



**3-Flat Shank  
19RK78**



**3-Flat Shank  
Without Point  
783YM4**



**3-Flat Shank Tube &  
Sheet Drill Bit  
783YG2**



**Tube & Sheet Set  
783YJ6**

**Hex-Shank  
Impact Rated  
2CJR4**



**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 Sizes	Size Range	Step Increments	Shank Diameter	Maximum Drilling Depth	Overall Length	Brand	Item No.
<b>3-Flat Shank Step Drill Bits</b>							
<b>Cobalt, Black Oxide Finish</b>							
2	1/8 in to 1 1/8 in	1/4 in	3/8 in	1/2 in	2 1/2 in	IRWIN	2CJR7
8	3/16 in to 1 in	1/16 in	3/8 in	1/2 in	2 1/2 in	IRWIN	2CJR8
9	1/4 in to 3/4 in	1/16 in	3/8 in	1/2 in	2 1/2 in	IRWIN	2CJR5
12	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in	2 1/2 in	IRWIN	2CJR6
<b>High Speed Steel, Black Oxide Finish</b>							
1	1/8 in	3/32 in	3/8 in	—	1 1/16 in	IRWIN	4A951
	1/8 in to 1 1/8 in	3/4 in	1/4 in	—	2 3/16 in	Milwaukee	19RK78
	1 1/8 in	3/32 in	3/8 in	—	2 1/16 in	IRWIN	4A952
2	3/8 in to 1/2 in	1/16 in	1/4 in	—	2 in	Milwaukee	19RK77
	7/8 in to 1 1/8 in	1/4 in	3/8 in	1/2 in	2 1/2 in	IRWIN	4KX52
	7/8 in to 1 1/2 in	1/4 in	3/8 in	1 in	2 3/4 in	LENOX	4XL28
3	7/8 in to 1 1/8 in	1/4 in	3/8 in	—	2 1/16 in	Milwaukee	19RK80
	1/2 in to 1 1/8 in	3/8 in	1 in	4.5 mm	2 1/2 in	Westward	6EXN6
	1/2 in to 1 1/2 in	1/32 in	1/4 in	—	3 in	Milwaukee	19RK81
5	7/8 in to 1 3/8 in	3/16 in	1/4 in	—	3 1/16 in	Milwaukee	19RK82
	7/8 in to 1 3/8 in	3/16 in	3/8 in	1 in	—	LENOX	761Y44
	3/16 in to 1/2 in	1/16 in	1/4 in	—	3 1/16 in	Milwaukee	19RK73
6	3/16 in to 1/2 in	1/16 in	1/4 in	1 in	3 1/8 in	LENOX	4XL25
	3/16 in to 1/2 in	1/16 in	1/4 in	1 in	3 1/8 in	LENOX	4XL25
	6 mm to 18 mm	2 mm	3/8 in	3.5 mm	2 1/2 in	IRWIN	21Y395
8	3/16 in to 1 in	1 mm	3/8 in	1/2 in	2 1/2 in	IRWIN	4A947
	1/4 in to 3/4 in	1/16 in	3/8 in	—	2 3/16 in	Milwaukee	19RK74
	1/4 in to 3/4 in	1/16 in	3/8 in	1/2 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
	1/2 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 1/4 in	Milwaukee	48UT19
10	4 mm to 20 mm	2 mm	3/8 in	65 mm	2 1/4 in	Milwaukee	48UT21
	7 mm to 28.3 mm	1 mm	3/8 in	—	2 1/16 in	Milwaukee	48UT22
	1/4 in to 1 3/8 in	1/16 in	3/8 in	1/2 in	3 1/8 in	IRWIN	3UMJ7
12	1/4 in to 1 3/8 in	1/16 in	3/8 in	4 mm	3 in	Westward	6EXN5
	1/4 in to 1 3/8 in	1/16 in	3/8 in	3 in	3 in	Milwaukee	19RK76
	13/16 in to 1 3/8 in	1/16 in	3/8 in	1/2 in	2 1/16 in	IRWIN	388R34
13	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in	2 1/8 in	Milwaukee	19RK75
	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in	2 1/8 in	IRWIN	6A922
	3/16 in to 1/2 in	1/16 in	3/8 in	3.5 mm	2 1/8 in	Westward	6EXN4
15	1/8 in to 1/2 in	1/32 in	1/4 in	—	3 1/8 in	Milwaukee	19RK72
	1/8 in to 1/2 in	1/32 in	1/4 in	1 in	3 in	LENOX	4XL22
	1/8 in to 1/2 in	1/32 in	1/4 in	3.4 mm	2 1/8 in	Westward	6EXN3
15	5 mm to 32.5 mm	1 mm	3/8 in	—	3 1/16 in	Milwaukee	48UT23
	5 mm to 35 mm	2 mm	3/8 in	1/2 in	3 in	IRWIN	41GR89
	6 mm to 35 mm	1 mm	3/8 in	—	3 9/16 in	Milwaukee	48UT24

