POWER TEC™

91614
91615

Cryocobalt Drill Bits

Easily drill out spot welds in new generation ultra-high-strength boron steel body components with CryoCobalt™ drill bits.

Boron steel is one of the strongest weldable materials and is used by Ford, GM and many other manufacturers in the manufacture of new vehicles to improve safety and performance. Body shops have found that spot welds produced in these new steels are much harder to drill than in common mild steel sheet metal. Even hardened and treated HSS drill bits and spot-weld cutters are no longer effective in these next generation steels.

CryoCobalt™ drill bits are specially designed for drilling very hard metal. The added cobalt in the bit increases the microsharpness and red hardness. This makes the CryoCobalt™ bit better able to slice into harder metals and maintain hardness at elevated cutting temperatures. The patented cryogenic treatment process changes the structure of the steel and the result is a significant increase in the cutting life as compared to even the highest quality high speed steel drill bits.

The bit incorporates a thicker web to make it stronger when cutting harder metals. CryoCobalt™ bits are Cryophase™ treated to improve flexibility and extend bit life in tough applications. The bits are made with CM-88™ alloy to allow them to drill metals up to hardness 58Rc, enabling the bit to handle the high feed pressures and heat generated when drilling these tougher spot welds.

Application:

- Abrade the top surface of the spot weld.
- Centre punch the spot weld surface.
- Choose correct size of drill (**91614** - 6mm, **91615** - 8mm).
- Drill carefully using a **slow drill speed** with a constant **heavy feed pressure**.

TOOL CONNECTION
The Complete Connection

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Guarantee

This item contains consumable elements and are **NOT** covered by the Tool Connection Guarantee. For spares contact our service department direct on: **+44 (0) 1926 818186**.