ULTIMATECUT

FLOWSTEP® drilling, countersinking and threading tools for metalworking.



Choose Your Setup

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How to Order

Quote the RUKO item number, diameter or thread size, and quantity. For sets, use the complete kit code.

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APPLICATION GUIDE

Choose the Right Cutter

Start with the material, hole size and thickness. Match the tool to the job to reduce wandering, tool changes and rework.



FLOWSTEP Multidrill · RUKO specifies up to 10mm cutting depth in structural steel

Workshop application	What the tooling changes
Start a hole on round tube	The stepped FLOWSTEP point helps locate the drill on curved stock. Choose HSS for general steel and cobalt for demanding work such as stainless.
Open holes in sheet	A FLOWSTEP step drill moves smoothly between fixed diameters. One tool can cover several hole sizes on enclosures and brackets.
Enlarge holes in thicker steel	The FLOWSTEP Multidrill provides deeper steps for structural steel. Use it where access makes a larger drilling setup awkward.
Seat flush fasteners	4S BOOST uses four cutting edges and unequal spacing to reduce chatter and improve the finish of a 90° seat.
Drill and tap in one pass	A combi tap combines drilling, threading and deburring in suitable through holes, reducing bit changes on repeated jobs.

RUKO Multidrill application guide

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TWIST DRILLS / DIN 338

FLOWSTEP Twist Drills

The stepped point helps locate the drill on curved work such as tube. Choose HSS for general steel work or HSS-Co 5 for more demanding work. The new tip geometry applies to diameters from 3 to 13mm.



HSS



HSS-Co 5

Diameter	Overall length	Flute length	HSS	HSS-Co 5
1mm	34mm	12mm	259010	259010E
1.5mm	40mm	18mm	259015	259015E
2mm	49mm	24mm	259020	259020E
2.5mm	57mm	30mm	259025	259025E
3mm	61mm	33mm	259030	259030E
3.3mm	65mm	36mm	259033	259033E
3.5mm	70mm	39mm	259035	259035E
4mm	75mm	43mm	259040	259040E
4.2mm	75mm	43mm	259042	259042E
4.5mm	80mm	47mm	259045	259045E
5mm	86mm	52mm	259050	259050E
5.5mm	93mm	57mm	259055	259055E
6mm	93mm	57mm	259060	259060E
6.5mm	101mm	63mm	259065	259065E
6.8mm	109mm	69mm	259068	259068E
7mm	109mm	69mm	259070	259070E
7.5mm	109mm	69mm	259075	259075E
8mm	117mm	75mm	259080	259080E
8.5mm	117mm	75mm	259085	259085E
9mm	125mm	81mm	259090	259090E
9.5mm	125mm	81mm	259095	259095E
10mm	133mm	87mm	259100	259100E
10.2mm	133mm	87mm	259102	259102E
10.5mm	133mm	87mm	259105	259105E
11mm	142mm	94mm	259110	259110E
11.5mm	142mm	94mm	259115	259115E
12mm	151mm	101mm	259120	259120E
12.5mm	151mm	101mm	259125	259125E
13mm	151mm	101mm	259130	259130E

RUKO FLOWSTEP drill details

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TWIST DRILLS / LARGE DIAMETERS AND SETS

Large Drills & Sets

The stepped three-face shank helps secure larger drills in a suitable chuck. For a cased set, select material and diameter coverage.



Stepped three-face shank



259215RO



259205ERO

Diameter	Overall length	Flute length	HSS order code
13.5mm	160mm	108mm	259135
14mm	160mm	108mm	259140
14.5mm	169mm	114mm	259145
15mm	169mm	114mm	259150
15.5mm	178mm	120mm	259155
16mm	178mm	120mm	259160
16.5mm	184mm	125mm	259165
17mm	184mm	125mm	259170
17.5mm	191mm	130mm	259175
18mm	191mm	130mm	259180
18.5mm	198mm	135mm	259185
19mm	198mm	135mm	259190
19.5mm	205mm	140mm	259195
20mm	205mm	140mm	259200

DIN 338 FLOWSTEP Sets

Set	Included diameters	HSS	HSS-Co 5
5 pc	4, 5, 6, 8 and 10mm	259205RO	259205ERO
19 pc	1–10mm in 0.5mm steps	259214RO	259214ERO
25 pc	1–13mm in 0.5mm steps	259215RO	259215ERO

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SHEET METAL / EXPANDING HOLES

Step Drills & Multidrills

Use a step drill for sheet and a FLOWSTEP Multidrill for deeper cuts in structural steel. RUnaTEC improves wear resistance during repeated cutting.



