

This innovative step drill has been designed for use with our popular range of Powerbor® Electromagnetic drilling machines. The unique design of the Powerbor® Step Drill allows a number of popular hole sizes to be drilled with just one tool. The new Powerbor® Step Drill offers a number of advantages over conventional drilling and cutting methods and can be used for many different industrial applications.



ONE STEP DRILL = UP TO FIVE DRILLS

POWERBOR®

STEP DRILL



Industrial Application Examples:

- **General engineering**
- **Bridge and highway maintenance**
- **Truck and trailer manufacturing**
- **Construction**
- **Shipbuilding and railroad**
- **Offshore rigs and pipelines**
- **Elevator repair**
- **General metal fabrications**

*patent pending

STEP DRILLS | FIVE STEPS



NOMINAL STEP Ø (MM)

TOOL NO	STARTER/ FOLLOW ON	1ST STEP	2ND STEP	3RD STEP	4TH STEP	5TH STEP	MAX MATERIAL THICKNESS	SHANK Ø	NO OF FLUTES
MPSD 0816	STARTER	8	10	12	14	16	12mm	3/4"	2
MPSD 1018	STARTER	10	12	14	16	18	12mm	3/4"	2
MPSD 2028	STARTER	20	22	24	26	28	12mm	3/4"	2
MPSD 3038	FOLLOW ON	30	32	34	36	38	12mm	3/4"	3
MPSD 4048	FOLLOW ON	40	42	44	46	48	12mm	3/4"	3

NOMINAL STEP Ø INCHES

TOOL NO	STARTER/ FOLLOW ON	1ST STEP	2ND STEP	3RD STEP	4TH STEP	5TH STEP	MAX MATERIAL THICKNESS	SHANK Ø	NO OF FLUTES
IPSD 3156	STARTER	5/16	3/8	7/16	1/2	9/16	12mm	3/4"	2
IPSD 3863	STARTER	3/8	7/16	1/2	9/16	5/8	12mm	3/4"	2
IPSD 6994	STARTER	11/16	3/4	13/16	7/8	15/16	12mm	3/4"	2
IPSD 1013	FOLLOW ON	1	1.1/16	1.1/8	1.3/16	1.1/4	12mm	3/4"	3
IPSD 1316	FOLLOW ON	1.5/16	1.3/8	1.7/16	1.1/2	1.9/16	12mm	3/4"	3
IPSD 1619	FOLLOW ON	1.5/8	1.11/16	1.3/4	1.13/16	1.7/8	12mm	3/4"	3
IPSD 1922	FOLLOW ON	1.15/16	2	2.1/16	2.1/8	2.3/16	12mm	3/4"	3

STEP DRILLS | THREE STEPS



NOMINAL STEP Ø (MM)

TOOL NO	STARTER/ FOLLOW ON	1ST STEP	2ND STEP	3RD STEP	4TH STEP	5TH STEP	MAX MATERIAL THICKNESS	SHANK Ø	NO OF FLUTES
MPSD 1014	STARTER	10	12	14	-	-	25mm	3/4"	2
MPSD 1620	STARTER	16	18	20	-	-	25mm	3/4"	2
MPSD 2226	FOLLOW ON	22	24	26	-	-	25mm	3/4"	3
MPSD 2832	FOLLOW ON	28	30	32	-	-	25mm	3/4"	3
MPSD 3438	FOLLOW ON	34	36	38	-	-	25mm	3/4"	3
MPSD 4044	FOLLOW ON	40	42	44	-	-	25mm	3/4"	3
MPSD 4650	FOLLOW ON	46	48	50	-	-	25mm	3/4"	3

NOMINAL STEP Ø INCHES

TOOL NO	STARTER/ FOLLOW ON	1ST STEP	2ND STEP	3RD STEP	4TH STEP	5TH STEP	MAX MATERIAL THICKNESS	SHANK Ø	NO OF FLUTES
IPSD 4456	STARTER	7/16	1/2	9/16	-	-	25mm	3/4"	2
IPSD 6375	STARTER	5/8	11/16	3/4	-	-	25mm	3/4"	2
IPSD 8194	FOLLOW ON	13/16	7/8	15/16	-	-	25mm	3/4"	3
IPSD 1011	FOLLOW ON	1	1.1/16	1.1/8	-	-	25mm	3/4"	3
IPSD 1213	FOLLOW ON	1.3/16	1.1/4	1.5/16	-	-	25mm	3/4"	3
IPSD 1415	FOLLOW ON	1.3/8	1.7/16	1.1/2	-	-	25mm	3/4"	3
IPSD 1617	FOLLOW ON	1.9/16	1.5/8	1.11/16	-	-	25mm	3/4"	3
IPSD 1819	FOLLOW ON	1.3/4	1.13/16	1.7/8	-	-	25mm	3/4"	3
IPSD 1921	FOLLOW ON	1.15/16	2	2.1/16	-	-	25mm	3/4"	3



