BST GROUP

Alpha

VERSADRIVE©

PATENT PROTECTED

Reinventing onsite metalworking processes

The world's 1st modular quick-change
cutting & drilling system
designed for **Impact & Rotary tools**

Contents

VERSADRIVE© PATENT PROTECTED — Reinventing onsite metalworking processes

IMPACT RATED

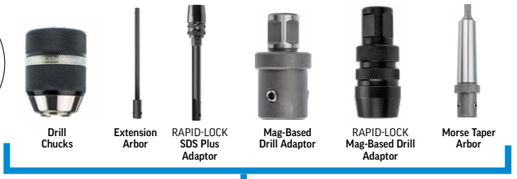
For high speed applications like drilling, reaming & tapping.

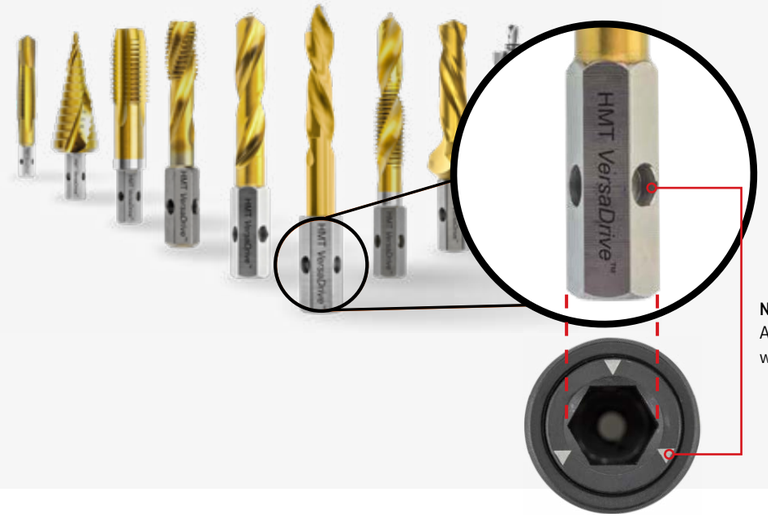
MODULAR ADAPTORS OPTIMISE METALWORKING PROCESSES

INDUSTRIAL STRENGTH TOOLS FOR MAXIMUM LIFE

ROTARY RATED

For slow speed applications like heavy duty tapping, countersinking or broaching.





VersaDrive™ Hex Shank

- Fits all standard 1/2" drill chucks
- High strength, non-slip shank design – no slipping in the chuck like standard tools
- Three concentric lock positions give perfect alignment & accuracy

Non-Slip Shank Fitment
Align the dimples on the VersaDrive® Hex Shank with lock position arrows on the VersaDrive® Adaptor

The world's 1st modular quick-change **cutting & drilling system** designed for **Impact & Rotary tools**

View product overview at www.rebrand.ly/VersaDrive

RAPID-LOCK
1/4" Impact Driver Adaptor

1/4" QUICK CHANGE

Drive Size	Ø mm	OAL mm	CODE
1/4" Hex	28	75	**111026-014A**

- New RAPID-LOCK single handed loading
- Improved quick release collar prevents accidental tool release caused by vibrations or contact with the work-piece
- Knurled collar provides ultimate grip in greasy or damp conditions
- High quality, heavy duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/4" Hex impact drivers
- Converts standard 1/4" impact drivers for use with VersaDrive™

RAPID-LOCK
1/2" Impact Wrench Adaptor

1/2" SQUARE IMPACT

Rated to 650nm

Supplied with retention pin & ring

Drive Size	Ø mm	OAL mm	CODE
1/2" Drive	28	55	**111130-012A**

- New RAPID-LOCK single handed loading
- Improved quick release collar prevents accidental tool release caused by vibrations or contact with the work-piece
- Knurled collar provides ultimate grip in greasy or damp conditions
- High quality, heavy duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/2" impact wrenches
- Converts standard 1/2" impact drivers for use with VersaDrive™

RAPID-LOCK
HD Impact Wrench Adaptors

1/2" SQUARE IMPACT

Drive Size	Ø mm	OAL mm	CODE
1/2" Drive	25	55	**111120-012A**

- Engineered for heavy duty applications
- Impact hardened manganese phosphate adaptor
- ½" HD adaptor has full-forward release which reduces risk of tool loosening during use

3/4" SQUARE IMPACT

Drive Size	Ø mm	OAL mm	CODE
3/4" Drive	38	60	**111110-034A**

- Engineered for heavy duty applications
- ¾" Adaptor has pull back release
- Developed to work with latest generation of high torque cordless impact wrenches capable of generating above 1,000Nm of torque

RAPID-LOCK
SDS Plus Adaptor

SDS plus

Ø mm	OAL mm	CODE
28	140	**112010-01**

- New RAPID-LOCK single handed loading
- Improved quick release collar prevents accidental tool release caused by vibrations or contact with the work-piece
- Knurled collar provides ultimate grip in greasy or damp conditions
- High quality, heavy duty steel components
- Converts all standard SDS Plus rotary hammer drills for use with VersaDrive™ system (in rotary mode)

ALSO AVAILABLE

Alpha

SDS Max to SDS Plus Adaptor

OAL 220mm **Code:** SX-SPADP

Extension Arbor - 300mm

VERSADRIVE
STANDARD
HEX SHANK

Ø mm	OAL mm	CODE
23	300	111010-0002

- Join multiple extensions for extra length
- Will pass through holes larger than 23mm
- Not rated for impact wrench use

Morse Taper Arbors

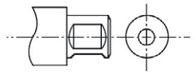
VERSADRIVE
STANDARD
HEX SHANK

Shank Size	Ø mm	OAL mm	CODE
MT2	30	80	111040-0001*
MT3	30	99	111040-0002*

- 3x stainless steel M8 grub screws supplied per adaptor
- Ideal for workshop use with radial arm drills & pedestal drill
- Also suitable for mag-based drills with morse taper capability

*Available on request (lead times apply)

RAPID-LOCK
Mag-Based Drill Adaptor

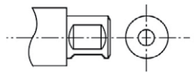


WELDON SHANK

Shank Size	Ø mm	OAL mm	CODE
19.05mm (3/4")	28	66	111035-01

- New RAPID-LOCK single handed loading
- Improved quick release collar prevents accidental tool release caused by vibrations or contact with the work-piece
- Fits all standard 19.05mm (3/4") mag-based drill arbors

Mag-Based Drill Adaptor

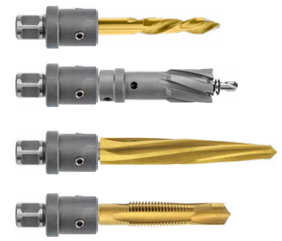


WELDON SHANK

VERSADRIVE
STANDARD
HEX SHANK

Shank Size	Ø mm	OAL mm	CODE
19.05mm (3/4")	30	63.5	111030-0001

- 3x stainless steel M8 doghead grub screws supplied per adaptor
- Fits into any standard 19.05mm (3/4") mag-based drill arbor



Clutched Tap Adaptor

IMPACT RATED

ROTARY RATED

Versatile blind hole tapping

The VersaDrive™ clutched tap collet system is a unique method of effectively threading blind holes.

All collets work with the full range of VersaDrive™ taps. When the tap comes to the bottom of the hole, the clutch system will engage and stop the tap from breaking. The tap is then reversed out of the completed hole.

This system fits a 19.05mm (3/4") Mag-Based Drill Arbor, or can be adapted for use with a 1/2" or 3/4" impact wrench.

- Quick change system accepts all VersaDrive™ taps
- Collets are pre-set to the appropriate clutch settings
- Further clutch adjustment options available
- For blind hole tapping with VersaDrive™ Spiral Flute Taps
- For use with variable speed, reversible mag-based drills, pedestal drills or imapct wrenches

Weldon Shank Tap Collet Holder

19.05mm / 3/4 **Code: 120010***

Clutched Blind Hole Tap Collet

M6-M12 **Code: 121015-M12***

M16-M24 **Code: 121015-M24***

M6-M24 Blind Hole Tapping Kits

7 x Spiral Flute Taps (Metric Coarse): 6, 8, 10, 12, 16, 20 & 24mm

includes 1/2" Impact Adaptor **Code: 121015-SET12***

includes 3/4" Impact Adaptor **Code: 121015-SET34***

*Available on request (lead times apply)

IMPACT RATED

ROTARY RATED

30 PCE Metric Site Installation Kit

Code: VSD-INSET-ME

Keep the job moving

The Site Installation Kit has been created to meet the demanding Australian on-site industrial and remote location hole making challenges i.e heavy engineering, mining, plant maintenance, construction, rail, heavy industrial and steel fabrication.

Utilises all portable tool types with a complete range of adaptors – it's the perfect starters kit.

Presented in a tough ABS case with cut out foam inserts, protecting your tools from the elements in the harshest environments.

Code: VSD-INSET-ME

ALSO AVAILABLE

Alpha C.D.T Cutting Lubricant

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals.

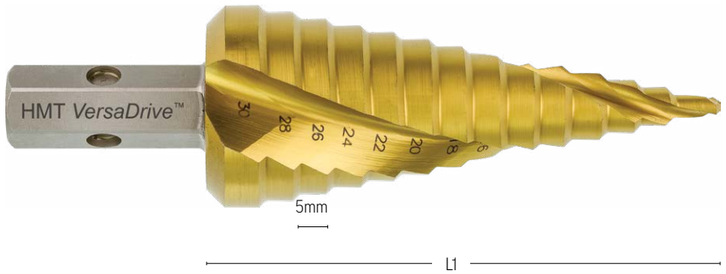
Code: ATL005

Product	QTY	Sizes / Details
ImpactaTaps®	5	M8, M10, M12, M16, M20
Countersinks	3	16.5, 20.5 & 25.0mm
Impact Reamers	4	10.0, 14.0, 18.0, 22.0mm
TurboTip Drill Bits	5	6.8, 8.5, 10.5, 12.0, & 14.0mm
TCT Hole Cutters complete with Arbor & Pilot Drill/Spring	5	12.0, 14.0, 18.0 22.0 & 26.0mm
Step Drill 4 – 22mm	1	4, 6, 8, 10, 12, 14, 16, 18 & 22mm
SDS Plus Adaptor	1	11mm Hex Shank x SDS Plus
1/2" Impact Wrench Adaptor	1	11mm Hex shank x 1/2" SQ
1/4" Impact Driver Adaptor	1	11mm Hex shank x 1/4" Quick change
Mag-Based Drill Adaptor	1	11mm Hex shank x 3/4" Weldon shank
300mm Extension Arbor	1	11mm Hex shank x 11mm Hex shank
Pilot Drill	1	101030P-0001
Pilot Pin	1	101030P-0003
Hex Keys	3	3, 4 & 5mm

Impact Step Drills

IMPACT RATED

ROTARY RATED



Suits all Adaptors

pags 4 to 7

Also suitable with any standard drill chuck

The first step drill optimised for use with impact wrenches and impact drivers allowing the user to create holes in seconds.

