

Exact 38244

Exact 38244 Spiral Drill Bit User Manual

Model: 38244

INTRODUCTION

This manual provides comprehensive instructions for the safe and effective use of the Exact 38244 Spiral Drill Bit. This high-speed steel ground (HSS-G) drill bit conforms to DIN 338 standards, featuring a Form C, Type N design with a reduced shank. It is specifically engineered for drilling larger diameters, compatible with standard drills equipped with a chuck up to 13.0 mm.

PRODUCT OVERVIEW



Figure 1: Exact 38244 Spiral Drill Bit. This image displays the full length of the drill bit, highlighting its spiral flutes and reduced shank.

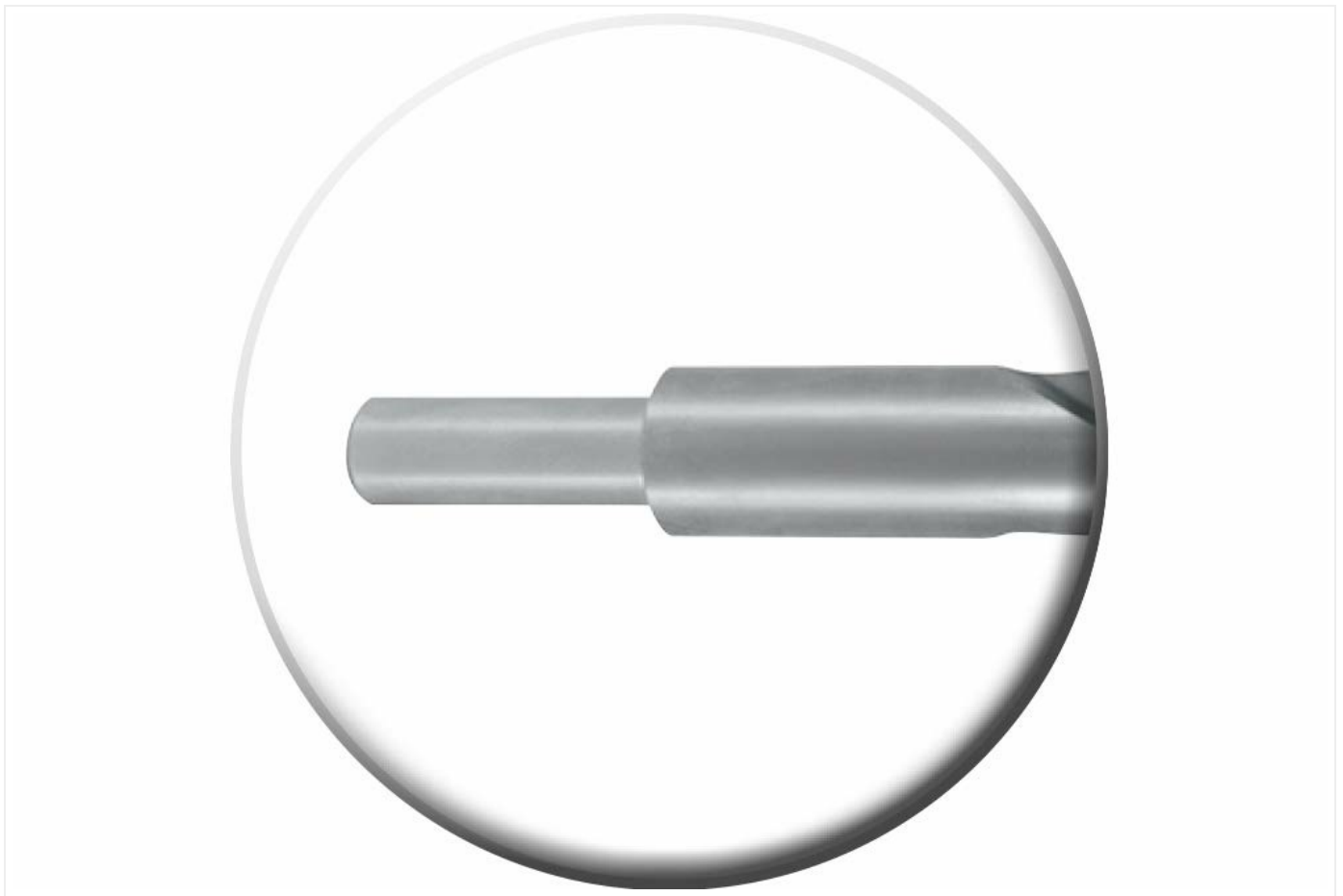


Figure 2: Close-up view of the reduced shank. This image focuses on the cylindrical portion of the drill bit designed to fit into smaller chucks.

