Self-Feed Bits Instructions

(New style beginning 2007)

PIPE TOOLS & VISES
SINCE 1896

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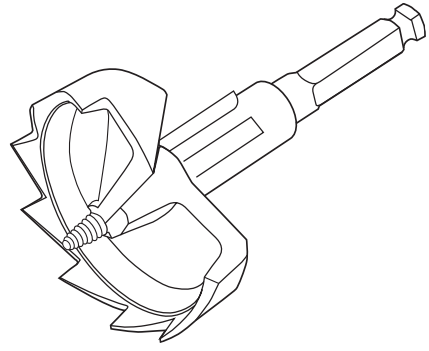

Reed Self-Feed Bits were designed to bore large diameter holes through wood studs and floors for running pipe and conduit. The lead screws will feed the bit through both hard and soft wood, practically without effort from the operator. Ideal for construction, plumbing and electrical work. Can be resharpened with a file. All shanks 1/2" diameter with 6 flats. Overall length 5".

CAT. NO.	ITEM CODE	ACTUAL O.D./IN.	NOMINAL PIPE SIZE*	ACTUAL O.D./mm	WEIGHT lbs	WEIGHT kg
B16	06400	1"	1/2" IPS—3/4" CTS	25	0.3	0.1
B18	06401	1 1/8"	3/4" IPS	28	0.3	0.1
B20	06402	1 1/4"	1" CTS	32	0.3	0.1
B22	06403	1 3/8"	3/4" IPS	35	0.4	0.2
B24	06404	1 1/2"	1 1/4" CTS	38	0.4	0.2
B28	06405	1 3/4"	1 1/2" CTS	44	0.5	0.2
B32	06406	2"	1 1/4" IPS	51	0.7	0.3
B34	06407	2 1/8"	1 1/2" IPS	54	0.7	0.3
B36	06408	2 1/4"	2" CTS	57	0.8	0.4
B41	06409	2 9/16"	2" IPS	65	0.8	0.4
B48	06410	3"	2 1/2" IPS—2 1/2" CTS	76	1.2	0.5
B58	06411	3 5/8"	3" IPS—3" CTS	92	2.2	1.0
B74	06412	4 5/8"	4" IPS—4" CTS	117	2.6	1.2

* **IPS** — Iron Pipe Size — All standard and xhvy steel, PVC, and rigid conduit pipe sizes.
CTS — Copper Tubing Size — All types (K, L, M, and DWV) copper tubing nominal (not O.D.) sizes, and thin wall.

— WARNING —

HIGH ROTATING FORCE.
HOLD OR BRACE SECURELY TO PREVENT PERSONAL INJURY OR DAMAGE TO DRILL.

READ SAFETY INSTRUCTIONS BEFORE OPERATING.
ALWAYS WEAR SAFETY GLASSES.

BIT EXTENSIONS

One-piece extensions feature two set screws with knurled cup points to prevent bit from vibrating loose. Fits all Self-Feed Bits listed above.

CAT. NO.	ITEM CODE	LENGTH in	LENGTH mm	WEIGHT lbs	WEIGHT kg
BEX512	06424	5 1/2"	140	0.8	0.4
BEX12	06425	12"	305	1.2	0.5
BE18	06422	18"	455	1.5	0.7

PARTS	
40120	Kit for 3" - 4 5/8" (3 lead screws, 1 set screw, 1 hex key)
40121	Kit for 1" - 2 9/16" (3 lead screws, 1 set screw, 1 hex key)
96418	Lead screws (3) for 3" - 4 5/8"
96424	Lead screws (3) for 1" - 2 9/16"

QUALITY & Service that Last a Lifetime

SHARPENING INSTRUCTIONS

KEEP BITS SHARP: It is suggested that Self-Feed Bits be kept continuously sharp by filing the teeth of the bit. The steel in these bits is of such a hardness that they can be sharpened with a file. Removal of the lead screw is recommended prior to sharpening the bit.

1. A small (8") flat or half round file is recommended when sharpening Reed Self-Feed Bits.

2. File the slanted edge of the spur back approximately 1/4" as shown in Fig. 1, maintaining a consistent height. Do not file the clearance angle of the chiplifter.

3. Check for uniform spur height with circular saw blade or rafter square. See Fig. 2

4. With the bit pointing down, file the inside cutting edge of the chiplifter as shown in Fig. 3. The outer end of the chiplifter is 1/32" less than the height of the spurs. This height difference should be maintained throughout the process. See Fig. 2. Do not file the chiplifter.

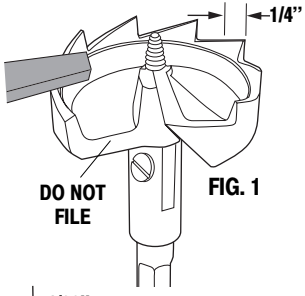

FIG. 1

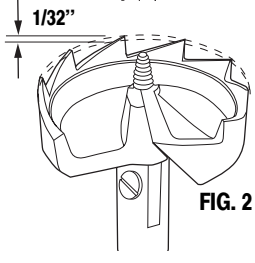

FIG. 2

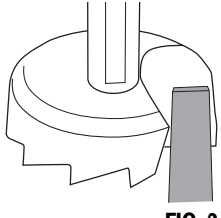
FIG. 3

REPLACING LEAD SCREWS

1. Loosen the set screw (Fig. 4) using a 1/8" hex wrench. Then, remove the lead screw from the bit body. If other end of lead screw is not worn or damaged, reverse it and reinsert it into the bit body. If both ends are worn, insert a new double end lead screw. (See parts.)

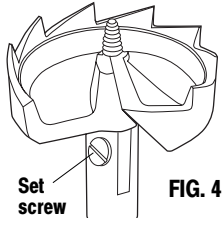

FIG. 4

2. Line up the flat on the lead screw with the set screw and retighten set screw with a 1/8" hex wrench.

ALWAYS unplug power tool before installing or removing bits.

EXERCISE CAUTION when using Self-Feed Bits to prevent binding. If a moving bit gets caught in the workpiece, the torque of the drill being used may cause the tool to spin in the opposite direction causing inaccurate drilling and possible injury to the operator. To help prevent accidents follow the instructions.

BRACE TOOL AND WORKPIECE: Before boring holes, secure material and brace the tool with the side handle. Be sure the tool is braced to prevent tool rotation in the direction opposite that of the bit rotation.

KEEP BIT SHARP: Dull Self-Feed Bits are more likely to bind and bore holes less accurately than a properly sharpened one. Avoid cutting through nails or screws as this will damage the bit. When using the Self-Feed Bit in areas where nails are suspected, use special care when bracing the drill in case the bit suddenly binds. Follow the instructions for sharpening the bits.