FLOWSTEP step drill



FLOWSTEP multidrill



Turbo-tip multidrill

Step size	Drill range	HSS	HSS coated	Co 5	Co 5 coated
0/9	5–12mm	101650-9	101650-9P	101650-9E	101650-9EP
1	6–20mm	101651	101651P	101651E	101651EP
2	8–30mm	101652	101652P	101652E	101652EP
3	9–38mm	101653	101653P	101653E	101653EP
3 pc set	Sizes 0/9, 1, 2	101626RO	101626PRO	101626ERO	101626EPRO

RUnaTEC Multidrills

Size	Drill range	FLOWSTEP tip	Turbo tip
S1	6–12mm	101682P	101082P
M2	6–20mm	101683P	101083P
L3	6–27mm	101684P	101084P
3 pc set	S1, S2 and S3	101687PRO	101087PRO

Match the Step to the Stock Thickness

Select a tool whose cutting step can clear the full thickness at the required diameter. For stainless sheet, choose a cobalt step drill and follow the speed guidance for that tool.

RUKO step drill and multidrill range

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COUNTERSINKING / 90°

4S BOOST Countersinks

Four cutting edges and unequal spacing help reduce chatter and produce a cleaner seat. The three-face shank improves grip in the chuck. Sizes run up to Ø 40mm.



HSS



HSS-Co 5 / RUnaTEC



102890EPRO

Ø	Overall	HSS	HSS coated	HSS-Co 5	Co 5 coated
10.4mm	50mm	102874	102874P	102874E	102874EP
12.4mm	56mm	102876	102876P	102876E	102876EP
15mm	60mm	102878	102878P	102878E	102878EP
16.5mm	60mm	102879	102879P	102879E	102879EP
19mm	63mm	102880	102880P	102880E	102880EP
20.5mm	63mm	102881	102881P	102881E	102881EP
23mm	67mm	102882	102882P	102882E	102882EP
25mm	67mm	102883	102883P	102883E	102883EP
31mm	71mm	102885	102885P	102885E	102885EP
40mm	80mm	102894	102894P	102894E	102894EP

Cased Sets

Contents	HSS	HSS coated	HSS-Co 5	Co 5 coated
6 pc	102890RO	102890PRO	102890ERO	102890EPRO

Six-piece sets contain 6.3, 8.3, 10.4, 12.4, 16.5 and 20.5mm.

RUKO countersink technical data

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COUNTERSINKING / 90°

3S Countersinks

Three-edge 90° DIN 335 Type C countersinks for fastener seats and deburring. Choose HSS for general work and cobalt or RUnaTEC options for more demanding jobs.



HSS



HSS-Co 5 / RUnaTEC



102790EPRO

Ø	Overall	HSS	HSS coated	HSS-Co 5	Co 5 coated
6.3mm	45mm	102767	102767P	102767E	102767EP
8.3mm	50mm	102771	102771P	102771E	102771EP
10.4mm	50mm	102774	102774P	102774E	102774EP
12.4mm	56mm	102776	102776P	102776E	102776EP
15mm	60mm	102778	102778P	102778E	102778EP
16.5mm	60mm	102779	102779P	102779E	102779EP
19mm	63mm	102780	102780P	102780E	102780EP
20.5mm	63mm	102781	102781P	102781E	102781EP
23mm	67mm	102782	102782P	102782E	102782EP
25mm	67mm	102783	102783P	102783E	102783EP
31mm	71mm	102785	102785P	102785E	102785EP

Cased Sets

Contents	HSS	HSS coated	HSS-Co 5	Co 5 coated
6 pc[1]	102790RO	102791PRO	102790ERO	102790EPRO

Six-piece sets contain 6.3, 8.3, 10.4, 12.4, 16.5 and 20.5mm. [1] HSS coated set contains five tools: 6.3, 10.4, 16.5, 20.5 and 25mm.

RUKO countersink technical data

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THREADING / METRIC THROUGH HOLES

Combi Taps & Threading Sets

Combination taps drill, cut the thread and deburr in one tool. Use a separate drill and Form B tap when the operation calls for separate drilling and tapping.



Coated combi tap



270620PRO



259048ERO

Thread	Pitch	Drill diameter	HSS	HSS coated
M3	0.50mm	2.5mm	270614	270614P
M4	0.70mm	3.3mm	270615	270615P
M5	0.80mm	4.2mm	270616	270616P
M6	1mm	5mm	270617	270617P
M8	1.25mm	6.8mm	270618	270618P
M10	1.50mm	8.5mm	270619	270619P

Metric Threading Sets

Set	Contents	Order code
HSS combi tap	M3, M4, M5, M6, M8 and M10 + magnetic holder	270620RO
HSS combi tap / coated	M3, M4, M5, M6, M8 and M10 + magnetic holder	270620PRO
HSS Form B	M3–M12 in seven sizes + seven HSS FLOWSTEP drills	259048RO
HSS-Co 5 Form B	M3–M12 in seven sizes + seven cobalt FLOWSTEP drills	259048ERO

RUKO combination machine tap details

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