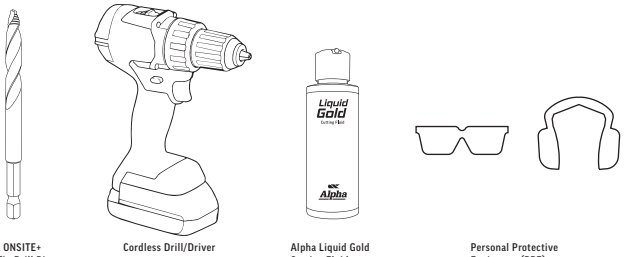
CORDLESS DRILL/DRIVER

STAINLESS FLAT BAR SS316 - 3.0mm | **DRILL BIT - 12.0mm**

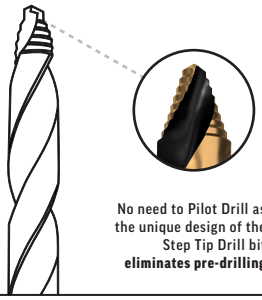
YOU WILL NEED



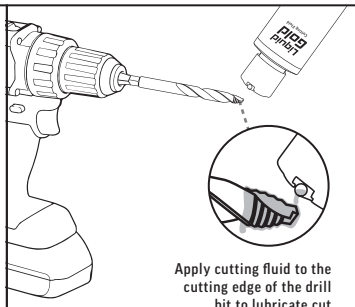
Alpha ONSITE+ Step Tip Drill Bit | Cordless Drill/Driver | Alpha Liquid Gold Cutting Fluid | Personal Protective Equipment (PPE)



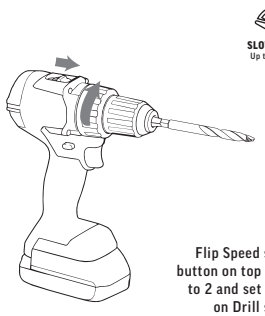
BEST PRACTICE GUIDE



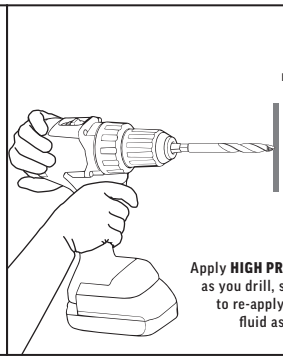
No need to Pilot Drill as the unique design of the Step Tip Drill bit **eliminates pre-drilling**



Apply cutting fluid to the cutting edge of the drill bit to lubricate cut against heat and friction



Flip Speed setting button on top of drill to 2 and set Torque on Drill setting



Apply **HIGH PRESSURE** as you drill, stopping to re-apply cutting fluid as needed

DRILL DIAMETER	MATERIAL	MATERIAL THICKNESS	TESTING TOOL	SPEED / TORQUE RECORDED	SPEED	PRESSURE	IMPACT	HOLES	BLUNT / RETIRED
12.0mm	Stainless Flat Bar SS316	3.0mm	Makita Drill/Driver DF001GZ 40V 5.0aH Battery	Slow Speed / Max Pressure	Slow (up to 650rpm)	High	N/A	57	Blunt

TIME TEST - DRILLING 5 HOLES

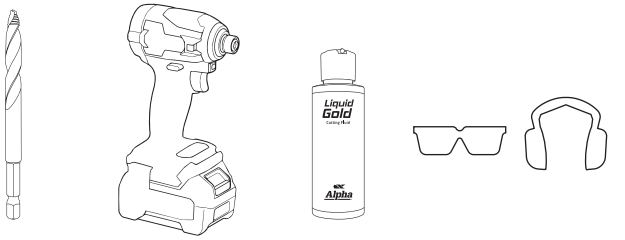
5:06

IMPACT DRIVER

STAINLESS FLAT BAR SS316 - 3.0mm | **DRILL BIT - 12.0mm**

NOT RECOMMENDED | **5 HOLES**

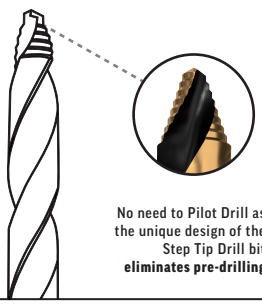
YOU WILL NEED



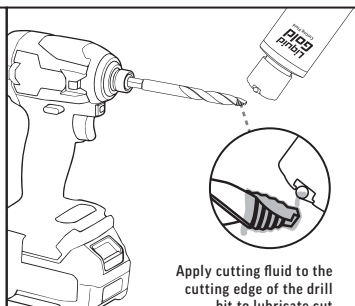
Alpha ONSITE+ Step Tip Drill Bit | Impact Driver | Alpha Liquid Gold Cutting Fluid | Personal Protective Equipment (PPE)



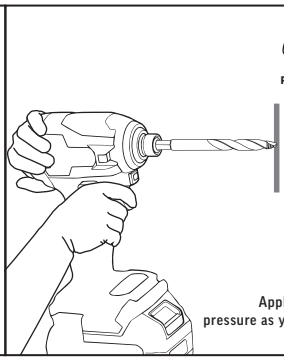
BEST PRACTICE GUIDE



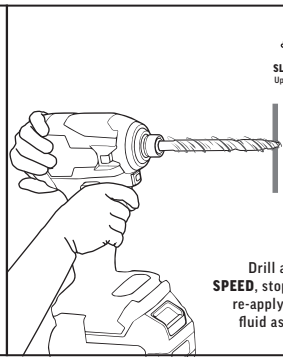
No need to Pilot Drill as the unique design of the Step Tip Drill bit **eliminates pre-drilling**



Apply cutting fluid to the cutting edge of the drill bit to lubricate cut against heat and friction



Apply **HIGH** pressure as you drill



Drill at **SLOW SPEED**, stopping to re-apply cutting fluid as needed

DRILL DIAMETER	MATERIAL	MATERIAL THICKNESS	TESTING TOOL	SPEED / TORQUE RECORDED	SPEED	PRESSURE	IMPACT	HOLES	BLUNT / RETIRED
12.0mm	Stainless Flat Bar SS316	3.0mm	Makita Impact Driver TD001GZ 40V 5.0aH Battery	Slow Speed / Max Pressure	Slow (up to 1,100rpm)	High	High	5	Blunt

TIME TEST - DRILLING 5 HOLES

5:30

NOTES:

Impact not recommended in this application