

# DRILL BITS AND CLAMPS

November 2014

1969-2014  
**45**  
YEARS OF QUALITY



**NEW!**

# NEW! SPOT WELD DRILL BITS

## 8.0mm x 45mm Boron STC Bit (Tri-Flute)



### Features

- Tungsten-Carbide
- Triple Fluted
- Friction-Free Multi-layered Coating
- For Boron Steel, UHSS & Usibor
- Operate at 1000 RPM

Description	Art #
8.0mm x 45mm Boron STC Bit	<b>07108090</b>

### SPECIAL INTRODUCTORY PRICE!

# \$89.99 EA

Valid until December 31, 2014 • Use price type "SP" for special price.

The Boron STC drill bit, made from tungsten-carbide, is designed specifically for use on spot welds made for boron steel with tensile strength from 450N/mm<sup>2</sup> - 1.580N/mm<sup>2</sup>. Triple fluted to spread the torque forces over a greater area, and special multi-layer coating is applied to help reduce friction.

**Due to the brittle nature of this drill bit, it has a higher possibility to break or chip instead of dull.**

### Directions

Start the bit centering nib against the metal. Let the C-clamp approach the panel from behind and take the impact. Do not let the drill bit impact the metal. **Do not start the drill bit at an angle or you increase the odds of breaking off a flute or edge.** Set the depth correctly so there is no "pop through" lateral torque applied on the bit. Firmly hold the drill with both hands. **Good, consistent pressure and lower RPM will maximize the bit life.** Cutting fluid, while helpful, is not necessary.



## 8.0mm x 80mm HSCo Bit



### Features

- High Speed Steel/Cobalt (HSCo) alloy
- Center Nib
- Use with any chuck type drill
- Operate at max. 1800 RPM

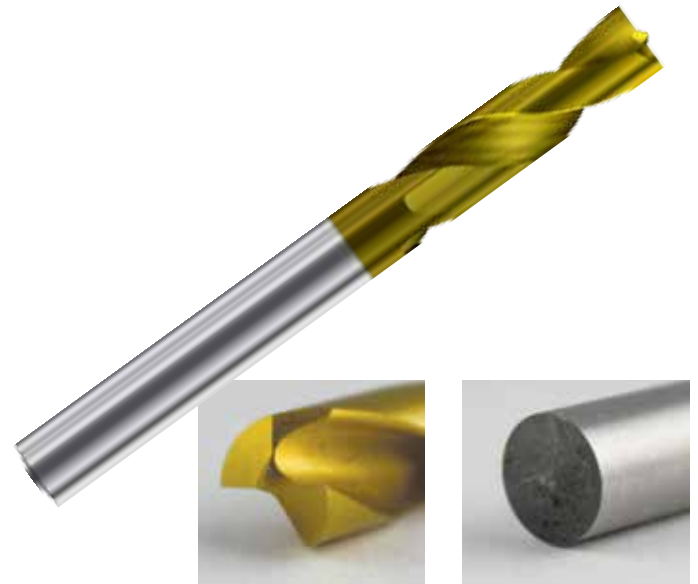
Designed for efficient removal of spot welds in high strength steel. High speed steel allows for faster cutting speeds and the Cobalt alloy helps maintain the hardness at higher temperatures. The centering nib helps start and set the bit. The flat lip angle of the tip ensures strong support for the cutting edge.

### Directions

Maximum RPM is 1800. Start the bit centering nib against the metal. Do not start the drill bit at an angle or you increase the odds of breaking off a flute. Heat is the largest factor in dulling and can be seen as a blue-ing of the cutting edge. Cutting chips remove heat from the drilling point. Remove your finger from the trigger when cutting has stopped to prevent excessive heat build up. Good, consistent pressure will maximize the bits life. Cutting fluid, while helpful, is not necessary.

