



## ***High Speed Cobalt Steel Titanium Nitride Step Drill Bits Instructions***

- Self-Start Dual Cutting Split Point- provides engagement and minimizes walking
- Spiral Cut with relief angle provides a continuous cutting action for up to 4X faster cutting speeds
- Constructed out of M35 Cobalt Steel with Titanium Nitride coating, which provides strength and durability while the titanium nitride coating extends the life of the bit
- Impact Rated makes it compatible with cordless and impact rated drills

For extend life of step drill bits abide by following operation and safety guidelines.

### **Safety First!**

- Always wear eye protection when using this product.
- Wear appropriate working clothes and shoes as needed.
- Wear hearing protection while using this product.
- Utilize a cap to keep long hair away from moving drill.
- Be cautious of foot position as substrates may be hot once ejected.
- Do not touch object or pick up chips immediately after cutting as high heat is generated that can cause a burn.
- Do not modify step drill bit for any other purpose. Any inappropriate modification of the step drill bit may cause an accident and result in personal injury.

### **Guidelines for Best Step Drill Bit Operation**

- Choose the appropriate size of step drill bit per the application.
- Choose drill with adjustable speed function to avoid damage on cutting edge.
- Keep step drill bit vertical with cutting object when in use.
- For best performance, follow the recommended step bit operating speeds.
- If drilling through metal, we highly recommend the use of good grade of cutting oil to assure cleaner cut and extend the life of the step drill bit.

### **Step Bit Operating Speeds**

For materials less than or equal to 7/8" Max Speed is 650 RPM

For materials greater than 7/8" Max Speed is 470 RPM

### **Material Specifications**

IDEAL Step Drill Bits are compatible with a wide array of metals from sheet metal, stainless steel, brass, carbon steel, cast iron as well as plastics up to 8 gauge.



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