



# XSR

## STEP REAMERS

Step Drills are great tools for cutting thin metal, but they are limited in capacity when it comes to other industrial applications. The Brute XSR STEP REAMER is a solution oriented high-performance tool that solves this problem. It is a HEAVY DUTY hybrid between a STEP DRILL and a REAMER, allowing the operator to enlarge and align holes in steel up to 1/2" thick. The XSR is ideal for cutting bolt hole sizes for a variety of industries. Users will appreciate and value the convenience of having 5 drill sizes per tool-optimizing productivity on their job.

### 5 DRILL SIZES • 1 TOOL

#### Efficient, Productive, High Value Tool

- Enlarge, Align & Drill Holes In Steel Plate Up to 1/2" Thick
- Engineered For Heavy Duty Applications
- Safety Collar Prevents Overpenetration
- Fast Cutting. Long Tool Life. Bur-Free Holes

Material Applications: Cut Steel, Stainless Steel & Tough Alloys  
Power Tool Guidelines: Use In Portable Power Drill Or Drill Press

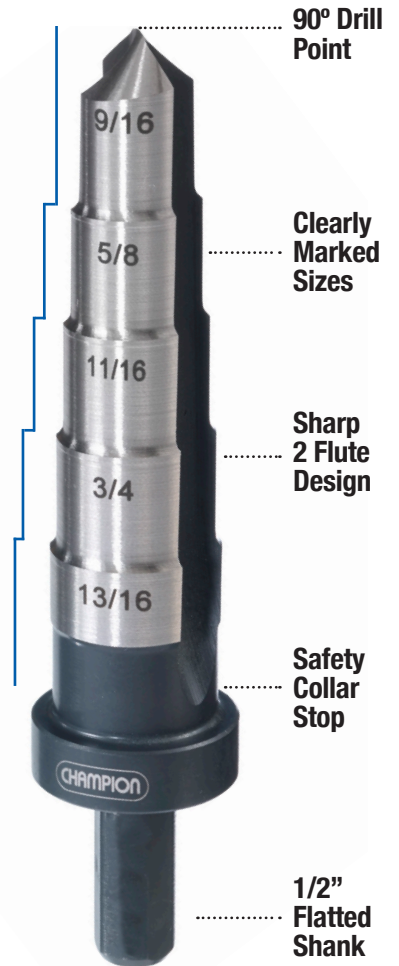
#### Sizes Available

| Product Code             | Drill Sizes   | List Price |
|--------------------------|---|------------|
| XSR-5/16x9/16            | 5/16, 3/8, 7/16, 1/2, 9/16"                         | \$90.00    |
| XSR-9/16x13/16           | 9/16, 5/8, 11/16, 3/4, 13/16"                       | 100.00     |
| XSR-13/16x1-1/16         | 13/16, 7/8, 15/16, 1, 1-1/16"                       | 115.00     |
| XSR-SET<br>(3 Piece Set) | XSR-5/16x9/16<br>XSR-9/16x13/16<br>XSR-13/16x1-1/16 | 315.00     |

All XSR Sizes-Flute Length: 2-3/4"  
XSR-5/16x9/16, 9/16x13/16 OAL: 4-1/2"  
XSR-13/16x1-1/16 OAL: 4-5/8"

#### Popular Industry Applications

- Steel Fabrication:** Structural Steel & Beam Fabrication, Bridge Erection
- Construction :** Commercial, Infrastructure
- Industrial:** Aerospace, Automotive, Water Utilities, Energy, Oil & Gas, Mining
- MRO:** Truck & Trailer, Automotive, Municipalities, Farm Equipment, Elevator
- MEP:** HVAC, Electrical Systems, Plumbing



# **BRUTE** PLATINUM **XSR** **STEP REAMERS**

## **SAFETY PROCEDURES**

- Follow safety procedures - Always wear eye and ear protection
- Workpiece should be securely clamped
- Use BruteLube cutting fluid or wax
- Operating Speeds (see suggested speeds below)
- Apply consistent feed pressure
- After use, clean and lubricate tools and store properly

## **SPEED GUIDELINES**

Operating speeds can vary based on:

- Material thickness
- Type of material
- Other variables including feed pressure

| XSR-5/16 - 9/16 | Speed RPM | XSR-9/16 - 13/16 | Speed RPM | XSR-13/16 - 1-1-/16 | Speed RPM |
|-----------------|-----------|------------------|-----------|---------------------|-----------|
| Ferrous         | 570       | Ferrous          | 380       | Ferrous             | 300       |
| Stainless       | 340       | Stainless        | 230       | Stainless           | 180       |
| Non-Ferrous     | 1350      | Non-Ferrous      | 700       | Non-Ferrous         | 530       |

## **BruteLube Cutting Fluid & Wax**



BruteLube is highly recommended for most metal drilling applications.

By enhancing tool heat resistance, operators will experience smoother cuts, longer tool life, and increased productivity.

| Cutting Fluid | Cutting Wax          |
|---------------|----------------------|
| XLUB4 (4oz)   | XLUB-WAX-2 (2oz)     |
| XLUB16 (16oz) | XLUB-WAX-16 (16oz)   |
| XLUB128 (Gal) | XLUB-STICK-16 (16oz) |

\*BruteLube is environmentally safe. MSDS available upon request.

