ONSITE+

Step Tip Reduced Shank Drill Bit

BEST PRACTICE GUIDELINES - PEDESTAL DRILL

The Alpha Onsite+ Step Tip Reduced Shank Drill Bits have been designed to put less load on the pedestal drill motor, and will give superior performance with lower powered pedestal 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 entered, clean cut and burr-free holes.

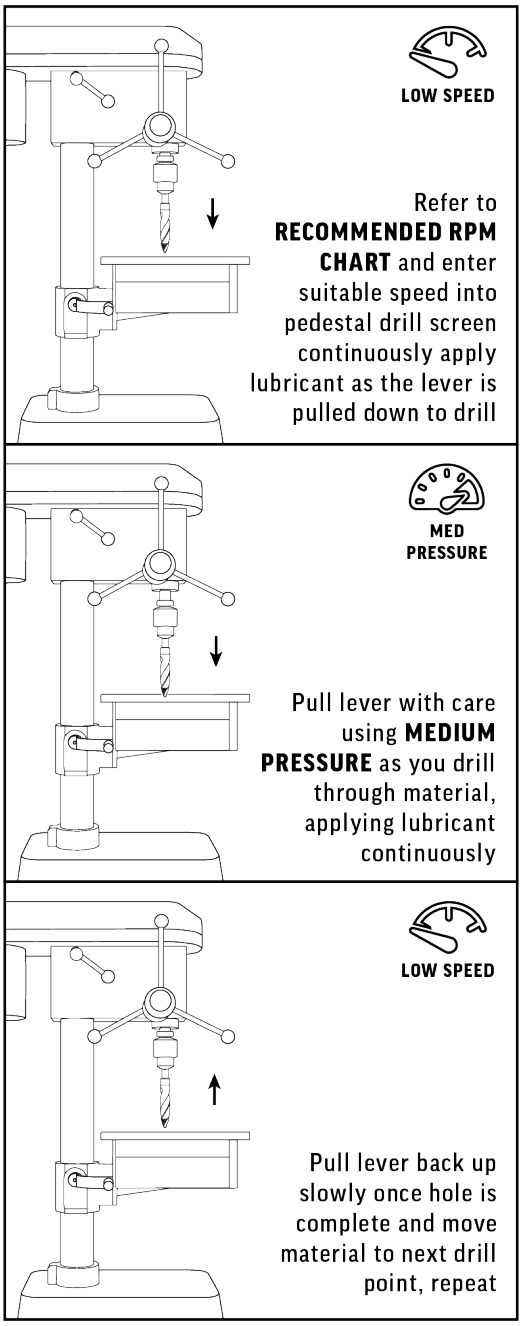
Each drill is Black Oxide treated to maximise lubricant hold, assisting chip flow and heat dissipation.

Instructions for pedestal drill usage

- **Always apply lubricant before drilling into metal materials**
- **Apply recommended RPM & pressure (See below) - ultimate performance at speeds around 20% faster than recommended RPM for standard reduced shank drill bits, when used in metal such as mild steel, stainless steel, aluminium etc**
- **Recommended RPM will remain the same as standard reduced shank drill bits when drilling into timber or similar**

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 - PEDESTAL DRILL

Ultimate performance at speeds around 20% faster than recommended RPM for standard reduced shank drill bits, when used in metal such as mild steel, stainless steel, aluminium etc. Recommended RPM will remain the same as standard reduced shank drill bits when drilling into timber or similar.

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)