

POWER TOOLS

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3-Flat Shank 19RK78



3-Flat Shank Without Point 783YM4



3-Flat Shank Tube & Sheet Drill Bit 783YG2



**Tube & Sheet Set
783YJ6**



IRWIN *Milwaukee* **LENEX**

Step Drill Bits

These cone-shaped drill bits have steps of increasing diameter marked along their cutting head and allow for a range of different sized holes with a single bit. As the bit is pushed into a piece of sheet metal or other thin material each step on the bit widens the hole. They have a self-starting split point, except 3-Flat Shank Step Drill Without Point bits, that prevents the bits from moving or walking when starting to drill. Suitable for drilling thin materials up to 1/8" thick.

3-Flat Shank Step Drill Bits—Have shanks with three flats that help prevent the bits from slipping in the drill chuck during drilling.

3-Flat Shank Step Drill Without Point

Bits have no self-starting point and require a starter hole before drilling.

Hex-Shank Impact-Rated Step Drill Bits—Have a hex shank and install into impact drills with standard three-jaw chucks.

Number Hole Size	Size Range	Step Increments	Shank Diameter	Maximum Drilling Depth	Overall Length	Brand	Item No.
3-Flat Shank Step Drill Bits							
Cobalt, Black Oxide Finish							
2	1/8 in to 1 1/8 in	1/4 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	2CJR7
12	3/8 in to 7/8 in	1/8 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	2CJR6
Cobalt Alloy Steel, Black Oxide Finish							
8	3/8 in to 1 1/4 in	1/8 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	2CJR8
9	1/4 in to 3/4 in	1/8 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	2CJR5
High Speed Steel, Black Oxide Finish							
1	1/8 in	3/32 in	3/8 in	—	1 13/16 in	IRWIN	4A951
	1/8 in to 1 1/8 in	3/4 in	1/8 in	—	2 3/4 in	Milwaukee	19RK78
	1 1/8 in	5/32 in	7/8 in	—	2 13/16 in	IRWIN	4A952
2	3/8 in to 1/2 in	1/16 in	1/4 in	—	2 in	Milwaukee	19RK77
	1/2 in to 1 1/8 in	1/4 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	4XK52
	7/8 in to 1 1/4 in	1/4 in	3/8 in	1 in	2 3/4 in	LENOX	4XL28
	7/8 in to 1 1/4 in	3/4 in	3/8 in	—	2 15/16 in	Milwaukee	19RK80
3	1/2 in to 1 1/8 in	3/8 in	3/8 in	4.5 mm	2 3/8 in	Westward	6EXN6
	1 1/2 in to 1 3/2 in	3/2 in	1/4 in	—	3 in	Milwaukee	19RK81
5	7/8 in to 1 3/8 in	3/16 in	1/4 in	—	3 1/8 in	Milwaukee	19RK82
	7/8 in to 1 3/8 in	3/8 in	3/8 in	1 in	—	LENOX	761Y44
6	3/4 in to 1 1/2 in	1/16 in	1/4 in	—	3 1/8 in	Milwaukee	19RK73
	3/4 in to 1 1/2 in	1/8 in	1 in	3 1/8 in	—	LENOX	4XL25
7	6 mm to 18 mm	2 mm	3/8 in	3.5 mm	2 1/2 in	IRWIN	21Y395
8	3/8 in to 1 in	1/16 in	3/8 in	1 1/8 in	2 1/8 in	IRWIN	4A947
	1/4 in to 3/4 in	1/16 in	3/8 in	—	2 1/8 in	Milwaukee	19RK74
	1/4 in to 3/4 in	1/8 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	4A948
9	1/2 in to 1 in	1/16 in	1/4 in	—	3 1/4 in	Milwaukee	19RK79
	1 1/2 in to 1 in	1/16 in	3/8 in	1 in	3 in	LENOX	4XL23
	4 mm to 12 mm	1 mm	1/4 in	65 mm	2 9/16 in	Milwaukee	48UT19
	4 mm to 20 mm	2 mm	3/8 in	65 mm	2 9/16 in	Milwaukee	48UT21
	7 mm to 28.3 mm	1/16 in	3/8 in	—	2 11/16 in	Milwaukee	48UT22
10	1/4 in to 1 3/8 in	1/16 in	3/8 in	1 1/8 in	3 1/8 in	IRWIN	3UMJ7
	1/4 in to 1 3/8 in	1/8 in	3/8 in	4 mm	3 in	Westward	6EXN5
	1/4 in to 1 3/8 in	1/8 in	3/8 in	—	3 in	Milwaukee	19RK76
	1 1/8 in to 1 3/8 in	1/16 in	1/8 in	1 1/8 in	2 11/16 in	IRWIN	38BR34
12	3/4 in to 1 1/8 in	1/16 in	3/8 in	—	2 15/16 in	Milwaukee	19RK75
	3/4 in to 1 1/8 in	1/8 in	3/8 in	1 1/8 in	2 1/8 in	IRWIN	6A922
	3/4 in to 1 1/8 in	1/16 in	3/8 in	3.5 mm	2 1/8 in	Westward	6EXN4
	1 1/8 in to 1 1/2 in	3/32 in	1/4 in	—	3 1/8 in	Milwaukee	19RK72
13	1 1/8 in to 1 1/2 in	1/32 in	1/4 in	1 in	3 in	LENOX	4XL22
	1 1/8 in to 1 1/2 in	1/32 in	1/4 in	3.4 mm	2 7/8 in	Westward	6EXN3
	5 mm to 32.5 mm	1/16 in	3/8 in	—	3 11/16 in	Milwaukee	48UT23
	5 mm to 35 mm	2 mm	3/8 in	1 1/8 in	3 in	IRWIN	41GR89
15	6 mm to 35 mm	1/16 in	3/8 in	—	3 3/8 in	Milwaukee	48UT24