The Exact 38244 drill bit is manufactured from HSS-G (High-Speed Steel Ground) for enhanced durability and precision. Key features include:

- **Material:** HSS-G (High-Speed Steel Ground)
- **Standard:** DIN 338
- **Type:** N
- **Shank:** Reduced shank, diameter 13 mm, allowing use with drills having a 13 mm chuck capacity.
- **Tip Cut:** Form C - split cut, for improved centering and reduced thrust force.

SETUP

Proper setup is crucial for safe and effective drilling. Always wear appropriate personal protective equipment (PPE), including safety glasses, before beginning any drilling operation.

1. **Select the Correct Drill:** Ensure your drill has a chuck capacity of at least 13 mm to accommodate the reduced shank of this drill bit.
2. **Clean the Chuck:** Before inserting the drill bit, ensure the drill chuck jaws are clean and free of debris.
3. **Insert the Drill Bit:** Insert the reduced shank of the drill bit fully into the drill chuck. Ensure the shank is seated as deeply as possible to minimize runout and maximize grip.
4. **Tighten the Chuck:** Hand-tighten the chuck firmly. For keyless chucks, ensure an audible click or firm resistance is felt. For keyed chucks, use the chuck key to tighten all three jaws securely. Do not overtighten, as this can damage the chuck or the drill bit shank.
5. **Verify Security:** Gently pull on the drill bit to confirm it is securely held in the chuck. The drill bit should not slip or

wobble.

OPERATING INSTRUCTIONS

This drill bit is designed for general-purpose drilling in various materials, including alloy steel. Always prioritize safety during operation.



Figure 3: The Exact 38244 drill bit actively drilling into a metal surface, showing metal shavings being produced.

1. **Material Preparation:** Secure the workpiece firmly using clamps or a vise to prevent movement during drilling. Mark the drilling location accurately.
2. **Pilot Hole (Optional):** For very large holes or hard materials, consider drilling a smaller pilot hole first to aid in centering and reduce strain on the larger drill bit.
3. **Drilling Speed:** Select an appropriate drilling speed for the material. Generally, harder materials require slower speeds, while softer materials can tolerate higher speeds. Refer to drill manufacturer guidelines for specific speed

recommendations.

- 4. **Apply Pressure:** Apply steady, consistent pressure to the drill. Avoid excessive force, which can cause the drill bit to overheat, dull prematurely, or break.
- 5. **Lubrication/Coolant:** For drilling in metals, especially harder ones, use a suitable cutting fluid or coolant to reduce friction, dissipate heat, and extend the life of the drill bit.
- 6. **Chip Clearance:** Periodically withdraw the drill bit from the hole to clear chips and allow coolant to penetrate. This prevents chip packing and overheating.
- 7. **Safety Precautions:**
 - Always wear safety glasses to protect against flying debris.
 - Wear appropriate gloves to protect hands, but avoid loose-fitting gloves that could get caught in rotating machinery.
 - Do not wear loose clothing or jewelry that could become entangled.
 - Ensure adequate ventilation, especially when using cutting fluids.
 - Disconnect power before changing drill bits or performing maintenance.

MAINTENANCE

Proper maintenance extends the life and performance of your drill bit.

- **Cleaning:** After each use, clean the drill bit to remove chips, dust, and residue. A stiff brush or compressed air can be used. Ensure the bit is dry before storage.
- **Lubrication/Corrosion Protection:** Apply a thin coat of machine oil or rust preventative to the drill bit, especially if it will be stored for an extended period or in a humid environment. This prevents corrosion of the HSS-G material.
- **Storage:** Store the drill bit in its original packaging or a dedicated drill bit case to protect the cutting edges from damage and prevent contact with other tools that could cause dulling or chipping. Store in a dry place.
- **Sharpening:** If the drill bit becomes dull, it can be professionally sharpened or sharpened using appropriate drill bit sharpening tools. A dull drill bit will generate excessive heat, produce poor quality holes, and require more force to operate.

TROUBLESHOOTING

Refer to the following table for common issues and their potential solutions.

Problem	Possible Cause	Solution
Drill bit not cutting or cutting slowly	Dull cutting edge; Incorrect speed; Insufficient pressure; Wrong drill bit for material.	Sharpen or replace drill bit; Adjust drilling speed; Increase feed pressure; Verify drill bit suitability for workpiece material.
Excessive heat or smoke	Dull drill bit; Too high speed; Insufficient coolant/lubrication; Chip packing.	Sharpen or replace drill bit; Reduce drilling speed; Apply more coolant/lubrication; Clear chips frequently.
Drill bit breakage	Excessive force; Drill bit wobble/runout; Workpiece not secured; Drill bit hitting hard inclusion.	Reduce feed pressure; Ensure drill bit is securely chucked; Secure workpiece firmly; Inspect workpiece for hidden obstacles.
Hole is oversized or out of round	Drill bit wobble; Worn chuck; Excessive side pressure.	Ensure drill bit is securely chucked; Inspect drill chuck for wear; Apply even, axial pressure.

