



OUR STORY

Initially working in a small family-run welding & engineering supplies business we received a stream of requests for specialist metal drilling tools that didn't exist no matter where we looked.

As we investigated further we discovered that drilling or modifying steel connection holes when limited to the use of portable or hand-held tools seemed to be the biggest pain point in the industry. These challenges would often contribute to missed deadlines and painful project over-runs. If specifications changed at the last minute, fabrication errors were made or emergency repairs were needed, the tools needed to get the job done quickly just didn't exist in the marketplace.

The industry needed a solution so in response we formed Holemaker Technology with one aim in mind: To speed up metalworking through cutting tool innovation.

Combining our pioneering, impact rated and now patented VersaDrive system with the latest generation of high-torque cordless power tools has created a revolutionary level of drilling speed & performance, never before possible with portable tools.

8 years, around 500,000 tools and a patent or two later, these game-changing products are now sold widely in over 50 countries around the world.

There is a long way still to go and we invite you to join our journey and help us continue to improve and speed up metalworking.

Regards

Piers Crane & Hugh Crane - Co-Founders



WHAT WE DO

Holemaker Technology is a specialist manufacturer of cutting and drilling products

We make the tools that allow you to create and modify the connection holes which hold our world together.

Our specialist area is Portable Cutting & Drilling tools, for those times you have to take the tools to the job.

We focus on relentless product innovation and improvement so we can provide the metalwork and fabrication industries with unique tooling that speeds up any task involving working with connection holes.



WORKING WITH US

HOLEMAKER-TECHNOLOGY.COM
HMT

We want every experience that you have with HMT to be effortless and enjoyable. Here's the 4 pillars we constantly work on and improve to deliver this.

SUPPORT

One of our core values is "Optimise", and this means helping users get the best out of their HMT tooling, with training, demonstrations and site visits in addition to data sheets and training videos. Over 300 dealers make the products available throughout more than 50 countries.

SERVICE

With a stock holding of more than \$1M we have over 95% stock availability on catalogue items meaning orders placed by 2PM EST will be shipped to you the same day. Your order will be processed & confirmed within 2 hours and courier tracking will be emailed on dispatch of goods. Barcoded warehousing technology ensures total picking accuracy.

PRODUCTS

The motto here is - if the products are right, then the success will follow. A relentless focus on quality control and Patent-protected innovation means that each HMT product is created to be a market leader in its own right.

TEAM

A hand picked team full of energy and enthusiasm, with industry experience drawn from market leading industrial brands.



OUR MISSION & VALUES

HMT MISSION

To speed up metalworking through cutting tool innovation

HMT VISION

To be the leading brand of fabricators cutting tools

THE 5 HMT VALUES

Innovate, Specialise, Optimise, Be Agile and Be Nice



STAKIT Site Kits

p10

VersaDrive Adapters

p12

VersaDrive ImpactaStep

p16

VersaDrive Step Drills

p18



VersaDrive Extra Long HoleCutters

p40

VersaDrive STAKIT

p42

V35 Magnet Drill

p46

V60T & V85T Magnet Drills

p48



VersaDrive Reamers

p20

VersaDrive TurboTips

p22

VersaDrive UNC ImpactaTaps

p24

VersaDrive Metric & NPT ImpactaTaps

p26



V100T Magnet Drill

p50

V125T Magnet Drill

p51

OverReach System

p52

RTQ40 Magnet Drill

p53



VersaDrive Long Series ImpactaTaps

p27

VersaDrive Farrier Taps

p27

VersaDrive Clutched Adapter

p28

VersaDrive Spiral Flute Taps

p29



CarbideMax 1.5" & 2"

p54

CarbideMax 4"

p58

CarbideMax XL 2"

p59

CarbideMax XL 4"

p60



VersaDrive Drill Taps

p30

VersaDrive Heavy Duty Drill Taps

p32

VersaDrive Countersinks

p34

VersaDrive HoleCutters

p36



CarbideMax ULTRA

p61

TCT MultiSink

p64

Accessories

p66

Lubricants

p68



VERSADRIVE®

PATENT PROTECTED

The world's 1st modular quick-change cutting & drilling system for use with both Impact and Rotary tools

VersaDrive by Holemaker Technology is the 1st modular cutting system in the world that allows cutting tools to be used across Impact Wrenches/Drivers as well as Rotary drills like Magnet drills, Hand-Held drills and Pillar drills.

This innovative system features a range of Impact rated and Rotary rated cutting tools as well as a collection of specially designed and custom engineered adapters to rapidly fit cutting tool to power tool, with fast tool changeover.

Tools in the range have also been specifically designed and developed to outperform and outlast the closest comparable products. With faster cuts, longer life and more holes per product VersaDrive tools save time, money & increase productivity.



IMPACT & ROTARY RATED

WHY IMPACT?

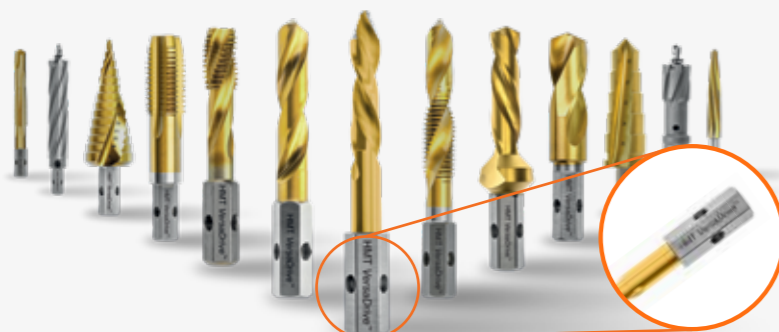
For high speed applications like drilling, reaming and tapping VersaDrive's range of Impact Rated tools and adapters offer precision performance alongside the speed, safety and controlled power offered by Impact drivers and wrenches.

Phenomenal cutting performance is achieved through the design of the tool, cutting with the double hardened edges of the cutting face rather than the tip.

WHY ROTARY?

For slow speed applications like heavy duty tapping, countersinking or broaching with a holesaw optimum performance can be achieved by cutting with the tip and flutes of the tool.

Our rotary rated range of tools have been designed to do just this and provide excellent cutting performance whilst outlasting any comparable tool on the market.



The VersaDrive Patent Protected Shank System

VersaDrive Patent-Protected Hex shank. The VersaDrive Hexagon shank design fits into all standard drill chucks. No slipping in the chuck like standard tools. Three concentric lock positions give perfect alignment and accuracy when the tooling is used in any of the modular adapters to optimise metalworking processes and increase the tools working life.

Features & Benefits

- Up to 10x longer life
- Up to 15x faster than standard everyday methods
- Quick-change, Rapid-Lock adapters
- Dual hardened for Impact use
- High-Grade tool steel
- Non-Slip Hex shank fits all standard 1/2" drill chucks
- Safer working - minimal kickback
- Precision ground for accurate, clean holes
- GoldMax low-friction titanium coating to stop burn-out



L x W x H - 21.5" x 15.5" x 4"

N.B. STAKIT Mid Case required to connect Top case to Base cases

| Part No | Product |
|---------------|---|
| STC-TOP-VSD02 | STAKIT Impact Starter Kit - Inch |
| STC-TOP-VSD01 | STAKIT Impact Starter Kit - Metric |

The VersaDrive® **STAKIT** Top box is the crowning case of the **STAKIT** system. Available as either complete kitted sets or in 'Build Your Own' formats, the top case can hold up to 16 tools across either the VersaDrive or CarbideMax ranges, or a combination of both, plus 5 VersaDrive adapters.

The Impact Starter Kit, pictured here, features essential Impact rated tooling that solves almost all common hole making challenges on site.

