

DRILL/TAP BITS FOR STAINLESS STEEL

//////////////////// Tips for Optimal Performance //////////////////////

Use cutting oil when drilling and tapping all stainless steel material for extended tool life



462-1

Use with 18V battery drills and similar or larger sizes



Use low setting on battery drill



Operation Instructions

1. Apply oil to the drill tip
2. Use a low RPM and a clockwise rotation to begin cutting the hole
3. Keep a steady pressure on the drill until chips form
4. Continue with the same force until hole is cut into steel, while keeping the drill bit at a right angle to the material
5. Stop drilling and add more oil to the threaded section of the bit
6. Insert bit into the drilled hole at a right angle – apply slight force to tap the hole
7. Cut the chamfer of the hole by applying force to the bit
8. Reverse the direction of the battery drill – using low RPM, pull the bit back at a right angle until it is completely out of the hole
9. Clean the hole of oil and chips – the hole is now completed

