

FORM 1

635701

AUSTRALIA

Patents Act 1952

APPLICATION FOR A STANDARD PATENT

We, UNIBIT CORPORATION, of Dewitt, Nebraska 68341, United States of America, hereby apply for the grant of a standard patent for an invention entitled "A METAL CUTTING TOOL" which is described in the accompanying complete specification.

Details of basic application:

Application No 228378 filed on 4 August, 1988, in the name of the inventor, Harry C Oakes, in the United States of America.

Our address for service is:

CHRYSILIOU MOORE CHRYSILIOU,

P.O. Box 373,

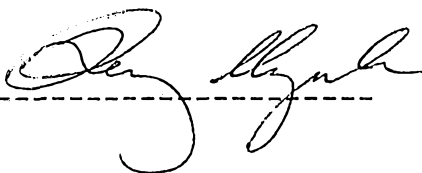
Collaroy Beach. N.S.W. 2097.

Dated this fourteenth day of March, 1989

UNIBIT CORPORATION

By its Attorneys

CHRYSILIOU MOORE CHRYSILIOU

200-174 18/03/89


To: The Commissioner of Patents

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AUSTRALIA
PATENTS ACT 1952

DECLARATION IN SUPPORT OF A CONVENTION APPLICATION FOR A PATENT

In support of the Convention application made for a patent for an invention entitled "A METAL CUTTING TOOL",

I, James E Siegel, of One Chase Road, Scarsdale, New York, 10583 United States of America, do solemn ly and sincerely declare as follows:

1. I am authorised as attorney-in-fact of Unibit Corporation, the applicant for the patent, to make this declaration on its behalf.

2. The actual inventor of the invention is Harry C Oakes, Engineer, a United States citizen, of 2771 Club Road, Perry, New York 14530, USA and the facts upon which the applicant is entitled to make the application are as follows:

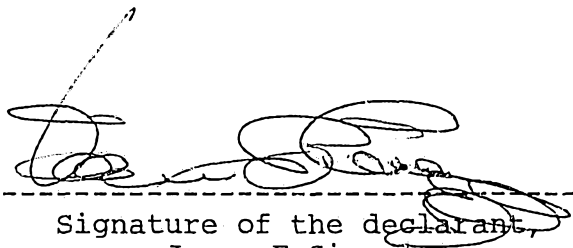
The inventor has assigned his rights in the invention to the applicant.

3. The basic application as defined by section 141 of the Act was made on 4 August, 1988, in USA, No. 228378, in the name of the inventor.

4. The basic application referred to on paragraph 3 of this declaration was the first application made in a Convention country in respect of the invention the subject of the application.

Declared at: Scarsdale, New York 10583

this 11 day of April , 1989



Signature of the declarant,
James E Siegel

To:
The Commissioner of Patents



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- (71) Applicant(s)
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- (56) Prior Art Documents
US 4408935
US 4352610
US 4147464
- (57) Claim

1. A metal cutting tool for trepanning holes in a sheet metal, said cutting tool comprising:

a cutter body extending from a first front end to a second rear end and having a substantially cylindrical outer wall substantially matching the diameter of a hole to be produced, a base disposed within the cutter body, an inner wall tapering radially inwardly from the first front end to the base, said inner wall joining said outer wall of the body to form a forward edge at said first front end, said cutter body having a notch penetrating substantially therethrough and extending for substantially the length of the body from said first end to said second end for removal of cut material and defined by at least side walls thereof, a socket disposed within one said wall of the notch at the first front end of the cutter body,

said socket being adapted to accept a cutting tip therein;

said cutting tip secured to the body and having at least an outer wall, an inner wall, a top surface, a rear wall, a bottom wall and a front face, said front face and said top surface join to form a cutting edge extending forwardly of the cutter body;

said top surface sloping from said cutting edge in the front to back direction relative to the direction of rotation of said cutting tool; at least a part of said inner wall of the cutting tip slopes from the top cutting surface towards the base, said front face of the tip slopes from said cutting edge to said side wall of the notch, the cutting tip extending above the forward edge of the cutter body;

an axial bore extending through the cutter body, pilot means disposed within said axial bore and permanently secured to said body, said pilot means being adapted for aligning the tool at the desired hole location; and a shank extending from said cutter body for releasable engagement with a drive device.

