	B	500-5/8S	70.52

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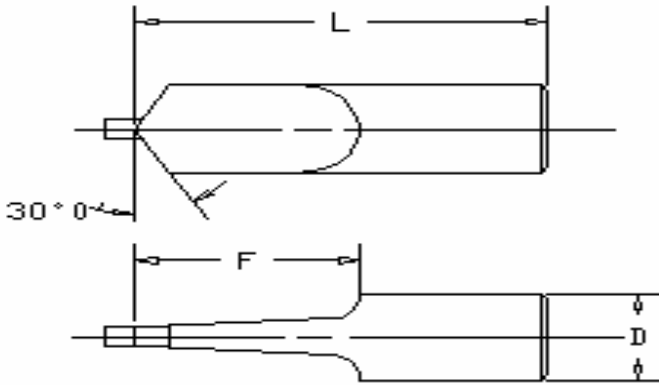
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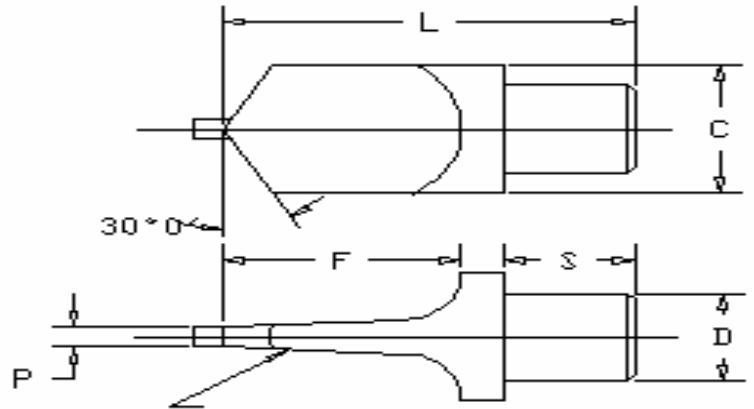
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Flat Drill Blanks
M-42 H.S.S.
Hardened & Ground
Centers Both Ends



Style "A"



5 DEG. TAPER
PER SIDE

Style "B"

Prices and Specifications

Tool #	Style	D	L	F	C	S	P	Price
FDB-38	A	3/8	2 1/4	1"	—	—	1/8	18.15
FDB-50	A	1/2	2 1/2	1 1/8	—	—	3/16	19.78
FDB-62	A	5/8	2 3/4	1 1/4	—	—	7/32	23.55
FDB-75	A	3/4	3"	1 3/8	—	—	1/4	28.20
FDB-100	A	1"	3 1/2	1 3/4	—	—	5/16	38.65
FDB-125	B	1"	3 3/4	1 3/4	1 1/4	1 1/4	3/8	49.73
FDB-150	B	1"	3 3/4	2"	1 1/2	1 1/4	7/16	64.16

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- * *FOR RIGHT OR LEFT HAND OPERATIONS*
- * *SHORT LENGTHS FOR SCREW MACHINE USE*
- * *SHANK DIAMETERS FINISH GROUND*
- * *HIGH SPEED STEEL HARDENED*
- * *M-42 MATERIAL 65-67 RC*

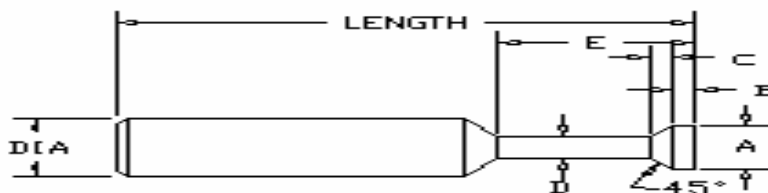
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Circular Recess Tool Blanks
 M-2 H.S.S.
 Hardened And
 Ground



Available in a wide variety of shank sizes, head diameters and lengths to fit all recessing tools and for all types of jobs. These tool blanks are made from hardened M-2 high speed steel and are ground all over.

Catalog Number	Diameter	Length	A	B	C	D	E	Price
RCS250-1	1/4	7/8	.140	.030	.030	.080	5/16	12.63
RCS250-2	1/4	1	.190	.030	.040	.110	7/16	12.63
RCS250-3	1/4	1 1/8	.240	.030	.045	.150	9/16	12.63

RCS313-1	5/16	2	.140	.030	.030	.080	5/16	15.22
RCS313-2	5/16	1 1/4	.220	.040	.035	.150	1/2	14.08
RCS313-3	5/16	2	.220	.040	.035	.150	1/2	15.22
RCS313-4	5/16	1 3/8	.260	.040	.040	.180	5/8	14.08
RCS313-5	5/16	1 1/2	.300	.040	.045	.210	3/4	14.08

RCS375-1	3/8	1 1/2	.240	.045	.030	.180	9/16	14.85
RCS375-2	3/8	2	.240	.045	.030	.180	9/16	17.62
RCS375-3	3/8	1 5/8	.300	.045	.040	.200	11/16	15.38
RCS375-4	3/8	2	.300	.045	.040	.200	11/16	17.62
RCS375-5	3/8	1 3/4	.360	.045	.055	.250	13/16	16.04

RCS500-1	1/2	1 7/8	.270	.050	.035	.200	5/8	18.20
RCS500-2	1/2	2	.330	.050	.040	.250	3/4	17.43
RCS500-3	1/2	2 1/4	.400	.050	.050	.300	1	18.30



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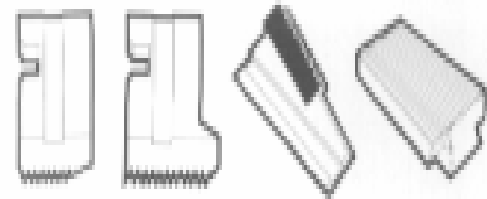
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