# ONSITE+

**Step Tip** Reduced Shank Drill Bit

## BEST PRACTICE GUIDELINES - HANDHELD/CORDLESS DRILLS

The Alpha Onsite+ Step Tip Reduced Shank Drill Bits have been designed to also be used in handheld/cordless/portable drills.

Available in the following sizes:
14.0, 14.5, 15.0, 15.5, 16.0, 16.5, 17.0, 17.5, 18.0, 19.0, 20.0, 21.0, 22.0 & 25.0

Our Patented step tip design eliminates pre-drilling and produces perfectly centered, clean cut and burr-free holes.

Each drill is Black Oxide treated to maximise lubricant hold, assisting chip flow and heat dissipation.

### Instructions for handheld/cordless drill usage

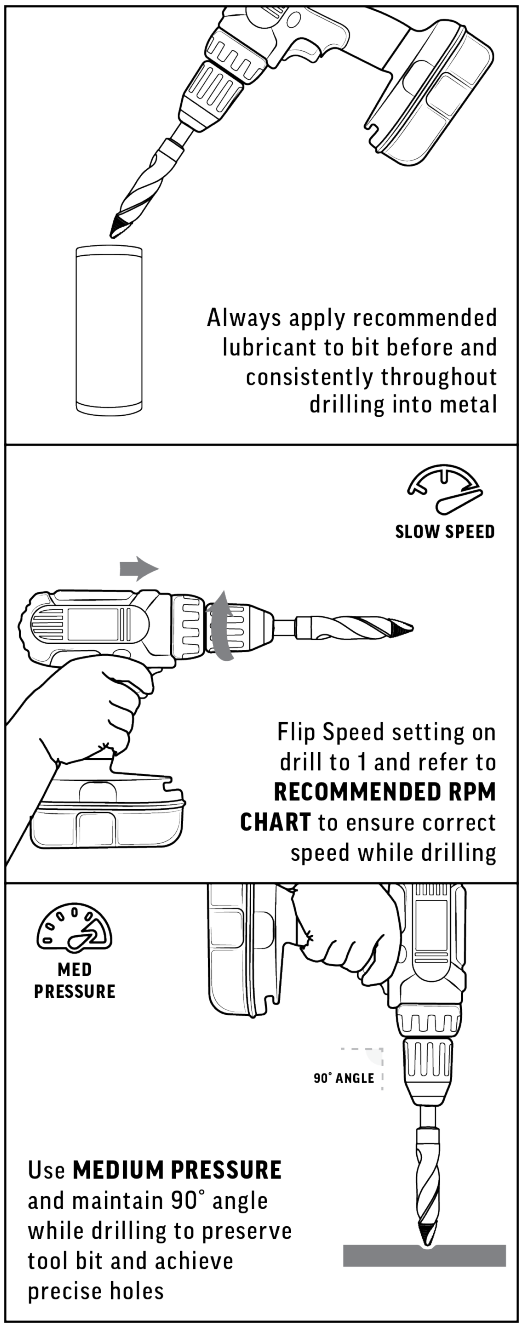
- **Always apply lubricant before drilling into metal materials**
- **Low speed is recommended (generally Speed 1 on a 2 speed drill) with medium pressure, when drilling metals - refer to Recommended RPM Chart**
- **Onsite+ Reduced Shank Drills will perform best in a portable drill for thinner materials, and are also perfect for accurately enlarging existing smaller holes**
- **The use of an additional extension handle on a cordless drill is also recommended when drilling larger diameter holes**

Always use the appropriate lubricant when drilling to ensure product efficiency and longevity. Consistently applying lubricant is critical to protecting bit against heat and friction and provide excellent surface finish.

Always wear Personal Protective Equipment (PPE) when using power tool accessories. Bits can become very hot with continuous usage.

Scan QR Code for more product information, videos and testing data

**For product warranty information and Alpha Tool's policies, please visit www.alphatools.com.au/warranty-policy/**




## RECOMMENDED RPM CHART - HANDHELD/CORDLESS DRILLS

Low speed is recommended (generally Speed 1 on a 2 speed drill ) with medium pressure, when drilling metals.

| Drill ø mm | Stainless Steel | | Tool Steel | | Cast Iron | | Malleable Iron | | Medium Carbon Steel | | Free Cutting Steel | | Aluminium/Brass/Plastic | | Wood | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank | Standard Reduced Shank | Onsite+ Step Tip Reduced Shank |
| 14 | 244 | **293** | 367 | **440** | 489 | **587** | 550 | **660** | 611 | **733** | 856 | **1027** | 1222 | **1466** | 1833 | **1833** |
| 16 | 222 | **266** | 333 | **400** | 444 | **533** | 500 | **600** | 556 | **667** | 778 | **934** | 1111 | **1333** | 1667 | **1667** |
| 18 | 204 | **245** | 306 | **367** | 407 | **488** | 458 | **550** | 509 | **611** | 713 | **856** | 1019 | **1223** | 1528 | **1528** |
| 20 | 189 | **227** | 224 | **269** | 378 | **454** | 425 | **510** | 473 | **568** | 662 | **794** | 946 | **1135** | 1419 | **1419** |
| 22 | 175 | **210** | 262 | **314** | 349 | **419** | 393 | **472** | 437 | **524** | 611 | **733** | 873 | **1048** | 1310 | **1310** |
| 25 | 153 | **184** | 229 | **275** | 306 | **367** | 344 | **413** | 382 | **458** | 535 | **642** | 764 | **917** | 1146 | **1146** |

Feed rate per revolution recommended 0.35 to 0.45 (mm/rev)