635701

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COMPLETE SPECIFICATION

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Complete Specification for an invention entitled:

"A METAL CUTTING TOOL"

The following statement is a full description of this invention, including the best method of performing it known to me: -

TECHNICAL FIELD

15 This invention relates to metal cutting tools and more particularly to trepanning tools for cutting holes in sheet metal using a hand held drill.

BACKGROUND

20 Tools for cutting holes in various materials such as sheet metal generally fall into two types, those which operate by cutting or removing the entire interior area of a circle and those which operate by cutting only the circumferential area of a circle thereby producing an interior circular plug during the cutting operation. A conventional fluted drill is an example
25 of the former type of tool. Such tools have the disadvantage of requiring substantially more cutting activity in order to produce the desired hole. Over a certain diameter, it is much more efficient and generally quicker to utilize a tool which cuts a thin circumferential circle for removing the metal as a
30 plug. Such tools are generally known as trepanning tools. Tools of this type require substantially less cutting to

achieve a desired hole and therefore provide large diameter holes quickly and with substantially less energy consumption.

The use of trepanning tools which cut only the circumferential area of circles to provide large diameter holes is widely known. Such tools generally comprise an elongated tubular cutting head having cutting blades or tips secured thereto which engage a work piece to shave or cut portions thereof to define the circumference of a circle upon rotation of the tool. Accordingly, as cutting of a work piece is effected, a center plug is produced which is received in the center area of the elongated tubular cutting head. Various ejector devices are commonly used with such tools to remove the plug from the tool, such as spring loaded arms. Tools of this type have been available for cutting holes having diameters ranging from approximately less than an inch to holes having extremely large diameters for example up to 10 inches or more. Such large diameter trepanning tools are generally associated with lathe type machines which are fixedly mounted for producing holes in an automated fashion. Generally, such trepanning tools are therefore rigidly aligned with the material to be cut which is usually also clamped or fixed to prevent movement. While such applications are well known in the art, there has been a continuing effort to produce tools suitable for use in a hand held fashion which will provide a relatively precise and smooth hole in thin sheet metal for use, for example, in field construction such as by an electrician in cutting holes in electrical boxes. In addition, it is desirable to cut holes in other types of sheet metal such as stainless steel, which is

finding more use in home and building construction.

Various efforts have been made to produce trepanning tools which can be effective in cutting holes in sheet metal in diameters from approximately 1/2 inch up to 2 inches. However, such efforts have been generally unsatisfactory, as it is difficult to align hand held tools for producing smooth round holes. In addition to the loss of rigidity, hand held drills have torque and RPM limits considerably less than those available in a fixed machine structure. Consequently, a trepanning tool for hand held applications must produce holes with a minimum of resistance to preclude stalling or binding.

Most of the tools produced to date have suffered from rapid wear which requires frequent replacement of either the entire tool or of the cutting tips attached thereto. For example, in U.S. Patent No. 4,490,080 to Kezran, there is disclosed a hole cutting tool which includes removable cutting tips. Kezran relies on means which retain the tips in slots comprising a retaining wedge which engages the leading edge of the slot and engages the leading edge of the tip to urge it against the trailing edge of the slot so that the cutting tip is wedged in position with the angle of the wedge and the angle of the trailing edge of the slot preventing outward movement of the tip. While such a trepanning tool may be effective in various applications, where field use is complicated it is difficult to provide for tip replacement as such tips are small and easily lost. Should a trepanning tool with dull tips be used, it would require additional torque and undergo accelerated wear, and produce a ragged hole due to binding of the

tips in the sheet metal.

Generally, where multi-tip tools are used, wear may be uneven, causing binding to occur through misalignment of one or more tips within the hole. Such binding is
5 frustrating for the tool operator, and difficult to control with a hand held driving device, requiring additional manual force to overcome. Such a problem is additionally time consuming and often produces a ragged hole. Consequently, the search continues for a trepanning
10 tool which is substantially wear resistant, and capable of producing smooth holes without binding in field applications using a hand held drill and to do so without requiring frequent replacement.

SUMMARY OF THE INVENTION

15 It is an object of the present invention to provide a trepanning tool which does not require a plurality of cutting tips to produce a hole in sheet metal.

It is a further object of the present invention to provide a trepanning tool which is capable of producing smooth
20 holes in sheet metal in field locations using a common hand held drill.

It is another object of the present invention to produce a trepanning tool capable of efficiently ejecting both cut shavings and the center plug out from a work piece.



