

# OPERATING INSTRUCTION FOR

## CARBIDE DRILLS TO REMOVE JAMMED TAPS:

The drilling (removing) must be done dry, with approx. 1500-3500 Rpm. By using the suitable core hole drill. The core of the tap can be drilled easily and the remaining parts of the tap can be removed properly out of the drill hole. The work piece has to be clamped very stable in order to prevent any movements when operating with high speed. In case the tap is not broken straight, in this case there has to be made a centering point by a multiple approaching with the Carbide Drill. Only after that the final drilling can be started. Furthermore also the chips have to be removed several times.

Shortly before finishing the drilling you will notice some vibrations. Then do not use anymore the Drill. Now it is possible to tap a new thread with a Tap.

Due to the strong use when drilling, the cutting edges of the Carbide Drill have to be resharpened from time to time, in order to achieve best results.

The metric sizes from M 3 up to M 12 can be supplied ex stocks. Delivery times for other sizes on request.