SPECIFICATIONS

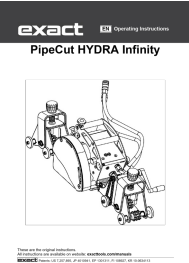
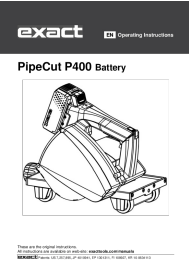
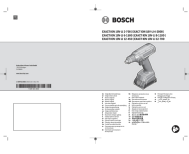
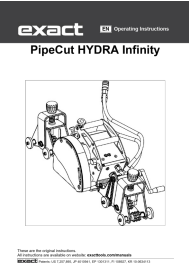
Detailed technical specifications for the Exact 38244 Spiral Drill Bit.

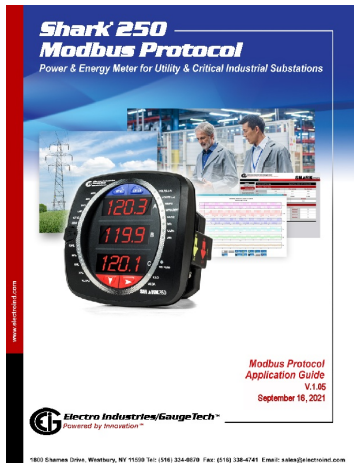
Specification	Value
Model Number	38244
Material	HSS-G (High-Speed Steel Ground) / Alloy Steel
Standard	DIN 338
Type	N
Form	C (Split Cut Tip)
Diameter	17.0 mm
Reduced Shank Diameter	13 mm
Total Length	184 mm
Blade Length	35 mm
Drilling Depth	5 x D (5 times diameter)
Tip Angle	118°
Spiral Angle	20-30°
Finish Type	Steam Tempered
Item Weight	200 g
Product Dimensions (L x W x H)	18.4 x 1.7 x 1.7 cm
Included Components	1 x Exact Twist drill bit, diameter 17.0 mm, HSS-G, DIN 338, form C, type N, reduced shaft

WARRANTY AND SUPPORT

For information regarding product warranty, returns, or technical support, please refer to the official Exact product documentation or contact your point of purchase. Specific warranty terms may vary by region and retailer. For further assistance, you may visit the [Exact brand page on Amazon.in](#).



	Exact PipeCut HYDRA Infinity: Operating Instructions and Safety Guide Comprehensive operating instructions, safety guidelines, technical specifications, and maintenance information for the Exact PipeCut HYDRA Infinity pipe cutting machine. Covers blade suitability, operation procedures, hazard warnings, and warranty details.
	Exact PipeCut P400 Battery Operating Instructions Comprehensive operating instructions for the Exact PipeCut P400 Battery pipe cutting system, covering safety, operation, maintenance, and troubleshooting.
	eXact® Micro 20 Dual Wavelength Advanced Photometer System Instruction Manual Instruction manual for the eXact® Micro 20 Dual Wavelength Advanced Photometer System, detailing its features, operation, and maintenance for various water quality testing applications.
	X-Rite eXact 2: Advanced Color Measurement Solution Discover the X-Rite eXact 2, a next-generation handheld spectrophotometer and densitometer. This document details its advanced features, including improved usability, contactless measurement, wireless connectivity, and integration with the eXact 2 Suite for comprehensive color management.
	Bosch EXACT ION 18V-LI Serie: Industrielle Akkuschauber Bedienungsanleitung Bedienungsanleitung und technische Daten für die Bosch EXACT ION Serie von industriellen Akkuschaubern. Enthält Sicherheitshinweise, Produktinformationen und Spezifikationen für Modelle wie EXACT ION 18V-LI 2-700, 4-2000, 6-1500, 8-1100, 12-450, 12-700.
	Exact PipeCut HYDRA Infinity: Operating Instructions and Safety Guide Comprehensive operating instructions, safety guidelines, technical specifications, and maintenance information for the Exact PipeCut HYDRA Infinity pipe cutting machine. Covers blade suitability, operation procedures, hazard warnings, and warranty details.