It is another object of the present invention to provide a tool which is easily manufactured, producing a tool with substantially enhanced life at low cost.

It is another object of the present invention to
5 provide a trepanning tool which cuts holes substantially faster than conventional tools, with a minimum of resistance, thereby reducing operator fatigue.

Accordingly, the present invention provides
a metal cutting tool for trepanning holes in a sheet
10 metal, said cutting tool comprising:

a cutter body extending from a first front end to a second rear end and having a substantially cylindrical outer wall substantially matching the diameter of a hole to be produced, a base disposed within the cutter body, an
15 inner wall tapering radially inwardly from the first front end to the base, said inner wall joining said outer wall of the body to form a forward edge at said first front end, said cutter body having a notch penetrating substantially therethrough and extending for substantially
20 the length of the body from said first end to said second end for removal of cut material and defined by at least side walls thereof, a socket disposed within one said wall of the notch at the first front end of the cutter body, said socket being adapted to accept a cutting tip therein;

25 said cutting tip secured to the body and having at



least an outer wall, an inner wall, a top surface, a rear wall, a bottom wall and a front face, said front face and said top surface join to form a cutting edge extending forwardly of the cutter body;

- 5 said top surface sloping from said cutting edge in the front to back direction relative to the direction of rotation of said cutting tool; at least a part of said inner wall of the cutting tip slopes from the top cutting surface towards the base, said front face of the tip
- 10 slopes from said cutting edge to said side wall of the notch, the cutting tip extending above the forward edge of the cutter body;

- an axial bore extending through the cutter body, pilot means disposed within said axial bore and
- 15 permanently secured to said body, said pilot means being adapted for aligning the tool at the desired hole location; and a shank extending from said cutter body for releasable engagement with a drive device.

It is preferred that the cutter body is composed of steel.

- 20 It is especially preferred that the cutter body is composed of tool steel, heat-treated for hardness and toughness.

Conveniently, the notch is substantially rectangular in shape.



Preferably, the cutting tip includes an outer wall substantially alignable with the outer wall of the cutter body, an inner wall which slopes inwardly from an upper end thereof so as to join with a vertical wall of the cutting tip which is substantially parallel to the outer wall of the cutting tip and a front face which joins with a top cutting surface of the cutting tip to form the blunt cutting edge.

In one preferred embodiment of the present invention the pilot means comprises a pilot bit having a fluted section and a cylindrical shaft section. The fluted section is disposed above the height of the cutting tip and is provided for drilling a pilot hole, whereas the cylindrical shaft section may extend behind the fluted section and is provided for entering the pilot hole prior to the cutting tip contact the sheet metal. Most conveniently, the pilot bit further includes a 135 degrees split point to assure proper hole placement without requiring a prick punch.

In an especially preferred embodiment of the present invention the pilot bit includes limited fluted sections at opposite ends thereof, a first locking means and a second locking means symmetrical herewith. The first locking means is provided for holding the pilot bit within the cutter body bore, whereas the second locking means is provided to allow removal of the pilot bit from the cutter



body bore for switching of the fluted ends after one end becomes dull.

By way of example only some preferred embodiments of the present invention will now be described with reference to
5 the accompanying drawings, wherein:

Fig. 1 is an enlarged perspective view of a preferred embodiment of a metal cutting tool of the present invention;

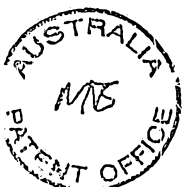
Fig. 2 is a longitudinal cross-sectional view of the same
10 cutting tool illustrating the location and placement of the cutting tip within the cutter body, taken along line 2-2 of Fig. 1;

Fig. 3A is an enlarged front view, 3B, an enlarged side view, and 3C an enlarged top view of the cutting tip
15 locate in the cutter body.

DETAILED DESCRIPTION OF THE INVENTION

Referring to Figs. 1 and 2, the metal cutting tool of the present invention is shown. The tool 10 includes a drive engaging section 11, and a cutter body 12. The drive
20 engaging section may be of any suitable shape for engaging a conventional drill chuck common, for example, to 3/8 or 1/2 inch drive drills.