- Specially hardened for impact wrench use
- Market leading 5mm thick drilling capacity
- Precision ground flutes for easy chip clearance with 135° split point angle for easy starting & accuracy
- Spiral flute design, for fast, smooth drilling with minimal kickback
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. For fastest performance use on impact wrenches & impact drivers
2. Excellent life & performance when used with rotary pistol drills or drill presses
3. Apply firm, steady feed pressure throughout the cut
4. Avoid lateral movement or tilting which can cause tool damage
5. Ensure regular application of quality cooling lubricant, especially when drilling hardened materials
6. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- When drilling into box section ensure the tip of the step drill is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool
- When drilling stainless steel & harder materials, a lower RPM is recommended

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Recommended applications

Impact Step Drills – **Metric**

Ø mm	No. of Steps	Step Depth mm	OAL mm	L1 mm	Ø included	CODE	IMPACT: Impact Wrench	IMPACT: Impact Driver	IMPACT: Hammer Drill	ROTARY: Cordless Drill	ROTARY: Pedestal Drill	ROTARY: Mag-Based Drill
4 – 12	5	5	75	47	4, 6, 8, 10 & 12mm	505020-0120	●	●	●	●	●	●
4 – 22	9	5	86	58	4, 6, 8, 10, 12, 14, 16, 18 & 22mm	505020-0220	●	●	●	●	●	●
4 – 30	13	5	105	77	4, 6, 8, 10, 12, 14, 16, 18, 22, 24, 26, 28 & 30mm	505020-0300	●	●	●	●	●	●
6 – 40	11	6	101	72	6, 8, 10, 12, 16, 20, 25, 29, 32, 36 & 40mm	505020-0400	●	●	●	●	●	●

Legend: ● Optimal ✖ Not recommended

SETS – Metric

3 PCE

Sizes: 4 – 12, 4 – 22 & 4 – 30mm

Code: 505020-SET1

4 PCE

Sizes: 4 – 12, 4 – 22, 4 – 30 & 6 – 40mm

Code: 505020-SET2

Reference Chart

Impact Torque Nm

Step Drill	Impact Torque
Ø mm	Nm Torque
3 – 12	200-280
14 – 22	330-400
24 – 30	400-485
32 – 40	610-750

Rotary RPM

Step Drill	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Ø mm	RPM Range					
3 – 12	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
14 – 22	597-430	390-270	200-145	600-440	245-180	380-275
24 – 30	420-330	260-215	140-110	420-330	175-135	275-180
32 – 40	260-230	160-145	85-75	260-230	95-85	150-140

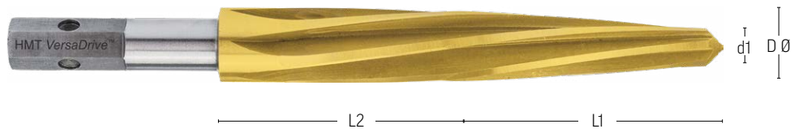
Impact Reamers

IMPACT RATED

ROTARY RATED

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck



Enlarge or align existing holes with an impact wrench

VersaDrive™ Impact Reamers are the perfect hole alignment and enlarging tool for metalworkers and fabricators for keeping the job moving when a hole is misaligned or the incorrect size.

- Specially hardened for impact wrench use
- Precision 6-flute design for smooth cutting
- Safer reaming with minimal kickback
- High grade tool steel for high accuracy & long life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- Use on Impact or Rotary
- High strength, non-slip shank design

User Guide

1. For fastest performance use on impact wrenches & impact drivers
2. Reamer should be rotating before starting the cut
3. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly & cautiously during the first 1mm of cut
4. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
5. Avoid lateral movement or tilting which can cause tool damage
6. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

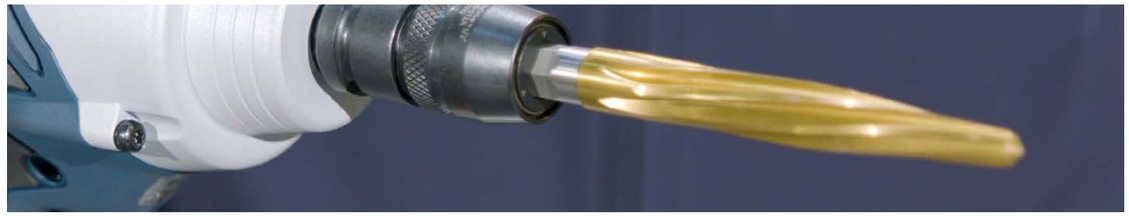
- To maximise tool life do not attempt to increase the existing hole diameter beyond 2 – 3mm
- If a larger finished hole size is required, use a succession of reamers increasing in 2mm increments until the finished hole diameter is reached
- Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation the hole can be reamed out with a slow speed mag-based drill
- For materials thicker than 20mm a ImpactaMag Reamer is recommended (available upon request)

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions



Recommended applications

Reamers – Metric

Ø mm	d1 Ø mm	OAL mm	L1 mm	L2 mm	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
8	4.4	108	34	36	501030-0080	●	●	●	●	●	●
10	6.0	108	34	36	501030-0100	●	●	●	●	●	●
12	7.1	144	43	59	501030-0120	●	●	●	●	●	●
14	7.5	144	52	50	501030-0140	●	●	●	●	●	●
16	8.0	152	58	56	501030-0160	●	●	●	●	●	●
18	9.4	170	58	56	501030-0180	●	●	●	●	●	●
20	11.2	178	61	65	501030-0200	●	●	●	●	●	●
21	12.3	185	61	66	501030-0210*	●	●	●	●	●	●
22	13.2	185	61	66	501030-0220	●	●	●	●	●	●
24	15.1	185	63	64	501030-0240	●	●	●	●	●	●
26	15.9	185	61	64	501030-0260	●	●	●	●	●	●

Reamers – Imperial

Ø	d1 Ø	OAL	L1	L2	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
1/2" (12.7mm)	19/64"	5 1/2"	1-15/16"	2-1/16"	501040-0040*	●	●	●	●	●	●
9/16" (14.3mm)	9/32"	5 1/2"	2-1/16"	1-15/16"	501040-0050*	●	●	●	●	●	●
5/8" (15.9mm)	5/16"	6"	2-11/64"	2-21/64"	501040-0060*	●	●	●	●	●	●
11/16" (17.5mm)	3/8"	6"	2-1/4"	2-1/4"	501040-0070*	●	●	●	●	●	●
3/4" (19.05mm)	13/32"	7"	2-31/64"	2-33/64"	501040-0080*	●	●	●	●	●	●
13/16" (20.63mm)	15/32"	7"	2-33/64"	2-31/64"	501040-0085*	●	●	●	●	●	●
7/8" (22.2mm)	17/32"	7"	2-19/32"	2-13/32"	501040-0090*	●	●	●	●	●	●
15/16" (23.8mm)	19/32"	7"	2-43/64"	2-21/64"	501040-0100*	●	●	●	●	●	●
1" (25.4mm)	5/8"	7"	2-43/64"	2-21/64"	501040-0110*	●	●	●	●	●	●
1-1/16" (27mm)	45/64"	7"	2-9/16"	2-7/16"	501040-0120*	●	●	●	●	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

SETS – Metric

3 PCE
Sizes: 14, 18, & 22mm
Code: 501030-3SET*

5 PCE
Sizes: 12, 14, 18, 22, & 26mm
Code: 501030-SET*

SETS – Imperial

3 PCE
Sizes: 11/2, 5/8 & 3/4"
Code: 501040-3SET*

5 PCE
Sizes: 1/2, 5/8, 3/4, 7/8 & 1 1-16
Code: 501040-5SET*

Reference Chart

Impact Torque Nm

Reamer	<12mm Steel	<25mm Steel
Ø mm	Torque Nm	
8	200	380
10	220	400
12	280	420
14	320	480
16	340	510
18	360	540
20	380	570
21	390	580
22	400	600
24	520	780
26	520	840

Rotary RPM

Reamer	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min
Ø mm	RPM Range				
8	940	540	410	1020	550
10	900	510	380	1005	530
12	875	490	370	995	520
14	690	360	305	700	450
16	640	335	225	660	340
18	535	290	210	550	305
20	490	230	195	510	250
21	480	225	190	500	240
22	460	210	180	470	235
24	360	150	140	430	215
26	310	140	135	375	200

Impact Torque Ft Lb

Reamer	<1/2" Steel	<1" Steel
Ø inches	Ft Lb	
1/2"	205	310
9/16"	235	355
5/8"	250	375
11/16"	265	400
3/4"	280	420
7/8"	295	440
15/16"	380	575
1"	390	620
1-1/16"	440	660

Rotary RPM

Reamer	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Cast Iron 16m/min	Aluminium 45m/min
Ø inches	RPM Range				
1/2"	875	490	370	520	1275
9/16"	690	360	305	450	1025
5/8"	640	335	225	340	975
11/16"	535	290	210	305	860
3/4"	490	230	195	250	745
7/8"	460	210	180	235	675
15/16"	360	150	140	215	540
1"	310	140	135	200	410
1-1/16"	295	130	125	190	385

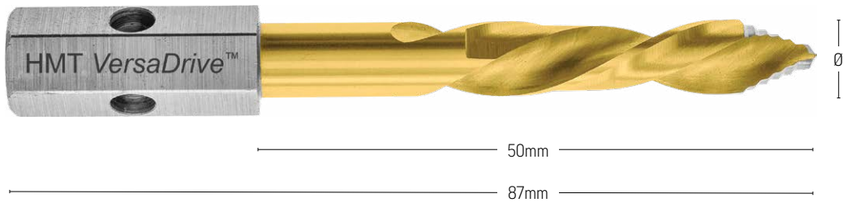
TurboTip® Drill Bits

IMPACT RATED

ROTARY RATED

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck



VersaDrive™ TurboTip® Drill Bits are stepped tip bits that drill at twice the speed of standard bits without the need for pilot drilling while cutting a perfectly round hole.

