STEP DRILLS

CMS
Industrial Equipment Company
6112 N. Mesa St. #127, El Paso, TX 79912
Ph: 1-866-566-0222

RUKO

Step drills

The flutes of RUKO high performance step drills are CBN ground from the solid hardened form. Because CBN (cubical boron nitride) is a much harder abrasive than even silicium carbide or corundum, a better and sharper cutting edge is achieved - without burrs.

And, with higher dimensional precision the drills will last considerably longer while maintaining the precise process tolerances.

The ideal tool for sheet metal working in the following sectors of industries: electrical (size 4 + size 9), sanitary engineering and heating technics (size 6 + size 7) or automotive, mechanical engineering, aviation (size 0/5, size 0/9, size 1, size 2, size 3, size 5) and switching systems (size 0/9k, size 1k, size 2k) up to 2,0 mm sheet thickness.

This tough tool is suitable for all standard industrial materials: nonferrous metal, special steel, thermoplastics and duroplastics as well as sheet metals up to 4,0 mm thickness.

This durable and versatile tool will center, spot-drill, bore and debur - all in one smooth, high performance working cycle.

By using RUKO cutting spray or RUKO cutting paste tool life will be considerably prolonged.

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Overview of symbols

HSS — High-speed steel

HSSE Co 5 — High-speed steel with 5 % Cobalt content, ground

Shape C: split point

right hand cutting

Step angle, e.g. 90°

Shank: 3-way clamping surface

Bit shank: 6,35 mm x 27,0 mm

3 cutting edges

Point angle: 118°

Point cut: work´s specification

Ø tolerance: work´s specification

bright surface

TiAlN coating

TiN coating

Product Information

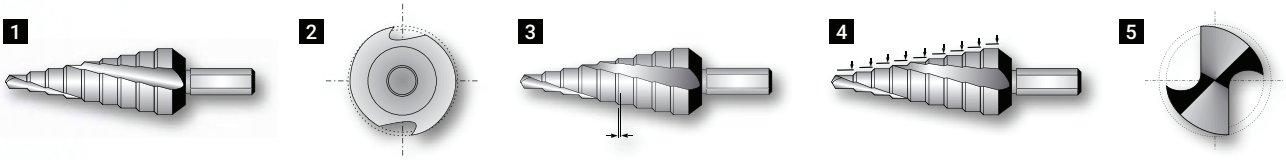
1 CBN ground flute
CBN ground spiral flutes enable very sharp and burr-free cutting edges compared to the ordinary milled flutes. Especially the chip flow is optimized, so even long, non-breaking chips will be removed easily. The optimized chip flow protects the cutting edges and reduces built-up edges and cold weld marks. Due to these special features, cutting performance and tool life are extended significantly.

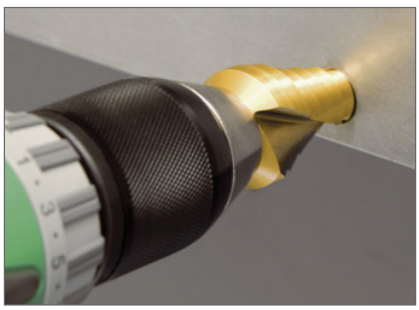
2 Radially adjusted relief produced by CBN grinding
Each step has a radially adjusted relief produced by CBN grinding that relates directly to the diameter of the step.
This means the cutting edge is always the highest point of the diameter.

3 Flute
Each step is axially CBN relief ground. This means the cutting edge is always the highest point of the axial cutting axis.

4 CBN ground relief angle
The cutting edge of each step has relief angle. This means the cutting edge is also the highest point in advance direction.

5 CBN ground bit with split point DIN 1412 C
The CBN ground bit ensures centering and spot-drilling even in thin-walled material.