The cutter body 12 includes an outer cylindrical surface 13, essentially matching the size of the hole desired,



with the cutter body further including an inner, inwardly tapered surface 14 which joins at a base 15. The inner and outer surfaces join at a forward edge 16 of cutting body 12. Having an inwardly tapered surface allows plug discharge without requiring auxiliary plug removers such as spring loaded arms. Essentially, as a plug is cut, it tends to bow due to the cutting pressure, which forces the plug into the cutting body. After the plug is released from the sheet metal, it is driven by its own resiliency, acting on the tapered surface to self discharge, an important feature for field operation. Generally a taper of from 10-40 degrees may be used with about 27 degrees preferred in a 7/8 inch diameter tool.

The cutter body further includes a notch 17 extending from the forward edge 16 to the drive section 11 of the cutter body 12 and which penetrates through the cutter body 12. The notch 17 is essentially rectangular, including sides 18 and 19, and a bottom 20. While a rectangular notch is shown, it will be understood that other shaped notches may also be used. The notch is preferably narrow, for example, on the order of about 0.25 inches wide in a 7/8 inch tool, to prevent hooking during hole cutting. The notch 17 enables faster and more efficient hole cutting since it permits constant ejection of shavings and cutting chips. Constant drilling is thus possible without the need to regularly remove the tool from the drill pit to clear



chips. In particular, the notch 17 allows cut material to pass rearwardly through the cutting body 14 and be constantly disposed of thereby. The design of notch 17 is especially critical when relatively thick materials are cut. Prior art trepanning devices such as that disclosed in United States Patent Serial No. 4,408,935 typically include only very shallow discharge openings such as grooves which are totally covered when thicker materials are drilled and which become clogged by shaving fragments necessitating regular withdrawal of the tool from the drill pit.

A leading edge 21 of the side 18, in reference to the rotation of the tool, includes a socket having a bottom wall 23 and a side wall 24, with the socket sized to accept a cutting tip therein. The cutter body further includes a concentric bore 25 extending from the drive end through the base 15 of the cutter body.

Generally, the cutter body may be composed of steel, alloy or a high carbon steel known as "tool steel", and is preferably composed of A.I.S.I. 6150 steel, heat treated for maximum hardness and toughness.

The metal cutting tool includes a cutting tip 26 which is secured in the socket. Referring to Figs. 3A-3C, the cutting tip 26 includes an outer wall 27 which is straight sided to essentially match the outer wall 13 of the cutter



body 12. The tip outer wall 27 may optimally include a
beveled outer leading edge for assuring that a smooth
sided hole is provided during through cutting. The
cutting tip further includes a bottom wall 29 and a rear
5 wall 30 which mate with the bottom wall 23 and side wall
24 of the socket. In a preferred embodiment, best seen
in Fig. 3A, the rear wall to bottom wall junction is
curved rather than square edged in order to assure proper
alignment and maximize distribution of the cutting forces
10 over the surface of the cutter body. The bottom wall and
rear wall should also be sized to provide a maximum
surface area for bonding. For example, a bottom width of
about 0.165 inches and a rear wall height of about 0.265
inches, joined with a radius of about 0.0625 inches,
15 provides a large surface area for assuring firm bonding in
a 7/8 inch -----



diameter tool.

The cutting tip further includes a flat front face 31 which is generally in alignment with the side wall 18 of the notch 17. The carbide tip also includes an inwardly sloped wall 32, tapering towards the base 15 of the cutter body, which joins with a vertical section 33 forming an essentially pyramidically shaped tip. The wall 32 tapers essentially in about the same amount as the cutter body inner wall, i.e. about 10-40 degrees, with 30 degrees preferred (angle D). The carbide tip further includes a top flat surface 34 which slopes and tapers rearwardly in the direction of rotation. The top surface slope may be fairly steep, on the order of about 5-20 degrees, sloping rearwardly until the back of the top surface 34 is essentially flush with the forward edge 16 of the cutter body 12 (see Fig. 3A, angle A). For example, in a 7/8 inch tool, an 8 degree slope may be used. Similarly the taper may vary with tool size, being dependent on the desired clearance, with inner and outer tapers of 5-15 degrees possible (see Fig. 3B, angles B and C). Again, for a 7/8 inch tool, an inner taper of 10 degrees (B), and an outer taper of 12 degrees (C) are exemplary, with the difference in taper angle resulting from the difference in radius between the inner and outer walls.

