



Drill Bit No.	Impact Torque		Impact Torque	
	Grade 8.8 bolts		Grade 8.8 bolts	
	Nm Torque	Ft Lb Torque	Nm Torque	Ft Lb Torque
#3	160	178		
#4	280	207		
#5	300	222		
#6	580	430		
#7	Rotary Only	Rotary Only		

Extractor No.	Impact Torque		Impact Torque	
	Grade 8.8 bolts		Grade 8.8 bolts	
	Nm Torque	Ft Lb Torque	Nm Torque	Ft Lb Torque
#3	140	130		
#4	200	145		
#5	220	160		
#6	430	320		
#7	500	380		

LEFT HANDED DRILL BITS BEST PRACTICE ADVICE

GUIDELINE PARAMETERS ONLY -
Actual parameters may vary depending on operating conditions

1. Designed for use in left hand direction (Reverse) only.
2. For best results drilling through hardened bolts and materials, it is recommended to start with a small diameter drill bit and step up to the finished diameter with increasingly larger drill bits
3. Ensure ample application of lubricant (SpeedLube/BioCut Blue) during the drilling process to prevent overheating & work hardening of the fastener.
4. Wherever possible use a scribed or drawn mark to find the exact center of the fastener to be drilled.
5. For best results drill all the way through the bolt/stud before inserting the Screw Extractor
6. Where the application allows, using the Left Hand drills in a reversible Magnet Drill will make the drilling process faster and more stable.
7. For larger diameter drill bit sizes (#6/#7) or when drilling particularly hard materials, using a rotary or magnetic drill may provide better results than an Impact wrench.

BOLT EXTRACTOR BEST PRACTICE ADVICE

GUIDELINE PARAMETERS ONLY -
Actual parameters may vary depending on operating conditions

1. Ensure the correct sized pilot hole is drilled into seized bolt using VersaDrive® Left Hand bits
2. Use a soft-faced hammer to securely tap the extractor into pilot hole
3. Attach VersaDrive® Impact Adapter and use on left hand rotation (Reverse Mode)
4. Where possible ensure ample lubricant is applied to the drilled hole and time allowed for the fastener to cool after drilling and to allow the lubricant to penetrate into the drilled hole and threads.
5. To assist with successful extraction it is important that the pilot hole is drilled square to the centre of the fastener to avoid the extractor running off plane when reversing out, and potentially breaking or coming loose.
6. Whilst the VersaDrive extractors are superior to standard stud extractors readily available, it is recognised that stud/fastener extraction is a very challenging task and a complete success cannot be guaranteed in all circumstances. Using heating methods and/or releasing fluids can often assist with the removal process.

QUICK GUIDE

- Drill correct sized pilot hole in seized bolt using VersaDrive® Left Hand bits
- Use a hammer to securely tap the extractor into pilot hole
- Attach VersaDrive® Impact Adapter and use on left hand rotation

MORE INFO