Inch Sized Kit Contents:

- 3 x Reamers 9/16, 11/16, 13/16"
- 3 x DrillTaps 1/4-20, 5/16-18, 3/8-16 UNC
- 3 x ImpactaTaps 1/2-13, 5/8-11, 3/4-10 UNC
- 7 x TurboTips #F, 9/32, 5/16, 3/8, 27/64, 7/16, 1/2"

• 3 x VersaDrive Rapid-Lock Adapters

- 1/4" Impact Driver Adapter
- 1/2" Impact Wrench Adapter
- 5" Extension

Metric Sized Kit Contents:

- 3 x Reamers 14, 18, 22mm
- 3 x DrillTaps M6, M8, M10
- 3 x ImpactaTaps M12, M16, M20
- 7 x TurboTips 6.8, 8, 8.5, 10, 10.5, 12 & 14mm

• 3 x VersaDrive Rapid-Lock Adapters

- 1/4" Impact Driver Adapter
- 1/2" Impact Wrench Adapter
- 130mm Extension



L x W x H - 23" x 15.5" x 5.5"

| Part No | Contents |
|---------------|---|
| STC-EMID-INIK | STAKIT Installation Kit - Inch |
| STC-EMID-MEIK | STAKIT Installation Kit - Metric |

The **STAKIT** Site Installation Kit is created to combine an essential set of best-selling VersaDrive products to overcome all common site installation and steel erection holemaking challenges. Keeps the job moving when you find an unexpected challenge.

Presented in the STAKIT Mid Case and connects to all Top cases and Base cases.

Inch Sized Kit Contents:

- 5 x TurboTips 1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
- 5 x HoleCutters 9/16, 5/8, 3/4, 7/8, 1"
- 2 x ImpactaStep 9/16, 13/16"
- 3 x DrillTaps 5/16, 3/8, 1/2"
- 3 x ImpactaTaps 1/2, 5/8, 3/4"
- 4 x Reamers 1/2, 9/16, 11/16, 13/16"

• 5x Rapid lock adapters

- 1/4" Impact Driver Adapter
- 1/2" Impact Wrench Adapter
- Magnet Drill Adapter
- 5" Extension
- 12" Extension

Metric Sized Kit Contents:

- 5 x TurboTips 6.35, 8.0, 10.5, 12, 14mm
- 5 x HoleCutters 14, 17, 18, 20 & 22mm
- 2 x ImpactaStep 16 & 22mm
- 3 x DrillTaps M6, M8 & M10
- 3 x ImpactaTaps M12, M16 & M20
- 4 x Reamers 12, 14, 18 & 22mm

• 5x Rapid lock adapters

- 1/4" Impact Driver Adapter
- 1/2" Impact Wrench Adapter
- Magnet Drill Adapter
- 130mm Extension
- 300mm Extension



VersaDrive 1/4" Rapid-Lock Impact Driver Adapter



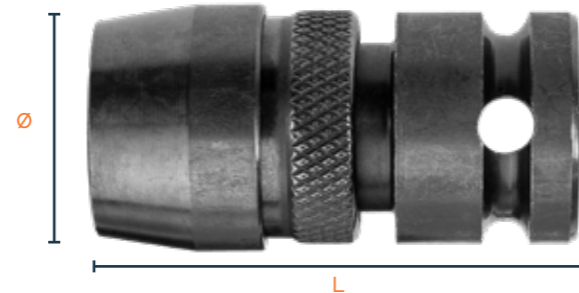
| Part No | Drive Size | Ø | L |
|-------------|------------|---------|----|
| 111026-014A | 1/4" Hex | 1-7/64" | 3" |

Adapter Benefits

This upgraded VersaDrive Impact Driver adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/4" Hex Impact Drivers.
- Converts standard 1/4" Impact Drivers for use with VersaDrive

VersaDrive 1/2" Rapid-Lock Impact Wrench Adapter



| Part No | Drive Size | Ø | L |
|-------------|------------|---------|---------|
| 111130-012A | 1/2" Drive | 1-7/64" | 2-5/32" |

Adapter Benefits

Rated to 480 ft lbs
Supplied with retention pin & ring

This upgraded VersaDrive Impact Wrench adapter features:

- New Rapid-Lock, single handed loading action
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/2" Impact Wrenches
- Converts standard 1/2" Impact Wrenches for use with VersaDrive

VersaDrive 3/4" Heavy Duty Impact Wrench Adapter



| Part No | Drive Size | Ø | L |
|-------------|------------|--------|---------|
| 111120-012A | 1/2" Drive | 1" | 2-5/32" |
| 111120-034A | 3/4" Drive | 1 1/2" | 2-3/8" |

Adapter Benefits

- Impact hardened Manganese Phosphate adapter
- Heavy Duty Pull-Forward Release mechanism with hardened steel collar
- Developed to work with latest generation of high torque cordless impact wrenches capable of generating above 735 ft lbs of Torque

VersaDrive Rapid-Lock Weldon Adapter



| Part No | Shank Size | Ø | L |
|-----------|------------|---------|---------|
| 111035-01 | 3/4" | 1-7/64" | 2-9/32" |

Adapter Benefits

This upgraded VersaDrive Magnet Drill adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar mechanism preventing accidental tool release caused by vibrations or contact with the workpiece
- Fits to all standard magnet drills with 3/4" Weldon magnet drill shank

VersaDrive Rapid-Lock SDS+ Adapter



| Part No | Ø | L |
|-----------|---------|--------|
| 112010-01 | 1-7/64" | 5-1/2" |

Adapter Benefits

- This upgraded SDS+ VersaDrive adapter features:
- New Rapid-Lock, single handed loading action
 - Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
 - Knurled collar - ultimate grip in greasy or damp conditions
 - High quality, Heavy Duty steel components
 - Converts all standard SDS+ Rotary Hammer Drills for use with VersaDrive system (Use in rotary mode only)



VersaDrive Rapid-Lock Extension Arbor - 5"



| Part No | Shank Size | Ø | L |
|------------|------------|---------|----|
| 111015-130 | 7/16" | 1-7/64" | 5" |

Adapter Benefits

- Extends the working reach of all VersaDrive tools
- Rapid-Lock, single handed loading action and can also be used in combination with other Versadrive adapters
- Hex shank for non-slip use in any drill chuck
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Rated for impact wrench use



VersaDrive Rapid-Lock Extension Arbor - 12"



| Part No | Ø | L |
|------------|---------|-----|
| 111015-300 | 1-7/64" | 12" |

Adapter Benefits

- Extends the working reach of all VersaDrive tools
- Rapid-Lock, single handed loading action and can also be used in combination with other Versadrive adapters
- Hex shank for non-slip use in any drill chuck
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Rated for impact wrench use



VersaDrive Rapid-Lock Morse Taper Arbor



| Part No | Shank Size | Ø | L |
|-----------|------------|---------|----|
| 111045-02 | MT2 | 1-7/64" | 3" |
| 111045-03 | MT3 | 1-7/64" | 4" |

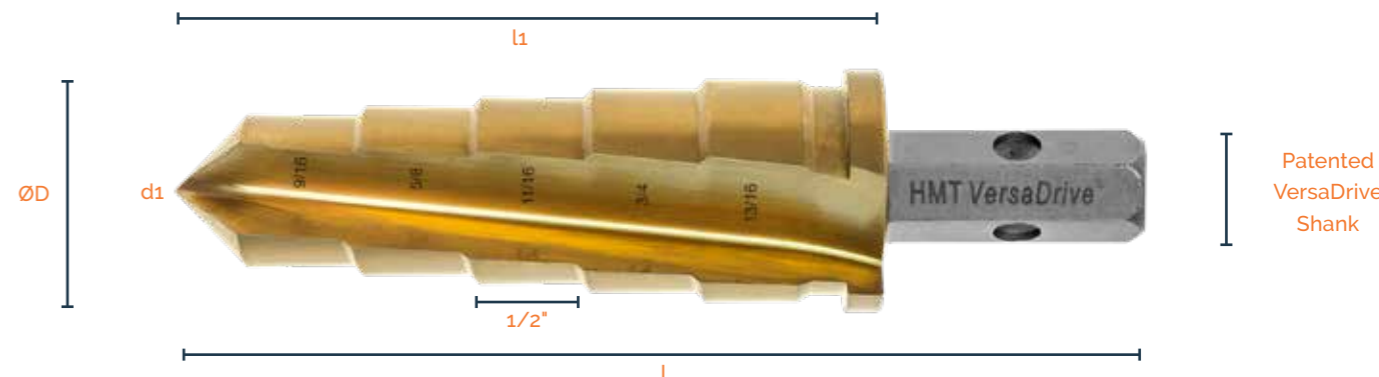
Adapter Benefits

- Ideal for workshop use with radial arm drills & pillar drills
- Rapid-Lock, single handed loading action
- Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components

A Versadrive exclusive innovation, the ImpactaStep Cutter offers combined drilling and reaming on materials up to 1/2" thick.

