

## CRYONITRIDE™ GOLD STEP SPLIT TIP BIT WITH HEX SHANK QUICK CHANGE FEATURE

### DY802700 SERIES

Cryogenically treated, Nitride coated, 1/4" hex shank, gold step bit for cutting steel plate, stainless steel, sheet metal and tubing. The tip of the bit is designed with a "walk-no-more" self-starting split tip, dual flutes for smooth cutting and a 1/4" hex shank for use in quick change drivers.



### FEATURES & BENEFITS

- Versatile Cutting – the CryoNitride™ Gold step bit is designed to cut through steel plate, stainless steel, sheet metals of all types and metal tubing. All five bits offer up to 48 different hole diameters.
- Quick Change Driver – 1/4" hex shank provides for quick change in today's quick change driver power tools.
- Split Point Tip – Provides self-starting tip to minimize bit walking at start up.
- Two Flute Design – Drilling is balanced, creating cleaner symmetrical holes.
- Hi-Viz step Measurements – Step sizes are laser marked on the tool. Gold background provides high visibility of step sizes.
- High Performance/Long life Coating – Gold CryoNitride™ coating extends the life of the tool and provides additional lubricity of enhanced cutting performance.
- Cryophase™ treatment – The treatment enhances tool flexibility, provides longer tool life, and higher heat resistance.

### SPECIFICATIONS

Tip Design.....Split Point  
 Hardness.....63-66 Rc  
 Temperature Resistance.....1,112F  
 Material.....High Speed Steel  
 Coating.....CryoNitride  
 Coating Hardness.....63-66 Rc  
 Cryophase.....Treated by our patented thermal cycling cryogenic treatment

| Code #            | Description   |
|-------------------|---|
| <b>DY80270010</b> | Cryonitride Gold 1/4 Shank, 13 Hole 1/8"-1/2" Step Drill                |
| <b>DY80270020</b> | Cryonitride Gold 1/4 Shank, 6 Hole 3/16"-1/2" Step Drill                |
| <b>DY80270030</b> | Cryonitride Gold 1/4 Shank, 9 Hole 1/4"-3/4" Step Drill                 |
| <b>DY80270040</b> | Cryonitride Gold 1/4 Shank, 12 Hole 3/16"-7/8" Step Drill               |
| <b>DY80270050</b> | Cryonitride Gold 1/4 Shank, 8 Hole 9/16"-1" Step Drill                  |
| <b>DY80270001</b> | Cryonitride Gold 3 pc. Set, 3pc index, 1/8"-1/2", 3/16"-1/2", 1/4"-3/4" |

### INDUSTRIES

- Automotive
- Fabrication and Assembly Operations
- Construction
- Power & utilities
- Transportation
- Shipyards

## APPLICATIONS

- Steel Plate up to 1/8" inch thick
- Stainless Steel Plate up to 1/8" inch thick
- Aluminum plate up to 1/8" inch thick
- Sheet metal up to 1/8" thick
- Sheet copper up to 1/8" thick
- Wood, laminates
- Fiberglass
- Metal tubing, steel, copper, Stainless Steel, aluminum, laminates, plastic, wood, sheet metal

## ASSOCIATED ITEMS



**DY80169010**  
**1/4" Hex Shank**  
**Quick Change Adapter**



**DY60025035**  
**EZ Cut Aerosol**



**DY21001070**  
**EZ Cut Stick**



**DY70010055**  
**EZ Cut 2 x 2-1/2 Gallon**  
**Containers**

## DEMONSTRATION STEPS

1. Install DY80169010 1/4" Hex Shank Quick Change Adapter on hand drill. Tighten chuck by hand or chuck key for secure and tight fit.
2. Show customer the quick release feature of the bits hex shank.
3. Show customer the split "walk-no-more" tip on the bit.
4. Show customer the two-flute design for smooth and balanced cutting applications.
5. Show customer the step sizes are laser marked on the tool. Gold background provided high visibility of step sizes.
6. Show high performance gold Cyonitride™ Gold coating extends the life of the tool and provides additional lubricity of enhanced cutting performance.
7. Clamp steel plate in vice checking for a snug unmovable fit.
8. Put on Safety glasses, offer to customer as well
9. Begin drilling slowly showing how the bit seats well and does not walk.
10. Increase speed of drilling to a comfortable level to create small curls of cut steel.
11. Show how the bit proceeds through each step smoothly and with control so as to not oversize the desired hole.
12. Stop drilling and when metal plate is cool to the touch, show customer the smoothness of the hole and the absence of a burr on both the front and back of the plate.
13. Give hand drill to the customer and have them start with step 9-11.
14. Repeat step 9-11 by applying DY60025035 EZ Cut to show the improvement of the cutting process with lubrication, though not required.
15. Repeat steps 7 - 12 with other materials with maximum thickness of 1/8" such as aluminum, copper, sheet metal, metal tubing, laminates, wood, fiberglass.

## SUPPLIES NEEDED

1. 1 DY80270020 Cryonitride Gold 1/4" shank 3/16-1/2 step drill bit.
2. 1 DY80169010 1/4" Hex Shank Quick Change Adapter.
3. 1 Hand Drill, battery operated or corded.
4. 1 Steel Plate 1/8" maximum thickness.
5. 1 appropriately sized vice or clamping tool.
6. 1 DY60025035 EZ Cut Aerosol
7. 2 pair Safety Glasses (for you and customer) or other protective eyewear.