A blunt cutting edge 35 is formed at the junction of the front face 31 with the top surface 34. The tip, at the cutting edge 35, extends above the forward edge of the cutter body, generally from 0.010 to 0.020 inches. For example, in a 7/8 inch tool for cutting sheet metal up to 0.14 inches thick,

the tip extends about 0.015 inches above the forward edge of the cutter body. The cutting edge may be from 0.05 to 0.10 inches wide, with the top surface narrowing in the direction of rotation until it approximates the width of the cutter body forward edge, i.e. about 0.04 inches. The blunt cutting edge provided by this geometry is substantially more durable than the pointed cutting edges common to other tools which are prone to rapid wear or breakage. For the illustrative 7/8 inch tool, the cutting edge is preferably about 0.07 inches wide.

The cutting tip may be composed of tungsten carbide such as industry code number C-10, and is preferably composed of micro fine grain tungsten cobalt carbide. The cutting tip may be brazed, welded or otherwise bonded to the cutter body to assure that the tip does not move during cutting. Generally, brazing is preferred for bonding the tip to the cutter body, providing an economic yet reliable means of producing the metal cutting tool.

Referring to Fig. 2, the metal cutting tool of the present invention further includes a pilot drill bit 36 disposed within the bore 25 extending through the cutter body 12. Such a pilot bit includes a fluted section 37 which preferably has a double sided flute and a pointed end 38. A 135 degree split point is preferred to assure proper hole placement without requiring a prick punch mark. The pilot bit is a modified version of a common body drill used in the sheet metal trade, having no margin or clearance which is common to twist drills. Generally, if a common twist drill with standard fluted end were used, the side thrust generated by the trepan-

ing tool cutting edge would cause the drill to cut on the side as an end mill, quickly producing an oversized egg shaped pilot hole which could allow the carbide tip to bind, producing a ragged hole. The pilot bit therefore includes a limited flute section to allow for first cutting a pilot hole using the
 5 fluted end and then insertion of an unfluted shaft section 39 within the pilot hole for guiding the cutting tip in the proper orbit without the side thrust causing hole enlargement.

The fluted section extends for at least the depth of
 10 the maximum gauge sheet metal for which the tool is designed, with about 0.25 inches generally adequate for most applications. The fluted section extends above the maximum height of the tip to allow the fluted end to disengage from the sheet metal prior to the tip contacting the sheet metal. In a
 15 preferred embodiment, shown in Fig. 2, the pilot is double ended, having a second fluted section 37a. The pilot may be removed by loosening a locking screw 40 which is engageable with a recess 41, allowing removal of the pilot and exchange of the dull end with a sharp end.

The metal cutting tool of the present invention is particularly suited for field use using a hand held driver such as a standard drill, being surprisingly durable and therefore capable of long term use. Utilizing a blunt cutting edge
 20 provides a smooth hole with a minimum of resistance, while substantially increasing wear resistance. In addition, limiting the metal cutting tool to a single tooth design prevents uneven wear, further reducing the potential for
 25 binding. Placing such a tip with a large bonding area in the

cutting body previously described assures firm holding of the tip with a minimum of distortion, thereby reducing the chances for breakage. The shape of the cutter body also presents an outside body surface which rubs in the cut such that any misalignment caused by the lack of rigidity in the hand held operation causes a reverse thrust to return the tool to the proper orbit. Utilizing a narrow notch prevents the notch from hooking when the hand held drill is tipped at an angle to the hole axis, allowing intersecting holes to be drilled without binding, so long as a pilot hole can be provided. The tapered inner wall of the cutter body also provides near automatic discharge of the cut plug without requiring auxiliary devices.

While the preferred embodiment of the present invention has been described in relation to a metal cutting tool including a rectangular notch and a particularly shaped cutting tip extending from a cutter body, it will be understood by those skilled in the art that other similarly shaped cutting tips, notches or pilot bits can be used without varying from the scope of the present invention. In addition, it will be understood by those skilled in the art that the means for attaching to a drive member such as a hand held drill may vary in accordance with the various drill chucks common to the art.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A metal cutting tool for trepanning holes in a sheet metal, said cutting tool comprising:

5 a cutter body extending from a first front end to a second rear end and having a substantially cylindrical outer wall substantially matching the diameter of a hole to be produced, a base disposed within the cutter body, an inner wall tapering radially inwardly from the first front end to the base, said inner wall joining said outer wall of the body to form a forward edge at said first front
10 end, said cutter body having a notch penetrating substantially therethrough and extending for substantially the length of the body from said first end to said second end for removal of cut material and defined by at least side walls thereof, a socket disposed within one said wall
15 of the notch at the first front end of the cutter body, said socket being adapted to accept a cutting tip therein;