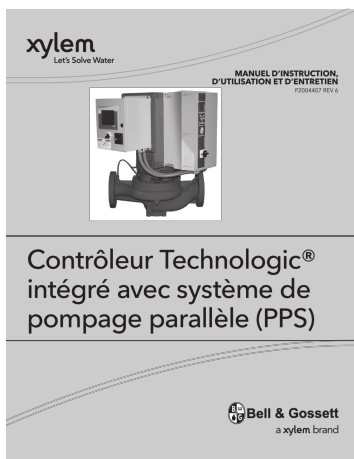


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Shark 250 Modbus Manual V 1 05 Electro Industries Shark® Meter Protocol Application Guide Jan 2000

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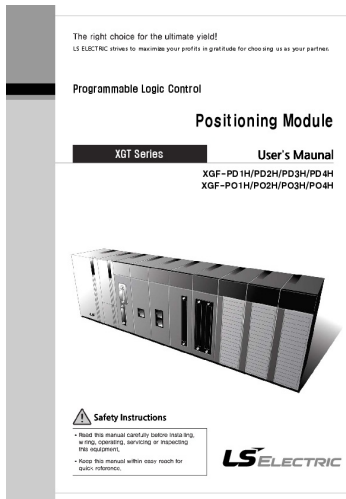
[\[pdf\]](#) Instructions

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INSTRUCTIONS FOR USE AIO 3.0 LOXONTM SET FOR OVERHANG OF 54 CM BASE PLATES FOR EXACT COUCH MR safe ... he standard LoxonsTM Art. No. 38203 . This product consists of 2 sets of 2 loxons. Set 1 Art. No. **38244** is the cranial set. Set 2 Art. No. 38245 is the caudal set. Both sets have a left and right...

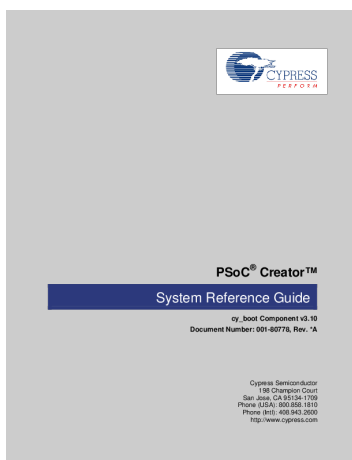
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[LS ELECTRIC XGT Series Positioning Module User's Manual](#)

Comprehensive user's manual for the LS ELECTRIC XGT Series Positioning Module, covering installation, wiring, operation, and safety instructions for models XGF-PD1H/PD2H/PD3H/PD4H and XGF-PO1H/PO2H/PO3H/PO4H.

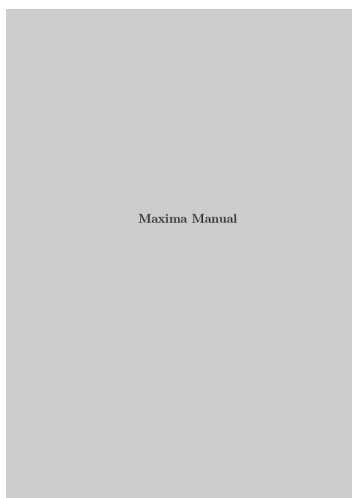
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System Reference Guide PSoC® Creator™ Cypress CyBoot V 3 10 001 80778 cypress docID 38244 PSoC Creator™ System Reference Guide cy_boot Component v3.10 Document Number: 001-80778, Rev. *A Cypress Semiconductor 198 Champion Court San Jose, CA 95134-1709 Phone USA : 800.858.1810 Phone Intl : 408.943.2600 <http://www.cypress.com> Copyrights Cypress Semiconductor Corporation, 2012. The in...

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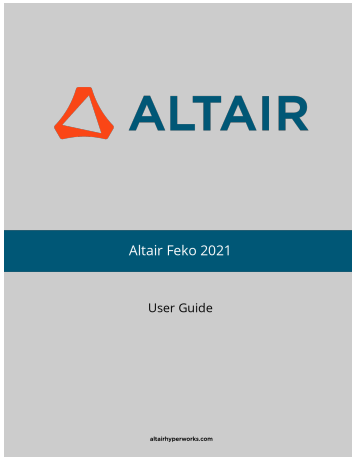