Featuring 5 individual cutting diameters and a straight flute design for strength and easy resharpening, the ImpactaStep Cutter is optimised for use with Impact Drivers and Impact Wrenches as well as the latest range of VersaDrive Premium Magnet Drills.

VersaDrive ImpactaStep Cutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- 5 drill bits in one
- Create & enlarge holes in material up to 1/2" thick
- Safety breakthrough collar to prevent injury & damage
- Fast, smooth drilling & reaming with minimal kickback
- Specially hardened for impact wrench use
- GoldMax low-friction titanium coating to stop burn out

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



Impact Driver Adapter
111026-014A
Page 12



Impact Wrench Adapter
111130-012A
Page 12



Use with any
standard drill
chuck



Magnet Drill Adapter
111035-01
Page 13



SDS+ Adapter
112010-01
Page 14

Quick Guide

- For fastest performance use on impact wrenches & impact drivers
- Pilot drilling is recommended for a faster operation and to enhance tool life
- When used for reaming, tool should be rotating before starting cut with steady pressure

Watch the video & find more info online



VersaDrive ImpactaStep Cutter

| | Part No | Ø D | d1 | l1 | L | Step Diameters | Step Depth |
|-------------|-------------|---------|--------|--------|---------|------------------------------------|------------|
| Inch | 506030-0010 | 9/16" | 5/16" | 3-1/8" | 4-3/16" | 5/16 - 3/8 - 7/16 1/2 - 9/16" | 1/2" |
| | 506030-0020 | 13/16" | 9/16" | 3-1/4" | 4-5/16" | 9/16 - 5/8 - 11/16 3/4 - 13/16" | 1/2" |
| | 506030-0030 | 1-1/16" | 13/16" | 3-3/8" | 4-7/16" | 13/16 - 7/8 - 15/16 1 - 1 1/16" | 1/2" |

| | Part No | Ø D | d1 | l1 | L | Step Diameters | Step Depth |
|---------------|-------------|------|------|------|-------|-----------------------------|------------|
| Metric | 506010-0160 | 16mm | 8mm | 79mm | 107mm | 8 - 10 - 12 - 14 - 16mm | 12mm |
| | 506010-0220 | 22mm | 14mm | 82mm | 110mm | 14 - 16 - 18 - 20 - 22mm | 12mm |
| | 506010-0260 | 26mm | 18mm | 84mm | 112mm | 18 - 20 - 22 - 24 - 26mm | 12mm |
| | 506010-0320 | 32mm | 24mm | 87mm | 115mm | 24 - 26 - 28 - 30 - 32mm | 12mm |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill / Press
- Magnet Drill

| Powertool Recommendations (Mild Steel Material) | | | | | | |
|--|---|---|---|---|---|---|
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| • | ○ | × | • | • | • | • |
| • | × | × | ○ | • | • | • |
| • | × | × | ○ | • | • | • |

• Optimal ○ Possible (Refer to data sheet)
× Not Recommended

ImpactaStep Sets

| Part No: | Set Contents |
|-------------|---|
| 506030-SET1 | VersaDrive IMPACTASTEP Cutter Set, 9/16, 13/16, 1-1/16" |
| 506010-SET1 | HMT VersaDrive IMPACTASTEP Cutter Set 16, 22, 26mm |



"My favourite tool must be the new ImpactaStep cutter. Being able to carry just a few TurboTip drill bits & the cutter means most work can be tackled. Often used with 12v impact tools."

James Sinclair
Dexta Moors

The first step drill optimised for use with impact wrenches & impact drivers allowing the user to create holes in seconds.

Featuring a spiral flute design with self-starting drill tip, for fast, smooth drilling with a rotary drill or impact wrench and market leading 3/16" thick drilling capacity.

VersaDrive Step Drills have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of power tools such as Magnetic Drills.



Features & Benefits

- Market Leading 3/16" thick drilling capacity
- Fast, smooth drilling with minimal kickback
- Specially hardened for impact wrench use
- Precision ground flutes with easy chip clearance
- 118° split point angle for easy starting & accuracy
- GoldMax low-friction titanium coating to stop burn out

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



Impact Driver Adapter
111026-014A
Page 12

Impact Wrench Adapter
111130-012A
Page 12

Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 14

Extension - 12"
111015-300
Page 14

Quick Guide

- For fastest performance use on impact wrenches & impact drivers
- Excellent life and performance when used with rotary pistol drills or drill presses
- Suitable for stainless and harder materials if used at low RPM
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



VersaDrive Step Drill

| | Part No | Ø D | I1 | L | Step Diameters | Step Depth |
|-------------|-------------|--------|---------|---------|---|------------|
| Inch | 505030-0010 | 1/2" | 1-1/2" | 2-43/64 | 3/16, 1/4, 5/16, 3/8, 7/16, 1/2" | 3/16" |
| | 505030-0020 | 7/8" | 2-9/32" | 3-15/32 | 3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8" | 3/16" |
| | 505030-0030 | 1 3/8" | 1-31/32 | 3 5/32 | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1-1/8, 1-1/4, 1-3/8" | 3/16" |

| | | | | | | |
|---------------|---------------------------------------|--------|------|-------|---|-----|
| Metric | 505020-0120 | 12mm | 47mm | 75mm | 4, 6, 8, 10, 12mm | 5mm |
| | 505020-0220 | 22mm | 58mm | 86mm | 4, 6, 8, 10, 12, 14, 16, 18, 22mm | 5mm |
| | 505020-0300 | 30mm | 77mm | 105mm | 4, 6, 8, 10, 12, 14, 16, 18, 22, 24, 26, 28, 30mm | 5mm |
| | 505020-0400 | 40mm | 72mm | 101mm | 6, 8, 10, 12, 16, 20, 25, 29, 32, 36, 40mm | 6mm |
| | Electrical Step Drill 4-32.5mm | | | | | |
| | 505040-0320 | 32.5mm | 70mm | 99mm | 4, 6, 8.5, 10.5, 12.5, 14.5, 16, 18.5, 20.5, 23.5, 25, 30.5, 32.5mm | 5mm |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill

Power tool Recommendations
(Mild Steel Material)

| | | | | | |
|---|---|---|---|---|---|
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• Optimal ○ Possible (Refer to data sheet)
× Not Recommended

Step Drill Sets

| Part No: | Set Contents |
|-------------|---|
| 505030-SET1 | 3 piece Set: 1/2, 7/8, 1-3/8" Step Drills |
| 505020-SET1 | 3 piece Set: 12, 22, 30mm Step Drills |
| 505020-SET2 | 4 piece Set: 12, 22, 30, 40mm Step Drills |



VersaDrive reamers are the perfect hole alignment and enlarging tool for metalworkers & steel erectors for keeping the job moving when a hole is misaligned or the incorrect size for the fixing.

Featuring a specially designed 6 flute cutting geometry and Titanium coating, VersaDrive Reamers are fully Impact rated and perform fastest when used with an Impact wrench providing ultimate cutting performance with virtually no powertool kickback.

