

For best performance, please read these instructions carefully and keep for your reference.

FEATURES

- Fast accurate cutting of steel plate up to 3/16" thick.
- Overlapping and interrupted cutting.
- Ultra-hard carbide teeth.
- Pilot drill provides a smoother entry into the work piece.

DRILLS

Recommended for use in corded or cordless drills.
Small diameter hole cutters should be run at high speed, while large diameter hole cutters should be run slower.

DRILLING CONDITIONS

Cutting fluid is recommended for best tool performance and long cutting tool life.

OPERATING INSTRUCTIONS

- Insert the hole cutter into the drill.
- Secure drill chuck jaws on flats of hole cutter shank.
- Begin drilling using light feed pressure until the hole cutter has begun drilling.
- Apply medium feed pressure once the cutter has engaged in material.
- Do not use impact or hammer mode on any power drill with this product.

REPLACEMENT PARTS

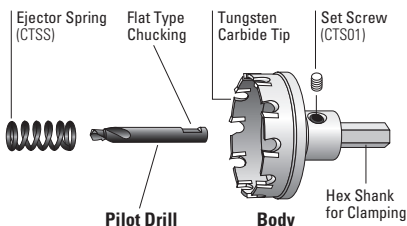
Pilot Drill : CTSP, Set Screw: CTS01, Spring: CTSS

SPEED RECOMMENDATION

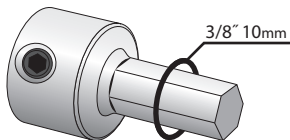
SIZE -inches / (mm)	STEEL	STAINLESS STEEL
9/16"–13/16" (14-21)	700 - 1000 RPM	300 - 700 RPM
7/8"–1-3/16" (22-30)	500 - 800 RPM	200 - 450 RPM
1-7/32"–1-9/16" (31-40)	300 - 600 RPM	175 - 315 RPM
1-5/8"–1-15/16" (41-50)	200 - 500 RPM	120 - 225 RPM
2"–2-3/8" (51-60)	200 - 400 RPM	95 - 195 RPM
2-7/16"–3" (61-76)	150 - 300 RPM	80 - 150 RPM
3-1/8"–5" (77-127)	100 - 200 RPM	60 - 120 RPM

APPLICATIONS

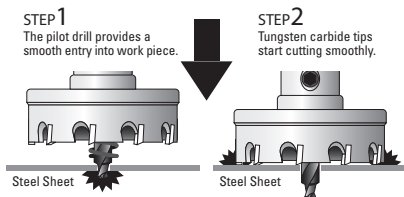
For drilling iron, steel, copper and cast iron to 3/16", stainless steel and aluminum to 1/8".



⚠ Attach to the shank securely.



⚠ Allow pilot drill to smoothly enter the work piece.



⚠ CAUTION

- Always wear eye and ear protection when drilling.
- Properly prepare the work environment prior to cutting.
- Never touch moving cutter, and keep hands clear from any moving parts.
- Do not touch the cutter, chips, or plug immediately after drilling as these may be extremely hot.
- Carefully read the instruction manual of the drill prior to use.

Questions? 800.733.3377 • 330.453.8187. mkmorse.com