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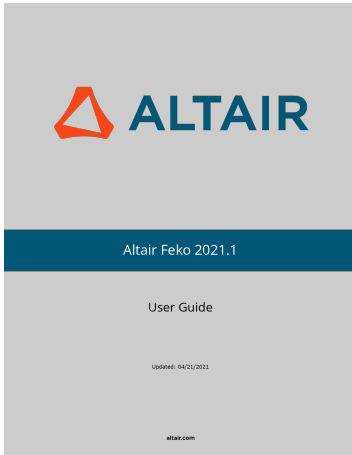
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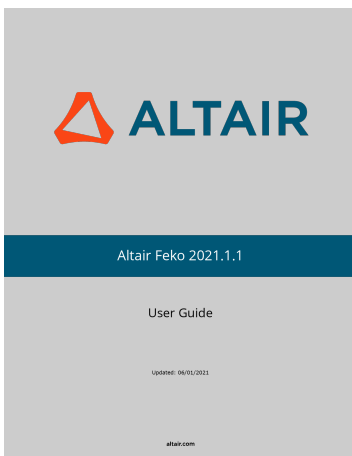
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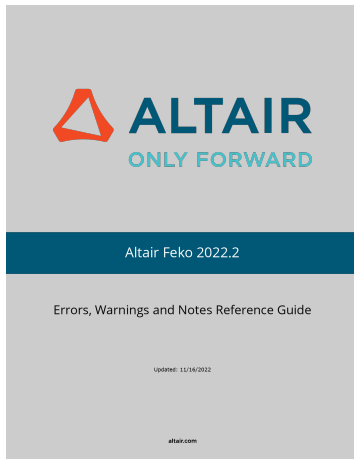
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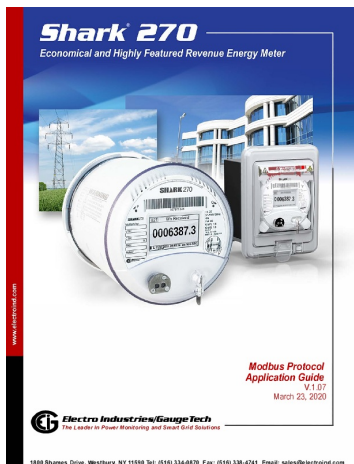
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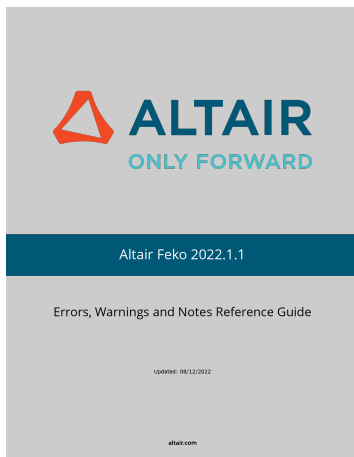
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Shark 270 Meter Modbus Manual V 1 07 Electro Industries 08 Customer support is available 8 00 am to pm Eastern Standard Time Monday through Friday Please have the model serial number and a detailed problem

2 Organization of this This chapter an introduction Shark@270 Protocol Applica tion Guide Shark® Application Published by GaugeTech 1800 Shames Drive EnergyPQA TM Software User 3 Retrieving Logs Using 39 s Map section describes meter log interface system which that uses retrieve data from stored historical interval waveform other logs programming point view It intended for programmers Use bookmarks navigate sections con tained in Chapter 4 The map includes following Info Information Section Registers 57 Table Contents1 Introduction 11 1Software instructions If security enabled there are E159718 electroind products manuals

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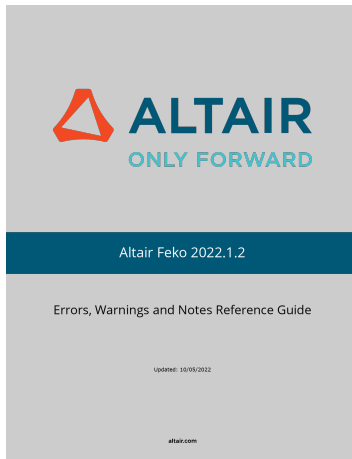
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A comprehensive reference guide for understanding and resolving errors, warnings, and notes encountered within Altair Feko 2022.1.1. This guide details how to interpret various messages, their causes, and recommended corrective actions for efficient simulation and modeling.