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Parts and applications overview:

	Material	Surface	Shape	Point angle	Step angle	Point cut	Shank	Size no.	Article no.	Page
	HSS			118°			3	4,0 - 12,0 - 6,0 - 40,0	101 050-5 - 101 097	110
	HSSE Co 5			118°			3	4,0 - 12,0 - 6,5 - 32,5	101 050-9 E - 101 534 E	110
	HSS	TiN		118°			3	4,0 - 12,0 - 6,0 - 40,0	101 050-5 T - 101 097 T	110
	HSS	TiAlN					3	4,0 - 12,0 - 6,0 - 40,0	101 050-5 F - 101 097 F	110
	HSS			118°				4,0 - 12,0 - 4,0 - 30,0	101 050-9 H - 101 052 H	112
	HSS	TiN		118°				4,0 - 12,0 - 4,0 - 30,0	101 050-9 TH - 101 052 TH	112
	HSS			118°			3	4,0 - 12,0 - 4,0 - 30,0	101 061 - 101 063	112
	HSS			118°			3	3/16 - 1/2 - 7/8 - 1 1/8	101 701 - 101 709	113
	HSSE Co 5			118°			3	3/16 - 1/2 - 7/8 - 1 1/8	101 701 E - 101 709 E	113
	HSS	TiN		118°			3	3/16 - 1/2 - 7/8 - 1 1/8	101 701 T - 101 709 T	113
	HSS	TiAlN		118°			3	3/16 - 1/2 - 7/8 - 1 1/8	101 701 F - 101 709 F	113
	HSS			118°			3	4,0 - 12,0 - 4,0 - 30,0	101 350-9 - 101 352	114
	HSS			118°			3	5,3 - 30,5 - 6,5 - 32,5	101 090 - 101 093	115
	HSS	TiN		118°			3	5,3 - 30,5 - 6,5 - 32,5	101 090 T - 101 093 T	115
	HSS	TiAlN		118°			3	5,3 - 30,5 - 6,5 - 32,5	101 090 F - 101 093 F	115
	HSS						3	12,0 - 20,0 - 30,0 - 40,0	101 361 - 101 363	115

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■ Main application ☐ Other application

Steel (N/mm2) < 900	Steel (N/mm2) < 1100	Steel (N/mm2) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed
■				■	■	□	■	□	
■	■		■	■	■	□	■	□	
■			□		■	□	■	□	
■	■	□	□	■	■	□	■	□	
■				■	■	□	■	□	
■			□		■	□	■	□	
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■	■		■	■	■	□	■	□	
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Step drills HSS and HSSE-Co 5, CBN ground, spiral fluted with split point

The CBN ground and spiral flutes guarantee quiet running and high cutting performance.
Especially the chip flow is optimized, so even long, non-breaking chips will be removed easily.
The optimized chip flow protects the cutting edges and reduces built-up edges and cold weld marks.
The cone makes it easier to withdraw the tool from the material.

Packing unit: in plastic tubes of 1

- Cooling
- Adjust speed
- Do not press
- Step drill is pulled automatically into the plate

Steel (N/mm2) < 900	■	■	■	■
Steel (N/mm2) < 1100		■		■
Steel (N/mm2) < 1300				□
Rust-resistant steel		■	□	□
Aluminium	■	■		■

Brass	■	■	■	■
Bronze	□	□	□	□
Plastics	■	■	■	■
Cast iron	□	□	□	□
Titanium alloyed				

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	HSSE Co 5	HSS TiN	HSS TiAlN	
0/5	4,0 - 12,00	65,0	5	6,0	101 050-5	–	101 050-5 T	101 050-5 F	1
0/9	4,0 - 12,00	65,0	9	6,0	101 050-9	101 050-9 E	101 050-9 T	101 050-9 F	1
1	4,0 - 20,00	75,0	9	8,0	101 051	101 051 E	101 051 T	101 051 F	1
2	4,0 - 30,00	100,0	14	10,0	101 052	101 052 E	101 052 T	101 052 F	1
3	6,0 - 38,00	100,0	12	10,0	101 053	–	101 053 T	101 053 F	1
4	6,0 - 26,75	75,0	8	10,0	101 055	–	101 055 T	101 055 F	1
5	4,0 - 39,00	107,0	13	10,0	101 056	101 056 E	101 056 T	101 056 F	1
6	6,0 - 32,00	75,0	8	10,0	101 057	–	101 057 T	101 057 F	1
7	5,0 - 28,00	69,0	7	10,0	101 058	–	101 058 T	101 058 F	1
8	6,0 - 30,50	80,0	9	10,0	101 098	–	101 098 T	101 098 F	1
9	6,0 - 37,00	100,0	12	10,0	101 060	101 060 E	101 060 T	101 060 F	1
12	6,0 - 32,00	76,0	9	10,0	101 096	–	101 096 T	101 096 F	1
13	6,0 - 40,00	105,0	16	13,0	101 097	–	101 097 T	101 097 F	1
18	6,5 - 32,50	91,0	12	10,0	–	101 534 E	–	–	1

