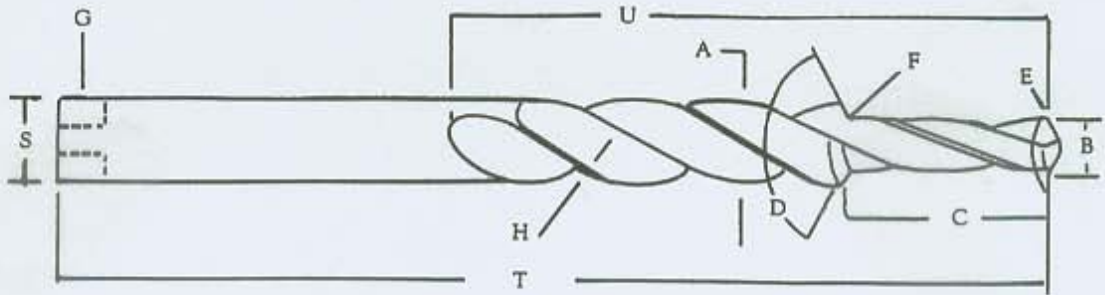


For Ordering Special Multiple-Diameter Drills



SPECIFY:

- A = Large Diameter _____
- B = Small Diameter _____
- C = Length of Step _____
- D = Included Angle _____ °
- E = Included Point Angle _____
- Type of Point = **Regular / Helical / Split**
- F = Radius _____
- G = Tang Yes _____ No _____

- H = Margin Yes _____ No _____
- S = Shank, Straight _____ Reduced Diameter _____ Length _____
- T = Overall Length _____
- U = Flute Length _____
- V = Surface Treatment* _____
- Special Markings _____

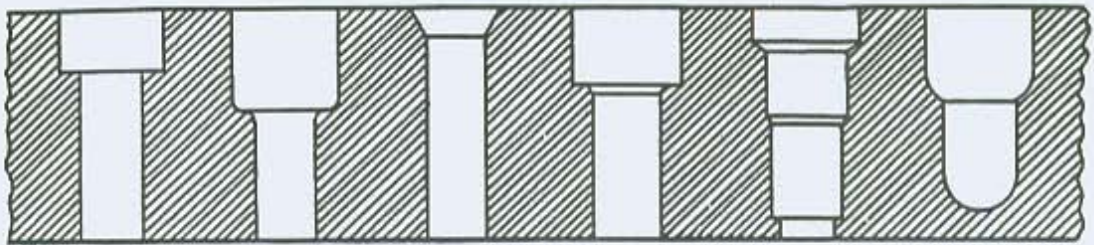
Specify whether drills are to be of high speed or cobalt steel. Advise kind of material to be drilled, and if annealed or heat-treated. Also state Brinell or Rockwell hardness if possible.

When possible send sample or sketch if available of drill wanted. Also give full particulars about the operating conditions, kind of machine being used, etc.

Step Drills



The two flute Step Drill eliminates operations by performing two operations in one production setup. They can drill and countersink, drill and counterbore or drill and drill. Double margin piloted step drills are also used for sizing of holes.



- 1. Drill and Counterbore
- 2. Drill and Radius Counterbore
- 3. Drill and Countersink
- 4. Drill, Counterbore and Chamfer
- 5. Drill and Multiple Counterbore
- 6. Radius Drill and Counterbore

Step Core Drills



Piloted Core Drills are designed to open holes 20% - 40% under their major diameter. These tools are intended for straightening and truing of holes. Although stepped core drills produce holes of good standard quality, they cannot replace reamers if high precision size and finish is required.