

# Standard Step Drills

## High Speed Steel

For Drilling and Countersinking 82° Flat Head Machine Screws



Jobber Length

Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code	Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code
No. 6	0.142	9/32	1/2	2-15/16	4-1/4	311306	5/16	0.320	5/8	3/4	5-3/16	7-1/8	311310
No. 8	0.169	Q	1/2	3-7/16	4-3/4	311307	3/8	0.383	3/4	7/8	5-5/8	7-5/8	311311
No. 10	0.196	W	5/8	3-3/4	5-1/8	311308	1/2	0.510	7/8	1	3-1/2	*5-1/2	311312
1/4	0.257	1/2	11/16	4-13/16	6	311309							

\*Shorter than jobber length

For Drilling 45° Chamfered Holes to be Tapped



Jobber Length

Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code	Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code
5-40	0.101	9/64	1/2	1-3/4	2-7/8	311313	5/16-18	0.261	13/32	15/16	3-7/8	5-1/4	311321
6-32	0.109	5/32	1/2	2	3-1/8	311314	5/16-24	0.272	13/32	15/16	3-7/8	5-1/4	311322
8-32	0.136	3/16	1/2	2-5/16	3-1/2	311315	3/8-16	0.316	31/64	1	4-3/8	5-7/8	311323
8-36	0.136	3/16	1/2	2-5/16	3-1/2	311316	3/8-24	0.339	31/64	1	4-3/8	5-7/8	311324
10-24	0.152	1/4	5/8	2-3/4	4	311317	7/16-14	0.375	17/32	1-1/16	4-13/16	6-5/8	311325
10-32	0.161	1/4	5/8	2-3/4	4	311318	7/16-20	0.390	17/32	1-1/16	4-13/16	6-5/8	311326
1/4-20	0.204	21/64	13/16	3-5/16	4-5/8	311319	1/2-13	0.437	5/8	1-1/16	5-3/16	7-1/8	311327
1/4-28	0.218	21/64	13/16	3-5/16	4-5/8	311320	1/2-20	0.452	5/8	1-1/16	5-3/16	7-1/8	311328

Taper Length

Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code	Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Code
5-40	0.101	9/64	1/2	3	5-3/8	311329	5/16-18	0.261	13/32	15/16	4-3/8	7	311337
6-32	0.109	5/32	1/2	3	5-3/8	311330	5/16-24	0.272	13/32	15/16	4-3/8	7	311338
8-32	0.136	3/16	1/2	3-3/8	5-3/4	311331	3/8-16	0.316	31/64	1	4-3/4	7-3/4	311339
8-36	0.136	3/16	1/2	3-3/8	5-3/4	311332	3/8-24	0.339	31/64	1	4-3/4	7-3/4	311340
10-24	0.152	1/4	5/8	3-3/4	6-1/8	311333	7/16-14	0.375	17/32	1-1/16	4-3/4	8	311341
10-32	0.161	1/4	5/8	3-3/4	6-1/8	311334	7/16-20	0.390	17/32	1-1/16	4-3/4	8	311342
1/4-20	0.204	21/64	13/16	4-1/8	6-1/2	311335	1/2-13	0.437	5/8	1-1/16	4-7/8	8-3/4	311343
1/4-28	0.218	21/64	13/16	4-1/8	6-1/2	311336	1/2-20	0.452	5/8	1-1/16	4-7/8	8-3/4	311344