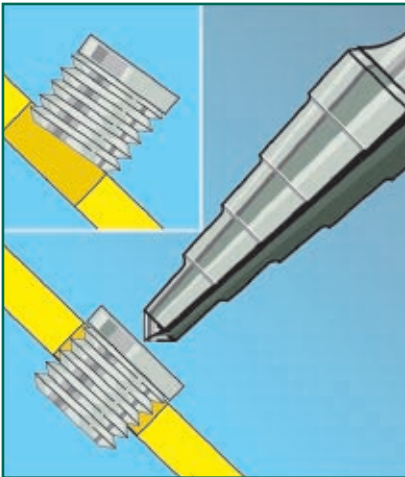
PLEASE NOTE:

The recommended drilling speed for each step of the Powerbor step drill is the same as for the equivalent size HSS cutter shown on page 13.

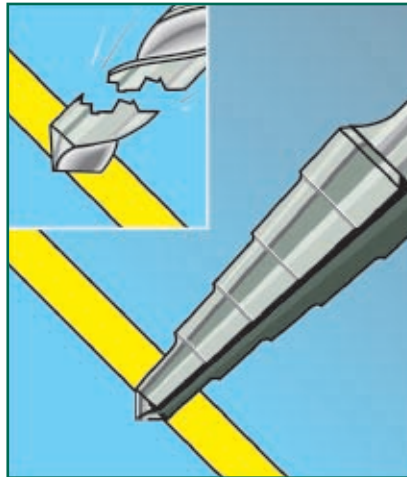
STEP DRILL



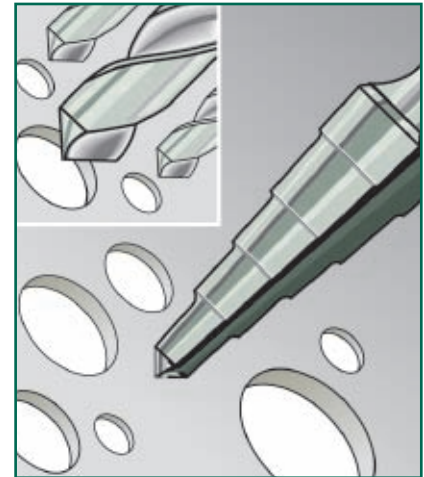
ADVANTAGES OVER CONVENTIONAL DRILLS:



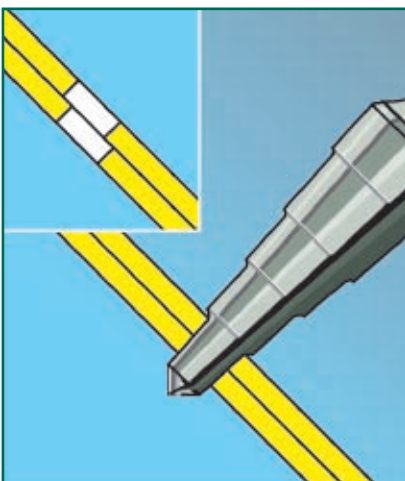
Easy to enlarge holes



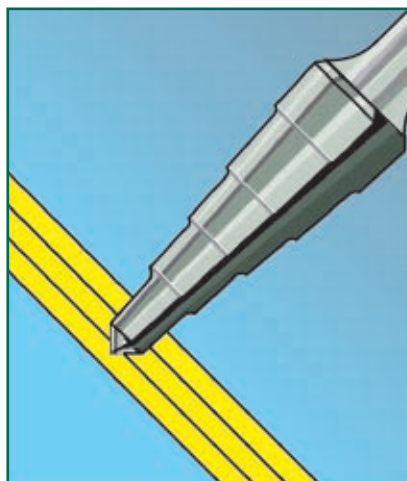
Increased rigidity



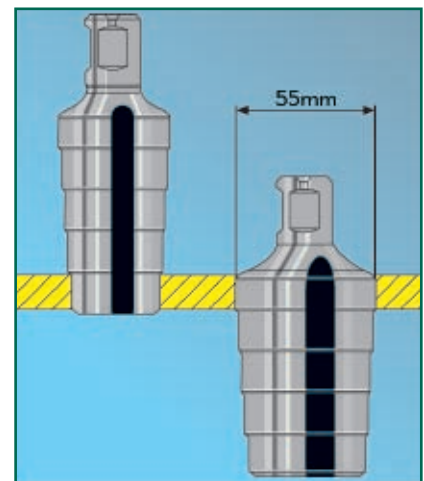
3 or 5 drill sizes on 1 tool



Rectify out of line holes



Drill through several stacked plates



Increased maximum diameter capability of Powerbor® Drilling Machine