Patented Drill Point

- Specially hardened for impact wrench use
- 50% faster drilling with 30% less pressure
- Fully impact rated on structural steel
- Incredible finished hole quality
- Instant drill start with no slipping
- No 'snatch' when drill bit breaks through
- Fantastic tool life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. For fastest performance use on impact wrenches & impact drivers
2. For optimum life & accuracy use with pedestal drills & mag-based drills
3. Apply firm, steady feed pressure throughout the cut
4. Avoid lateral movement or tilting which can cause tool damage
5. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
6. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- Hardened, stainless steel & heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Recommended applications

TurboTip® Drill Bits – **Metric**

Ø mm	Tap Size (Metric Coarse)	CODE	IMPACT			ROTARY		
			Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
6.0		209015-0060	●	●	●	●	●	●
6.8	M8	209015-0068	●	●	●	●	●	●
7.0		209015-0070	●	●	●	●	●	●
8.0		209015-0080	●	●	●	●	●	●
8.5	M10	209015-0085	●	●	●	●	●	●
9.0		209015-0090	●	●	●	●	●	●
10.0		209015-0100	●	●	●	●	●	●
10.5		209015-0105	●	●	●	●	●	●
11.0		209015-0110	●	●	●	●	●	●
12.0	M14	209015-0120	●	●	●	●	●	●
13.0		209015-0130	●	●	●	●	●	●
14.0	M16	209015-0140	●	●	●	●	●	●
16.0		209015-0160	●	●	●	●	●	●
18.0		209015-0180	●	●	●	●	●	●
20.0		209015-0200	●	●	●	●	●	●
22.0		209015-0220	●	●	●	●	●	●

TurboTip® Drill Bits – **Imperial**

Ø inches	Ø mm	Tap Size	CODE	IMPACT			ROTARY		
				Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
3/16"	4.8		209016-0010	●	●	●	●	●	●
#7	5.1	1/4-20 UNC	209016-0020	●	●	●	●	●	●
7/32"	5.6		209016-0030	●	●	●	●	●	●
1/4"	6.4		209016-0040	●	●	●	●	●	●
#F	6.6	5/16-18 UNC	209016-0050*	●	●	●	●	●	●
9/32"	7.1		209016-0060	●	●	●	●	●	●
5/16"	7.9	3/8-16 UNC	209016-0070	●	●	●	●	●	●
11/32"	8.7		209016-0080	●	●	●	●	●	●
3/8"	9.5		209016-0090	●	●	●	●	●	●
27/64"	10.7	1/2-13 UNC	209016-0100	●	●	●	●	●	●
7/16"	11.1		209016-0120	●	●	●	●	●	●
1/2"	12.7		209016-0130	●	●	●	●	●	●

SETS – Metric

4 PCE
Sizes: 6, 8, 10 & 12mm
Code: 209015-SET1

7 PCE
Sizes: 6, 7, 8, 9, 10, 11 & 12mm
Code: 209015-SET2

7 PCE
Sizes: 6.8, 8, 8.5, 10, 10.5, 12 & 14mm
Code: 209015-SET3

Legend: ● Optimal ✖ Not recommended

*Available on request (lead times apply)

Reference Chart

Impact Torque Nm

Drill Bit	8mm Thick Steel	9 – 20mm Thick Steel
Ø mm	Nm Torque	
6 – 8	140-200	200-250
8.5 – 10.5	200-340	260-405
11 – 13	360-430	420-550
14 – 15	440-500	570-620
16 – 18	550-660	640-720
20 – 22	680-750	750-995

Rotary RPM

Drill Bit	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min
Ø mm	RPM Range						
3 – 4	3400-2550	1700-1250	850-700	3400-2550	2000-1300	4300-2000	5200-3500
5 – 9	2100-1140	1020-575	760-420	2050-1130	1200-600	1750-1040	3400-1550
10 – 15	1030-660	520-350	385-225	1020-660	550-340	1025-620	1500-950
16 – 20	640-490	335-230	220-195	640-510	330-250	600-470	975-745
21 – 25	460-330	220-140	190-150	500-410	240-200	460-350	730-500
26 – 32	310-250	140-110	150-120	320-275	200-175	335-320	400-315

Cobalt Drill Bits

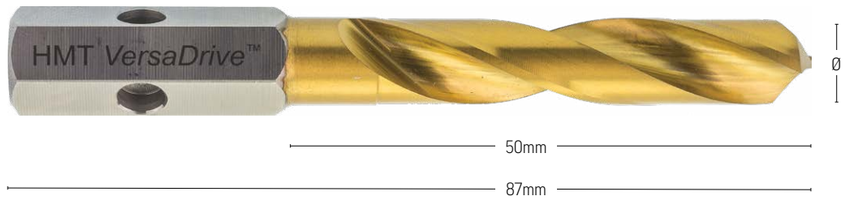
IMPACT RATED

ROTARY RATED

Heavy duty cobalt drill bits

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck



VersaDrive™ Heavy Duty Cobalt Drills are made from premium grade 8% cobalt high speed steel, with an additional high-quality titanium nitride coating. Perfect for hard materials, cobalt drill bits drill faster and for longer, helping you get the job done right the first time.

- Specially hardened for impact wrench use
- Fast drilling with minimal kick-back
- Dual hardened for impact wrench use up to 10mm (*see application information)
- Precision ground flutes for easy chip clearance
- 135° Split point for easy starting & high accuracy
- 8% Cobalt for long life & high performance
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. **Drills up to 10mm can be used on impact wrenches & impact drivers for fast cutting performance**
2. **Drills above 10mm are not recommended be used with impact wrenches, as impact wrenches tend to run at high RPMs, which may cause premature wear or breakage**
3. Good results can be achieved in larger sizes with SDS hammer drills (in rotary mode only)
4. For fastest performance use on impact wrenches & impact drivers
5. For optimum life & accuracy use with pedestal drills & mag-based drills
6. Apply firm, steady feed pressure throughout the cut
7. Avoid lateral movement or tilting which can cause tool damage
8. Use appropriate lubrication & correct RPM to achieve long tool life
9. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- Stainless steel, hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Cobalt Drill Bits – **Metric**

Recommended applications

Ø mm	Tap Size (Metric Coarse)	CODE	IMPACT			ROTARY		
			Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
4.2	M5	209010-0042	●	●	●	●	●	●
5.0	M6	209010-0050	●	●	●	●	●	●
5.5	-	209010-0055	●	●	●	●	●	●
6.0	-	209010-0060	●	●	●	●	●	●
6.5	-	209010-0065	●	●	●	●	●	●
6.8	M8	209010-0068	●	●	●	●	●	●
7.0	-	209010-0070	●	●	●	●	●	●
7.5	-	209010-0075	●	●	●	●	●	●
8.0	-	209010-0080	●	●	●	●	●	●
8.5	M10	209010-0085	●	●	●	●	●	●
9.0	-	209010-0090	●	●	●	●	●	●
9.5	-	209010-0095	●	●	●	●	●	●
10.0	-	209010-0100	●	●	●	●	●	●
10.2	M12	209010-0102	✖	✖	○	●	●	●
10.5	-	209010-0105	✖	✖	○	●	●	●
11.5	-	209010-0115	✖	✖	○	●	●	●
12.0	M14	209010-0120	✖	✖	○	●	●	●
12.5	-	209010-0125	✖	✖	○	●	●	●
13.0	-	209010-0130	✖	✖	○	●	●	●
14.0	M16	209010-0140*	✖	✖	○	●	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended ○ Possible (refer to User Guide)

Cobalt Drill Bit Sets

4 PCE

Sizes: 6.0, 8.0, 10.0 & 12.0mm

Code: 209010-SET1*

4 PCE

Sizes: 5.0, 6.8, 8.5 & 10.2mm

Code: 209010-SET2*

7 PCE

Sizes: 5.0, 6.0, 6.8, 8.0, 8.5, 10.0 & 10.2mm

Code: 209010-SET3*

Reference Chart

Impact Torque Nm

Drill Bit	Impact Torque
Ø mm	Nm Torque
6.0	140
6.8	170
7.0	195
8.0	240
8.5	270
9.0	360
10.0	375
11.0	405
12.0	420
13.0	435
14.0	440

Rotary RPM

Drill Bit	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min
Ø mm	RPM Range						
3 - 4	3400-2550	1700-1250	850-700	3400-2550	2000-1300	4300-2000	5200-3500
5 - 9	2100-1140	1020-575	760-420	2050-1130	1200-600	1750-1040	3400-1550
10 - 15	1030-660	520-350	385-225	1020-660	550-340	1025-620	1500-950
16 - 20	640-490	335-230	220-195	640-510	330-250	600-470	975-745
21 - 25	460-330	220-140	190-150	500-410	240-200	460-350	730-500
26 - 32	310-250	140-110	150-120	320-275	200-175	335-320	400-315

ImpactaTaps®

IMPACT RATED

ROTARY RATED

15x faster than hand tapping

Suits all Adaptors
pags 4 to 7

VersaDrive™ ImpactaTaps® are the first and only range of taps that are suitable for impact wrenches and impact drivers, providing at least 15x faster performance than tapping by hand.