* straight flute

Size no.	Drilling range Ø mm
0/5	4,0 / 6,0 / 8,0 / 10,0 / 12,0
0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0
3	6,0 / 9,0 / 13,0 / 16,0 / 19,0 / 21,0 / 23,0 / 26,0 / 29,0 / 32,0 / 35,0 / 38,0
4	6,0 / 9,0 / 11,4 (PG7) / 14,0 (PG9) / 17,25 (PG11) / 19,0 (PG13,5) / 21,25 (PG16) / 26,75 (PG21)
5	4,0 / 6,0 / 12,0 / 15,0 / 18,0 / 21,0 / 24,0 / 27,0 / 30,0 / 33,0 / 36,0 / 39,0
6	6,0 / 9,0 / 11,2 (R1/8) / 14,5 (R1/4) / 18,2 (R3/8) / 22,3 (R1/2) / 27,9 (R3/4) / 32,0
7	5,0 / 8,8 (G1/8) / 11,8 (G1/4) / 15,3 (G3/8) / 19,0 (G1/2) / 24,5 (G3/4) / 28,0
8	6,0 / 9,0 / 12,5 (PG7) / 15,2 (PG9) / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 28,3 (PG21) / 30,5
9	6,0 / 9,0 / 12,5 (PG7) / 15,2 (PG9) / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 26,0 / 28,3 (PG21) / 30,5 / 34,0 / 37,0 (PG29)
12	6,0 / 9,0 / 12,0 / 16,0 / 20,0 / 22,5 / 25,0 / 28,5 / 32,0
13	6,0 / 11,0 / 17,0 / 23,0 / 29,0 / 30,0 / 31,0 / 32,0 / 33,0 / 34,0 / 35,0 / 36,0 / 37,0 / 38,0 / 39,0 / 40,0
18	6,5 / 8,5 / 10,5 / 12,7 / 15,2 (PG9) / 16,2 / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 25,5 / 28,3 (PG21) / 32,5

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■ Main application □ Other application

Step drill sets HSS and HSSE-Co 5 in steel case

	HSS	HSSE Co 5	HSS TiN	HSS TiAlN
3-piece set of step drills spiral fluted, sizes 0/9, 1, 2	101 026	101 026 E	101 026 T	101 026 F

101 026

101 026 T

101 026 F

Step drill sets HSS and HSSE-Co 5 in plastic case

	HSS	HSSE Co 5	HSS TiN	HSS TiAlN
3-piece set of step drills spiral fluted, sizes 0/9, 1, 2	101 026 RO	101 026 ERO	101 026 TRO	101 026 FRO

101 026 RO

101 026 TRO

101 026 FRO

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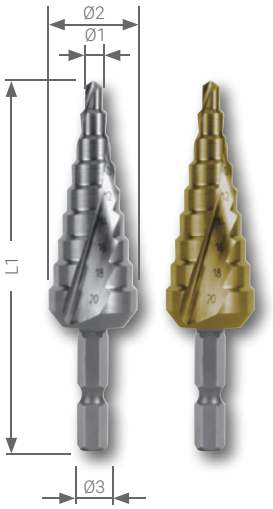
Step drills bit HSS, CBN ground, spiral fluted with split point

Packing unit: in plastic tubes of 1



Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		□
Aluminium	■	

Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	□
Titanium alloyed		

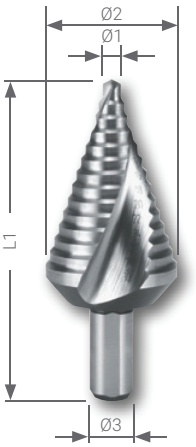
Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	Ø3 inch	HSS	HSS TiN	
0/9	4,0 - 12,00	72,0	9	6,35 x 27,0	1/4"	101 050-9 H	101 050-9 TH	1
1	4,0 - 20,00	81,0	9	6,35 x 27,0	1/4"	101 051 H	101 051 TH	1
2	4,0 - 30,00	105,0	14	6,35 x 27,0	1/4"	101 052 H	101 052 TH	1

0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0

Step drills HSS, CBN ground,spiral fluted with split point, short design

Step height 2,0 mm ideal to produce switchboards.