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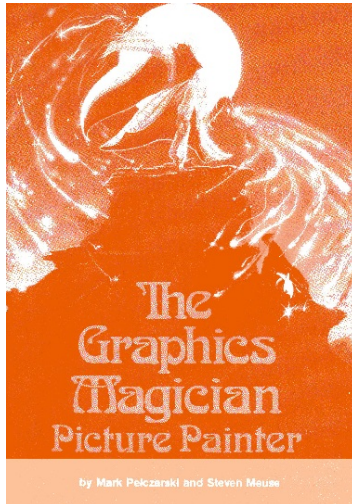
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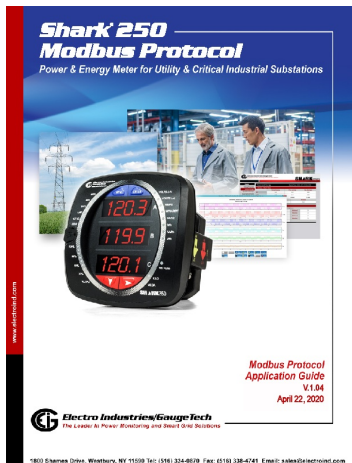


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The Graphics Magician Picture Painter User Manual mirrors apple2 org za ftp apple asimov net documentation applications misc

The Graphics Ill agicianTm Picture Painter by Mark Pelczarski and Steven Meuse The enclosed product ... , given x,y coordinate and an ASCII value A, put the ASCII value in 38242, put X in 38243, put Y in **38244**, and CALL 38245. Hexadecimal addresses 9562 9565 . A sample is shown in listing 7.1, and an ...

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Shark 250 Modbus Manual V 1 04 Electro Industries GaugeTech 05 Installation and Operation 2

Organization of this This chapter is an introduction to the Shark@250 Meter Protocol gerPQATM

EnergyPQA TM Software User For additional details about meter its operation see Shark@ Applica tion

Guide Customer support available 8 00 am pm Eastern Standard Time Monday through Friday Please

have model serial number a detailed problem 4 Map Use bookmarks navigate sections con tained in

Chapter The map includes following Introduction Overview 3 Retrieving Logs Using s Data Formats

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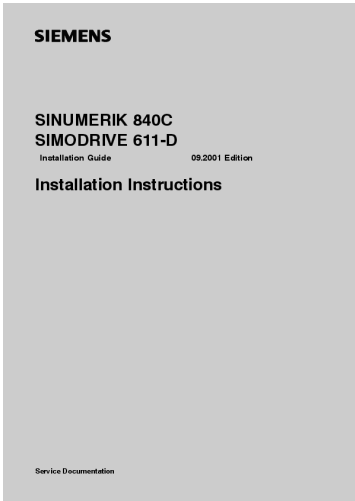
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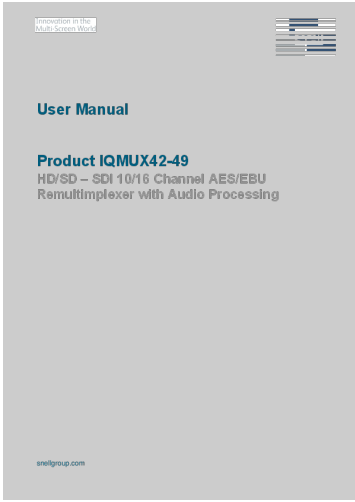
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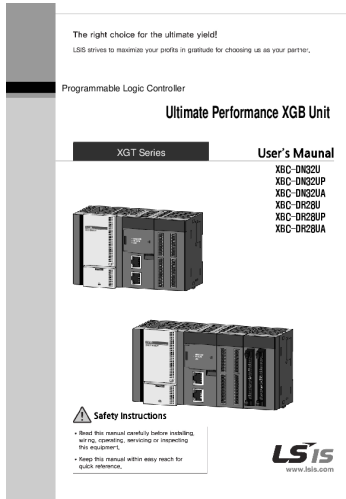
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IQMUX42 49 Snell Ltd Andrew Moore User Manual Product Grass Valley 2 HD SD SDI outputs 8 AES EBU balanced inputs 1 unbalanced monitor output Page 10 snellgroup Issue Remultiplexer with Audio Processing grassvalley docs Manuals sam modular infrastructure IQ User Manual Product IQMUX42-49 HD/SD SDI 10/16 Channel AES/EBU Remultiplexer with Audio Processing ... 66 9567 9568 9569 956a 956b 956c 956d 956e 956f 9588 9589 958a 958b 958c 958d 958e 958f 9590 38243 **38244** 38245 38246 38247 38248 38249 38250 38251 38252 38253 38254 38255 38280 38281 38282 38283 3828... lang:fr score:11 filesize: 2.84 M page_count: 130 document date: 2012-02-08

