Makita B-65399

Makita B-65399 Impact Gold 14 Pc. Titanium Drill Bit Set User Manual

Model: B-65399
Brand: Makita

Introduction Safety Information Product Overview Setup Operation Maintenance Troubleshooting Specifications Warranty & Support

1. Introduction

This manual provides essential information for the safe and effective use of your Makita B-65399 Impact Gold 14 Pc. Titanium Drill Bit Set. Please read this manual thoroughly before operation to ensure proper handling, maximize performance, and prolong the life of your drill bits.
The Makita Impact Gold drill bit set is engineered for durability and precision, featuring a titanium nitride (TiN) coating for extended life and a 135-degree split-point geometry for fast, accurate starts without walking. These bits are designed for use with 1/4-inch hex impact drivers and are suitable for drilling a variety of materials including metal, wood, and plastic.

2. Safety Information

Always observe proper safety precautions when using power tools and accessories. Failure to follow these guidelines may result in injury or damage to the product.

General Safety Rules:

- **Wear Eye Protection:** Always wear ANSI Z87.1 approved safety goggles or safety glasses with side shields when operating power tools.
- **Wear Hand Protection:** Use appropriate gloves to protect hands from sharp edges and debris.

- **Secure Workpiece:** Always clamp or otherwise secure the workpiece to prevent movement during drilling.
- **Use Correct Bit for Material:** Ensure the drill bit is appropriate for the material being drilled.
- **Avoid Overheating:** Allow bits to cool during prolonged use. Excessive heat can reduce bit life.
- **Inspect Bits Before Use:** Check for any signs of damage, cracks, or dullness. Do not use damaged bits.
- **Keep Work Area Clean:** Cluttered work areas and benches invite accidents.
- **Store Properly:** Store drill bits in their protective case when not in use to prevent damage and corrosion.

3. Product Overview

The Makita B-65399 set includes 14 titanium-coated drill bits with 1/4-inch hex shanks, designed for impact drivers. The set comes in a durable, organized case for easy storage and transport.

Components:

- 14 Titanium Drill Bits (sizes: 1/16", 5/64", 3/32", 7/64", 1/8" (x2), 9/64", 5/32", 3/16", 7/32", 1/4", 5/16", 3/8", 1/2")
- Durable Storage Case



Figure 3.1: The Makita B-65399 drill bit set displayed open in its protective case, showcasing the full range of titanium-coated drill bits.



Figure 3.2: The compact and durable green and black storage case for the Makita B-65399 drill bit set, featuring the Makita logo on the side.

4. Setup

Proper setup ensures safe and efficient drilling.

Inserting a Drill Bit into an Impact Driver:

1. **Select the Correct Bit:** Choose the appropriate drill bit size for your application. Refer to the markings on the bit or the case for size identification.
2. **Ensure Power Tool is Off:** Always ensure your impact driver or drill is turned off and unplugged (if corded) or has its battery removed (if cordless) before changing bits.
3. **Open Chuck:** Pull back the collar on your 1/4-inch hex impact driver's chuck to open it.
4. **Insert Bit:** Insert the hex shank of the drill bit fully into the chuck.
5. **Release Chuck:** Release the collar. The bit should snap securely into place. Tug lightly on the bit to ensure it is firmly seated and will not wobble during operation.

5. Operating Instructions

These drill bits are designed for optimal performance in various materials when used correctly.

Drilling Procedure:

