

MULTICUT[®]

HIGH SPEED STEEL STEP DRILLS

Designed for industrial applications, each step produces accurate, parallel holes with a small clearance on the nominal diameter.

The maximum material thickness is determined by the length of step
(If the work piece can be reversed multiply thickness by 2).

For use in industrial power tools or pedestal drilling machines.



HIGH SPEED STEEL STEP DRILLS

METRIC

The most comprehensive range of Step Drills for all applications. Below is listed our current standard stock range - please enquire for other sizes.



When drilling metals always use cutting compound - available in 30cc, 60cc and 1/2 kilo sizes.

TOOL NO	DRILL SIZE IN MILLIMETRES	MAX MATERIAL THICKNESS	SHANK TO FIT CHUCK SIZE	DRILLING SPEEDS RPM	
				FERROUS	NON-FERROUS
MC 1M	4 5 6 7 8 9 10 11 12	5mm	6.5mm	400-800	900-2000
MC 2M	10 11 12 13 14 15 16 17 18 19 20	4mm	10mm	200-600	500-1500
MC 3M	20 21 22 23 24 25 26 27 28 29 30	4mm	13mm	150-400	400-1000
MC 3MS	20 21 22 23 24 25 26 27 28 29 30	4mm	10mm	150-400	400-1000
MC 4M	4 6 8 10 12	10mm	6.5mm	400-800	900-2000
MC 5M	6 8 10 12 14 16 18 20 22 24	5mm	10mm	150-400	400-1000
MC 6M	6 8 10 12 14 16 18	5mm	10mm	200-600	500-1500
MC 7M	4 6 8 10 12 14 16 18 20	4mm	10mm	200-600	500-1500
MC 8M	+14 16 18 20 22 24	5mm	10mm	150-400	400-1000
MC 9M	+20 22 24 26 28 30 32 34	5mm	10mm	150-300	300-800
MC 10M	4 6 8 10 12 14 16 18 20 22 24 26 28 30	4mm	13mm	150-400	400-1000
MC 10MS	4 6 8 10 12 14 16 18 20 22 24 26 28 30	4mm	10mm	150-400	400-1000
MC 11M	4 6 8 10 12 14 16 18 20 22	5mm	10mm	150-400	400-1000
MC 535	5 7.5 10 13 16 19 21 23 26 29 31 33 35	3.5mm	13mm	100-300	300-700
MC 535S	5 7.5 10 13 16 19 21 23 26 29 31 33 35	3.5mm	10mm	100-300	300-700

+ Pilot hole required

IMPERIAL

TOOL NO	DRILL SIZE IN INCHES	MAX MATERIAL THICKNESS	SHANK TO FIT CHUCK SIZE	DRILLING SPEEDS RPM	
				FERROUS	NON-FERROUS
MC 1E	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	1/8"	1/4"	400-800	900-2000
MC 2E	1/4 5/16 3/8 7/16 1/2 9/16 5/8 11/16 3/4	1/8"	3/8"	200-600	500-1500
MC 3E	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	1/8"	3/8"	150-400	400-1000
MC 4E	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	1/8"	1/2"	100-300	300-500
MC 5E	3/16 1/4 5/16 3/8 7/16 1/2 9/16 5/8 11/16 3/4 13/16 7/8	1/8"	3/8"	200-400	400-1200
MC 6E	3/16 1/4 5/16 3/8 7/16 1/2	3/8"	1/4"	300-800	800-2000
MC 7E	3/16 1/4 5/16 3/8 7/16 1/2	1/8"	1/4"	300-800	800-2000
MC 8E	+9/16 5/8 11/16 3/4 13/16 7/8 15/16 1	1/8"	1/2"	150-400	400-1000
MC 9E	+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	1/8"	1/2"	150-300	300-800

+ Pilot hole required

TiN - TITANIUM NITRIDE COATED

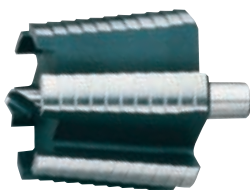


Prolongs tool life and reduces torque. Resists wear and abrasion while reducing pick-up along the cutting edge. Lower friction results in higher drilling speeds.

TOOL NO	DRILL SIZE IN MILLIMETRES	MAX MATERIAL THICKNESS	SHANK TO FIT CHUCK SIZE
MC 1MTiN	4 5 6 7 8 9 10 11 12	5mm	6.5mm
MC 2MTiN	10 11 12 13 14 15 16 17 18 19 20	4mm	10mm
MC 3MTiN	20 21 22 23 24 25 26 27 28 29 30	4mm	13mm

TREPANNING ACTION

Variable sizes of larger diameters can be drilled without the need for a pre-drilled hole, with a smooth multi-flute action ensuring that clean round holes are produced. For drilling holes up to 4mm thick in most materials and incorporating popular diameters for PG, Conduit, BS pipe and automotive fittings.