Number Hole Sizes	Size Range	Step Increments	Shank Diameter	Maximum Drilling Depth	Overall Length	Brand	Item No.
High Speed Steel, Bright (Uncoated) Finish							
2	1/8 in to 1 1/8 in	3/4 in	3/8 in	—	2 7/8 in	Milwaukee	780U06
5	1/8 in to 1 3/8 in	1/8 in	3/8 in	3 1/4 in	3 3/4 in	Westward	19N141
	1/4 in to 3/4 in	1/8 in	3/8 in	2 3/4 in	2 3/4 in	Westward	19N124
9	1/2 in to 1 in	1/8 in	3/8 in	3 1/4 in	3 1/4 in	Westward	19N142
	3/8 in to 7/8 in	1/8 in	3/8 in	—	2 3/8 in	Milwaukee	780U05
12	3/8 in to 1 1/8 in	1/8 in	3/8 in	3 1/4 in	3 1/4 in	Westward	19N127
13	1/8 in to 1 1/8 in	1/2 in	3/8 in	—	2 15/16 in	Milwaukee	780U04
High Speed Steel, TiN Finish							
9	1/4 in to 3/4 in	1/8 in	3/8 in	1 1/8 in	2 1/2 in	IRWIN	4XK68
12	3/8 in to 1 1/8 in	1/8 in	3/8 in	1 1/8 in	2 7/8 in	IRWIN	4XK69
3 Flat Shank Step Drill Without Point							
High Speed Steel, Bright (Uncoated) Finish							
9	12 mm to 20 mm	—	8 mm	12 mm	66 mm	Ruko Tools	783YM1
11	20 mm to 30 mm	—	10 mm	20 mm	78 mm	Ruko Tools	783YM3
	30 mm to 40 mm	—	10 mm	30 mm	78 mm	Ruko Tools	783YM4
High Speed Steel, TiN Finish							
9	12 mm to 20 mm	—	8 mm	12 mm	66 mm	Ruko Tools	783YM2
3 Flat Shank Tube & Sheet Drill Bits							
Cobalt, Bright (Uncoated) Finish							
2	1/8 in to 3/8 in	—	6 mm	3/8 in	58 mm	Ruko Tools	783YG2
	3/8 in to 1 3/8 in	—	9 mm	3/8 in	76 mm	Ruko Tools	783YG8
	1 3/8 in to 1 9/16 in	—	10 mm	1 3/8 in	89 mm	Ruko Tools	783YH1
High Speed Steel, Bright (Uncoated) Finish							
2	1/8 in to 3/8 in	—	6 mm	3/8 in	58 mm	Ruko Tools	783YG1
	3/8 in to 1 3/8 in	—	8 mm	3/8 in	71 mm	Ruko Tools	783YG4
	1 3/8 in to 1 7/8 in	—	8 mm	3/8 in	79 mm	Ruko Tools	783YK3
	1 3/8 in to 1 7/8 in	—	8 mm	3/8 in	79 mm	Ruko Tools	783YJ7
	1 3/8 in to 1 1/2 in	—	10 mm	3/8 in	87 mm	Ruko Tools	783YH6
	1 13/16 in to 2 in	—	12 mm	1 13/16 in	97 mm	Ruko Tools	783YH4
	1 3/8 in to 2 3/8 in	—	13 mm	1 3/8 in	103 mm	Ruko Tools	783YH4
High Speed Steel, TiAlN Finish							
2	1 3/8 in to 1 1/2 in	—	9 mm	3/8 in	103 mm	Ruko Tools	783YN2
High Speed Steel, TiN Finish							
2	1/8 in to 3/8 in	—	6 mm	3/8 in	58 mm	Ruko Tools	783YG3
	3/8 in to 1 3/8 in	—	8 mm	3/8 in	79 mm	Ruko Tools	783YJ8
	1 3/8 in to 1 1/2 in	—	9 mm	3/8 in	103 mm	Ruko Tools	783YJ0
	1 3/8 in to 1 1/2 in	—	10 mm	3/8 in	87 mm	Ruko Tools	783YJ7
	3/8 in to 1 3/8 in	—	9 mm	3/8 in	76 mm	Ruko Tools	783YJ9
	1 3/8 in to 1 3/8 in	—	10 mm	1 3/8 in	89 mm	Ruko Tools	783YH2
	1 3/8 in to 2 3/8 in	—	13 mm	1 3/8 in	103 mm	Ruko Tools	783YH5
Hex-Shank Impact-Rated Step Drill Bits							
Cobalt Alloy Steel, Black Oxide Finish							
6	1/8 in to 1/2 in	1/8 in	—	3/8 in	3 1/4 in	IRWIN	2CJR4
13	1/8 in to 1/2 in	1/2 in	—	1/8 in	3 3/8 in	IRWIN	2CJR3
