



Holesaw Diameter	Structural Steel <500Nm Based on mm/R Feed of 0.10	Structural Steel <1000Nm 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
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	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

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

**Quick Guide**

<b>1</b>	Optimum life and performance when used with rotary pistol drills
<b>2</b>	Good results from SDS Drills when used in Rotary-Only mode
<b>3</b>	For best results pre-drill the pilot hole
<b>4</b>	Use appropriate lubrication and correct RPM to achieve long tool life