TOOL NO	DRILL SIZE IN MILLIMETRES	MAX MATERIAL THICKNESS	SHANK TO FIT CHUCK SIZE	DRILLING SPEEDS RPM	
				FERROUS	NON-FERROUS
TMC 3040	30 31 32 33 34 35 36 37 38 39 40	4mm	13mm	100-300	300-500
TMC 4050	40 41 42 43 44 45 46 47 48 49 50	4mm	13mm	50-200	200-400
TMC 5060	50 51 52 53 54 55 56 57 58 59 60	4mm	13mm	50-150	150-400

Spare Centre Drill - can be purchased separately

SPECIAL APPLICATION

All key sizes are marked on the tool.



TOOL NO	APPROX STARTING DIAMETER	APPLICATION	MAX MATERIAL THICKNESS	SHANK TO FIT CHUCK SIZE	DRILLING SPEEDS RPM	
					FERROUS	NON-FERROUS
MC 1232	8.5mm	12, 16, 20, 25 & 32mm holes for conduit entry	3.5mm	10mm	130-300	300-800
MC 1240	8.5mm	12, 16, 20, 25, 32 & 40mm holes for conduit entry	3.5mm	13mm	100-300	300-500
MCT 1232	6.5mm	Drills core holes for ISO conduit threads M12, M16, M20, M25 & M32 (1.5mm Pitch)	3.5mm	10mm	130-300	300-800
MCT 1240	6.5mm	Drills core holes for ISO conduit threads M12, M16, M20, M25, M32 & M40 (1.5mm Pitch)	3.5mm	13mm	100-300	300-500
MCCT 1225	6.5mm	Core & entry holes for ISO conduit threads 12mm x 1.5, 16mm x 1.5, 20mm x 1.5mm, 25mm x 1.5mm	6mm (tapping) 3mm (clearance)	10mm	150-400	400-1000
MCCT 1232	6.5mm	Core & entry holes for ISO conduit threads 12mm x 1.5, 16mm x 1.5, 20mm x 1.5mm, 25mm x 1.5mm, 32mm x 1.5mm	6mm (tapping) 3mm (clearance)	10mm	130-300	300-800
MC 1625	6mm	16, 20 & 25mm holes for conduit entry	3.5mm	10mm	150-400	400-1000
MC 1632	11mm	16, 20, 25 & 32mm holes for conduit entry	3.5mm	13mm	130-300	300-800
MC PG21	6.5mm	Drills clearance holes for PG fittings PG7, 9, 11, 13.5, 16, 21. Also 30.5mm pushbutton holes	3mm	13mm	130-300	300-800
MC PG29	6.5mm	Drills clearance holes for PG fittings PG7, 9, 11, 13.5, 16, 21, 29. Also 33mm, 35mm dia and 30.5mm pushbutton holes	3mm	13mm	100-300	300-500
MC 521	5mm	Drills clearance holes to take 3/8", 7/16" and 3/4" screw sizes for 'Greenlee' standard punches, 'slug buster' punches and 'slug splitter' punches	4mm	10mm	200-500	500-1300
MC 3/4KO	5.5mm	Drills clearance holes for 7/8" (1/2 KO), 1.1/8" (3/4" KO)	3.5mm	10mm	150-400	400-1000
MC 1KO	5.5mm	Drills clearance holes for 7/8" (1/2 KO), 1.1/8" (3/4" KO), 1.7/32" (Oil Tight), 1.1/4", 1.3/8" (1" KO)	3.5mm	10mm	150-300	300-800

SETS | METAL CASSETTE

Metal cassette containing Multicut® tools and 30cc pot of special cutting compound.



SET REF	CONTAINS TOOL NUMBERS	RANGE
MCS 1	MC 1M, 2M & 3M	4 - 30mm
MCS 1TiN	MC 1MTiN, 2MTiN & 3MTiN	4 - 30mm
MCS 2	MC 1E, 2E & 3E	1/8" - 1.1/8"



FASTENER STEP DRILLS

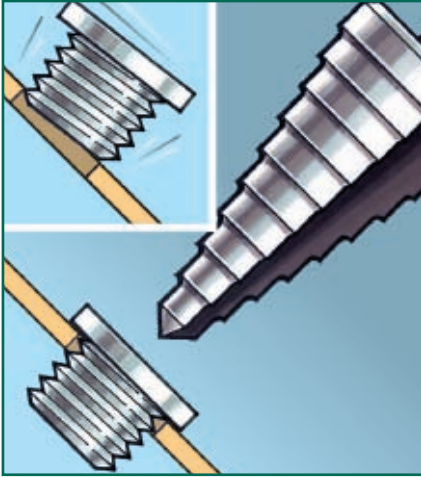
For threaded insert and riveted systems.