- Specially hardened for impact wrench use
- Precision ground for high accuracy to create the perfect tapped hole
- Safer tapping with minimal kick-back
- High grade tool steel for high performance & long life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. For fastest performance use with impact wrenches & impact drivers
2. For optimum life & accuracy use with pedestal drills & magnet drill
3. Pilot drill the exact tapping size hole for best results
4. Apply firm, steady feed pressure throughout the cut
5. Ensure the tap is inserted squarely to the hole, poorly aligned or off-centre taps will greatly increase the risk of breakage
6. When using cordless tools, the torque can drop when the battery is low which can cause tool damage
7. Tap the hole in one pass where possible, applying adequate lubrication before tapping
8. Ensure regular application of quality cooling lubricant, especially when tapping thick or hardened materials
9. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage. *If exact match is not available select the closest torque setting above the recommendation

Application information

- **ImpactaTaps®** are recommended for through hole applications only
- **Spiral Flute Taps** are designed primarily for tapping blind holes
- For blind hole tapping optimum performance & life, use the Clutched Tap Adaptor (refer to pg. 6)
- Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- Flame cut/punched holes will require more torque to tap than drilled holes due to heat build-up. **Caution:** sometimes flame cut holes do not have parallel sides creating risk of tap breakage
- If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adaptor & start it in the thread by hand, before reversing
- When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

ImpactaTaps® Metric Coarse

L1

Metric Coarse

Thread Ø	Pitch mm	OAL mm	L1 mm	Drill Size mm	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
M5	0.80	55	18	4.2	308010-0050	●	●	●	●	●	●
M6	1.00	55	20	5.0	308010-0060	●	●	●	●	●	●
M8	1.25	60	22	6.8	308010-0080	●	●	●	●	●	●
M10	1.50	70	24	8.5	308010-0100	●	●	●	●	●	●
M12	1.75	80	29	10.2	308010-0120	●	●	●	✖	●	●
M14	2.00	90	32	12.0	308010-0140*	●	●	●	✖	●	●
M16	2.00	90	32	14.0	308010-0160	●	●	●	✖	●	●
M20	2.50	100	37	17.5	308010-0200	●	●	●	✖	●	●
M24	3.00	110	45	21.0	308010-0240	●	●	●	✖	●	●
M27	3.00	130	48	24.0	308010-0270*	●	●	●	✖	●	●
M30	3.50	130	48	26.5	308010-0300*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

Recommended applications

SETS
Metric Coarse

5 PCE
Sizes: M6, M8, M10, M12 & M16

Code: 308010-SET1

4 PCE
Sizes: M12, M16, M20 & M24

Code: 308010-SET2

ImpactaTaps® Metric Fine

L1

Metric Fine

Thread Ø	Pitch mm	OAL mm	L1 mm	Tap Hole Size	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
MF6	0.75	60	19	5.2mm	308030-0060*	●	●	●	●	●	●
MF8	1.00	70	22	7.0mm	308030-0800*	●	●	●	●	●	●
MF10	1.25	70	24	8.8mm	308030-0100*	●	●	●	●	●	●
MF12	1.50	80	29	10.5mm	308030-0120*	●	●	●	✖	●	●
MF16	1.50	90	32	14.5mm	308030-0160*	●	●	●	✖	●	●
MF18	1.50	100	37	16.5mm	308030-0180*	●	●	●	✖	●	●
MF20	1.50	100	37	18.5mm	308030-0200*	●	●	●	✖	●	●
MF24	1.50	120	92	22.5mm	308030-0240*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

Recommended applications

ImpactaTaps® Metric Coarse Oversized

Used for tapping holes used with galvanised fixings

L1

Metric Coarse Oversized

Recommended applications

Thread Ø	Pitch mm	OAL mm	L1 mm	Tap Hole Size mm	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
M5 + 0.4	0.80	55	18	4.2	308020-0050*	●	●	●	●	●	●
M6 + 0.4	1.00	55	20	5.0	308020-0060*	●	●	●	●	●	●
M8 + 0.4	1.25	60	22	6.8	308020-0080*	●	●	●	●	●	●
M10 + 0.4	1.50	70	24	8.5	308020-0100*	●	●	●	●	●	●
M12 + 0.4	1.75	80	29	10.2	308020-0120*	●	●	●	✖	●	●
M16 + 0.4	2.00	90	32	14.0	308020-0160*	●	●	●	✖	●	●
M20 + 0.4	2.50	100	37	17.5	308020-0200*	●	●	●	✖	●	●
M24 + 0.4	3.00	110	45	21.0	308020-0240*	●	●	●	✖	●	●
M30 + 0.4	3.50	130	48	26.5	308020-0300*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

SET Metric Coarse Oversized

6 PCE

Sizes: M5, M6, M8, M10, M12 & M16

Code: 308020-SET1

ImpactaTaps® BSW British Standard Whitworth

L1

BSW

Recommended applications

Thread Ø inches	TPI	OAL mm	L1 mm	Tap Hole Size	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
1/4"	20	58	20	5.1mm	308060-0010*	●	●	●	●	●	●
5/16"	18	60	22	6.5mm	308060-0015*	●	●	●	●	●	●
3/8"	16	70	24	7.9mm	308060-0020*	●	●	●	●	●	●
1/2"	12	80	29	10.5mm	308060-0030*	●	●	●	✖	●	●
5/8"	11	90	32	13.5mm	308060-0040*	●	●	●	✖	●	●
3/4"	10	100	37	16.25mm	308060-0050*	●	●	●	✖	●	●
1	8	110	45	22mm	308060-0060*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

ImpactaTaps® UNC Unified National Coarse

L1

UNC

Recommended application

Thread Ø	TPI	OAL mm	L1 mm	Drill Size mm	Tap Hole Size	CODE	IMPACT			ROTARY		
							Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
1/4"	20	58	20	5.10	#7	308050-0010*	●	●	●	●	●	●
5/16"	18	60	22	6.60	#F	308050-0020	●	●	●	●	●	●
3/8"	16	70	24	8.00	5/16"	308050-0030	●	●	●	●	●	●
1/2"	13	80	29	10.80	27/64"	308050-0040	●	●	●	✖	●	●
5/8"	11	90	32	13.50	17/32"	308050-0050	●	●	●	✖	●	●
3/4"	10	100	37	16.50	21/32"	308050-0060	●	●	●	✖	●	●
7/8"	9	105	40	19.50	49/64"	308050-0065	●	●	●	✖	●	●
1"	8	110	45	22.25	7/8"	308050-0070	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

SETS – UNC

5 PCE

Sizes: 1/4, 5/16, 3/8, 1/2 & 5/8"

Code: 308050-SET1*

4 PCE

Sizes: 1/2, 5/8, 3/4 & 1"

Code: 308050-SET2*

ImpactaTaps® BSPF British Standard Pipe Fitting

L1

BSP

Recommended applications

Thread Ø	TPI	OAL mm	L1 mm	Tap Hole Size	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
1/8"	28	70	24	8.8mm	308070-0010*	●	●	●	●	●	●
1/4"	19	90	32	11.8mm	308070-0020*	●	●	●	●	●	●
3/8"	19	90	32	15.25mm	308070-0030*	●	●	●	●	●	●
1/2"	14	100	37	19mm	308070-0040*	●	●	●	✖	●	●
5/8"	14	100	37	21mm	308070-0050*	●	●	●	✖	●	●
3/4"	14	100	37	24.5mm	308070-0060*	●	●	●	✖	●	●
1"	11	110	45	30.75mm	308070-0070*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

Spiral Flute Taps – Metric Coarse

Metric Coarse

Recommended applications: Impact Wrench, Impact Driver, Hammer Drill, Cordless Drill, Pedestal Drill, Mag-Based Drill

Thread Ø	Pitch mm	OAL mm	L1 mm	Tap Hole Size mm	CODE	IMPACT			ROTARY		
M6	1.00	58	20	5.0	309010-0060*	●	●	●	●	●	●
M8	1.25	60	22	6.8	309010-0080*	●	●	●	●	●	●
M10	1.50	70	24	8.5	309010-0100*	●	●	●	●	●	●
M12	1.75	80	29	10.2	309010-0120*	●	●	●	✖	●	●
M16	2.00	90	32	14.0	309010-0160*	●	●	●	✖	●	●
M20	2.50	100	37	17.5	309010-0200*	●	●	●	✖	●	●
M24	3.00	110	45	21.0	309010-0240*	●	●	●	✖	●	●
M30	3.50	130	48	26.5	309010-0300*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

SETS
Spiral Flute Taps
Metric Coarse

5 PCE
Sizes: M6, M8, M10, M12 & M16
Code: 309010-SET1*

4 PCE
Sizes: M12, M16, M20 & M24
Code: 309010-SET2*

M6 – M24 Blind Hole Tapping Kits

7 x Spiral Flute Taps (Metric Coarse): 6, 8, 10, 12, 16, 20 & 24

includes 1/2" Impact Adaptor **Code: 121015-SET12***

includes 3/4" Impact Adaptor **Code: 121015-SET34***

Spiral Flute Taps – UNC Unified National Coarse

UNC

Recommended applications: Impact Wrench, Impact Driver, Hammer Drill, Cordless Drill, Pedestal Drill, Mag-Based Drill

Thread Ø	TPI	OAL mm	L1 mm	Tap Hole Size		CODE	IMPACT			ROTARY		
1/4"	20	58	20	5.1mm	#7	309020-0010*	●	●	●	●	●	●
5/16"	18	60	22	6.6mm	#F	309020-0020*	●	●	●	●	●	●
3/8"	16	70	24	8.0mm	5/16"	309020-0030*	●	●	●	●	●	●
1/2"	13	80	29	10.8mm	27/64"	309020-0040*	●	●	●	✖	●	●
5/8"	11	90	32	13.5mm	17/32"	309020-0050*	●	●	●	✖	●	●
3/4"	10	100	37	16.5mm	21/32"	309020-0060*	●	●	●	✖	●	●
7/8"	9	105	40	19.5mm	49/64"	309020-0065*	●	●	●	✖	●	●
1"	8	110	45	22.25mm	7/8"	309020-0070*	●	●	●	✖	●	●
1-1/4"	7	128	41	28.17mm	1-7/64"	309020-0110*	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

