



Diameter	Structural Steel <500 Mpa Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Aluminium	Cast Iron (Grey)	Fibreglass	Composite	Plastics	Wood
	RPM Range								
13-17mm	1350-850	840-585	500-360	2210-1575	900-625	780-705	1350-850	900-640	1495-1010
18-25mm	850-625	580-420	350-250	1575-1125	600-455	700-520	850-625	620-450	990-895
26-31mm	620-500	415-325	240-195	1080-885	435-345	500-405	620-500	440-345	895-850
32-39mm	480-410	320-275	195-160	875-740	330-285	400-330	480-410	345-280	850-740
40-46mm	390-340	270-220	160-145	730-620	285-240	315-275	390-340	175-235	740-610
47-53mm	335-300	220-180	140-120	615-545	235-215	275-245	335-300	235-215	600-505
54-60mm	295-260	180-165	115-100	525-485	210-180	240-215	295-260	210-185	500-460
61-70mm	260-225	165-155	100-90	475-415	180-160	205-185	260-225	180-160	455-400
71-80mm	220-195	155-140	90-75	410-365	155-140	180-160	220-195	155-140	395-360

## BEST PRACTICE ADVICE

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

1. Centre punch or pilot drill the surface for accurate hole start
2. Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage
3. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
4. Avoid lateral movement or tilting which can cause damage to the tool
5. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
6. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
7. When using a Magnet Drill regularly check that slides, handles, arbors and movable parts have not vibrated loose over time
8. Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling
9. For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
10. For thicker materials, predrill 6.35mm pilot hole first and use then sprung pilot drill or pilot pin as a guide

## QUICK GUIDE

- Optimum life & performance when used with Rotary Pistol Drills
- Good results from SDS Drills when used in Rotary-Only mode
- For best results pre-drill the pilot hole
- Use appropriate lubrication and correct RPM to achieve long tool life

## MORE INFO