20 said cutting tip secured to the body and having at least an outer wall, an inner wall, a top surface, a rear wall, a bottom wall and a front face, said front face and said top surface join to form a cutting edge extending forwardly of the cutter body;

said top surface sloping from said cutting edge in the front to back direction relative to the direction of rotation of said cutting tool; at least a part of said



inner wall of the cutting tip slopes from the top cutting surface towards the base, said front face of the tip slopes from said cutting edge to said side wall of the notch, the cutting tip extending above the forward edge of
5 the cutter body;

an axial bore extending through the cutter body, pilot means disposed within said axial bore and permanently secured to said body, said pilot means being adapted for aligning the tool at the desired hole
10 location; and a shank extending from said cutter body for releasable engagement with a drive device.

2. A tool as claimed in claim 1 wherein the notch is substantially rectangular in shape.

3. A tool as claimed in claim 1 or 2 wherein the cutter
15 body is composed of steel.

4. A tool as claimed in claimed 3 wherein the cutter body is composed of tool steel, heat-treated for hardness and toughness.

5. A tool as claimed in any one of claims 1 to 4
20 wherein the cutting tip includes an outer wall which is substantially alignable with the outer wall of the cutter body, an inner wall which slopes inwardly from an upper end thereof, joining with a vertical wall which is substantially parallel to the outer wall of the cutting



tip, and a front face which joins with a top cutting surface to form the blunt cutting edge.

6. A tool as claimed in claim 5 wherein the cutting tip extends above a top surface of the cutter body by at least
5 0.005 inches (0.013cm) at the cutting edge thereof.

7. A tool as claimed in claim 5 or 6 wherein the top cutting surface is substantially flat and slopes from front to rear relative to the cutter body.

8. A tool as claimed in claim 7 wherein the top cutting
10 surface slopes from front to rear from about 5 to 15 degrees relative to the cutter body.

9. A tool as claimed in claim 8 wherein the top surface slopes from front to rear at about 8 degrees.

10. A tool as claimed in any one of claims 1 to 9
15 wherein the blunt cutting edge is from 0.05 to 0.01 inches (0.13 to 0.25cm) wide.

11. A tool as claimed in any one of claims 1 to 10 wherein the cutting tip is composed of tungsten carbide.

12. A tool as claimed in any one of claims 1 to 11
20 wherein the cutting tip is composed of micro-fine grain tungsten cobalt carbide.

13. A tool as claimed in any one of claims 1 to 12 wherein the pilot means comprises a pilot bit having a

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fluted section, for drilling a pilot hole, disposed above the height of the cutting tip, and a cylindrical shaft section extending behind the fluted section for entering the pilot hole prior to the cutting tip contacting the
5 sheet metal.

14. A tool as claimed in claim 13 wherein the pilot bit further includes a 135 degree split point to facilitate proper hold placement without requiring a prick punch.

15. A tool as claimed in claim 13 wherein the pilot bit
10 includes limited fluted sections at opposite ends thereof, a first locking means and a second locking means symmetrical therewith, said first locking means provided for holding the pilot bit within the cutter body bore, said second locking means provided to allow removal of the
15 pilot bit from the cutter body bore for switching of the fluted ends after one end becomes dull.

16. A metal cutting tool substantially as hereinbefore described with reference to and as illustrated in the accompanying drawings.

UNIBIT CORPORATION
by its Patent Attorney



Dated this 29th day of January 1993.



ABSTRACT

A metal cutting tool is disclosed which includes a cylindrical cutting body (12) having an outer cylindrical surface (13) approximating the size of the hole desired and an inner wall (14) which tapers towards a base (15). The cutter body further includes a notch (17) for removal of cutting chips which has a socket disposed on the leading edge thereof. A carbide cutting tip (26) is disposed in the socket with the cutting tip being substantially pyramidically shaped, having a blunt cutting edge (35) extending above the cutter body. The metal cutting tool further includes a pilot bit (36) extending axially through the center of the cutter body, with the pilot including a short fluted (37) section which extends above the top of the cutting tip and provides a pilot hole for guiding the cutting tip during hole cutting. The metal cutting tool is extremely durable and is particularly suited for use with a hand held drill, providing a minimum of resistance during cutting, reducing tip binding or breakage and thereby providing smooth holes in sheet metal at field locations.