SETS
Spiral Flute Taps
UNC

5 PCE
Sizes: 1/4, 5/16, 3/8, 1/2 & 5/8"
Code: 309020-SET1*

3 PCE
Sizes: 1/2, 3/4 & 1"
Code: 309020-SET2*

Reference Chart – Metric ImpactaTaps®

Impact Torque Nm

Thread	6mm Thick Steel Impact Tapping	12mm Thick Steel Impact Tapping	25mm Thick Steel Impact Tapping
Ø	Nm Torque		
M3	105	160	N/A
M4	120	180	N/A
M5	135	200	N/A
M6	145	240	400
M8	150	280	448
M10	170	300	480
M12	185	320	512
M14	190	340	544
M16	200	360	576
M20	315	400	640
M24	N/A	600	960
M27	N/A	740	1184
M30	N/A	800	1200

Rotary RPM

Thread	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
M8	365	310	245	1095	485
M10	295	245	195	870	390
M12	240	200	162	730	330
M14	210	175	140	625	275
M16	185	155	125	550	243
M20	145	125	100	440	194
M24	120	100	85	370	165
M27	105	90	75	330	145
M30	95	80	60	310	130

Reference Chart – Imperial ImpactaTaps®

Impact Torque Ft Lb

Thread	1/4" Thick Steel Impact Tapping	1/2" Thick Steel Impact Tapping	1" Thick Steel Impact Tapping
Ø inches	Ft Lbs Torque		
1/4	105	175	295
5/16	110	205	330
3/8	125	220	355
1/2	135	235	375
5/8	145	365	425
3/4	230	295	470
7/8	N/A	370	710
1"	N/A	445	735

Rotary RPM

Thread	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø inches	RPM Range				
1/4	485	405	325	1455	650
5/16	365	310	245	1095	485
3/8	295	245	195	870	390
1/2	240	200	162	730	330
5/8	185	155	125	550	243
3/4	145	125	100	440	194
7/8	130	115	92	410	180
1"	120	100	85	370	165

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

ImpactaTap® **Drill Taps**

IMPACT RATED

ROTARY RATED

Drill & Tap
in one easy operation
with an impact wrench

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck

Impacta Drill Taps are a time saving solution for pilot drilling and tapping in one easy operation. The titanium nitride coating provides wear resistance and faster cutting performance.

- Specially hardened for impact wrench use
- Drill & tap in one easy operation
- Safer tapping with minimal kick-back
- Ground flute twist drill creates the perfect tapping hole
- High grade tool steel for high accuracy & long life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. For fastest performance use on impact wrenches & impact drivers (check minimum torque requirement)
2. For optimum life & accuracy use with pedestal drills & mag-based drills
3. Ensure the drill tap is inserted squarely, lateral movement or misalignment will greatly increase the risk of breakage
4. Drill & tap the hole in one pass where possible applying adequate lubrication before commencing
5. Apply firm, steady feed pressure throughout the cut
6. **Up to M10 (3/8") can also be used on cordless drills**
7. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- Recommended for through hole applications only
- Maximum tapping thickness is the thread diameter of the drill-tap when using an impact wrench*
- Stainless steel, hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- Flame cut/punched holes will require more torque to tap than drilled holes due to heat build-up. **Caution:** sometimes flame cut holes do not have parallel sides creating risk of tap breakage

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

*When tapping material thicker than recommended, it is advisable to pilot drill the hole first, before drill-tapping the hole

Recommended applications

Impacta Drill Taps
Metric Coarse

Thread Ø	Pitch mm	d1 mm	OAL mm	L1 mm	Max tapping depth with impact wrench	CODE	IMPACT			ROTARY		
							Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
M3	0.50	2.5	55	6	3mm	301125-0030*	●	●	●	●	●	●
M4	0.70	3.3	60	9	4mm	301125-0040*	●	●	●	●	●	●
M5	0.80	4.2	71	13	5mm	301125-0050	●	●	●	●	●	●
M6	1.00	5.0	75	17	6mm	301125-0060	●	●	●	●	●	●
M8	1.25	6.8	82	20	8mm	301125-0080	●	●	●	●	●	●
M10	1.50	8.5	92	25	10mm	301125-0100	●	●	●	●	●	●
M12	1.75	10.2	103	31	12mm	301125-0120	●	●	●	✖	●	●

5 PCE SET
Metric Coarse
Sizes: M5, M6, M8, M10 & M12

Code: 301125-SET1

UNC

Thread Ø	TPI	d1	OAL	L1	Max tapping depth with impact wrench	CODE	IMPACT			ROTARY		
							Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
4 UNC	40	3/32	2-11/64	15/64"	3/32"	301126-0010*	●	●	●	●	●	●
6 UNC	32	7/64	2-23/64	23/64"	1/8"	301126-0020*	●	●	●	●	●	●
8 UNC	32	9/64	2-23/64	23/64"	5/32"	301126-0030*	●	●	●	●	●	●
10 UNC	24	5/32	2-51/64	33/64"	13/64"	301126-0040*	●	●	●	●	●	●
1/4"	20	13/64	2-61/64	19/32"	1/4"	301126-0050	●	●	●	●	●	●
5/16"	18	1/4	3-15/64	45/64"	5/16"	301126-0060	●	●	●	●	●	●
3/8"	16	5/16	3-5/8	55/64"	3/8"	301126-0070	●	●	●	●	●	●
1/2"	13	27/64	4/16	1-7/64"	1/2"	301126-0080	●	●	●	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended

4 PCE SET
UNC
Sizes: 1/4, 5/16, 3/8 & 1/2"

Code: 301126-SET1

Reference Charts

Impact Torque Nm

Impacta Drill Taps	12mm Thick Steel Impact Tapping	25mm Thick Steel Impact Tapping
Ø Metric Coarse	Nm Torque	
M3	160	N/A
M4	180	N/A
M5	200	N/A
M6	240	N/A
M8	280	N/A
M10	300	N/A
M12	320	512

Impact Torque Ft Lb

Impacta Drill Taps	1/2" Thick Steel Impact Tapping	1" Thick Steel Impact Tapping
Ø UNC	Ft Lbs Torque	
4 - 40 & 3 -32	120	N/A
8 -32 & 10 - 24	130	N/A
1/4	175	295
5/16	205	330
3/8	220	355
1/2	235	375

Rotary RPM

Impacta Drill Taps	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø Metric Coarse	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
M8	365	310	245	1095	485
M10	295	245	195	870	390
M12	240	200	162	730	330

Rotary RPM

Impacta Drill Taps	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø UNC	RPM Range				
4 - 40 & 3 -32	960	809	650	2700	1295
8 -32 & 10 - 24	730	610	490	2060	975
1/4	485	405	325	1455	650
5/16	365	310	245	1095	485
3/8	295	245	195	870	390
1/2	240	200	162	730	330

Heavy Duty ImpactaTap® Drill Taps

ROTARY RATED

Drill & tap in one easy operation

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck

The Heavy Duty Impacta-Drill Taps are an industrial metalwork and fabrication tool for drilling and tapping heavy steel in one easy operation.

Primarily designed to be used with a reversible mag-based drill, thought they can also be adapted for use with an impact wrench to enlarge and tap existing holes.

- Specially hardened for impact wrench use (*check application Guide)
- Drill point optimised for use in fixed drilling machines including mag-based drills & pedestal drills
- Unique dual-point starting angle for easy alignment & fast cut
- Fast tapping with minimal kick-back
- Chipbreaker action for automatic chip clearance when impact tapping (check application guide)
- High-grade tool steel for high accuracy & long life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. For optimum life and accuracy use with pedestal drills & mag-based drills
2. **For impact wrench use, pilot drilling is necessary**
3. **Not recommended for use in cordless drills**
4. For best results, pilot drill the exact tapping size hole first
5. Ensure the drill-tap is inserted squarely, lateral movement or misalignment will greatly increase the risk of breakage
6. Ensure the work-piece is clamped securely, lateral movement or misalignment will greatly increase the risk of breakage
7. Drill & tap the hole in one pass where possible, applying adequate lubrication prior to drilling
8. Apply firm, steady feed pressure throughout the cut
9. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
10. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage. **Correct RPM is critical for good performance on larger drill taps**

Application information

- Recommended for through hole applications only
- Designed for use with mag-based drills & pedestal drills, or for tapping pre-drilled holes with an impact wrench. **They are not designed for drill-tapping with hand-held rotary tools**
- Maximum tapping thickness is the thread diameter of the drill-tap when using an impact wrench. **Note:** when tapping material thicker than 15 – 20mm, it is advisable to pilot drill the hole first
- Stainless steel, hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- Flame cut/punched holes will require more torque to tap than drilled holes due to heat build-up. **Caution:** sometimes flame cut holes do not have parallel sides creating risk of tap breakage
- Select correct NM torque power for impact wrench applications

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

Recommended applications

Heavy Duty Impacta Drill Taps

Metric Coarse

Thread Ø	Pitch mm	d1 mm	OAL mm	L1 mm	Max tapping depth	CODE	IMPACT: Impact Wrench	IMPACT: Impact Driver	IMPACT: Hammer Drill	ROTARY: Cordless Drill	ROTARY: Pedestal Drill	ROTARY: Mag-Based Drill
M8	1.25	6.8	100	30	20mm	301130-0080	❍	✖	✖	✖	●	●
M10	1.50	8.5	105	30	20mm	301130-0100	❍	✖	✖	✖	●	●
M12	1.75	10.2	117	35	25mm	301130-0120	❍	✖	✖	✖	●	●
M16	2.00	14	117	37	25mm	301130-0160	❍	✖	✖	✖	●	●
M20	2.50	17.5	135	40	35mm	301130-0200	❍	✖	✖	✖	●	●
M24	3.00	21	148	45	40mm	301130-0240	❍	✖	✖	✖	●	●

UNC

Thread Size & Pitch	d1	OAL	L1	Max tapping depth	CODE	IMPACT: Impact Wrench	IMPACT: Impact Driver	IMPACT: Hammer Drill	ROTARY: Cordless Drill	ROTARY: Pedestal Drill	ROTARY: Mag-Based Drill
1/2-13 UNC	27/64	4 -23/32	1-3/8	1	301140-0001*	❍	✖	✖	✖	●	●
5/8-11 UNC	17/32	5-1/8	1-29/64	1	301140-0002*	❍	✖	✖	✖	●	●
3/4-10 UNC	21/32	5-33/64	1-37/64	1-3/8	301140-0003*	❍	✖	✖	✖	●	●
1-8 UNC	7/8	6-19/64	1-49/64	1-37/64	301140-0005*	❍	✖	✖	✖	●	●

