

HIGH SPEED STEEL 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. | FLUTE LENGTH | OVERALL LENGTH | ITEM NO. | PRICE |
|------------|------------|------------|-------------|------------|--------------|----------------|------------|-------|
| #4 | .116 | 15/64 | 3/8 | 15/64 | 2-5/8 | 3-7/8 | SDJL82-#04 | 13.76 |
| #5 | .128 | "F" | 3/8 | "F" | 2-7/8 | 4-1/8 | SDJL82-#05 | 13.80 |
| #6 | .142 | 9/32 | 1/2 | 9/32 | 2-15/16 | 4-1/4 | SDJL82-#06 | 14.04 |
| #8 | .169 | "Q" | 1/2 | "Q" | 3-7/16 | 4-3/4 | SDJL82-#08 | 17.48 |
| #10 | .196 | "W" | 5/8 | "W" | 3-3/4 | 5-1/8 | SDJL82-#10 | 19.42 |
| 1/4 | .257 | 1/2 | 11/16 | 1/2 | 4-1/2 | 6 | SDJL82-016 | 23.66 |
| 5/16 | .320 | 5/8 | 3/4 | 5/8 | 5-3/16 | 7-1/8 | SDJL82-020 | 35.32 |
| * 3/8 | .383 | 3/4 | 7/8 | 3/4 | 3-1/8 | 5 | SDJL82-024 | 48.02 |
| *7/16 | .446 | 13/16 | 1 | 13/16 | 3-3/8 | 5-1/4 | SDJL82-028 | 54.58 |
| *1/2 | .510 | 7/8 | 1 | 7/8 | 3-1/2 | 5-1/2 | SDJL82-032 | 64.56 |

*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.

| ILLUSTRATION | TYPE OF STEP DRILL | ITEM NO. | PRICE |
|---|--------------------|-----------|--------|
| <p>6 PC STEP DRILL SET #6 to 3/8</p> | Jobber Length 45° | SDJLS45-6 | 102.58 |
| | Jobber Length 82° | SDJLS82-6 | 152.30 |
| | Jobber Length 90° | SDJLS90-6 | 127.66 |