

COBALT

- > Cobalt drills are industrial quality - incredibly strong and can be operated at much higher speeds than standard HSS bits
- > They have very long product life in comparison to standard HSS drill bits
- > The ability to withstand heat generation enables them to perform for long periods without the requirement for cooling
- > They are ideal for cutting through most hardened metals such as stainless steel, titanium, bronze and cast iron. Also having the ability to cut through weld seams. They are less suitable for more general purpose applications.
- > Split point for quick start and no skidding on surfaces

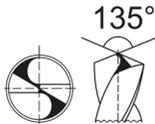
FLUTE GROUND

- > Flute Ground drills are industrial use but are ideal for more wide ranging, general use in relatively hard metals, plastics and wood. Occasional use in stainless steel and other hard materials
- > Split point for quick start and no skidding on surfaces
- > Will wear more quickly in harder materials such as stainless steel

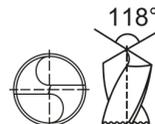
ROLL FORGED

- > Medium use and for general purpose applications on softer materials

HIGH SPEED DRILLS FOR METAL - DRILL POINTS



- > Drill harder steel alloys - self-centering
- > Flatter cutting face so engages quicker
- > Ideal for use in handheld power drills
- > Requires less operator force than 118° Point Drills



- > General purpose use - Not self-centering
- > More aggressive tip
- > For drilling softer materials like wood, aluminum and low to medium steel alloys
- > Will require centre punch for hard materials



DRILLING SPEEDS

HIGH SPEED STEEL DRILLS FOR METAL - RPM

DIAMETER	STAINLESS STEEL	MILD STEEL	GREY CAST IRON	ALUMINIUM COPPER BRASS
1.0mm	4456	7003	10504	12732
2.0mm	2228	3501	5252	6366
3.0mm	1485	2334	3501	4244
4.0mm	1114	1751	2626	3183
5.0mm	891	1401	2101	2546
6.0mm	743	1167	1751	2122
7.0mm	637	1000	1501	1819
8.0mm	557	875	1313	1592
9.0mm	495	778	1167	1415
10.0mm	446	700	1050	1340
11.0mm	405	637	955	1157
12.0mm	371	584	875	1061
13.0mm	343	539	808	979

AUGER WOOD DRILLS (HEX/SBS) - RPM

DIAMETER	SOFTWOOD	HARDWOOD
6-10mm	2000	1500
11-15mm	1500	1250
16-20mm	1250	1000
21-25mm	1000	750
26-32mm	750	500

FLAT WOOD BITS - RPM

DIAMETER	COMPOSITES / SOFTWOOD
10-13mm	2000
14-25mm	1750
26-40mm	1500