



Diameter	Structural Steel <500 Mpa (S275, S355) <small>Based on MMR Feed of 0.10</small>	Structural Steel <1000 Mpa <small>Based on MMR Feed of 0.10</small>	Stainless Steel INOX <small>Based on MMR Feed of 0.13</small>	Cast Iron-Grey	Aluminium
	RPM Range				
12-18mm	665-500	325-255	320-230	480-360	980-690
19-23mm	480-375	250-180	230-180	360-275	690-505
24-28mm	350-285	180-165	180-150	265-220	500-405
29-33mm	260-225	165-125	150-130	215-180	400-345
34-41mm	225-200	120-115	125-100	175-150	340-300
42-45mm	200-180	115-105	100-85	145-125	295-280
46-48mm	180-170	105-95	85-75	125-110	280-270
49-50mm	170-150	90-80	75-70	120-110	270-255

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 cutter
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. Regularly check that magnet drill 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. Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task

QUICK GUIDE

- Adjust RPM to match the material
- Slowly and cautiously begin cutting before increasing pressure
- For best results & swarf clearance always select a cutter longer than the material thickness
- For hard or challenging materials (eg Stainless steels, Hardox etc) use Carbidemax & Ultra coated cutters

MORE INFO