*Available on request (lead times apply)

Legend: ● Optimal ✖ Not recommended ❍ Possible (refer to User Guide)

4 PCE SET
Metric Coarse
Sizes: M12, M16, M20, M24
Code: 301130-SET1

4 PCE SET – UNC
Sizes: 1/2, 5/8, 3/4, 1"
Code: 301140-SET1*

Reference Charts

Impact Torque Nm

HD Drill Taps	12mm Thick Steel Impact Tapping	25mm Thick Steel Impact Tapping
Ø Metric Coarse	Nm Torque	
M8	280	N/A
M10	300	N/A
M12	320	512
M16	360	576
M20	400	640
M24	600	960

Rotary RPM

HD Drill Taps	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø Metric Coarse	RPM Range				
M8	365	310	245	1095	485
M10	295	245	195	870	390
M12	240	200	162	730	330
M16	185	155	125	550	243
M20	145	125	100	440	194
M24	120	100	85	370	165

Impact Torque Ft Lb

HD Drill Taps	1/2" Thick Steel Impact Tapping	1" Thick Steel Impact Tapping
Ø UNC	Ft Lbs Torque	
1/2	235	375
5/8	365	425
3/4	295	470
1"	445	735

Rotary RPM

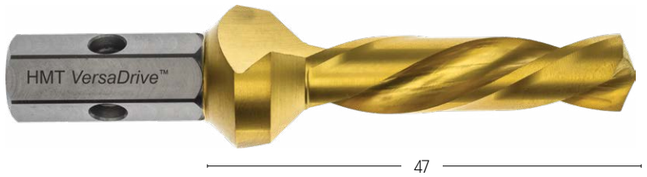
HD Drill Taps	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Ø UNC	RPM Range				
1/2	240	200	162	730	330
5/8	185	155	125	550	243
3/4	145	125	100	440	194
1"	120	100	85	370	165

Combination DrillSink

IMPACT RATED

ROTARY RATED

Ultimate precision for countersunk holes



Suits all Adaptors

pags 4 to 7

Also suitable with any standard drill chuck

The VersaDrive™ Drillsink is an innovative combined drilling and countersinking tool to save metalworkers time and increase hole accuracy by drilling and countersinking in one operation.

This piloted countersink tool provides perfect countersinking accuracy by locating the drilled hole in perfect alignment to the countersink, preventing movement of the countersink whilst drilling. Additionally this helps prevent tool chatter and blunting commonly found with standard countersinks.

- Drill & Countersink in one easy operation
- Concentricity creates the perfect countersink & leaves no sharp edges
- Unique combination prevents chattering
- Precision ground flutes for high accuracy & long life
- High-grade tool steel
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

User Guide

1. Optimum life & performance when used with rotary pistol drills or drill presses
2. For fast cutting performance, Drillsinks with **countersinks up to 16.5mm can be used on impact wrench & impact drivers**
3. **Drillsinks with countersinks above 16.5mm are not recommended to be used with impact wrenches, as most impact wrenches tend to run at too high RPM, which may cause premature wear or breakage**
4. Good results can be achieved in larger sizes with SDS hammer drills (in rotary mode only)
5. The DrillSink should be used with a variable speed motor, the drill & countersink operations should be run at the appropriate speed for each process
6. Apply firm, steady feed pressure throughout the cut
7. Avoid lateral movement or tilting which can cause tool damage
8. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
9. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- Suitable for harder materials & stainless steel when used at reduced RPM
- For maximum torque in variable speed machines, use at highest available gear setting
- Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use correct RPM (if unsure use tachometer to check drill speed)

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Recommended applications

Combination DrillSinks – **Metric Coarse** 90° Point Angle

Ø Drill Size mm	Countersink Size	OAL mm	Countersunk Screw	CODE	IMPACT			ROTARY		
					Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
6.8	16.5	85	M8 (Tapped)	603070-68165	●	●	●	●	●	●
8.0	12.4	96	M6	603070-08124	●	●	●	●	●	●
8.5	20.5	89	M10 (Tapped)	603070-85205	✖	✖	○	●	●	●
10.0	16.5	85	M8	603070-10165	●	●	●	●	●	●
10.2	25.0	93	M12 (Tapped)	603070-102250	✖	✖	○	●	●	●
11.0	20.5	88	M10	603070-11205	✖	✖	○	●	●	●
12.0	20.5	88	M10	603070-12205	✖	✖	○	●	●	●
13.0	25.0	92	M12	603070-13250	✖	✖	○	●	●	●
14.0	25.0	92	M12	603070-14250	✖	✖	○	●	●	●

Legend: ● Optimal ✖ Not recommended
○ Possible (refer to User Guide)

DrillSink Set

4 PCE

Sizes: 8/12.4mm, 10/16.5mm, 12/20.5 & 14/25mm

Code: 603070-SET4

Reference Chart Drilling Data

Rotary RPM

Drill Bit	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min
Ø mm	RPM Range						
5 - 9	2100 - 1140	1020 - 575	760 - 420	2050 - 1130	1200 - 600	1750 - 1040	3400 - 1550
10 - 15	1030 - 660	520 - 350	385 - 225	1020 - 660	550 - 340	1025 - 620	1500 - 950
16 - 20	640 - 490	335 - 230	220 - 195	640 - 510	330 - 250	600 - 470	975 - 745
21 - 25	460 - 330	220 - 140	190 - 150	500 - 410	240 - 200	460 - 350	730 - 500
26 - 32	310 - 250	140 - 110	150 - 120	320 - 275	200 - 175	335 - 320	400 - 315

Reference Chart Countersinking Data

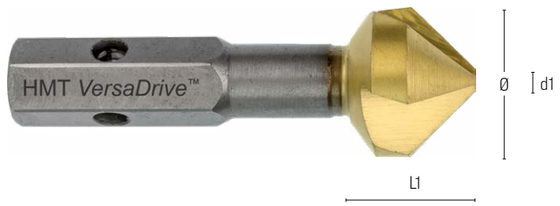
Rotary RPM

Countersink	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Cast Iron (Grey)	Plastics	Aluminium
Ø mm	RPM Range					
12.4	385	255	110	265	480	635
16.5	295	185	80	210	345	485
20.5	230	155	50	165	280	385
25.0	185	130	50	130	225	315
31.0	155	105	35	105	185	265

3 Flute Countersinks 90°

IMPACT RATED

ROTARY RATED



The VersaDrive™ Countersink is a premium quality countersink with fully ground flutes and titanium nitride coating to help reduce wear and blunting.

Utilise the convenience and power of an impact wrench to quickly deburr and countersink holes up to 16.5mm with minimal torque kick-back:

- Specially hardened for impact wrench use up to 16.5mm
- Safer use with minimal kick-back
- 90° Point angle for countersunk bolt heads
- High-grade tool steel for high accuracy & long life
- Titanium nitride coating reduces heat & increases lubricity for extended life
- High strength, non-slip shank design

Suits all Adaptors

pags 4 to 7

Also suitable with any standard drill chuck

User Guide

1. Optimum life & performance when used with rotary pistol drills or drill presses
2. For fast cutting performance **countersinks up to 16.5mm can be used on impact wrench & impact drivers**
3. **Countersinks above 16.5mm are not recommended be used with impact wrenches, as most impact wrenches tend to run at too high RPM, which may cause premature wear or breakage**
4. Apply firm, steady feed pressure throughout the cut
5. Avoid lateral movement or tilting which can cause tool damage
6. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- Suitable for harder materials & stainless steel when used at reduced RPM
- For maximum torque in variable speed machines, use at highest available gear setting
- Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use correct RPM (if unsure use tachometer to check drill speed)

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Recommended applications

3 Flute Countersinks 90° – Metric

Ø mm	Ø d1 mm	OAL mm	L1 mm	Countersunk Screw	CODE	IMPACT			ROTARY		
						Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
6.3	1.5	45	17	M3	603060-0063	●	●	●	●	●	●
8.3	2.0	50	22	M4	603060-0083	●	●	●	●	●	●
10.4	2.5	50	22	M5	603060-0104	●	●	●	●	●	●
12.4	2.8	56	28	M6	603060-0124	●	●	●	●	●	●
16.5	3.2	60	32	M8	603060-0165	●	●	●	●	●	●
20.5	3.5	63	35	M10	603060-0205	✖	✖	✖	✖	●	●
25.0	3.8	67	39	M12	603060-0250	✖	✖	✖	✖	●	●
31.0	4.2	71	43	M16	603060-0310	✖	✖	✖	✖	●	●

Legend: ● Optimal ✖ Not recommended

Countersink Set

5 PCE

Sizes: 12.4, 16.5, 20.5, 25 & 31mm

Code: 603060-5SET

Reference Chart

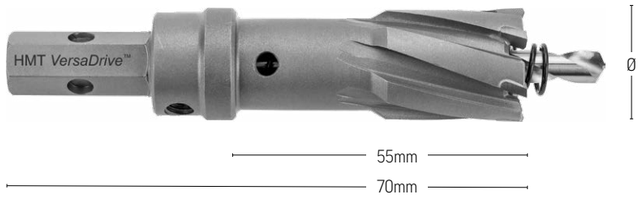
Rotary RPM

Countersink	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Cast Iron (Grey)	Plastics	Aluminium
Ø mm	RPM Range					
6.3	765	505	265	500	850	1250
8.3	565	375	190	405	705	955
10.4	460	300	145	315	530	765
12.4	385	255	110	265	480	635
16.5	295	185	80	210	345	485
20.5	230	155	50	165	280	385
25.0	185	130	50	130	225	315
30.0	155	105	35	105	185	265
40.0	120	80	30	80	140	205

TCT Hole Cutters

ROTARY RATED

10x longer life than standard holesaws



VersaDrive™ TCT Hole Cutters are a high performance solution for cutting larger diameter holes quickly and effectively.