VersaDrive Reamers have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- Precision 6-flute design for smooth cutting
- Safer reaming with minimal kickback
- Specially hardened for impact wrench use
- High grade tool steel for high accuracy and long life
- Goldmax low-friction titanium coating to stop burn-out
- High strength, non-slip shank design

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12



Magnet Drill Adapter
111035-01
Page 13



Use with any standard drill chuck



SDS+ Adapter
112010-01
Page 14



Extension - 12"
111015-300
Page 14

Quick Guide

- For fastest performance use on impact wrenches & impact drivers
- Not recommended for impact use with Flame or Plasma cut holes. Use with a Magnet Drill
- Reamer should be rotating before starting the cut & steady feed pressure used throughout
- For materials thicker than 3/4" use of ImpactMag reamers is recommended

Watch the video & find more info online



VersaDrive Reamers

| | Part No. | ØD | d1 Ø | I1 | I2 | L |
|-------------|-------------|------------------|--------|----------|----------|--------|
| Inch | 501040-0040 | 1/2" (12.7mm) | 19/64" | 1-15/16" | 2-1/16" | 5 1/2" |
| | 501040-0050 | 9/16" (14.3mm) | 9/32" | 2-1/16" | 1-15/16" | 5 1/2" |
| | 501040-0060 | 5/8" (15.9mm) | 5/16" | 2-11/64" | 2-21/64" | 6" |
| | 501040-0070 | 11/16" (17.5mm) | 3/8" | 2-1/4" | 2-1/4" | 6" |
| | 501040-0080 | 3/4" (19.05mm) | 13/32" | 2-31/64" | 2-33/64" | 7" |
| | 501040-0085 | 13/16" (20.63mm) | 15/32" | 2-33/64" | 2-31/64" | 7" |
| | 501040-0090 | 7/8" (22.2mm) | 17/32" | 2-19/32" | 2-13/32" | 7" |
| | 501040-0100 | 15/16" (23.8mm) | 19/32" | 2-43/64" | 2-21/64" | 7" |
| | 501040-0110 | 1" (25.4mm) | 5/8" | 2-43/64" | 2-21/64" | 7" |
| | 501040-0120 | 1-1/16" (27mm) | 45/64" | 2-9/16" | 2-7/16" | 7" |

| | Part No. | ØD | d1 Ø | I1 | I2 | L |
|---------------|-------------|------|--------|------|------|-------|
| Metric | 501030-0080 | 8mm | 4.4mm | 34mm | 36mm | 108mm |
| | 501030-0100 | 10mm | 6mm | 34mm | 36mm | 108mm |
| | 501030-0120 | 12mm | 7.1mm | 43mm | 59mm | 144mm |
| | 501030-0140 | 14mm | 7.5mm | 52mm | 50mm | 144mm |
| | 501030-0160 | 16mm | 8.0mm | 58mm | 56mm | 152mm |
| | 501030-0180 | 18mm | 9.4mm | 58mm | 56mm | 170mm |
| | 501030-0200 | 20mm | 11.2mm | 61mm | 65mm | 178mm |
| | 501030-0210 | 21mm | 12.3mm | 61mm | 66mm | 185mm |
| | 501030-0220 | 22mm | 13.2mm | 61mm | 66mm | 185mm |
| | 501030-0240 | 24mm | 15.1mm | 62mm | 66mm | 185mm |
| | 501030-0260 | 26mm | 15.9mm | 63mm | 66mm | 185mm |



Powertool Recommendations (Mild Steel Material)

| | Impact Wrenches | Impact Drivers | SDS Drill (Rotary) | Cordless Drill | Pillar Drill Press | Magnet Drill |
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• Optimal ○ Possible (Refer to data sheet)
× Not Recommended

Reamer Sets

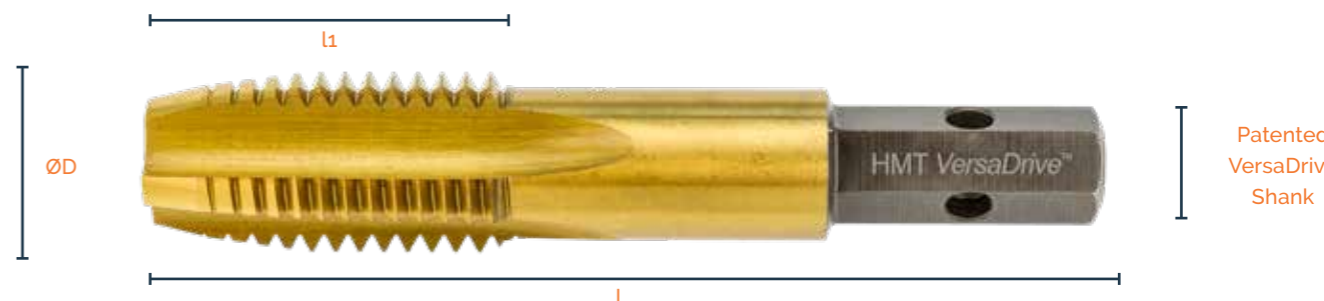
| Part No: | Set Contents |
|-------------|--|
| 501040-3SET | Set contains: 1/2, 5/8, 3/4" VersaDrive Reamers |
| 501040-5SET | Set contains: 1/2, 5/8, 3/4, 7/8, 1 1-16" VersaDrive Reamers |
| 501030-3SET | Set contains: 14, 18, 22mm VersaDrive Reamers |
| 501030-SET | Set contains: 12, 14, 18, 22, 26mm VersaDrive Reamers |



VersaDrive ImpactaTaps are the first and only range of taps that are suitable to be driven by impact wrenches and impact drivers, providing at least 15x faster performance than tapping by hand.

With a specially designed twin-lead, cutting geometry - the dual hardening process with Titanium coating provides a fantastic solution for tapping holes in steel.

VersaDrive ImpactaTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills (up to 3/8") or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills. They can even be used by hand in a socket wrench.



Features & Benefits

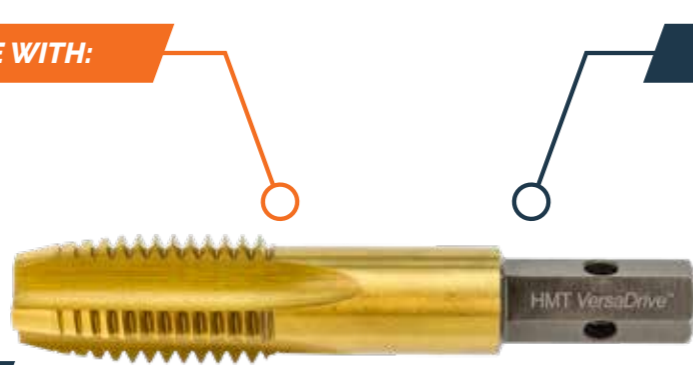
- Ground Flutes create the perfect tapped hole
- Safer tapping with minimal kickback
- Specially hardened for impact wrench use
- High grade tool steel for high accuracy & long life
- Goldmax low friction titanium coating to stop burn out
- Wide range of sizes

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Magnet Drills

CAN ALSO BE USED WITH:

Extension Arbor



ADAPTERS



Impact Driver Adapter
111026-014A
Page 12



Impact Wrench Adapter
111130-012A
Page 12



Magnet Drill Adapter
111035-01
Page 13



Extension - 12"
111015-300
Page 14

Quick Guide

- For fastest performance use on impact wrenches & impact drivers
- Check the minimum torque requirement
- Tapping Stainless Steel requires higher impact torque
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



VersaDrive ImpactaTaps - UNC Thread

| | Part No | M Thread Size & Pitch | L | L1 | Tap Hole Size Inch |
|-------------|-------------|-----------------------|----------|----------|--------------------|
| Inch | 308050-0010 | 1/4 x 20 UNC | 2-9/32" | 25/32" | #7 |
| | 308050-0020 | 5/16 x 18 UNC | 2-23/64" | 55/64" | #F |
| | 308050-0030 | 3/8 x 16 UNC | 2-3/4" | 15/16" | 5/16" |
| | 308050-0040 | 1/2 x 13 UNC | 3-5/32" | 1-9/64" | 27/64" |
| | 308050-0050 | 5/8 x 11 UNC | 3-35/64" | 1-17/64" | 17/32" |
| | 308050-0060 | 3/4 x 10 UNC | 3-15/16" | 1-29/64" | 21/32" |
| | 308050-0065 | 7/8 x 9 UNC | 4-9/64" | 1-37/64" | 49/64" |
| | 308050-0070 | 1 x 8 UNC | 4-21/64" | 1-49/64" | 7/8" |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill (w. reverse)