TOOL NO	RANGE	COMPATIBLE WITH
NRT 13	Drills Ø mm for thread size: 5.1 6.1 7.1 9.1 11.1 13.1 M3 M4 M5 M6 M8 M10	Tucker, Emhart and similar systems
NRA 10	Drills Ø mm for thread size: 4.8 6.4 7.2 9.6 10.65 M3 M4 M5 M6 M8	Avdel and similar systems
PR 1	Drills Ø mm: 3.3mm 4.1mm 4.9mm	Tucker, 'Pop' Rivet and other blind riveting systems

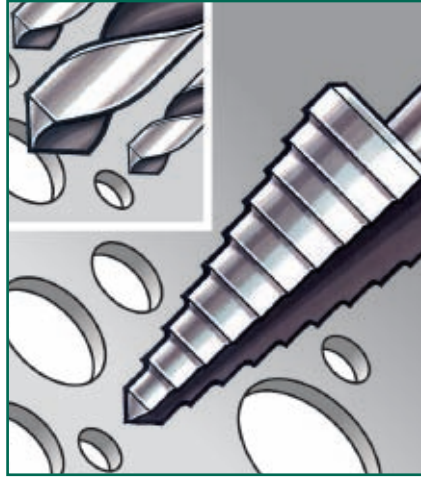
CUTTING COMPOUND

SEE CONECUT® SECTION (PAGE 18) FOR FULL PRODUCT DETAILS

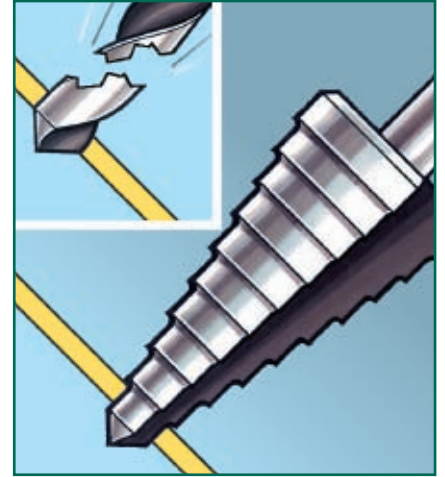
ADVANTAGES OVER CONVENTIONAL DRILLS:



EASY TO ENLARGE HOLES



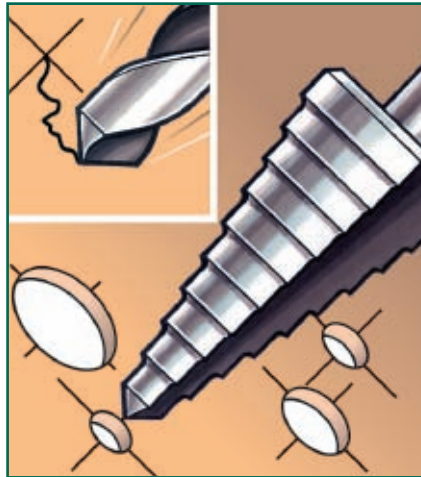
ONE TOOL - A RANGE OF SIZES



STRONGER - MORE RIGID



BURR FREE HOLES



NON-SLIP POINTS



DRILLS PLASTICS EASILY

APPLICATIONS:

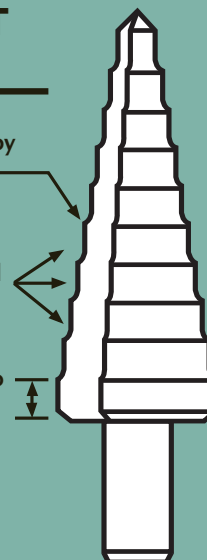
- ELECTRICAL
- HEATING
- VENTILATION
- PLUMBING
- SHOPFITTING INSTALLATIONS ETC.
- AUTO BODY REPAIR
- CONTROL PANELS
- SHEET METALWORK ETC.
- MAINTENANCE

MULTICUT FEATURES

Holes deburred by same operation

Up to 14 conventional drill sizes on one tool

Drills material up to 10mm thick



Non-slip point; needs no centre punch

No flexing of drill whilst drilling

Multi-flute design

Drills from 4mm - 60mm dia.

Enlarges existing holes

Shank will not slip in chuck