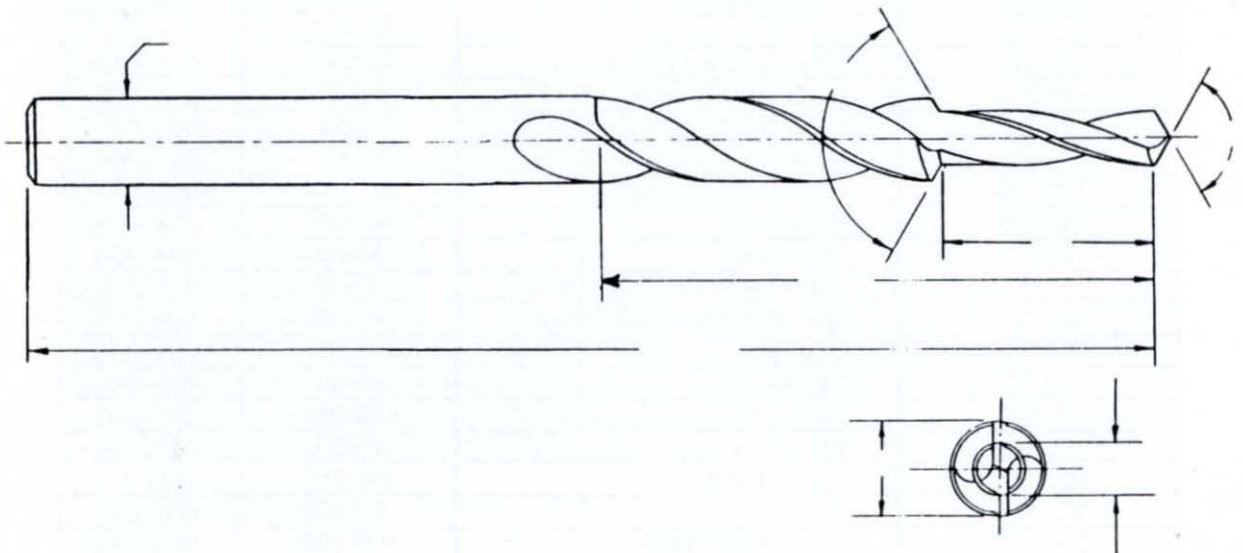


STEP DRILL SPECIFICATIONS

When designing step drills the lowest costs can be attained by observing the following limits:

- A. Steps must not be less than $1/3$ body diameter.
- B. Steps must not exceed 10 diameters in length.
- C. Tolerance on diameters: $+.000, -.0005$ ".
- D. Tolerance on lengths: $1/64$ " (± 008 ")
- E. Tolerance on Angles: $\pm 0^\circ 30'$
- F. Tolerance on concentricity: $\pm .001$ "
- G. Minimum radius on inside corners: $.010$ "
- H. Closer limits on above elements: price on application.



SOLID CARBIDE END MILLS

Sketch to use when Special End Mills are needed.

