

Heavy Duty Hollow Drills

[Español](#)

All Brands!

We have been manufacturing Hollow Paper Drills for over 30 years. We manufacture Paper drills for all machines: **Challenge, Lawson, HFD, Baum, Nygren-Dahly, Seybold, Pioneer, Iram, Sterling, Lihit, Imperial, and Hang**. You can buy the products directly from us!

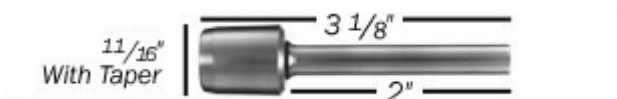
[Lawson](#)



[Hang & Corta](#)



[Challenge](#)



[Martin Yale Lihit Imperial](#)



[Pioneer](#)



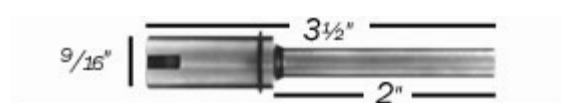
[Spinnit](#)



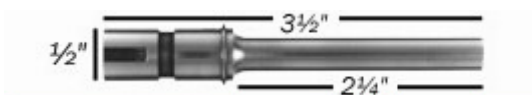
[Nygren](#)



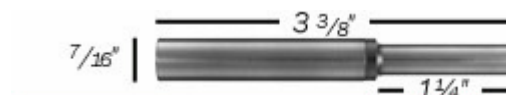
[Iram](#)



[Seybold](#)



[Bielomatik](#)



Other Products:

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Sharpeners](#)

[Coating](#)

[Drill Blocks](#)

For Maximum Performance

1. Seat drills up past the drive pin and up against the shoulder. Keep the inside of the spindle clean with a small toothbrush and solvent, paying particular attention to the drive pin.
2. Most drill breakage is caused by operating dull and/or unseated drills which will ram into the wood block. Be sure to remove slugs and sharpen drills after every shift change.
3. Keep drills sharp and clean. Heavy duty carbide sharpening reamer available - designed to produce a razor sharp edge.

Paper Drilling Tips

Handy Info For Your Convenience

Keep Drill Bits Sharp

The primary cause of drill breakage and poor work quality is a dull bit. For best results, drill bit. For best results, drill bits should be sharpened after every 4 to 8 hours of use. They should be sharpened even more often when drilling through hard stocks, fireboard or abrasive stocks.

Hard Drill Sharpeners shown on [here](#) and Drilling Accessories shown on [here](#)

Keep Drill bits Clean

Another cause of broken bits is a clogged bit. This is commonly cause when drilling through perfect bound books and glue. If the inner diameter of the bit is not cleaned out after shift change or break, glue hardens and the bit will snap upon next start up. Clean out bits after each use. When not in use, drill bits can be lights oiled to prevent rust and corrosion.

Lubricate Drills or use Coated Drills

DHP specializes in coated drills, See [here](#) for information on Titanium #35, Teflon and Duralon. Coating allow easier drilling of vanish, laminated and aqueous coated stocks. Also available is the #7604 Lubricating stick which can be applied to the drill bit every few strokes and works like a coated drill bit.

Suggestions for speed & Feed

Increase the RPM of the drill bit when drilling smaller diameters (1/8" or 3/16"). As you increase the diameter of the bit, decrease the RPM accordingly (i.e., 1/2" bits should be run much slower than 1/8" bits).

The feed (or strokes per minute) should be adjusted depending on the type of stock being drilled. Generally, the softer the stock being drilled, the slower the feed. A good starting point for 1/4" bit drilling through 2" of 10 lb. stock is 2000-2500 RPM at strokes per minute.

Remember that a paper drill must cut/drill the paper ,not punch it like a hammer. Give the bit time to drill the paper. The drill should never turn purple from overheating.