High Speed Steel, Black Oxide Finish							
1	—	1/2 in	3/2 in	—	1 3/8 in	IRWIN	4A950
6	3/8 in to 1/2 in	1/8 in	—	3/8 in	3 1/4 in	IRWIN	4A949
10	4 mm to 22 mm	2 mm	3/8 in	3.5 mm	2 15/16 in	IRWIN	21Y397
13	1/8 in to 1/2 in	1/2 in	—	1/8 in	3 3/8 in	IRWIN	4A946
27	3/8 in to 1/2 in	1/8 in	3/8 in	1/8 in, 3/8 in, 3/4 in	2 1 1/16 in, 2 7/8 in, 3 1/4 in	IRWIN	4XK67
High Speed Steel, TiAlN Finish							
2	1/8 in to 1 1/8 in	3/4 in	1/4 in	—	3 3/4 in	Milwaukee	492R88
6	3/8 in to 1/2 in	1/8 in	1/4 in	—	3 3/8 in	Milwaukee	492R84
9	1/8 in to 1 in	1/4 in	1/4 in	—	3 3/8 in	Milwaukee	492R87
10	3/8 in to 3/4 in	3/4 in	1/4 in	—	3 3/4 in	Milwaukee	492R85
12	3/8 in to 7/8 in	1/8 in	1/4 in	—	3 3/8 in	Milwaukee	492R86
13	1/8 in to 1/2 in	1/2 in	1/4 in	—	3 1/8 in	Milwaukee	492R83
High Speed Steel, TiN Finish							
10	4 mm to 22 mm	2 mm	3/8 in	3.5 mm	2 15/16 in	IRWIN	21Y402
13	1/8 in to 1/2 in	1/2 in	—	1/8 in	3 3/8 in	IRWIN	4XK66
High Speed Steel, Titanium Nitride Coating Finish							
2	1/8 in to 1 1/8 in	3/4 in	1/4 in	1 in	3 3/8 in	DeWalt	34D733
6	3/8 in to 1/2 in	1/8 in	1/4 in	1 in	3 1/2 in	DeWalt	34D731
12	3/8 in to 1 1/8 in	1/8 in	1/4 in	1 in	3 3/8 in	DeWalt	34D732
13	1/8 in to 1/2 in	1/2 in	1/4 in	1 in	3 3/8 in	DeWalt	34D730
Number Hole Sizes							
Size Range							
Brand							
Item No.							
Step Drill Bit Sets							
Cobalt Alloy Steel, Black Oxide Finish							
17	1/8 in to 3/4 in					IRWIN	2CJR9
High Speed Steel, Black Oxide Finish							
12	3/8 in to 1 1/8 in					Milwaukee	451N44
16	1/8 in to 1 1/8 in					Milwaukee	451N45
17	1/8 in to 3/4 in					IRWIN	41GR65
17	1/8 in to 7/8 in					Milwaukee	780U07
20	1/2 in to 1 1/8 in, 1/8 in to 1/2 in, 3/8 in to 7/8 in					Westward	6EXN2
21	1/8 in to 1 in					LENOX	4XL29
22	1/8 in to 1 3/8 in					LENOX	4XLM5
31	3/8 in to 1 3/8 in					Milwaukee	19RK04
31	1/8 in to 7/8 in					Milwaukee	19RK83
32	4 mm to 35 mm					Milwaukee	48UT25
39	1/8 in to 1 1/8 in					Milwaukee	19RK85
41	1/8 in to 1/2 in, 1 3/8 in to 1 3/8 in, 3/8 in to 1/2 in, 3/8 in to 1 3/8 in					IRWIN	3YDW5
High Speed Steel, TiAlN Finish							
24	1/8 in to 1 in					Milwaukee	492R90
27	1/8 in to 1 1/8 in					Milwaukee	492R91
31	1/8 in to 3/8 in					Milwaukee	492R89
High Speed Steel, TiN Finish							
17	1/4 in to 3/4 in, 1/8 in to 1/2 in, 3/8 in to 1 1/8 in					IRWIN	4XKT3
High Speed Steel, Titanium Nitride Coating Finish							
31	1/8 in to 7/8 in					DeWalt	34D734
Tube & Sheet Drill Bit Sets							
High Speed Steel, Bright (Uncoated) Finish							
6	1/8 in to 1 3/8 in					Ruko Tools	783YJ4
High Speed Steel, TiN Finish							
6	1/8 in to 1 3/8 in					Ruko Tools	783YJ6
6	3 mm to 30.5 mm					Ruko Tools	783YJ5