

Standard Step Drills

High Speed Steel



MADE IN
USA



MICHIGAN
DRILL & CUTTING TOOLS

An essential tool for every tool room. One tool does two jobs in a single pass.
They can be sharpened repeatedly and are easily modified for any special length-of-step.

Special Step Drills available.
Please inquire.

For Drilling and Counterboring Cap Screw Clearance Holes

List No. 371 – Jobber Length

List No. 471 – Taper Length



Screw Size	Minor Diameter	Major Diameter	Step Length	Jobber Length 371			Taper Length 471		
				Flute Length	Overall Length	Price Each	Flute Length	Overall Length	Price Each
No. 4	.136	7/32	3/8	2-1/2	3-3/4	15.38	—	—	—
No. 5	.141	.228	3/8	2-5/8	3-7/8	16.17	—	—	—
No. 6	.150	1/4	1/2	2-3/4	4	17.12	3-3/4	6-1/8	23.96
No. 8	.178	"L"	1/2	2-15/16	4-1/4	19.60	4	6-3/8	35.18
No. 10	.204	"Q"	5/8	3-7/16	4-3/4	21.45	4-1/8	6-1/2	36.30
1/4	9/32	13/32	11/16	3-7/8	5-1/4	24.75	4-3/8	7	40.26
5/16	11/32	1/2	3/4	4-1/2	6	32.87	4-3/4	7-3/4	45.54
3/8	13/32	19/32	7/8	5-3/16	7-1/8	52.54	4-7/8	8-3/4	63.82
7/16	15/32	11/16	1	5-5/8	7-5/8	62.70	—	—	—
1/2	17/32	25/32	1	3-1/4	5-1/8*	86.46	6	9-7/8	95.30
5/8	21/32	31/32	1	3-7/8	5-7/8*	115.50	6-3/8	11	127.78

*Shorter than Jobber Length.

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

List No. 372 – Jobber Length



Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Price Each
No. 4	.116	15/64	3/8	2-5/8	3-7/8	16.58
No. 5	.128	F	3/8	2-7/8	4-1/8	17.34
No. 6	.142	9/32	1/2	2-15/16	4-1/4	18.15
No. 8	.169	Q	1/2	3-7/16	4-3/4	21.44
No. 10	.196	W	5/8	3-3/4	5-1/8	23.41

Screw Size	Minor Diameter	Major Diameter	Step Length	Flute Length	Overall Length	Price Each
1/4	.257	1/2	11/16	4-1/2	6	28.97
5/16	.320	5/8	3/4	5-3/16	7-1/8	45.42
3/8	.383	3/4	7/8	3-1/8	5*	62.93
7/16	.446	13/16	1	3-3/8	5-1/4*	81.97
1/2	.510	7/8	1	3-1/2	5-1/2*	90.45

*Shorter than Jobber Length.

For Drilling 45° Chamfered Holes To-Be-Tapped (To produce approx. 70% thread)

List No. 370 – Jobber Length

List No. 470 – Taper Length



Screw Size	Minor Diameter	Major Diameter	Step Length	Jobber Length 370			Taper Length 470		
				Flute Length	Overall Length	Price Each	Flute Length	Overall Length	Price Each
4-40	.089	.1285	3/8	1-5/8	2-3/4	14.55	3	5-3/8	21.82
5-40	.101	9/64	1/2	1-3/4	2-7/8	15.31	3	5-3/8	22.90
6-32	.109	5/32	1/2	2	3-1/8	15.50	3	5-3/8	23.41
8-32	.136	3/16	1/2	2-5/16	3-1/2	15.88	3-3/8	5-3/4	23.60
8-36	.136	3/16	1/2	2-5/16	3-1/2	16.13	3-3/8	5-3/4	24.04
10-24	.152	1/4	5/8	2-3/4	4	16.89	3-3/4	6-1/8	26.50
10-32	.161	1/4	5/8	2-3/4	4	16.89	3-3/4	6-1/8	26.50
12-24	.179	9/32	11/16	2-15/16	4-1/4	19.61	—	—	—
1/4-20	.204	21/64	13/16	3-5/16	4-5/8	20.81	4-1/8	6-1/2	30.02
1/4-28	.218	21/64	13/16	3-5/16	4-5/8	21.19	4-1/8	6-1/2	30.68
5/16-18	.261	13/32	15/16	3-7/8	5-1/4	23.72	4-3/8	7	33.65
5/16-24	.272	13/32	15/16	3-7/8	5-1/4	24.04	4-3/8	7	34.47
3/8-16	.316	31/64	1	4-3/8	5-7/8	31.37	4-3/4	7-3/4	48.71
3/8-24	.339	31/64	1	4-3/8	5-7/8	31.94	4-3/4	7-3/4	48.71
7/16-14	.375	17/32	1-1/16	4-13/16	6-5/8	54.68	4-3/4	8	59.84
7/16-20	.390	17/32	1-1/16	4-13/16	6-5/8	54.68	4-3/4	8	59.84
1/2-13	.437	5/8	1-1/16	5-3/16	7-1/8	63.13	4-7/8	8-3/4	72.74
1/2-20	.452	5/8	1-1/16	5-3/16	7-1/8	63.89	4-7/8	8-3/4	72.74
5/8-11	.531	3/4	1-1/16	5-5/8	7-5/8	79.57	—	—	—