Powertool Recommendations
(Mild Steel Material)

| | | | | | |
|---|---|---|---|---|---|
| • | • | × | • | • | • |
| • | • | × | • | • | • |
| • | • | × | • | • | • |
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| • | × | × | × | • | • |
| • | × | × | × | • | • |

• Optimal ○ Possible (Refer to data sheet)
× Not Recommended

ImpactaTap® Sets

| Part No | Contents |
|-------------|---|
| 308050-SET1 | VersaDrive ImpactaTap Set, 1/4, 5/16, 3/8, 1/2, 5/8 UNC |
| 308050-SET2 | VersaDrive ImpactaTap Set, 1/2, 5/8, 3/4, 1" |

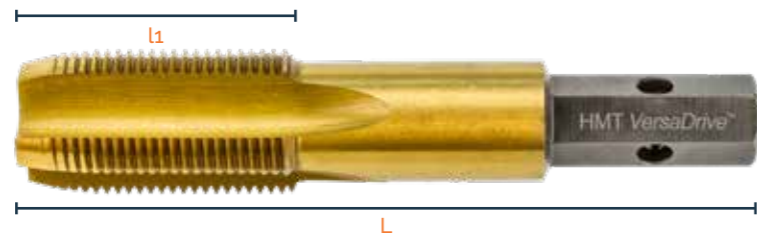


ImpactaTap® & TurboTip Set

| Part No | Contents |
|-------------|---|
| 328016-SET1 | TurboTip Drill Bit #7, #F, 5/16, 27/64" & ImpactaTaps 1/4, 5/16, 3/8 & 1/2" c.w 1/2" Impact Adapter |

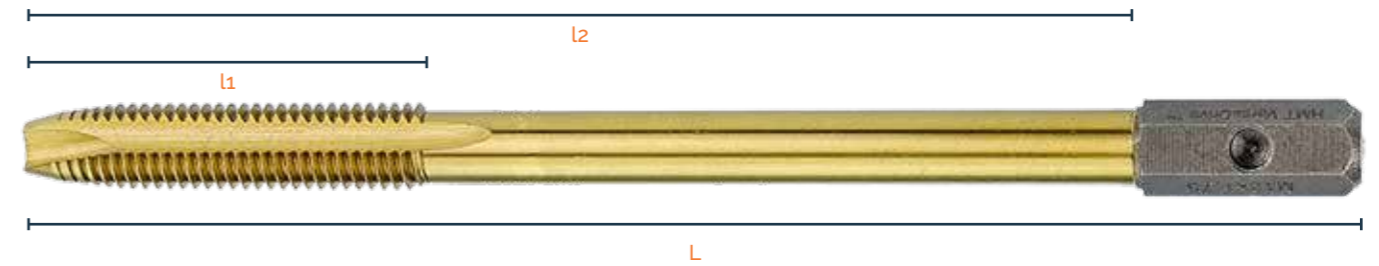


ImpactaTaps® NPT Thread



| Part No | M Thread Size & Pitch | L | L1 | Tap Hole Size |
|-------------|--------------------------|----------|----------|---------------|
| 308075-0010 | 1/8" x 27 NPT | 3-35/64" | 3/4" | 13/32" |
| 308075-0020 | 1/4" x 18 NPT | 3-15/16" | 1-1/16" | 17/32" |
| 308075-0030 | 3/8" x 18 NPT | 4-21/64" | 1-1/16" | 43/64" |
| 308075-0040 | 1/2" x 14 NPT | 4-23/32" | 1-3/8" | 53/64" |
| 308075-0050 | 3/4" x 14 NPT | 4-23/32" | 1-3/8" | 1-3/64" |
| 308075-0060 | 1" x 11.5 NPT | 5-1/8" | 1-47/64" | 1-5/16" |

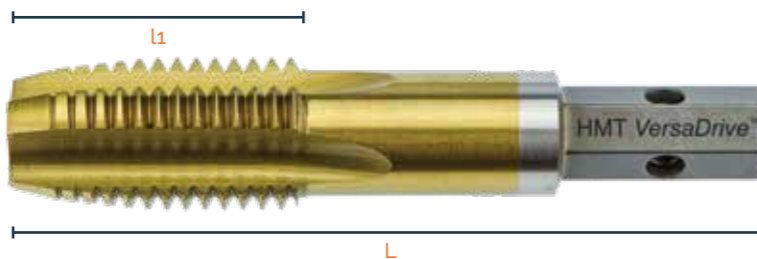
ImpactaTaps® Long Series - Metric Coarse



Spiral Point Taps for fast chip ejection in through holes.

| Part No | M Thread Size & Pitch | L mm | L1 mm | L2 mm | Tap Hole Size |
|-------------|--------------------------|---------|----------|----------|------------------|
| 308015-0080 | M8 x 1.25 | 140 | 45 | 112 | 6.8mm |
| 308015-0100 | M10 x 1.50 | 155 | 50 | 127 | 8.5mm |
| 308015-0120 | M12 x 1.75 | 180 | 55 | 152 | 10.2mm |
| 308015-0160 | M16 x 2.0 | 200 | 65 | 172 | 14.0mm |
| 308015-0200 | M20 x 2.5 | 230 | 70 | 202 | 17.5mm |
| 308015-0240 | M24 x 3.0 | 260 | 75 | 232 | 21.0mm |

ImpactaTaps® Metric Coarse Thread



| Part No | M Thread Size & Pitch | L mm | L1 mm | Tap Hole Size (Metric Coarse thread) |
|-------------|---|---------|----------|---|
| 308010-0050 | M5 x 0.80 | 55 | 18 | 4.2mm |
| 308010-0060 | M6 x 1.00 | 55 | 20 | 5.0mm |
| 308010-0080 | M8 x 1.25 | 60 | 22 | 6.8mm |
| 308010-0100 | M10 x 1.50 | 70 | 24 | 8.5mm |
| 308010-0120 | M12 x 1.75 | 80 | 29 | 10.2mm |
| 308010-0140 | M14 x 2.00 | 90 | 32 | 12.0mm |
| 308010-0160 | M16 x 2.00 | 90 | 32 | 14.0mm |
| 308010-0180 | M18 x 2.50 | 100 | 37 | 15.5mm |
| 308010-0200 | M20 x 2.50 | 100 | 37 | 17.5mm |
| 308010-0240 | M24 x 3.00 | 110 | 45 | 21.0mm |
| 308010-0270 | M27 x 3.00 | 130 | 48 | 24.0mm |
| 308010-0300 | M30 x 3.50 | 130 | 48 | 26.5mm |
| Sets | Contents | | | |
| 308010-SET1 | 5 piece set contains: M6, M8, M10, M12, M16 ImpactaTaps | | | |
| 308010-SET2 | 4 piece set contains: M12, M16, M20, M24 ImpactaTaps | | | |

FarrierTap - BSW Thread



FarrierTap - BSW Thread

| Part No | M Thread Size & Pitch | L | L1 | Tap Hole Size |
|-------------|--------------------------|----------|--------|---------------|
| 308060-0015 | 5/16 x 18 BSW | 2-23/64" | 55/64" | 1/4" |
| 308060-0020 | 3/8 x 16 BSW | 2-3/4" | 15/16" | 5/16" |

FarrierTap Combi DrillTap

| Part No | M Thread Size & Pitch | d1 | L | L1 | Max tapping depth with impact wrench |
|-------------|--------------------------|-------|--------|--------|---|
| 301127-0030 | 3/8-16 BSW | 5/16" | 3-5/8" | 55/64" | 21/64" |

FarrierTap Kit

| Part No: | Set Contents |
|-------------|---|
| 301127-SET1 | Set contains: 3/8 BSW FarrierTap, 3/8 BSW Combi Drill Tap, 1/4" VersaDrive Impact Adapter |

The HMT VersaDrive Clutched tap collet system is a unique method of effectively threading blind holes.

One collet works with the range of Patented VersaDrive taps. When the tap comes to the bottom of the hole, the clutch system will engage and stop the tap from breaking. The tap is then reversed out of the completed hole.

