

CORDLESS DRILL/DRIVER

ZINC STEEL SHEET - 0.8mm DRILL BIT - 5.0mm

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 **LIGHT PRESSURE** as you drill, re-applying cutting fluid as needed

DRILL DIAMETER	MATERIAL	MATERIAL THICKNESS	TESTING TOOL	SPEED / TORQUE RECORDED	SPEED	PRESSURE	IMPACT	HOLES	BLUNT / RETIRED
5.0mm	Zinc Steel Sheet	0.8mm	Makita Drill/Driver DF001GZ 40V 5.0Ah Battery	Flat out / Light Pressure	High (up to 2,600rpm)	Light	N/A	2000+	N/A

TIME TEST - DRILLING 5 HOLES

0:12

IMPACT DRIVER

ZINC STEEL SHEET - 0.8mm DRILL BIT - 5.0mm

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 **LIGHT PRESSURE** as you drill

Drill at **HIGH SPEED**, re-applying cutting fluid as needed

DRILL DIAMETER	MATERIAL	MATERIAL THICKNESS	TESTING TOOL	SPEED / TORQUE RECORDED	SPEED	PRESSURE	IMPACT	HOLES	BLUNT / RETIRED
5.0mm	Zinc Steel Sheet	0.8mm	Makita Impact Driver TD001GZ 40V 5.0Ah Battery	N/A	High (up to 3,200rpm)	Light	Low	2000+	N/A

NOTES:

No advantage from using impact