

## DRILL/TAP BITS FOR STAINLESS STEEL

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



Use with 18V battery drills and similar or larger sizes



Use low setting on battery drill



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- 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
- Continue with the same force until hole is cut into steel, while keeping the drill bit at a right angle to the material
- Stop drilling and add more oil to the threaded section of the bit

- 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