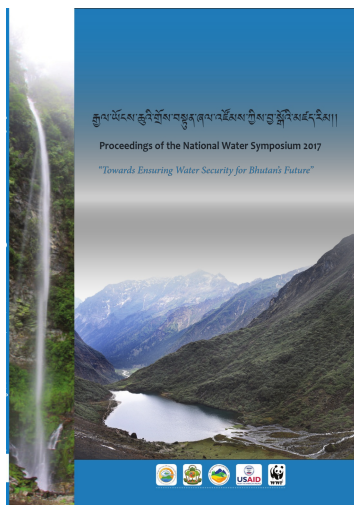


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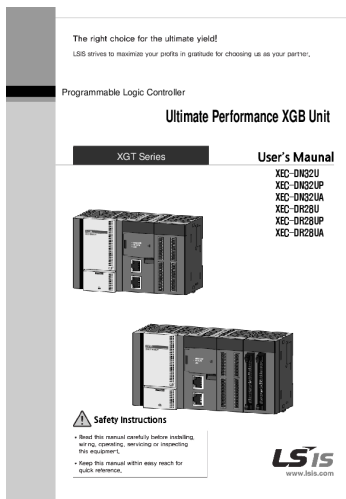


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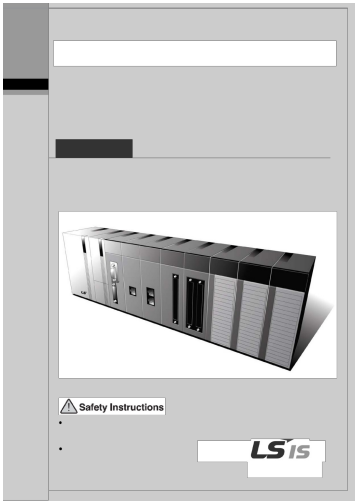
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List of Error IDs out of Aastra Intelligent	
1 #	Bridge received unexpected event, parameter is the EventId
2 #	For received message to unknown domain, Parameter is Signal
3 #	Trunk to remove unexisting entry from mapping table
4 #	Take Event received unexpected event, parameter event id
5 #	Could not find a subpage which matches the incoming event, parameter event, id
6 #	Could not find an instance for the called object, parameter object id
7 #	General error event id
8 #	Unique value is too large, All have been allocated, See systemerror.h
9 #	Mapping error, probably a not existing error when values are finished with)
10 #	A new point with invalid parameters was added
11 #	Asynch failed
12 #	A file segment without a valid data block was detected, Shouldn't even happen.
13 #	An unhandled signal was passed to the process framework, Parameter 1: Signal Name and Minor ID (if exists), Parameter 2: Source PID, Parameter 3: Receiver PID, If all parameters are 0, this means that a N.A.L. signal pointer was received.
14 #	withholding process error
15 #	Turning to release an object with an id that does not exist in the handlepool
16 #	Unable to cancel memory from the heap, The reference and id of the objects to be released is deleted
17 #	Unable to release the handle ID pool, Trying to create a new one
18 #	Entry is locked although it shouldn't, skip
19 #	Integrity check: Handle ID is not of allowed range
20 #	Integrity check: Object reference doesn't point into heap
21 #	Integrity check: Too many errors during check, Can not deallocate all invalid IDs
22 #	Integrity check: Unknown state in recordpool, Invalid to default
23 #	Could not create new handle ID for an object
24 #	Unable to allocate memory from heap with new
25 #	Unable to free entry in deallocated pool
26 #	Unable to get handle ID from reference, Can not deallocate handle ID
27 #	Fatal error: Could not deallocate memory with operator delete -> crash
28 #	Could not get reference from handle ID
29 #	Subtraction returned a value < 0, Absolute value is taken, memory allocated via _lock will never be freed, This does not mean that it creates a real memory leak, it can be allocated again by the code after you call, But you will get serious problems using _lock in dynamic processes, because they crash! filling the
30 #	Try to get size of a compressed application file with no valid header
31 #	CRC check of compressed application file failed
32 #	Try to check CRC of compressed application file with no valid header
33 #	Try to start a timer without setting the expiry time
34 #	Wrong parameter passed to setTimer
35 #	Statevector received can't happen event
36 #	Event handler is wrong linkage
37 #	This Warning is issued if an event of a Statevector is sent to a non existing instance, This can happen if the instance was deleted during the event was in the queue
38 #	CRC of object corrupted
39 #	couldn't add the new handle to the DataReceiver list
40 #	could not allocate new id
41 #	could not deallocate id pool
42 #	CRC of receiver list corrupted
71 1003 18.01.2011	