Number Hole Sizes	Size Range	Step Increments	Shank Diameter	Maximum Drilling Depth	Overall Length	Brand	Item No.
<b>High Speed Steel, Bright (Uncoated) Finish</b>							
2	1/8 in to 1 1/8 in	1/4 in	3/8 in	—	2 1/2 in	Milwaukee	780U06
5	1/8 in to 1 3/8 in	1/16 in	3/8 in	3 1/4 in	3 1/4 in	Westward	19N141
9	1/4 in to 1 in	1/16 in	3/8 in	2 3/4 in	2 3/4 in	Westward	19N124
12	1/2 in to 1 in	1/16 in	3/8 in	3 1/4 in	3 1/4 in	Westward	19N142
	3/16 in to 1/2 in	1/16 in	3/8 in	—	2 5/8 in	Milwaukee	780U05
13	3/16 in to 1/2 in	1/16 in	3/8 in	3 1/4 in	3 1/4 in	Westward	19N127
13	1/8 in to 1/2 in	1/32 in	3/8 in	—	2 15/16 in	Milwaukee	780U04
<b>High Speed Steel, TIN Finish</b>							
9	1/4 in to 3/4 in	1/16 in	3/8 in	1/2 in	2 1/2 in	IRWIN	4XK68
12	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in	2 1/2 in	IRWIN	4XK69
<b>3 Flat Shank Step Drill Without Point</b>							
<b>High Speed Steel, Bright (Uncoated) Finish</b>							
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
<b>High Speed Steel, TIN Finish</b>							
9	12 mm to 20 mm	—	8 mm	12 mm	66 mm	Ruko Tools	783YM2
<b>3 Flat Shank Tube &amp; Sheet Drill Bits</b>							
<b>Cobalt, Bright (Uncoated) Finish</b>							
2	1/8 in to 3/8 in	—	6 mm	9/16 in	58 mm	Ruko Tools	783YG2
	3/8 in to 1 3/8 in	—	9 mm	3/4 in	76 mm	Ruko Tools	783YG8
	13/16 in to 1 1/8 in	—	10 mm	15/16 in	89 mm	Ruko Tools	783YH1
<b>High Speed Steel, Bright (Uncoated) Finish</b>							
2	1/8 in to 3/8 in	—	6 mm	9/16 in	58 mm	Ruko Tools	783YG1
	5/32 in to 3/8 in	—	8 mm	5/32 in	71 mm	Ruko Tools	783YG4
	13/64 in to 7/8 in	—	8 mm	3/8 in	79 mm	Ruko Tools	783YK3
	13/64 in to 7/8 in	—	8 mm	9/16 in	79 mm	Ruko Tools	783YJ7
	13/64 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 1/16 in	97 mm	Ruko Tools	783YN4
1 9/16 in to 2 3/8 in	—	13 mm	1 9/16 in	103 mm	Ruko Tools	783YH4	
<b>High Speed Steel, TiAlN Finish</b>							
2	13/64 in to 1 1/2 in	—	9 mm	3/8 in	103 mm	Ruko Tools	783YN2
<b>High Speed Steel, TIN Finish</b>							
2	1/8 in to 3/8 in	—	6 mm	9/16 in	58 mm	Ruko Tools	783YG3
	13/64 in to 7/8 in	—	8 mm	3/8 in	79 mm	Ruko Tools	783YJ8
	13/64 in to 1 1/2 in	—	9 mm	3/8 in	103 mm	Ruko Tools	783YJ0
	13/64 in to 1 1/2 in	—	10 mm	3/8 in	87 mm	Ruko Tools	783YH7
	3/8 in to 1 3/8 in	—	9 mm	3/8 in	76 mm	Ruko Tools	783YG9
	13/16 in to 1 1/8 in	—	10 mm	15/16 in	89 mm	Ruko Tools	783YH2
1 9/16 in to 2 3/8 in	—	13 mm	1 9/16 in	103 mm	Ruko Tools	783YH5	
<b>Hex-Shank Impact-Rated Step Drill Bits</b>							
<b>Cobalt, Black Oxide Finish</b>							
6	3/16 in to 1/2 in	1/16 in	—	3/8 in	3 1/4 in	IRWIN	2CJR4
13	1/8 in to 1/2 in	1/32 in	—	1/2 in	3 3/8 in	IRWIN	2CJR3