Premium grade tungsten carbide teeth provide ultimate cutting performance in a wide range of structural steels including stainless steel and cast iron.

The VersaDrive™ TCT Hole Cutters provide the perfect go-to solution for fabricators and steel erectors for drilling through heavy steel in locations where a rotary drill is more convenient and possibly safer than a mag-based drill.

- Massive 70mm reach with 55mm depth of cut
- Premium grade Sandvik tungsten carbide teeth for the highest performance
- Perfect for drilling in remote locations
- Ideal for use with cordless drills, drill presses & mag-based drills
- One piece design includes arbor & (replaceable) pilot drill/pin
- Can be combined with a multisink*, to broach & countersink in one operation
- Triple cut carbide teeth
- High strength, non-slip shank design
- Spring loaded pilot drill: centers & stabilises cutter during drilling & ejects metal slug upon completion

*available to order

Suits all Adaptors

pags 4 to 7

Also suitable with any standard drill chuck

User Guide

1. For fastest performance use with rotary pistol drills
2. Good results can be achieved with **SDS Hammer Drills** when used in **rotary mode only**
3. For optimum life use with pedestal/mag-based drills
4. When using in a mag-based drill, replace the supplied pilot drill with an ejector pin (code: 101030P- 0003)
5. Centre punch or pilot drill the surface for accurate hole start
6. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly & cautiously during the first 1mm of cut
7. Avoid lateral movement or tilting which can cause tool damage
8. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
9. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

RPM Speeds **pg. 33**

Application information

- For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
- **For thicker materials & larger tool diameters it is recommended to pre-drill a 6.35mm pilot hole, then use the sprung pilot drill or pilot pin as a guide**
- Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
- **Suitable for use on most metals including: structural steel, stainless steel, aluminium, cast iron (grey), fibreglass composite, plastics & wood**

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

TCT Hole Cutters – **Metric**

Recommended applications

Ø mm	Ø Inch	Tap Size (Metric Coarse)	CODE	IMPACT			ROTARY		
				Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
12		M14	101030-0120	×	×	○	●	●	●
13		-	101030-0130*	×	×	○	●	●	●
14	9/16"	M16	101030-0140	×	×	○	●	●	●
15		-	101030-0150*	×	×	○	●	●	●
16	5/8"	-	101030-0160	×	×	○	●	●	●
17	11/16"	-	101030-0170*	×	×	○	●	●	●
17.5		M20	101030-0175*	×	×	○	●	●	●
18		-	101030-0180	×	×	○	●	●	●
19	3/4"	-	101030-0190*	×	×	○	●	●	●
20		-	101030-0200	×	×	○	●	●	●
21	13/16"	M24	101030-0210*	×	×	○	●	●	●
22	7/8"	-	101030-0220	×	×	○	●	●	●
23		-	101030-0230*	×	×	○	●	●	●
24	15/16"	M27	101030-0240	×	×	○	●	●	●
25	1"	-	101030-0250*	×	×	○	●	●	●
26		-	101030-0260	×	×	○	●	●	●
27	1-1/16"	-	101030-0270*	×	×	○	●	●	●
28		-	101030-0280*	×	×	○	●	●	●
29	1-1/8"	-	101030-0290*	×	×	○	●	●	●
30	1-3/16"	-	101030-0300*	×	×	○	●	●	●
31		-	101030-0310*	×	×	○	●	●	●
32	1-1/4"	M36	101030-0320	×	×	○	●	●	●
33	1-5/16"	-	101030-0330*	×	×	○	●	●	●
34		-	101030-0340*	×	×	○	●	●	●
35	1/3-8"	-	101030-0350*	×	×	○	●	●	●
36		-	101030-0360*	×	×	○	●	●	●
37	1-7/16"		101030-0370*	×	×	○	●	●	●
38	1-1/2"		101030-0380*	×	×	○	●	●	●
39	1-9/16"		101030-0390*	×	×	○	●	●	●
40			101030-0400*	×	×	○	●	●	●
41	1-5/8"		101030-0410*	×	×	○	●	●	●
42			101030-0420*	×	×	○	●	●	●
43	1-11/16"		101030-0430*	×	×	○	●	●	●
44	1-3/4"		101030-0440*	×	×	○	●	●	●
45			101030-0450*	×	×	○	●	●	●
46	1-13/16"		101030-0460*	×	×	○	●	●	●
47			101030-0470*	×	×	○	●	●	●
48	1-7/8"		101030-0480*	×	×	○	●	●	●
49			101030-0490*	×	×	○	●	●	●
50			101030-0500*	×	×	○	●	●	●
51	2"		101030-0510*	×	×	○	●	●	●
52	2-1/16"		101030-0520*	×	×	○	●	●	●
55	2-5/32"		101030-0550*	×	×	○	●	●	●
60	2-3/8"		101030-0600*	×	×	○	●	●	●
65	2-9/16"		101030-0650*	×	×	○	●	●	●
70	2-3/4"		101030-0700*	×	×	○	●	●	●
75			101030-0750*	×	×	○	●	●	●
80	3-5/32"		101030-0800*	×	×	○	●	●	●

2 x Pilot Drills 6.35mm (d1)
for 12 & 13mm Hole Cutters
Supplied WITHOUT ejection spring
Code: 101030P-0130

2 x Pilot Drills 6.35mm (d1)
for 14 – 80mm Hole Cutters
Supplied WITH ejection spring
Code: 101030P-0001

2 x Pilot Pins 6.35mm (d1)
for 12 & 13mm Hole Cutters
for use with magnet broaching tools
Code: 101030P-0130

2 x Pilot Pins 6.35mm (d1)
for 14 to 80mm Hole Cutters
for use with magnet broaching tools
Code: 101030P-0003

SETS
TCT Hole Cutter

3 PCE
Sizes: 14, 18 & 22mm
Code: 101030-SET1

5 PCE
Sizes: 14, 17, 18, 21 & 22mm
Code: 101030-SET2

Legend: ● Optimal × Not recommended ○ Possible (refer to User Guide)

*Available on request (lead times apply)

RPM Speeds on following page

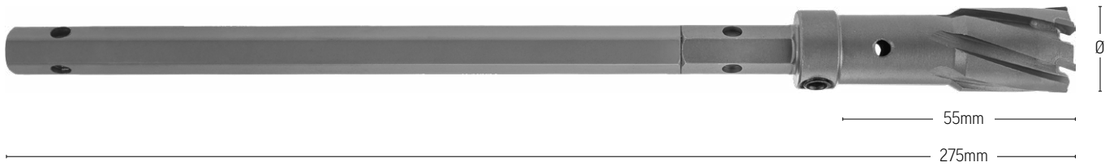
Rebar Cutters

ROTARY RATED

Fast & effective rebar cutting

Suits all Adaptors
pags 4 to 7

Also suitable with any standard drill chuck



The HMT VersaDrive™ Rebar Cutter is designed for applications where concrete has steel plate or rebar reinforced areas.

SDS and masonry drills will not effectively create holes through metal. When a hole is found to contain steel or reinforcement, withdraw the SDS drill and cut through the steel with the rebar cutter, then continue with the SDS drilling.

- Fixed extended arbor for deep reach
- 250mm reach, 55mm depth of cut
- Triple cut carbide teeth
- High Strength, non-slip shank design

User Guide

1. Good results can be achieved with **SDS hammer drills** when used in **rotary mode only**
2. Optimum life & performance when used with rotary pistol drills
3. Remove concrete debris from the hole to achieve the best tool life
4. Ensure regular application of quality cooling lubricant, before commencing
5. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly
6. Avoid lateral movement or tilting which can cause tool damage I
7. Designed for unpiloted use as located by existing hole
8. Refer to reference chart to set correct torque/RPM. Incorrect torque/RPM can lead to poor life or tool breakage

Application information

- **Ensure to remove metal slug between holes**
- Do not attempt to drill concrete or masonry with the rebar cutter as this will blunt the teeth
- For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Rebar Cutters – **Metric**

Recommended applications

Ø mm	Ø inch	CODE	IMPACT			ROTARY		
			Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
13		101032-0130*	×	×	○	●	×	×
14	9/16"	101032-0140*	×	×	○	●	×	×
16	5/8"	101032-0160	×	×	○	●	×	×
18		101032-0180	×	×	○	●	×	×
20		101032-0200	×	×	○	●	×	×
22	7/8"	101032-0220	×	×	○	●	×	×
24	15/16"	101032-0240	×	×	○	●	×	×
25	1"	101032-0250*	×	×	○	●	×	×
26		101032-0260	×	×	○	●	×	×
28		101032-0280*	×	×	○	●	×	×
30	1-3/16"	101032-0300*	×	×	○	●	×	×
32	1-1/4"	101032-0320*	×	×	○	●	×	×
34		101032-0340*	×	×	○	●	×	×
35	1-3/8"	101032-0350*	×	×	○	●	×	×
36		101032-0360*	×	×	○	●	×	×
38	1-1/12"	101032-0380*	×	×	○	●	×	×
40	1-9/16"	101032-0400*	×	×	○	●	×	×
45		101032-0450*	×	×	○	●	×	×
50		101032-0500*	×	×	○	●	×	×

*Available on request (lead times apply)

Legend: ● Optimal × Not recommended ○ Possible (refer to User Guide)

TCT Rebar Cutter Sets

4 PCE
1 x SDS Plus Adaptor
3 x Rebar Cutters: 14, 18 & 22mm
Code: 101032-SET1

6 PCE
1 x SDS Plus Adaptor
5 x Rebar Cutters: 14, 16, 18, 20 & 22mm
Code: 101032-SET2

Reference Chart – TCT Hole Cutters & Rebar Cutters

Rotary RPM

TCT Hole Cutter & Rebar Cutter	Structural Steel <500Nm based on mm/R feed of 0.10	Structural Steel <1000Nm based on mm/R feed of 0.10	Stainless Steel INOX based on mm/R feed of 0.13	Aluminium	Cast Iron (Grey)	Fibreglass	Composite	Plastics	Wood
Ø mm	RPM Range								
13 – 17	1350 – 850	840 – 585	500 – 360	2210 – 1575	900 – 625	780 – 705	1350 – 850	900 – 640	1495 – 1010
18 – 25	850 – 625	580 – 420	350 – 250	1575 – 1125	600 – 455	700 – 520	850 – 625	620 – 450	990 – 895
26 – 31	620 – 500	415 – 325	240 – 195	1080 – 885	435 – 345	500 – 405	620 – 500	440 – 345	895 – 850
32 – 39	480 – 410	320 – 275	195 – 160	875 – 740	330 – 285	400 – 330	480 – 410	345 – 280	850 – 740
40 – 46	390 – 340	270 – 220	160 – 145	730 – 620	285 – 240	315 – 275	390 – 340	175 – 235	740 – 610
47 – 53	335 – 300	220 – 180	140 – 120	615 – 545	235 – 215	275 – 245	335 – 300	235 – 215	600 – 505
54 – 60	295 – 260	180 – 165	115 – 100	525 – 485	210 – 180	240 – 215	295 – 260	210 – 185	500 – 460
61 – 70	260 – 225	165 – 155	100 – 90	475 – 415	180 – 160	205 – 185	260 – 225	180 – 160	455 – 400
71 – 80	220 – 195	155 – 140	90 – 75	410 – 365	155 – 140	180 – 160	220 – 195	155 – 140	395 – 360

CarbideMax® TCT Broach Cutters

ROTARY RATED

9x longer life than uncoated TCT tools

19.05mm (3/4") Weldon shank

CarbideMax® TCT Broach Cutters are specifically designed for the toughest broaching jobs.