Description	Art #
8.0mm x 80mm HSCo Bit	<b>07108800</b>

## 8.0mm x 80mm HSCo TiN Bit



### Features

- High Speed Steel/Cobalt (HSCo) alloy with Titanium Nitride (TiN) coating
- Center Nib
- Use with any chuck type drill
- Operate at max. 1800 RPM
- Coating extends cutting life

The high speed steel and cobalt (HSCo) alloyed drill bit is coated with a layer of titanium nitride (TiN), a very hard ceramic material giving the bit it's golden color. This heat resistant coating can extend the cutting life by three or more times, and cannot be properly sharpened, as the new edge will not have the coating provided.

### Directions

Maximum RPM is 1800. Start the bit centering nib against the metal. Do not start the drill bit at an angle or you increase the odds of breaking off a flute. Heat is the largest factor in dulling and can be seen as a blueing of the cutting edge. Cutting chips remove heat from the drilling point. Remove your finger from the trigger when cutting has stopped to prevent excessive heat build up. Good, consistent pressure will maximize the bits life. Cutting fluid, while helpful, is not necessary.

Description	Art #
8.0mm x 80mm HSCo TiN Bit	<b>07108801</b>

**SPECIAL INTRODUCTORY PRICE!**

**\$15.99 EA**

Valid until December 31, 2014 • Use price type "SP" for special price.

**SPECIAL INTRODUCTORY PRICE!**

**\$19.99 EA**

Valid until December 31, 2014 • Use price type "SP" for special price.

# NEW! BODY WELDING CLAMPS

## Butt Welding Clamp



### Features

- Holds panels of two different thickness
- Anchor panels nearly edge-to edge for MIG brazing an open butt joint
- Steel, Aluminum construction
- Dimensions: 1.25" x 1.5" x 2.75"

The Butt Welding Clamps are a fast and effective method of fastening materials for wire feed welders. Especially effective for positioning structural members, these clamps are useful with today's higher strength steels that require lower welding temperatures.

### Directions

After determining the proper gap width, position one panel between the blue body and the anchor bar on the bottom. Adjust to the thickness with the top wing nut. After positioning the panel between the blue body and anchor bar on the other side, set gap width. Adjust the clamp to the panel thickness on the other side by using the two screw adjustments to anchor into the desired position and gap.

**SPECIAL INTRODUCTORY PRICE!**

**\$9.99 EA**

Valid until December 31, 2014 • Use price type "SP" for special price.

Description	Art #
Butt Welding Clamp	07140200

## Micro Welding Clamp



### Features

- Fast & effective method of fastening for pinch/spot weld
- Huge clamping force for its size due to the wedge style clamping
- Low profile
- Flexible gripping surface
- No need to bear down on wing nut due to amplified force of the wedge
- Dimensions: 0.625" x 1.25" x 2.375"

The Micro Welding Clamp provides a fast and effective method of fastening materials for pinch/spot welds.

### Directions

Unscrew the top wing nut to disengage the clamp. Position the two pieces into the clamping area. Screw the wing nut to tighten to desired pressure. Can be used with additional micro weld clamps for additional clamping coverage.

Description	Art #
Micro Welding Clamp	07140201

**SPECIAL INTRODUCTORY PRICE!**

**\$9.99 EA**

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## Wheel Arch Clamp



### Features

- Used to clamp hard to reach access points like a wheel arch
- Wedge method applies strong clamping force
- Ergonomic tightening
- No need to bear down on wing nut due to amplified force of the wedge
- Flexible gripping surface
- Low profile

The wheel arch clamp can be set up in seconds. The unique design of the clamp allows the clamping end to fit into tight spaces and moves the wing nut adjustment to an easy-to-reach location.

### Directions

Unscrew the wing nut to open the clamping arms. Position the clamping area over the lip of the two metal panels. Screw the wing nut closed to lower the wedge piece and bring the clamping arms onto the panel. Apply the proper amount of pinch/spot welds.

**SPECIAL INTRODUCTORY PRICE!**

**\$15.99 EA**

Valid until December 31, 2014 • Use price type "SP" for special price.