Packing unit: in plastic tubes of 1



Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	
0/9k	4,0 - 12,00	48,0	9	6,0	101 061	1
1k	4,0 - 20,00	58,0	9	8,0	101 062	1
2k	4,0 - 30,00	72,0	14	10,0	101 063	1

0/9k	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1k	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2k	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0

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■ Main application □ Other application

Step drills HSS and HSSE-Co 5, fractional sizes, CBN ground, spiral fluted with split point

The CBN ground and spiral flutes guarantee quiet running and high cutting performance. Especially the chip flow is optimized, so even long, non-breaking chips will be removed easily. The optimized chip flow protects the cutting edges and reduces built-up edges and cold weld marks. The cone makes it easier to withdraw the tool from the material.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	■	■
Steel (N/mm2) < 1100		■		■
Steel (N/mm2) < 1300				□
Rust-resistant steel		■	□	□
Aluminium	■	■		■

Brass	■	■	■	■
Bronze	□	□	□	□
Plastics	■	■	■	■
Cast iron	□	□	□	□
Titanium alloyed				

Size no.	Ø1 - Ø2 inch	L1 inch	Steps	Ø3 inch	HSS	HSSE Co 5	HSS TiN	HSS TiAlN	
1	3/16 - 1/2	3 1/8	6	1/4	101 701	101 701 E	101 701 T	101 701 F	1
2	1/8 - 1/2	3 1/8	13	1/4	101 702	101 702 E	101 702 T	101 702 F	1
3	1/4 - 3/4	2 3/4	9	3/8	101 703	101 703 E	101 703 T	101 703 F	1
4	3/16 - 7/8	3 1/4	12	3/8	101 704	101 704 E	101 704 T	101 704 F	1
5	5/16 - 1	3 1/4	9	3/8	101 705	101 705 E	101 705 T	101 705 F	1
6	7/8 - 1 3/8	3 1/4	5	3/8	101 706	101 706 E	101 706 T	101 706 F	1
7	3/8 - 1/2	1 7/8	2	1/4	101 707	101 707 E	101 707 T	101 707 F	1
8	7/8	2 19/32	1	3/8	101 708	101 708 E	101 708 T	101 708 F	1
9	7/8 - 1 1/8	3 7/64	2	3/8	101 709	101 709 E	101 709 T	101 709 F	1

Size no.	Drilling range Ø mm
1	3/16 - 1/4 - 5/16 - 3/8 - 7/16 - 1/2
2	1/8 - 5/32 - 3/16 - 7/32 - 1/4 - 9/32 - 5/16 - 11/32 - 3/8 - 19/32 - 3/16 - 15/32 - 1/2
3	1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4
4	3/16 - 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4 - 13/16 - 7/8
5	5/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4 - 13/16 - 7/8 - 15/16 - 1"
6	7/8 - 1 1/8 - 1 7/32 - 1 1/4 - 1 3/8
7	3/8 - 1/2
8	7/8
9	7/8 - 1 1/8

Hexagonal magnetic holder

Packing unit: in plastic tubes of 1

Description	Article no.	
Hexagonal magnetic holder	270 013	1

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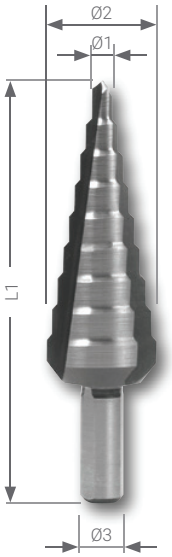
Step drills HSS, CBN ground with 3 cutting edges

The deep-ground flutes of step drills with 3 cutting edges guarantee absolutely chatter-free working. The reduced load of the cutting edges allows a higher feed rate especially for soft materials like non-ferrous metals. The cone makes it easier to withdraw the tool from the material.



Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	
0/9	4,0 - 12,00	65,0	9	6,0	101 350-9	1
1	4,0 - 20,00	75,0	9	8,0	101 351	1
2	4,0 - 30,00	100,0	14	10,0	101 352	1

0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0

Step drill sets HSS, with 3 cutting edges in steel case

Description	HSS
3-piece set of step drills with 3 cutting edges, sizes 0/9, 1, 2	101 326

101 326

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■ Main application □ Other application

Step drills HSS, CBN ground, spiral fluted with split point for metric cable connections

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100			■
Steel (N/mm2) < 1300			□
Rust-resistant steel		□	□
Aluminium	■		■

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			

Size no.	Measurements	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	HSS TiN	HSS TiAlN	
14	Core holes	5,3 - 30,5	79,0	9	10,0	101 093	101 093 T	101 093 F	1
15	Through holes	6,5 - 32,5	79,0	9	10,0	101 092	101 092 T	101 092 F	1
16	Core holes	5,3 - 38,5	96,0	11	10,0	101 091	101 091 T	101 091 F	1
17	Through holes	6,5 - 40,5	96,0	11	10,0	101 090	101 090 T	101 090 F	1

14	DIN/EN 60423	5,3 / 7,0 / 9,0 / 10,5 / 14,5 / 18,5 / 23,5 / 27,0 / 30,5
15	DIN/EN 50262	6,5 / 8,5 / 10,5 / 12,5 / 16,5 / 20,5 / 25,5 / 29,0 / 32,5
16	DIN/EN 60423	5,3 / 7,0 / 9,0 / 10,5 / 14,5 / 18,5 / 23,5 / 27,0 / 30,5 / 34,5 / 38,5
17	DIN/EN 50262	6,5 / 8,5 / 10,5 / 12,5 / 16,5 / 20,5 / 25,5 / 29,0 / 32,5 / 36,5 / 40,5

Step drills HSS without point, CBN ground

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	
20	12,0 - 20,00	66,0	9	8,0	101 361	1
30	20,0 - 30,00	78,0	11	10,0	101 362	1
40	30,0 - 40,00	78,0	11	10,0	101 363	1

20	12,0 / 13,0 / 14,0 / 15,0 / 16,0 / 17,0 / 18,0 / 19,0 / 20,0
30	20,0 / 21,0 / 22,0 / 23,0 / 24,0 / 25,0 / 26,0 / 27,0 / 28,0 / 29,0 / 30,0
40	30,0 / 31,0 / 32,0 / 33,0 / 34,0 / 35,0 / 36,0 / 37,0 / 38,0 / 39,0 / 40,0

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Table of cutting speeds for step drills

