

Tools needed:

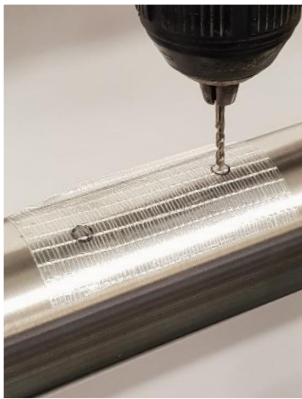
Drilling & tapping kit
Tap wrench – not included

Drilling & Tapping Kit:

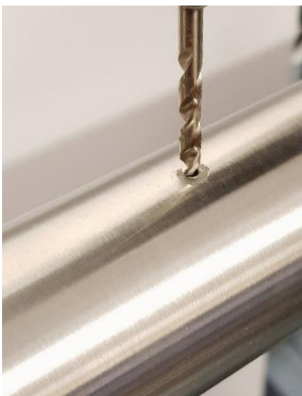
Small pilot drill bit
Main drill bit
Tap



A cordless drill can be used for tapping if you do not have a tap wrench. If using a cordless drill, take care and drill very slowly. For best results use a tap wrench.



1. Accurately mark where the tapped holes are required with a felt tip or similar.
2. If necessary, place a small piece of gauze tape over the tube first as this will stop the drill bit wandering later.
3. Ensure that you have the correct sized drill and tap kit for the desired result. See the next page for more information on our drill and tap sizes.
4. Take the smallest pilot drill bit and drill a pilot hole into the stainless steel. Drill entirely through the tubular material, or to the desired depth if a solid material. A pilot hole reduces the tendency of the larger drill bit to wander, and improves drilled hole accuracy.

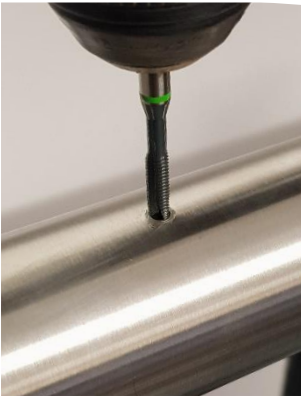


5. Then take the larger (main) drill bit, and enlarge the initial hole.
6. Once the hole is big enough, the thread can be cut into it.

Note:

Technical information, dimensions and illustrations in this guide are for guidance purposes only. We reserve the right to change product sizes and details without prior notice. We always recommend that the purchaser checks the sizes of the actual batch purchased prior to drilling other materials.

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7. Install the correct sized tap into the cordless drill or tap wrench.

8. Insert the tap into the drilled hole. Turn the tap clockwise to start tapping the hole. If using a cordless drill, tap slowly so as not to break the tap. Always ensure that you tap directly straight. Tapping at an angle often causes the tap to snap or break.

9. If the tap binds in the hole, turn counter clockwise to loosen. Continue alternation between clockwise and counter clockwise until you have a tapped hole.




10. The tapped hole can now be used to give a strong and secure fixing into stainless steel.

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Drilling & Tapping Kits		white metal 
Size	Distinction	Essentials
M4	2 x 2.5mm Pilot Drills 2 x 3.4mm Main Drills 1 x M4 Tap	1 x 2.5mm Pilot Drills 1 x 3.4mm Main Drills 1 x M4 Tap
M5	2 x 2.5mm Pilot Drills 2 x 4.3mm Main Drills 1 x M5 Tap	1 x 2.5mm Pilot Drills 1 x 4.3mm Main Drills 1 x M5 Tap
M6	2 x 2.5mm Pilot Drills 2 x 5.1mm Main Drills 1 x M6 Tap	1 x 2.5mm Pilot Drills 1 x 5.1mm Main Drills 1 x M6 Tap
M8	2 x 3.4mm Pilot Drills 2 x 6.9mm Main Drills 1 x M8 Tap	1 x 3.4mm Pilot Drills 1 x 6.9mm Main Drills 1 x M8 Tap
M10	2 x 3.4mm Pilot Drills 2 x 8.5mm Main Drills 1 x M10 Tap	1 x 3.4mm Pilot Drills 1 x 8.5mm Main Drills 1 x M10 Tap
M12	2 x 3.4mm Pilot Drills 2 x 10.2mm Main Drills 1 x M12 Tap	1 x 3.4mm Pilot Drills 1 x 10.2mm Main Drills 1 x M12 Tap

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