ONSITE+

**Step Tip** Step Drill

## BEST PRACTICE GUIDELINES - ALUMINIUM 0.25 - 3.5mm

The Alpha Onsite+ Step Tip Step Drill is part of Alpha's Onsite+ range, designed specifically to perform with maximum efficiency so you can save time onsite and knock off early.

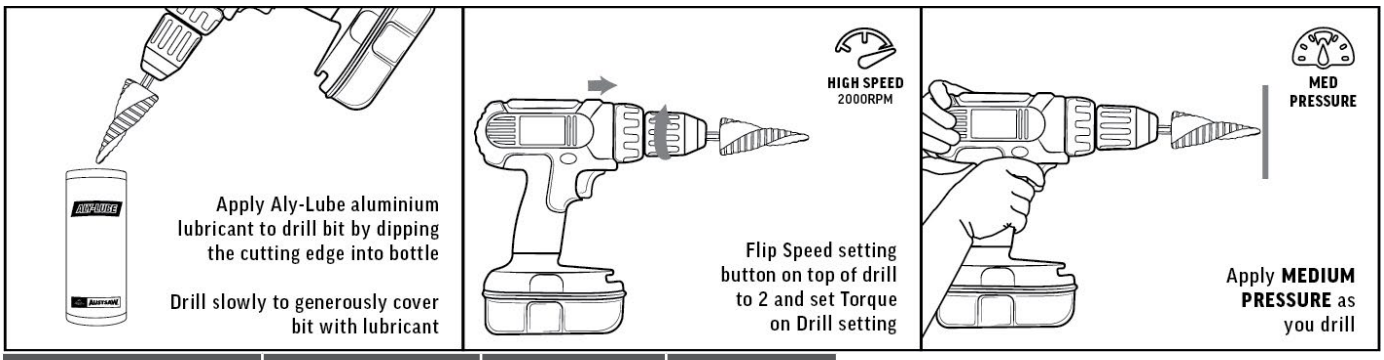
**The Onsite+ Step Tip Step Drills are available in the following sizes:**
**4.0 - 12.0mm, 4.0 - 20.0mm & 6.0 - 30.0mm**

Developed in-house using our patented step tip design to eliminate pre-drilling and produce perfectly centered, clean cut and burr-free holes. Each step drill is coated with AlTiN for extreme temperature resistance and long service life and has a 1/4" Quick-Change shank for convenient use in both a cordless drill and/or impact driver.

**Instructions**
- **Always apply lubricant before drilling**
- **Make sure you drill straight/at a 90˚ angle continuously**
- **Apply recommended RPM and pressure**
- **Drill bit is designed to do all of the work - do not add extra pressure mid-drill**
- **During drilling focus on the total length of the stepped bit to avoid damaging the bit and/or equipment**

Always use the appropriate lubricant when drilling to ensure product efficiency and longevity. Consistently applying lubricant will protect 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.




| DRILL ø | SPEED/TORQUE | RECOMMENDED RPM | PRESSURE |
|---|---|---|---|
| 4.0 - 12.0, 4.0 - 20.0 & 6.0 - 30.0mm | High Speed / Medium Feed | 2000 RPM | Medium |

## RECOMMENDED RPM CHART - CORDLESS DRILL

| DRILL ø mm | MATERIAL | SPEED/TORQUE | RECOMMENDED RPM | PRESSURE |
|---|---|---|---|---|
| 4.0 - 12.0mm | Aluminium 0.25 - 3.5mm | High Speed / Medium Feed | 2000 RPM | Medium |
| 4.0 - 20.0mm | Aluminium 0.25 - 3.5mm | High Speed / Medium Feed | 2000 RPM | Medium |
| 6.0 - 30.0mm | Aluminium 0.25 - 3.5mm | High Speed / Medium Feed | 2000 RPM | Medium |
| 4.0 - 12.0mm | Mild Steel 0.25 - 3.5mm | High Speed / Medium Feed | Up to 2600 RPM | Light - Medium |
| 4.0 - 20.0mm | Mild Steel 0.25 - 3.5mm | High Speed / Medium Feed | Up to 2600 RPM | Light - Medium |
| 6.0 - 30.0mm | Mild Steel 0.25 - 3.5mm | Medium Speed / Medium Feed | 1000 - 2000 RPM | Light - Medium |
| 4.0 - 12.0mm | Stainless Steel 0.25 - 3.5mm | Medium Speed / Medium Feed | 1300 RPM | Medium |
| 4.0 - 20.0mm | Stainless Steel 0.25 - 3.5mm | Medium Speed / Medium Feed | 1300 RPM | Medium |
| 6.0 - 30.0mm | Stainless Steel 0.25 - 3.5mm | Medium Speed / Medium Feed | START - 1300 RPM<br>FINISH - 450 RPM | START - Medium - High<br>FINISH - Medium |

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/