<b>High Speed Steel, Black Oxide Finish</b>							
1	1/2 in	3/32 in	—	1 in	2 1/4 in	LENOX	761Y43
	3/8 in	1/16 in	—	1 1/2 in	4 9/16 in	IRWIN	4A950
6	3/16 in to 1/2 in	1/16 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	1/32 in	—	1/2 in	3 3/8 in	IRWIN	4A946
27	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in, 3/8 in	2 1/16 in, 3 1/4 in	IRWIN	4XK67
	3/16 in to 1/2 in	1/16 in	3/8 in	1/2 in	3 1/4 in	IRWIN	4XK67
<b>High Speed Steel, TiAlN Finish</b>							
2	1/8 in to 1 1/8 in	3/4 in	1/4 in	—	3 3/4 in	Milwaukee	492R88
6	3/16 in to 1/2 in	1/16 in	1/4 in	—	3 5/8 in	Milwaukee	492R84
9	1/8 in to 1 in	1/16 in	1/4 in	—	3 7/8 in	Milwaukee	492R87
10	3/16 in to 3/4 in	3/4 in	1/4 in	—	3 1/4 in	Milwaukee	492R85
12	3/16 in to 7/8 in	1/16 in	1/4 in	—	3 5/8 in	Milwaukee	492R86
13	1/8 in to 1/2 in	1/32 in	1/4 in	—	3 1/8 in	Milwaukee	492R83
<b>High Speed Steel, TIN Finish</b>							
2	1/8 in to 1 1/8 in	3/4 in	1/4 in	1 in	3 3/8 in	DeWalt	34D733
6	3/16 in to 1/2 in	1/16 in	1/4 in	1 in	3 3/8 in	DeWalt	34D731
10	4 mm to 22 mm	2 mm	3/8 in	3.5 mm	2 15/16 in	IRWIN	21Y402
12	3/16 in to 7/8 in	1/16 in	1/4 in	1 in	3 3/8 in	DeWalt	34K732
13	1/8 in to 1/2 in	1/32 in	1/4 in	1 in	3 3/8 in	IRWIN	4XB66
13	1/8 in to 1/2 in	1/32 in	1/4 in	1 in	3 3/8 in	DeWalt	34D730
<b>Number Hole Sizes</b>							
<b>Step Drill Bit Sets</b>							
<b>Cobalt, Black Oxide Finish</b>							
17	1/8 in to 3/4 in	—	—	—	—	IRWIN	2CJR9
<b>High Speed Steel, Black Oxide Finish</b>							
12	3/16 in to 1 1/8 in	—	—	—	—	Milwaukee	451N44
16	7/8 in to 1 3/8 in	—	—	—	—	Milwaukee	451N45
17	1/8 in to 1 1/8 in	—	—	—	—	IRWIN	41GR65
17	1/8 in to 1 1/8 in	—	—	—	—	Milwaukee	780U07
20	1/2 in to 1 1/8 in, 1/2 in to 1 in, 3/8 in to 1 1/8 in	—	—	—	—	Westward	6EXN2
21	1/8 in to 1 in	—	—	—	—	LENOX	4XL29
22	1/8 in to 1 3/8 in	—	—	—	—	LENOX	2LML6
31	1/8 in to 1 3/8 in	—	—	—	—	Milwaukee	19RK84
31	1/8 in to 1 3/8 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 1/2 in, 13/16 in to 1 3/8 in, 3/8 in to 1 1/2 in, 3/8 in to 1 1/8 in	—	—	—	—	IRWIN	3YDW5
<b>High Speed Steel, TiAlN Finish</b>							
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 1 1/8 in	—	—	—	—	Milwaukee	492R89
<b>High Speed Steel, TIN Finish</b>							
17	1/4 in to 3/4 in, 1/2 in to 1 1/2 in, 3/8 in to 1 1/2 in	—	—	—	—	IRWIN	4XK73
31	1/8 in to 1 1/8 in	—	—	—	—	DeWalt	34D734
<b>Tube &amp; Sheet Drill Bit Sets</b>							
<b>High Speed Steel, Bright (Uncoated) Finish</b>							
6	1/8 in to 1 1/8 in	—	—	—	—	Ruko Tools	783YJ4
<b>High Speed Steel, TIN Finish</b>							
6	1/8 in to 1 3/8 in	—	—	—	—	Ruko Tools	783YJ6
6	3 mm to 30.5 mm	—	—	—	—	Ruko Tools	783YJ5