



INTERNATIONAL TOOL MANUFACTURING
71-08 51st Ave. Woodside, NY 11377

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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"

274MC0001
13 Steps 1/8" - 1/2"



3/16"
1/4"
5/16"
3/8"
7/16"
1/2"

274MC0002
6 Steps 3/16" - 1/2"



1/4"
5/16"
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"

274MC0003
9 Steps 1/4" - 3/4"

- ◆ HSS Step Drills
- ◆ Lobbed Non-Slip Shank
- ◆ Drill 1/8" Thick
- ◆ Double Flute
- ◆ Bright Finish

- Ferrous & Non-Ferrous Sheet Metals
- Plastic Laminates
- Sink Grade Stainless Steel
- Auto Body Repair
- Electrical
- HVAC



STEP DRILLS
ARE SOLD
INDIVIDUALLY.



3/16"
1/4"
5/16"
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
7/8"

274MC0004
12 Steps 3/16" - 7/8"



7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
7/8"
15/16"
1"
1-1/16"
1-1/8"

274MC0005
12 Steps 7/16" - 1-1/8"



3/4"
13/16"
7/8"
15/16"
1"
1-1/16"
1-1/8"
1-3/16"
1-1/4"
1-5/16"
1-3/8"

274MC0006
11 Steps 3/4" - 1-3/8"



3/8"
7/16"
3/4"

For drilling
3 standard
size holes to
accommodate
drive
screws for
knockout
punches.

274MC0007
3 Steps 3/8" - 3/4"



7/8"
1-1/8"

7/8" hole
for 1/2"
conduit.

1-1/8" hole
for 3/4"
conduit.

274MC0008
2 Steps 7/8" - 1-1/8"



7/8"
1-1/8"
1-7/32"
1-1/4"
1-3/8"

1-7/32" hole
for oil tight
switches.

274MC0009
5 Steps 7/8" - 1-3/8"

Recommended Cutting Speeds:

1/8" - 3/8"	1200RPM
3/8" - 1/2"	600 RPM
1/2" - 5/8"	400 RPM
5/8" - 3/4"	350 RPM
3/4" - 7/8"	300 RPM
1"	260 RPM
1-1/8"	240 RPM
1-1/2"	200 RPM

More accurate control of hole size in various sheet materials up to 1/8" thick. Each step bit drills a range of sizes. The further the bit advances, the larger the diameter of the hole gets. Because step drill bits enter the material one step at a time, the operator can drill the desired hole by counting the individual steps, or by using a washer as a simple stop. The self starting tip eliminates the need for pilot holes. Applications include junction boxes, switch boxes, metal studs, electrical applications, lighting fixtures, auto body work, and many other uses.



7/8"

274MC0010
1 Cone 7/8"