

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

## FEATURES

- Fast accurate drilling of steel plate up to 1" thick.
- Unique geometry and grind design.
- Overlapping and interrupted cutting.
- Ultra-hard carbide teeth.

## APPLICATIONS

For drilling iron and steel, aluminum, copper, cast iron, and stainless steels up to 1" thick

## DRILLS

Use the following electrical drills:

- Corded or cordless drills or those having the rotation mode.
- Magnetic ball grinding machines.
- Table ball grinding machines.

Power: 500 W - 800 W Speed: Approx. 500 - 1600 rpm

## CUTTING CONDITIONS

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

## OPERATING INSTRUCTIONS

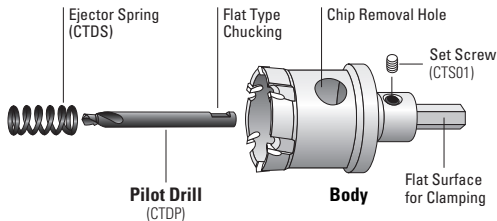
- Insert the hole cutter into the drill.
- Secure drill chuck jaws on flats of hole cutter shank.
- Begin drilling using light feed pressure until the hole cutter has begun cutting.
- Apply medium feed pressure once the cutter has engaged in material.
- Do not use impact or hammer mode on any power drill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

## REPLACEMENT PARTS

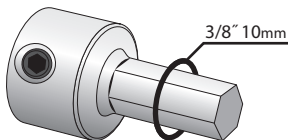
Pilot Drill : CTDP, Set Screw: CTS01, Spring: CTDS

## SPEED RECOMMENDATION

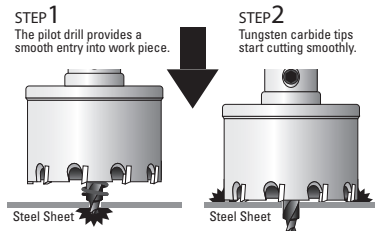
SIZE -inches / (mm)	STEEL	STAINLESS STEEL
9/16" - 13/16" (14-21)	700 - 1000 RPM	300 - 700 RPM
7/8" - 1-3/16" (22-30)	500 - 800 RPM	200 - 450 RPM
1-7/32" - 1-9/16" (31-40)	300 - 600 RPM	175 - 315 RPM
1-5/8" - 1-15/16" (41-50)	200 - 500 RPM	120 - 225 RPM
2" - 2-3/8" (51-60)	200 - 400 RPM	95 - 195 RPM
2-7/16"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



⚠ 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.

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