This system fits a 3/4" magnet drill arbor, or can be adapted for use with a 1/2" or 3/4" impact wrench.



Features & Benefits

-  Quick change system accepts all VersaDrive taps
-  Collets are pre-set to the appropriate clutch settings
-  Further Clutch adjustment options available
-  For blind hole tapping with VersaDrive Spiral Flute Taps
-  For use with variable speed, reversible magnet drill, pillar drill, or impact wrench

CLUTCHED TAP REPLACEMENT COLLET

120010 COLLET HOLDER



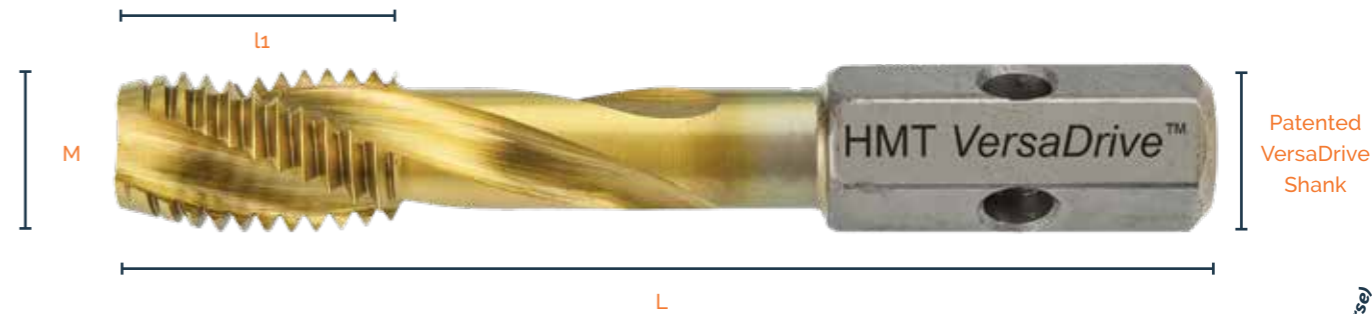
| Part No | Description |
|---------|--------------------------------------|
| 120010 | Weldon Shank Tap Collet Holder, 3/4" |

| | |
|------------|--|
| 121015-M12 | Clutched Blind Hole Tap Collet 1/4 - 1/2" Capacity |
| 121015-M24 | Clutched Blind Hole Tap Collet 5/8 - 1" Capacity |

| | |
|--------------|--|
| 00200-12A-19 | 1/2" Drive Impact Adapter for Blind Hole Tapping |
| 00200-34A-19 | 3/4" Drive Impact Adapter for Blind Hole Tapping |

| | |
|--------------|---|
| 121016-SET12 | Blind Hole Tapping Kit includes 1/4 - 1" Taps and 1/2" Impact Adapter |
| 121016-SET34 | Blind Hole Tapping Kit includes 1/4 - 1" Taps and 3/4" Impact Adapter |
| 121015-SET12 | Blind Hole Tapping Kit includes M6-M24 Taps and 1/2" Impact Adapter |
| 121015-SET34 | Blind Hole Tapping Kit includes M6-M24 Taps and 3/4" Impact Adapter |

N.B. Assembled length of Clutched adapter with fitted tap is up to 9 1/2" - ensure you select a mag drill with adequate stroke e.g. V100T & V125T VersaDrive Magnet Drills



VersaDrive Spiral Flute Taps

| | Part No | M Thread Size & Pitch | L | L1 | Tap Hole Size |
|-------------|-------------|--------------------------|----------|----------|---------------|
| Inch | 309020-0010 | 1/4 x 20 UNC | 2-9/32" | 25/32" | #7 |
| | 309020-0020 | 5/16 x 18 UNC | 2-23/64" | 55/64" | #F |
| | 309020-0030 | 3/8 x 16 UNC | 2-3/4" | 15/16" | 5/16" |
| | 309020-0040 | 1/2 x 13 UNC | 3-5/32" | 1-9/64" | 27/64" |
| | 309020-0050 | 5/8 x 11 UNC | 3-35/64" | 1-17/64" | 17/32" |
| | 309020-0060 | 3/4 x 10 UNC | 3-15/16" | 1-29/64" | 21/32" |
| | 309020-0065 | 7/8 x 9 UNC | 4-9/64" | 1-37/64" | 49/64" |
| | 309020-0070 | 1 x 8 UNC | 4-21/64" | 1-49/64" | 7/8" |
| | 309020-0110 | 1-1/4 x 7 UNC | 5-3/64" | 1-39/64" | 1-7/64" |

| | Part No | M Thread Size & Pitch | L | L1 | Tap Hole Size |
|----------------------|-------------|--------------------------|-------|------|---------------|
| Metric Coarse | 309010-0060 | M6 x 1.00 | 58mm | 20mm | 5.0 |
| | 309010-0080 | M8 x 1.25 | 60mm | 22mm | 6.8 |
| | 309010-0100 | M10 x 1.50 | 70mm | 24mm | 8.5 |
| | 309010-0120 | M12 x 1.75 | 80mm | 29mm | 10.2 |
| | 309010-0160 | M16 x 2.00 | 90mm | 32mm | 14.0 |
| | 309010-0200 | M20 x 2.50 | 100mm | 37mm | 17.5 |
| | 309010-0240 | M24 x 3.00 | 110mm | 45mm | 21.0 |
| | 309010-0300 | M30 x 3.50 | 130mm | 48mm | 26.5 |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill (w. reverse)

PowerTool Recommendations (Mild Steel Material)

| | | | | | |
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| ○ | ○ | × | ○ | ● | ● |
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| ○ | × | × | × | ● | ● |
| ○ | × | × | × | ● | ● |
| ○ | × | × | × | ● | ● |

● Optimal ○ Possible (Refer to data sheet)
× Not Recommended

Spiral Flute Tap Sets

| Part No: | Set Contents |
|-------------|---|
| 309020-SET1 | Spiral Flute ImpactaTap Set 1/4, 5/16, 3/8, 1/2, 5/8" UNC |
| 309020-SET2 | Spiral Flute ImpactaTap Set 1/2, 3/4, 1" UNC |
| 309010-SET1 | Spiral Flute ImpactaTap Set M6, M8, M10, M12, M16 |
| 309010-SET2 | Spiral Flute ImpactaTap Set M12, M16, M20, M24 |



VersaDrive Combi Drill Taps are a time saving solution for pilot drilling & tapping in one easy operation. The Titanium coating provides wear resistance and faster cutting performance.

VersaDrive Sheet Metal Impacta-DrillTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Recommended for use with Impact Drivers for high drilling and tapping productivity.



Features & Benefits

- Ground flute twist drill creates the perfect tapping hole
- Safer tapping with minimal kickback
- Specially hardened for impact wrench use
- High grade tool steel for high accuracy & long life
- Goldmax low friction titanium coating to stop burn out
- Drill & Tap in one easy operation

RECOMMENDED FOR USE WITH:

- Impact Drivers
- Impact Wrenches
- Rotary Drills
- Magnet Drills

CAN ALSO BE USED WITH:

- SDS+ Adapter
- Extension Arbor



ADAPTERS



VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

Magnet Drill Adapter
111035-01
Page 13

Use with any
standard drill
chuck

SDS+ Adapter
112010-01
Page 14

Extension - 12"
111015-300
Page 14

Quick Guide

- For fastest performance use on impact wrenches & drivers (Check torque requirement)
- Maximum tapping thickness is the thread diameter of the drill-tap
- Tapping Stainless Steel requires higher impact torque
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