The specialist ULTRA coating is proven to significantly increase tool life when working with extremely hard materials and wear plates such as **Hardox®, Creusabro®, Abro®, Raex®, Strenx® and Bisalloy®.** CarbideMax® TCT Broach Cutters will also perform well in other challenging materials such as armor plate, Inconel® and stainless steel.

- ULTRA coated for optimum performance & lifespan
- Increased wear resistance in the hardest materials
- Elaborate tool geometry for faster, quieter cutting
- Chatter free performance when used correctly
- Highest quality carbide teeth
- Individually brazed cutting teeth
- Up to 55mm depth of cut
- Standard 19.05mm Weldon shank

User Guide

1. Adjust RPM to match the material hardness
2. Cautious & gentle feed pressure should be used at all times, especially during the start of the cut and when exiting the material
3. For best results & swarf clearance always select a cutter longer than the material thickness
4. Centre punch or pilot drill the surface for an accurate hole start
5. Swarf removal is required periodically for longer tool life
6. Generous application of high quality cutting fluid should be used during the cut & applied frequently during the cut
7. Do not allow the cutter to run over swarf while cutting, as this will cause chatter, ultimately-causing the cutting edges to chip & blunt
8. Use a hand brush to clean cutter & material surface rather than a magnetic pickup tool
9. Incorrect RPM can lead to poor life or tool breakage

Application information

Drilling holes in very hard materials is a specialist task and good results are dependent on the correct set-up, including:

- Slow RPM speed
- Consistent feed
- Hi rigidity/clamping force
- Geared mag-based drills with high torque
- Abundant & high quality lubricant

Inadequate lubrication and/or using an incorrect or a poorly maintained mag-based drill with unstable drilling operation, poor magnet hold or excessive pressure is likely to result in tool failure.

ALSO AVAILABLE **Alpha C.D.T Cutting Lubricant**

Formulated for extreme cutting performance when tapping, drilling or reaming into all metals

Code: ATL005

GUIDELINE PARAMETERS ONLY – Actual parameters may vary depending on operating conditions

Recommended applications

CarbideMax® TCT Broach Cutters – **Metric**

Ø mm	Shank size	CODE	IMPACT			ROTARY		
			Impact Wrench	Impact Driver	Hammer Drill	Cordless Drill	Pedestal Drill	Mag-Based Drill
12	19.05mm 3/4"	108070-0120*	✖	✖	✖	✖	●	●
14	19.05mm 3/4"	108070-0140*	✖	✖	✖	✖	●	●
16	19.05mm 3/4"	108070-0160	✖	✖	✖	✖	●	●
18	19.05mm 3/4"	108070-0180	✖	✖	✖	✖	●	●
20	19.05mm 3/4"	108070-0200*	✖	✖	✖	✖	●	●
22	19.05mm 3/4"	108070-0220	✖	✖	✖	✖	●	●
24	19.05mm 3/4"	108070-0240*	✖	✖	✖	✖	●	●
26	19.05mm 3/4"	108070-0260*	✖	✖	✖	✖	●	●

Legend: ● Optimal ✖ Not recommended

2 x CarbideMax ULTRA 55 Pilot Pins

for 12 – 17mm Broach Cutters

Code: 108020P-0170

for 18 – 60mm Broach Cutters

Code: 108020P-0600

Broach Cutter Set

5 PCE

Sizes: 12, 14, 18, 22 & 26mm

Code: 108070-SET*

450 - 390 RPM is recommended for broaching typical hole sizes (14 - 26mm) in a range of materials

THUNDER MAX

New

NEW GENERATION IMPACT DRIVER BITS

Maximum strength for high impact & extreme torque loads

Perfect for metal to metal fastening when extreme tightening down is required

- Premium quality S2 raw material for superior performance
- Precision machined tip to avoid slipping for longer life
- Black oxide finish for extreme corrosion resistance
- Optimum full body hardness for longer service life and less wear

The torsion zone provides maximum strength for high impact & extreme torque loads

1/4" QUICK CHANGE

50x LIFE

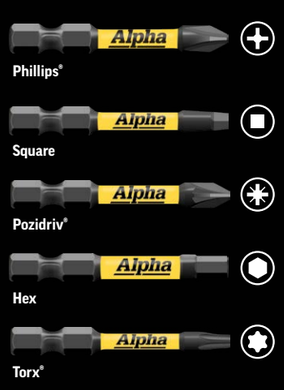
EXTREME TORSION

Ideal for Cordless drills

Magnetic

Superior magnetism helps the bit grip the screw and prevent cam-out

View the full range at alpha.com.au



33 PCE Set

Alpha

1/4" Hex Shank Range

Ideal for IMPACT DRIVERS

Step Drills 4 Flute Spiral

4 – 12mm	Code: C9STSFM4-12QR
4 – 20mm	Code: C9STSFM4-20QR
6 – 30mm	Code: C9STSFM6-30QR
6 – 32mm	Code: C9STSFM6-32QR
1/4" – 3/4"	Code: C9STSFI14-34QR

Sheet Metal · Steel · Plastic

Ideal for: Non-ferrous metals, sheet metal, plastic and stainless steel up to 3mm thick.

1/4" QUICK CHANGE

HEX Drive Drill Bits

Complete range available

Carded 1 PCE: 2.0 – 13.0mm

23 PCE SET Code: SM23HPB

Ideal for the widest range of materials:

Steel · Wood · Plastic · Stainless Steel

view video at https://wi.st/3aLNi1H

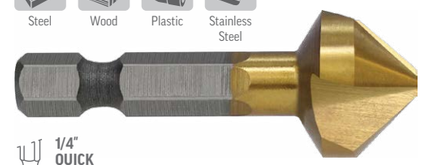
1/4" QUICK CHANGE

3 Flute 90° Countersinks

HSS Cobalt TiN Coating

13mm	Code: CS3-13QR
16mm	Code: CS3-16QR
19mm	Code: CS3-19QR

Steel · Wood · Plastic · Stainless Steel

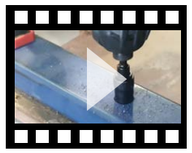


1/4" QUICK CHANGE

Thin Sheet Bi-Metal Holesaws

7 sizes available: 19 - 38mm

8 PCE SET Code: HSF-SET8

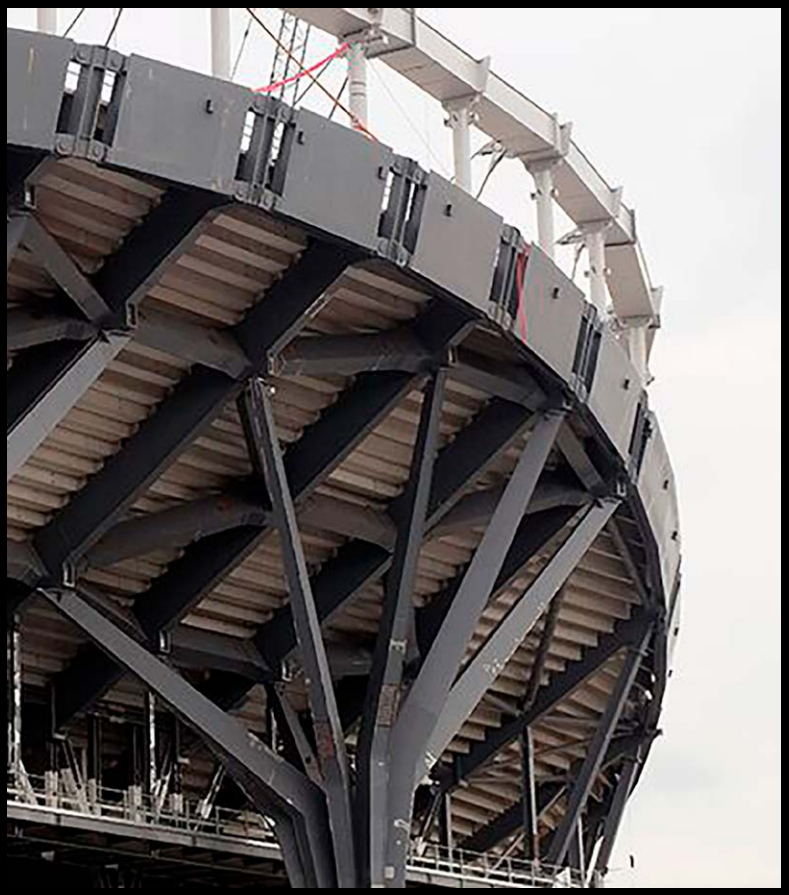


view video at https://bit.ly/AlphaHolesaw

SHEET METAL up to 3mm thick

Stainless Steel · Steel · Aluminium · Plastic

1/4" QUICK CHANGE



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