Description	Art #
Wheel Arch Clamp	<b>07140202</b>





# EXISTING CUTTERS

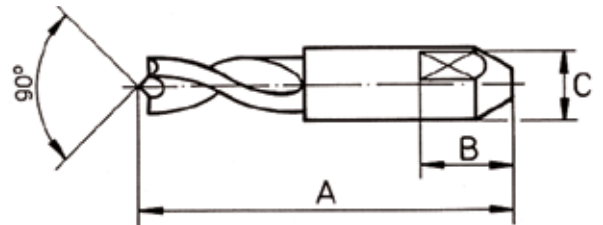
## Vario Point Cutters

### Titanium HSCO/TIN

- No need for center-punching
- Service life enhanced by a factor of between 2 and 3
- High cutting speed
- Cobalt with Titanium-Nitride coating

Diameter	Art #
6 mm	0710606
8 mm	0710808
9 mm	0710909

Length (A)	Shaft Length (B)	Shaft Dia. (C)
44.7 mm	17 mm	7.5 mm

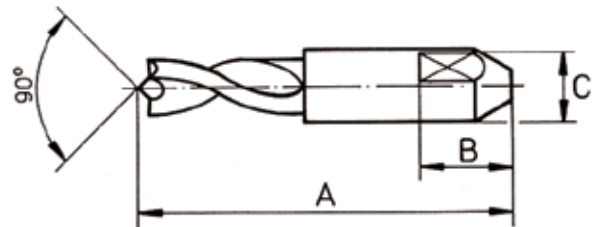


### Cobalt HSCO

- No need for center-punching

Size	Art #
6 mm	071060
8 mm	071080
9 mm	071090

Length (A)	Shaft Length (B)	Shaft Dia. (C)
44 mm	16 mm	7.5 mm

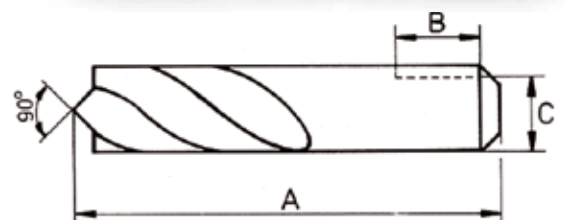


### Spottle Gun Cobalt HSCO

- No need for center-punching

Size	Art #
8 mm	0710081

Length (A)	Shaft Length (B)	Shaft Dia. (C)
38 mm	10 mm	7.5 mm



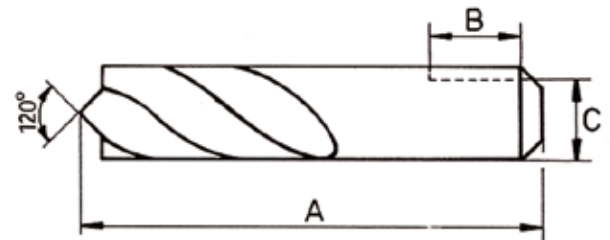
# Zebra Weld Point Cutter

## For High Strength Metals Such As Boron

- Suitable for Vario Drill

Size	Art #
8 mm	07108080

Length (A)	Shaft Length (B)	Shaft Dia. (C)
44 mm	22 mm	7.5 mm

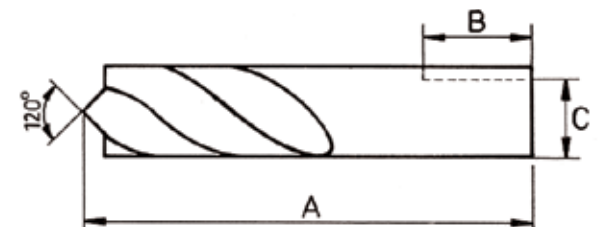


## For High Strength Metals Such As Boron

- Suitable for drills with pneumatic advance (screw-nail drill)

Size	Art #
8 mm	07108081

Length (A)	Shaft Length (B)	Shaft Dia. (C)
44 mm	22 mm	7.5 mm



### Tips to enhance the lifespan of the weld point cutter:

- The cutter should have reached its maximum speed prior to contact with the work piece
- Set the centering point gently down on the sheet, the drill swiftly with even pressure
- Wherever possible, we recommend using a contact pressure device

# DRILL BITS AND CLAMPS

**November 2014**

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