Material:		High carbon struc. steel up to 700 N/mm²	High carbon struc. steel over 700 N/mm²	Alloyed steel over 1000 N/mm²	Cast iron up to 250 N/mm²	Cast iron over 250 N/mm²	CuZn-alloy brittle	CuZn-alloy tough	Al-alloy up to 11% Si	Thermo-plastics	Duro-plastics
Sheet thickness mm:		up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Cooling lubricant:		Cutting spray	Cutting spray	Cutting spray	Air	Air	Air	Air	Cutting spray	Water	Air
Size	Ø mm	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m
0/5	4,0 - 12,0	800 - 2400	500 - 1600	500 - 1600	400 - 1200	300 - 800	1600 - 4800	900 - 2800	800 - 2400	500 - 1600	400 - 1200
0/9	4,0 - 12,0	800 - 2400	500 - 1600	500 - 1600	400 - 1200	300 - 800	1600 - 4800	900 - 2800	800 - 2400	500 - 1600	400 - 1200
1	4,0 - 20,0	500 - 2400	300 - 1600	300 - 1600	200 - 1200	200 - 800	1000 - 4800	600 - 2800	500 - 2400	300 - 1600	200 - 1200
2	4,0 - 30,0	300 - 2400	200 - 1600	200 - 1600	200 - 1200	100 - 800	600 - 4800	400 - 2800	300 - 2400	200 - 1600	200 - 1200
3	6,0 - 38,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
4	6,0 - 26,8	400 - 1600	200 - 1100	200 - 1100	200 - 800	100 - 500	700 - 3200	400 - 1900	400 - 1600	200 - 1100	200 - 800
5	4,0 - 32,0	300 - 2400	200 - 1600	200 - 1600	1200 - 100	100 - 800	600 - 4800	300 - 2800	300 - 2400	200 - 1600	100 - 1200
6	6,0 - 32,0	300 - 1600	200 - 1100	200 - 1100	800 - 100	100 - 500	600 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
7	5,0 - 28,0	300 - 1900	200 - 1300	200 - 1300	200 - 1000	100 - 600	700 - 3800	400 - 2200	300 - 1900	200 - 1300	200 - 1000
8	6,0 - 30,5	300 - 1600	200 - 1100	200 - 1100	200 - 800	100 - 500	600 - 3200	400 - 1900	300 - 1600	200 - 1100	200 - 800
9	6,0 - 37,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
10	4,8 - 10,7	900 - 2000	600 - 1300	600 - 1300	400 - 1000	300 - 700	1800 - 4000	1000 - 2300	900 - 2000	600 - 1300	400 - 1000
11	6,0 - 25,0	400 - 1600	300 - 1100	300 - 1100	200 - 800	100 - 500	800 - 3200	400 - 1900	400 - 1600	300 - 1100	200 - 800
12	6,0 - 32,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	600 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
13	6,0 - 40,0	200 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	200 - 1600	200 - 1100	100 - 800
14	5,3 - 30,5	300 - 1800	200 - 1200	200 - 1200	200 - 900	100 - 600	600 - 3600	400 - 2100	300 - 1800	200 - 1200	200 - 900
15	6,5 - 32,5	300 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	600 - 2900	300 - 700	300 - 1500	200 - 1000	100 - 700
16	5,3 - 38,5	200 - 1800	200 - 1200	200 - 1200	100 - 900	100 - 600	500 - 3600	300 - 2100	200 - 1800	200 - 1200	100 - 900
17	6,5 - 40,5	200 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	500 - 2900	300 - 1700	200 - 1500	200 - 1000	100 - 700
18	6,5 - 32,5	300 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	600 - 2900	300 - 1700	300 - 1500	200 - 1000	100 - 700
20	12,0 - 20,0	500 - 800	300 - 500	300 - 500	200 - 400	200 - 300	600 - 1600	600 - 900	500 - 800	300 - 500	200 - 400
30	20,0 - 30,0	300 - 500	200 - 300	200 - 300	200 - 200	100 - 200	600 - 1000	400 - 600	300 - 500	200 - 300	200 - 200
40	30,0 - 40,0	200 - 300	200 - 200	200 - 200	100 - 200	100 - 100	500 - 600	300 - 400	200 - 300	200 - 200	100 - 200

Size	Ø inch	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m
1	3/16 - 1/2	800 - 2000	500 - 1300	1300 - 500	400 - 1000	300 - 700	1500 - 4000	900 - 2300	800 - 2000	500 - 1300	400 - 1000
2	1/8 - 1/2	800 - 3000	500 - 2000	2000 - 500	400 - 1500	300 - 1000	1500 - 6000	900 - 3500	800 - 3000	500 - 2000	400 - 1500
3	1/4 - 3/4	500 - 1500	300 - 1000	1000 - 300	300 - 800	200 - 500	1000 - 3000	600 - 1800	500 - 1500	300 - 1000	300 - 800
4	3/16 - 7/8	400 - 2000	300 - 1300	1300 - 300	200 - 1000	100 - 700	900 - 4000	500 - 2300	400 - 2000	300 - 1300	200 - 1000
5	5/16 - 1	400 - 1200	300 - 800	800 - 300	200 - 600	100 - 400	800 - 2400	400 - 1400	400 - 1200	300 - 800	200 - 600
6	7/8 - 1 3/8	300 - 400	200 - 300	300 - 200	100 - 200	100 - 100	500 - 900	300 - 500	300 - 400	200 - 300	100 - 200
7	3/8 - 1/2	800 - 1000	500 - 700	700 - 500	400 - 500	300 - 300	1500 - 2000	900 - 1200	800 - 1000	500 - 700	400 - 500
8	7/8	400	300	300	200	100	900	500	400	300	200
9	7/8 - 1 1/8	300 - 400	200 - 300	300 - 200	200 - 200	100 - 100	700 - 900	400 - 500	300 - 400	200 - 300	200 - 200

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Table of application for step drills

