

## Standard Step Drills – Jobber Length

High Speed Steel – For Drilling and Counterboring Cap Screw Clearance Holes



Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
#6	0.150"	1/4"	1/2	2-3/4	4	311291
#8	0.178"	L	1/2	2-15/16	4-1/4	311292
#10	0.204"	Q	5/8	3-7/16	4-3/4	311293
1/4"	9/32"	13/32"	11/16	3-7/8	5-1/4	311294

Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
5/16"	11/32"	1/2"	3/4	4-1/2	6	311295
3/8"	13/32"	19/32"	7/8	5-3/16	7-1/8	311296
1/2"	17/32"	25/32"	1	3-1/4	*5-1/8	311297

\*Shorter than jobber length

High Speed Steel – For Drilling and Countersinking 82 Degree Flat Head Machine Screws



Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
#6	0.142"	9/32"	1/2	2-15/16	4-1/4	311306
#8	0.169"	Q	1/2	3-7/16	4-3/4	311307
#10	0.196"	W	5/8	3-3/4	5-1/8	311308
1/4"	0.257"	1/2"	11/16	4-13/16	6	311309

Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
5/16"	0.320"	5/8"	3/4	5-3/16	7-1/8	311310
3/8"	0.383"	3/4"	7/8	5-5/8	5	311311
1/2"	0.510"	7/8"	1	3-1/2	*5-1/8	311312

\*Shorter than jobber length

High Speed Steel – For Drilling 45 Degree Chamfered Holes to be Tapped



Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
5-40	0.101	9/64	1/2	1-3/4	2-7/8	311313
6-32	0.109	5/32	1/2	2	3-1/8	311314
8-32	0.136	3/16	1/2	2-5/16	3-1/2	311315
8-36	0.136	3/16	1/2	2-5/16	3-1/2	311316
10-24	0.152	1/4	5/8	2-3/4	4	311317
10-32	0.161	1/4	5/8	2-3/4	4	311318
1/4-20	0.204	21/64	13/16	3-5/16	4-5/8	311319
1/4-28	0.218	21/64	13/16	3-5/16	4-5/8	311320

Screw Size	Minor Dia.	Major Dia.	Step Length (Inch)	Flute Length (Inch)	Overall Length (Inch)	Code
5/16-18	0.261	13/32	15/16	3-7/8	5-1/4	311321
5/16-24	0.272	13/32	15/16	3-7/8	5-1/4	311322
3/8-16	0.316	31/64	1	4-3/8	5-7/8	311323
3/8-24	0.339	31/64	1	4-3/8	5-7/8	311324
7/16-14	0.375	17/32	1-1/16	4-13/16	6-5/8	311325
7/16-20	0.390	17/32	1-1/16	4-13/16	6-5/8	311326
1/2-13	0.437	5/8	1-1/16	5-3/16	7-1/8	311327
1/2-20	0.452	5/8	1-1/16	5-3/16	7-1/8	311328

## Self Starting Step Drills

High Speed Steel



Series	Number of Steps	Included Diameters	Code
SSD1	13	1/8, 5/32, 3/16, 7/32, 1/4, 9/32, 5/16, 11/32, 3/8, 13/32, 7/16, 15/32, 1/2	754700
SSD2	6	3/16, 1/4, 5/16, 3/8, 7/16, 1/2	754701
SSD3	9	1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4	754702
SSD4	12	3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8	754703