VersaDrive Drill Taps

| | Part No | M Thread Size & Pitch | d1 | L | l1 | Max Tapping Depth |
|---------------|-------------|--------------------------|--------|----------|---------|----------------------|
| Inch | 301126-0010 | 4-40 UNC | 3/32" | 2-11/64" | 15/64" | 3/32" |
| | 301126-0020 | 6-32 UNC | 7/64" | 2-23/64" | 23/64" | 1/8" |
| | 301126-0030 | 8-32 UNC | 9/64" | 2-23/64" | 23/64" | 5/32" |
| | 301126-0040 | 10-24 UNC | 5/32" | 2-51/64" | 33/64" | 13/64" |
| | 301126-0045 | 12-24 UNC | 5/32" | 2-51/64" | 33/64" | 13/64" |
| | 301126-0050 | 1/4-20 UNC | 13/64" | 2-61/64" | 19/32" | 1/4" |
| | 301126-0060 | 5/16-18 UNC | 1/4" | 3-15/64" | 45/64" | 5/16" |
| | 301126-0070 | 3/8-16 UNC | 5/16" | 3-5/8" | 55/64" | 3/8" |
| | 301126-0080 | 1/2-13 UNC | 27/64" | 4-1/16" | 1-7/64" | 1/2" |
| Metric | 301125-0030 | M3 x 0.50 | 2.5mm | 55mm | 6mm | 3mm |
| | 301125-0040 | M4 x 0.70 | 3.3mm | 60mm | 9mm | 4mm |
| | 301125-0050 | M5 x 0.80 | 4.2mm | 71mm | 13mm | 5mm |
| | 301125-0060 | M6 x 1.00 | 5.0mm | 75mm | 17mm | 6mm |
| | 301125-0080 | M8 x 1.25 | 6.8mm | 82mm | 20mm | 8mm |
| | 301125-0100 | M10 x 1.50 | 8.5mm | 92mm | 25mm | 10mm |
| | 301125-0120 | M12 x 1.75 | 10.2mm | 103mm | 31mm | 12mm |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill (w. reverse)

Powertool Recommendations
(Mild Steel Material)

| | Impact Wrenches | Impact Drivers | SDS Drill (Rotary) | Cordless Drill | Pillar Drill Press | Magnet Drill (w. reverse) |
|---|-----------------|----------------|--------------------|----------------|--------------------|---------------------------|
| ○ | ● | × | ● | ● | ● | ● |
| ○ | ● | × | ● | ● | ● | ● |
| ○ | ● | × | ● | ● | ● | ● |
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| ○ | ● | × | ● | ● | ● | ● |
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| ○ | ● | × | ○ | ● | ● | ● |
| ● | ○ | × | ○ | ● | ● | ● |
| ● | ○ | × | ○ | ● | ● | ● |

● Optimal ○ Possible (Refer to data sheet)
× Not Recommended

VersaDrive Drill-Tap Sets

| Part No: | Set Contents |
|-------------|---|
| 301126-SET1 | Set contains: : 1/4, 5/16, 3/8, 1/2" UNC Combi Drill Taps |
| 301125-SET1 | Set contains: M5, M6, M8, M10, M12 Combi Drill-Taps |



"This impact drilltap combo is amazing! No risk of snagging wrists etc and jamming up of the drill when used in the impact gun. Keep it lubed up and the performance is great."

Tim Berry
AnyWeld

VersaDrive Heavy Duty Impacta-Drill Taps are an industrial metalwork or fabrication tool for drilling and tapping heavy steel in one easy operation.

Primarily they are designed to be used with a reversible Magnet drill, although they can also be adapted for use with an impact wrench to enlarge and tap existing holes.

With a drill point optimised for use in fixed drilling machines like Magnetic Drills or Pillar drills, these are not recommended for use in a pistol drill. Where they are to be used with an impact wrench to enlarge and tap holes pilot drilling is recommended with a separate drill bit.



Features & Benefits

- Fast Tapping with Minimal Kickback
- Specially hardened for impact wrench use
- High grade tool steel for high accuracy & long life
- Goldmax low friction titanium coating to stop burn out
- Unique Dual-Point Starting Angle for easy alignment & fast cut
- Automatic chip clearance when Impact Tapping

RECOMMENDED FOR USE WITH:

Magnet Drills
MultiSink

CAN ALSO BE USED WITH:

Impact Wrench
Extension Arbor
Morse Taper Drills



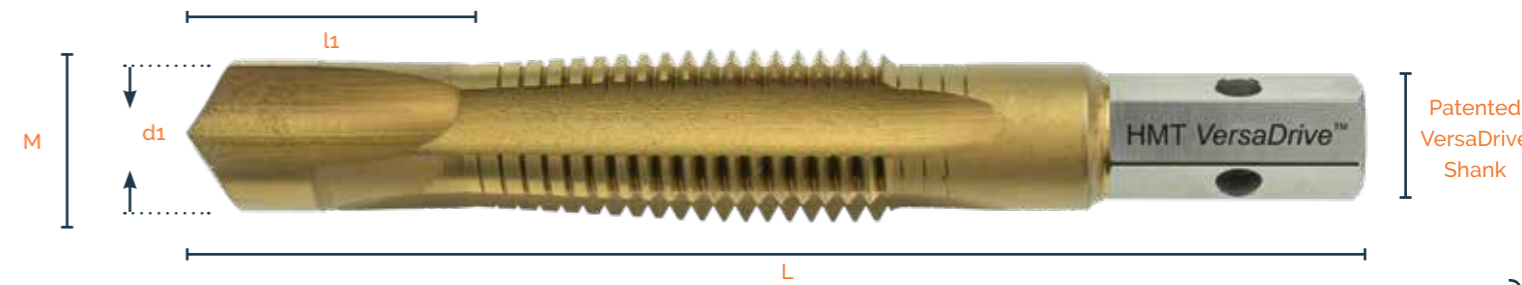
ADAPTERS

- Magnet Drill Adapter
111035-01
Page 13
- MultiSink
601055-
Page 64
- Impact Wrench Adapter
111130-012A
Page 12
- Extension - 12"
111015-300
Page 14
- Morse Taper Arbor
111045-
Page 15

Quick Guide

- Correct RPM is critical for good performance on larger drill taps
- Ideal for use in drill presses and magnet drills
- For impact wrench use, pilot drilling the hole with a separate drill bit is necessary
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



VersaDrive Heavy Duty Drill Taps

| | Part No | M Thread Size & Pitch | d1 | L | l1 | Max Tapping Depth |
|---------------|-------------|--------------------------|--------|----------|----------|-------------------|
| Inch | 301140-0001 | 1/2-13 UNC | 27/64" | 4-23/32" | 1-3/8" | 1" |
| | 301140-0002 | 5/8-11 UNC | 17/32" | 5-1/8" | 1-29/64" | 1" |
| | 301140-0003 | 3/4-10 UNC | 21/32" | 5-33/64" | 1-37/64" | 1-3/8" |
| | 301140-0005 | 1-8 UNC | 7/8" | 6-19/64" | 1-49/64" | 1-37/64" |
| Metric | 301130-0080 | M8 x 1.25 | 6.8mm | 100mm | 30mm | 20mm |
| | 301130-0100 | M10 x 1.50 | 8.5mm | 105mm | 30mm | 20mm |
| | 301130-0120 | M12 x 1.75 | 10.2mm | 117mm | 35mm | 25mm |
| | 301130-0160 | M16 x 2.00 | 14mm | 117mm | 37mm | 25mm |
| | 301130-0200 | M20 x 2.50 | 17.5mm | 135mm | 40mm | 35mm |
| | 301130-0240 | M24 x 3.00 | 21mm | 148mm | 45mm | 40mm |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill (w. reverse)

Powertool Recommendations
(Mild Steel Material)

| | | | | | |
|---|---|---|---|---|---|
| ● | ● | × | ○ | ● | ● |
| ● | ● | × | × | ● | ● |
| ● | ● | × | × | ● | ● |
| ● | ● | × | × | ● | ● |
| ○ | ○ | × | ○ | ● | ● |
| ○ | ○ | × | ○ | ● | ● |
| ○ | × | × | ○ | ● | ● |
| ○ | × | × | × | ● | ● |
| ○ | × | × | × | ● | ● |

● Optimal ○ Possible (Refer to data sheet)
× Not Recommended

VersaDrive Heavy Duty Drill-Tap Sets

| Part No: | Set Contents |
|-------------|--|
| 301140-SET1 | Set contains: : 1/2, 5/8, 3/4, 1" UNC Combi Drill Taps |
| 301130-SET1 | Set contains: M12, M16, M20, M24 Heavy Duty Combi Drill-Taps |



The VersaDrive Countersink is a premium quality countersink with fully ground flutes and Titanium coating to help reduce wear and blunting.