Size No-	Drilling range Ø mm													
0/5	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0									
0/9	for metric hole diameters													
	Ø 4,0	Ø 5,0	Ø 6,0	Ø 7,0	Ø 8,0	Ø 9,0	Ø 10,0	Ø 11,0	Ø 12,0					
1	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0	Ø 14,0	Ø 16,0	Ø 18,0	Ø 20,0					
2	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0	Ø 14,0	Ø 16,0	Ø 18,0	Ø 20,0	Ø 22,0	Ø 24,0	Ø 26,0	Ø 28,0	Ø 30,0
3	for metric hole diameters													
	Ø 6,0	Ø 9,0	Ø 13,0	Ø 16,0	Ø 19,0	Ø 21,0	Ø 23,0	Ø 26,0	Ø 29,0	Ø 32,0	Ø 35,0	Ø 38,0		
4	for steel conduit threads (core holes)													
	PG 7 / Ø 11,4		PG 9 / Ø 14,0		PG 11 / Ø 17,25		PG 13,5 / Ø 19,0		PG 16 / Ø 21,25		PG 21 / Ø 26,75			
5	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 9,0	Ø 12,0	Ø 15,0	Ø 18,0	Ø 21,0	Ø 24,0	Ø 27,0	Ø 30,0	Ø 33,0	Ø 36,0	Ø 39,0	
6	for pipe threads (external Ø, through holes)													
	R 1/8" / Ø 11,2		R 1/4" / 14,5		R 3/8" / Ø 18,2		R 1/2" / Ø 22,3		R 3/4" / Ø 27,9					
7	for pipe threads (core holes)													
	G 1/8" / Ø 8,8		G 1/4" / 11,8		G 3/8" / Ø 15,3		G 1/2" / Ø 19,0		G 3/4" / Ø 24,5					
8	for steel conduit threads (through holes)													
	PG 7 / Ø 12,5		PG 9 / Ø 15,2		PG 11 / Ø 18,6		PG 13,5 / Ø 20,4		PG 16 / Ø 22,5		PG 21 / Ø 28,3			
9	for steel conduit threads (through holes)													
	PG 7 / Ø 12,5		PG 9 / Ø 15,2		PG 11 / Ø 18,6		PG 13,5 / Ø 20,4		PG 16 / Ø 22,5		PG 21 / Ø 28,3		PG 29 / Ø 37,0	
10	for blind rivets M3 - M4 - M5 - M6 - M8													
	Ø 4,8	Ø 6,4	Ø 7,2	Ø 9,6	Ø 10,65									
11	for metric hole diameters with high steps													
	Ø 6,0	Ø 9,0	Ø 12,0	Ø 16,0	Ø 20,0	Ø 22,5	Ø 25,0							
12	for metric hole diameters with high steps													
	Ø 6,0	Ø 9,0	Ø 12,0	Ø 16,0	Ø 20,0	Ø 22,5	Ø 25,0	Ø 28,5	Ø 32,0					
13	for metric hole diameters and large diameters													
	Ø 6,0	Ø 11,0	Ø 17,0	Ø 23,0	Ø 29,0	Ø 30,0	Ø 31,0	Ø 32,0	Ø 33,0	Ø 34,0	Ø 35,0	Ø 36,0	Ø 37,0	Ø 38,0
	Ø 39,0	Ø 40,0												
14	for metric cable connections, core holes after DIN/EN 60423													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32						
	Ø 5,3	Ø 7,0	Ø 9,0	Ø 10,5	Ø 14,5	Ø 18,5	Ø 23,5	Ø 30,5						
15	for metric cable connections, through holes after DIN/EN 50262													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32						
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,5	Ø 16,5	Ø 20,5	Ø 25,5	Ø 32,5						
16	for metric cable connections, core holes after DIN/EN 60423													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32	M 40					
	Ø 5,3	Ø 7,0	Ø 9,0	Ø 10,5	Ø 14,5	Ø 18,5	Ø 23,5	Ø 30,5	Ø 38,5					
17	for metric cable connections, through holes after DIN/EN 50262													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32	M 40					
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,5	Ø 16,5	Ø 20,5	Ø 25,5	Ø 32,5	Ø 40,5					
18	for metric cable connections / for steel conduit threads, through holes													
	M 6	M 8	M 10	M 12 / PG 7		PG 9	M 16	PG 11	M 20 / PG 13,5		PG 16	M 25	PG 21	M 32
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,7		Ø 15,2	Ø 16,2	Ø 18,6	Ø 20,4		Ø 22,5	Ø 25,5	Ø 28,3	Ø 32,5

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