



# ACE

technical reference

## General Hints on Drilling

1. Keep drills sharp for maximum efficiency.
2. The liberal use of recommended cooling compound will increase the life of the tool. Take care to ensure that it reaches the point of the drill.
3. When the drill is being point ground ensure that all wear is removed and that the correct point angles are produced.
4. The chuck in which a straight shank drill is held must be of good quality. If the drill slips in the chuck and the feed is automatic, breakage of the drill is inevitable.
5. When driving taper shank drills into sockets use a soft faced hammer. Make certain that there is a good fit between the taper shank of the drill and the sleeve or socket, otherwise the tang may break.
6. The work must be held rigid and the machine spindle should have no play.
7. Use multi-fluted drills for opening out existing or cored holes. Two-fluted drills are not designed for this purpose.