

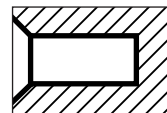
# 82° ANGLE STEP DRILLS

**ICS USA**

**SPECIAL PURPOSE**

**118° POINT**

High Speed Steel 82° Angle Step Drills are designed for drilling and countersinking 82° flat head machine screw clearance holes in one operation, saving machine time and reducing set up time. They can be resharpened or modified for a special length of step and are available in jobber length or taper length drill styles.



## For Drilling and Countersinking 82° Flat Head Machine Screw Clearance Holes

SCREW SIZE	MINOR DIA.	MAJOR DIA.	STEP LENGTH	SHANK DIA.	HIGH SPEED STEEL		
					JOBBER LENGTH 82°		ITEM NO. <b>SDJL82-</b>
					FLUTE LENGTH	OVERALL LENGTH	
#4	.116	15/64	3/8	15/64	2-5/8	3-7/8	\$13.10
#5	.128	"F"	3/8	"F"	2-7/8	4-1/8	13.14
#6	.142	9/32	1/2	9/32	2-15/16	4-1/4	13.36
#8	.169	"Q"	1/2	"Q"	3-7/16	4-3/4	16.64
#10	.196	"W"	5/8	"W"	3-3/4	5-1/8	18.50
1/4	.257	1/2	11/16	1/2	4-1/2	6	22.52
5/16	.320	5/8	3/4	5/8	5-3/16	7-1/8	33.64
* 3/8	.383	3/4	7/8	3/4	3-1/8	5	45.72
*7/16	.446	13/16	1	13/16	3-3/8	5-1/4	51.98
*1/2	.510	7/8	1	7/8	3-1/2	5-1/2	61.48

\*Shorter than jobber length.

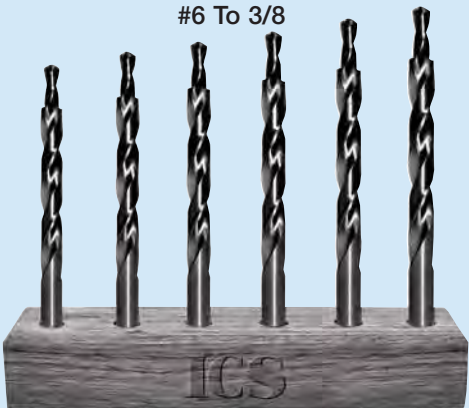
Reduced 1/2" shank available on screw sizes 5/16 to 1/2. (Add \$3.00)

Reduced 3/8" shank also available on screw sizes 5/16 to 1/2. (Add \$5.00)

## STEP DRILL SETS

**WOOD STAND**

High Speed Steel 6 Piece Step Drill Sets contain #6 to 3/8 screw sizes and are available in 45°, 82°, and 90° step angles in jobber length and taper length drill styles.

DESCRIPTION	ITEM NO.	TYPE OF STEP DRILL	PRICE
<b>6 PC STEP DRILL SET</b> #6 To 3/8 	SDJLS45-6	Jobber Length 45°	\$97.70
	SDJLS82-6	Jobber Length 82°	145.04
	SDJLS90-6	Jobber Length 90°	121.58