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1 ar 2 ar 3 ar 4 ar 5 ar 6 ar 7 ar 8 ar 9 ar 10 ar 11 ar 12 ar 13 ar 14 ar 15 ar 16 ar 17 ar 18 ar 1 ... 38233 ia 38234 ia 38235 ia 38236 ia 38237 ia 38238 ia 38239 ia 38240 ia 38241 ia 38242 ia 38243 ia **38244** ia 38245 ia 38246 ia 38247 ia 38248 ia 38249 ia 38250 ia 38251 ia 38252 ia 38253 ia 38254 ia 3...
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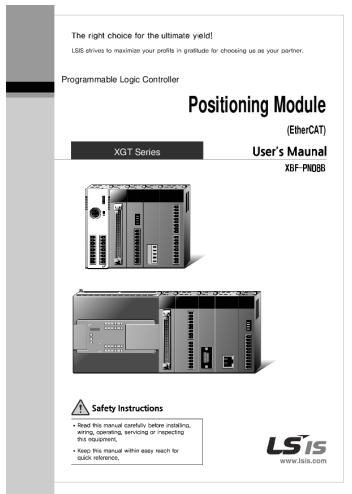
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Right choice for ultimate yield LSIS strives to maximize customers profit in gratitude of choosing ... 040 38052 38064 38076 38088 38100 38112 38124 38136 38148 38160 38172 38184 38196 38208 38220 38232 **38244** 38256 38268 38280 38292 38304 38316 38328 38340 38352 38364 38376 38388 38400 38412 Control w...
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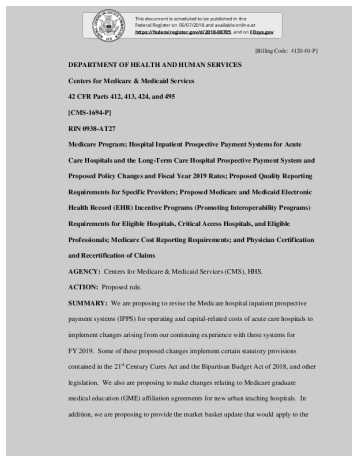
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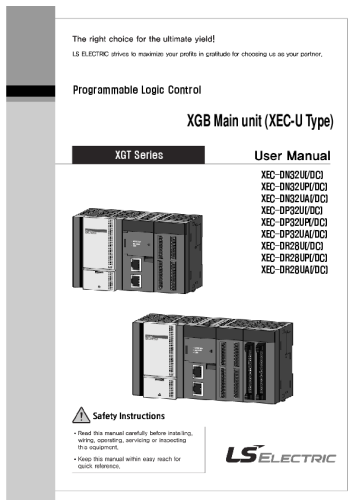
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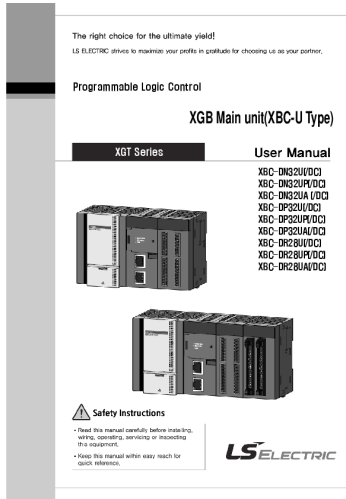
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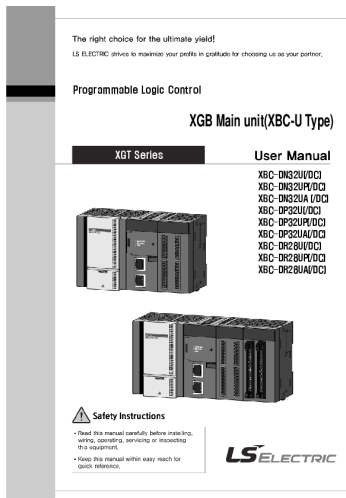


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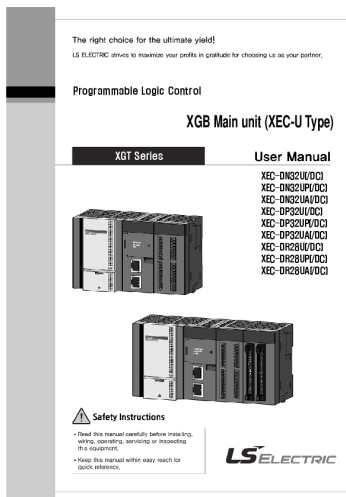


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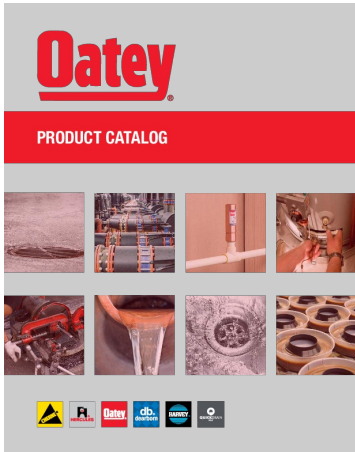


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