1. **Prepare Workpiece:** Secure the material to be drilled firmly to a workbench or stable surface using clamps. Mark the drilling location accurately.
2. **Position the Drill:** Place the tip of the drill bit on the marked drilling location. The 135-degree split-point design helps prevent bit walking.
3. **Start Drilling:** Begin drilling at a slow speed, applying light, steady pressure. As the bit starts to cut, gradually increase speed and pressure.
4. **Maintain Pressure:** Apply consistent, moderate pressure throughout the drilling process. Avoid excessive force, which can cause the bit to overheat, dull, or break.
5. **Clear Chips:** For deeper holes, periodically withdraw the bit from the hole to clear chips and allow the bit to cool. This is especially important when drilling metal.
6. **Coolant (for Metal):** When drilling metal, especially harder metals, use a cutting fluid or coolant to lubricate the bit and dissipate heat. This significantly extends bit life and improves cutting performance.
7. **Complete Hole:** Continue drilling until the desired depth is reached or the bit passes through the material. Reduce pressure as the bit breaks through to prevent splintering (in wood) or sudden jerking.
8. **Withdraw Bit:** Once the hole is complete, withdraw the bit from the hole while the drill is still rotating to clear any remaining debris.

Material-Specific Tips:

- **Metal (Ferrous, Non-Ferrous, Cast Iron, Stainless Steel):** Use slower speeds and apply cutting fluid. For stainless steel, use very slow speeds and constant pressure.
- **Wood:** Generally higher speeds can be used. Ensure the workpiece is well-supported to prevent splintering on the exit side.
- **Plastic:** Use moderate speeds to prevent melting the plastic. Clear chips frequently.

6. Maintenance

Proper maintenance ensures the longevity and performance of your drill bits.

Cleaning:

- After each use, wipe down the drill bits with a clean, dry cloth to remove any dust, debris, or residue.
- If cutting fluid was used, clean the bits thoroughly to prevent residue buildup.

Storage:

- Always store the drill bits in their original protective case. This prevents damage to the cutting edges and protects them from moisture and corrosion.
- Store the case in a dry environment, away from direct sunlight and extreme temperatures.

Inspection:

- Periodically inspect bits for signs of wear, such as dullness, chipping, or cracks.
- Dull bits can be sharpened by a professional or with appropriate sharpening tools, though the titanium nitride coating may be affected.
- Replace any severely damaged or broken bits immediately.

7. Troubleshooting

Here are some common issues and their solutions:

Problem	Possible Cause	Solution
Bit not cutting efficiently / Slow drilling	Dull bit; Incorrect speed/pressure; Wrong bit for material	Replace or sharpen bit; Adjust drill speed and pressure; Use appropriate bit for material.
Bit overheating / Smoking	Excessive speed/pressure; No coolant (for metal); Chips not clearing	Reduce speed/pressure; Apply cutting fluid (for metal); Clear chips frequently.
Bit breaking	Excessive side pressure; Bit binding; Damaged bit; Incorrect speed	Apply straight, consistent pressure; Ensure workpiece is secure; Replace damaged bit; Adjust speed.
Hole is not round or off-center	Bit walking; Workpiece not secure; Incorrect starting technique	Start slowly with light pressure; Secure workpiece firmly; Use a center punch for metal.
Bit wobbles in chuck	Bit not fully inserted; Chuck not tightened; Damaged shank	Re-insert bit fully; Ensure chuck is securely tightened; Replace bit if shank is damaged.

8. Specifications

Feature	Specification
Model Number	B-65399
Brand	Makita
Number of Pieces	14
Material	Titanium
Finish Type	Titanium Nitride (TiN)
Shank Type	1/4 inch Hex
Cutting Angle	135 Degrees (Split Point)
Included Sizes (Imperial)	1/16", 5/64", 3/32", 7/64", 1/8" (x2), 9/64", 5/32", 3/16", 7/32", 1/4", 5/16", 3/8", 1/2"
Measurement System	Inch
Item Weight	476 g
Country of Origin	China

9. Warranty & Support

Makita products are manufactured under strict quality control standards. For specific warranty information regarding your Makita B-65399 Impact Gold 14 Pc. Titanium Drill Bit Set, please refer to the warranty card included with your purchase or visit the official Makita website.

Customer Support:

For technical assistance, replacement parts, or service inquiries, please contact Makita customer support through their official channels. Contact information can typically be found on the Makita website or product packaging.
Website: www.makita.ca (or your regional Makita website)
Please have your product model number (B-65399) and purchase date available when contacting support.

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