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Step reamer

Aligning step matches the core drill.

Specification

Item	Value
Type	Reamer
Point	—
Material	—
Use for	Final sizing of large holes, after the step drill
Do not use for	—

A dash means the sources do not state it.

Notes

- **Inch values are official.** Aviation is designed and worked in inches. Millimetres are converted and are not official; where one is shown, the metric drill is the nearest alternative, not the official drill.
- Reamers should be available for both clearance and interference fit hole sizes.
- Withdraw in the cutting direction only: turning back can force chips in (H-31 p. 4-19). How much to leave for reaming differs by source: about 1/64 in (H-31 p. 4-20) or 0.003-0.007 in at most (H-30B p. 11-13). The repair data decides.

SOURCES · FAA-H-8083-31, AMT Handbook, Airframe, Volume 1

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/drills/step-reamer/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.