VersaDrive Countersinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Utilise the convenience and power of an impact wrench to quickly debur and countersink holes up to 5/8" with minimal torque kick-back against the operator.



Features & Benefits

- For Countersunk Bolt Heads
- Safer use with minimal kickback
- Specially hardened for impact wrench use up to 5/8"
- High-Grade Tool Steel for high accuracy & long life
- GoldMax low friction Titanium Coating to stop burn out
- 1st Impact rated countersinks on the market

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
Pillar Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



Use with any standard drill chuck



Magnet Drill Adapter
111035-01
Page 13



VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12



SDS+ Adapter
112010-01
Page 14



Extension - 12"
111015-300
Page 14

Quick Guide

- Optimum life and performance when used with rotary pistol drills or drill presses
- Up to 5/8" can be used on impact wrench & impact drivers for fast cutting performance
- Suitable for harder materials such as stainless steel when used at reduced RPM
- Not for use on plasma cut or flame cut holes
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



VersaDrive Countersinks

| | Part No | D Ø | Ø d1 | l1 | L | Countersunk Screw | Point Angle |
|-------------------|-------------|------|--------|--------|----------|-------------------|-------------|
| Inch - 82° | 603065-0100 | 1/4" | 1/16" | 7/64" | 1-27/32" | - | 82° |
| | 603065-0200 | 3/8" | 7/64" | 5/32" | 2-3/64" | - | 82° |
| | 603065-0300 | 1/2" | 7/64" | 7/32" | 2-9/32" | - | 82° |
| | 603065-0400 | 5/8" | 1/8" | 9/32" | 2-7/16" | - | 82° |
| | 603065-0500 | 3/4" | 1/8" | 11/32" | 2-9/16" | - | 82° |
| | 603065-0600 | 1" | 11/64" | 31/64" | 2-23/32" | - | 82° |

| | Part No | D Ø | Ø d1 | l1 | L | Countersunk Screw | Point Angle |
|---------------------|-------------|--------|-------|------|------|-------------------|-------------|
| Metric - 90° | 603060-0063 | 6.3mm | 1.5mm | 17mm | 45mm | M3 | 90° |
| | 603060-0083 | 8.3mm | 2.0mm | 22mm | 50mm | M4 | 90° |
| | 603060-0104 | 10.4mm | 2.5mm | 22mm | 50mm | M5 | 90° |
| | 603060-0124 | 12.4mm | 2.8mm | 28mm | 56mm | M6 | 90° |
| | 603060-0165 | 16.5mm | 3.2mm | 32mm | 60mm | M8 | 90° |
| | 603060-0205 | 20.5mm | 3.5mm | 35mm | 63mm | M10 | 90° |
| | 603060-0250 | 25mm | 3.8mm | 39mm | 67mm | M12 | 90° |
| | 603060-0310 | 31mm | 4.2mm | 43mm | 71mm | M16 | 90° |

- Impact Wrenches
- Impact Drivers
- SDS Drill (Rotary)
- Cordless Drill
- Pillar Drill Press
- Magnet Drill

Powertool Recommendations (Mild Steel Material)

| Impact Wrenches | Impact Drivers | SDS Drill (Rotary) | Cordless Drill | Pillar Drill Press | Magnet Drill |
|-----------------|----------------|--------------------|----------------|--------------------|--------------|
| ● | ● | ● | ● | ● | ● |
| ● | ● | ● | ● | ● | ● |
| ● | ● | ● | ● | ● | ● |
| ○ | ○ | ○ | ● | ● | ● |
| × | × | ○ | ● | ● | ● |
| × | × | ○ | ● | ● | ● |

| Impact Wrenches | Impact Drivers | SDS Drill (Rotary) | Cordless Drill | Pillar Drill Press | Magnet Drill |
|-----------------|----------------|--------------------|----------------|--------------------|--------------|
| ● | ● | ○ | ● | ● | ● |
| ● | ● | ○ | ● | ● | ● |
| ● | ● | ○ | ● | ● | ● |
| ● | ● | ○ | ● | ● | ● |
| ○ | ○ | ○ | ● | ● | ● |
| × | × | ○ | ● | ● | ● |
| × | × | ○ | ● | ● | ● |

● Optimal ○ Possible (Refer to data sheet)
× Not Recommended

VersaDrive Countersink Set

| Part No: | Set Contents |
|-------------|--|
| 603065-5SET | Set contains: 3/8", 1/2", 5/8", 3/4", 1" VersaDrive 82° Countersink Bits |
| 603060-5SET | Set contains: 12.4, 16.5, 20.5, 25, 31mm VersaDrive 90° Countersink Bits |



TCT HOLECUTTER®

TUNGSTEN CARBIDE TECHNOLOGY

Fast, efficient & cost effective
Outperforms & outlasts traditional HSS holesaws by up to 10 times!

VersaDrive TCT HoleCutters offer a fast, efficient and cost effective holemaking solution that outperform and outlast traditional HSS holesaws by up to 10 times!

Highly versatile and perfect for heavy duty applications VersaDrive HoleCutters are compatible with the VersaDrive system of extensions and adapters and feature cutting teeth manufactured from premium-grade Tungsten Carbide, one of the strongest materials for cutting tools. This ensures the highest levels of performance and durability, with faster cuts and increased life spans.

A complete hole cutting solution, the range offers Standard HoleCutters, Extra Long HoleCutters & the HMT exclusive HoleCutter and MultiSink combination.



SPRING LOADED PILOT DRILL

Centres and stabilises cutter during drilling & ejects metal slug upon completion

RAPID-LOCK SHANK

VersaDrive Hex shank fits all standard drill chucks, Rapid-lock adapters and extension arbors, offering the greatest flexibility & applications from a single tool.

TUNGSTEN CARBIDE TEETH

Premium grade Sandvik Tungsten Carbide teeth for the highest performance cutting & 10x greater life than standard holesaws.

THE RANGE

THE COMPLETE SOLUTION

VersaDrive HoleCutters offer the widest range of hole cutting solutions on the market.

Our flagship TCT HoleCutter is the ideal choice for inaccessible and heavy duty holemaking challenges.

For specialist jobs that require extended depth drilling our innovative Extra Long HoleCutters offer a 4" cutting depth.

Meanwhile all VersaDrive HoleCutters can be combined with the HMT exclusive multiSink system, allowing you to broach and countersink in one pass, as well as the complete range of VersaDrive Rotary adapters for use on Magnetic & SDS+ drills.

SIZES AVAILABLE

Standard HoleCutter:

Diameter (Ø): 9/16" - 3 5/32"

Cutting Length (L): 2 1/4"

Total Reach: 2 3/4"

Extra Long HoleCutter:

Diameter (Ø): 9/16" - 15/16"

Cutting Length (L): 4"

Total Reach: 4 2/3"

HoleCutter & MultiSink:

HoleCutter (Ø): 9/16" - 1 1/4"

MultiSink (Ø): 1 1/2" / 2 11/64"

Total Length: 4 3/8"

REPLACING MAGNET DRILLS

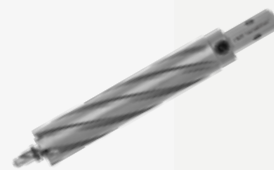
Many steel erectors and fabricators tell us that they are able to replace heavy and awkward magnetic drills with a standard cordless drill fitted with a VersaDrive hole cutter.

- No risk of a heavy magnet drill falling from height
- Quick to position and drill
- Carry less equipment, saving weight and increasing mobility

HoleCutter products available



Standard HoleCutter



Extra Long HoleCutter



HoleCutter with TCT MultiSink

1 HOLECUTTER - 3 SOLUTIONS

-When using with a magnet drill adapter or multiSink tool replace supplied pilot drill with 101030P-0003 ejector pin



Use in Pistol Drill



Adapt for Magnet Drill Use

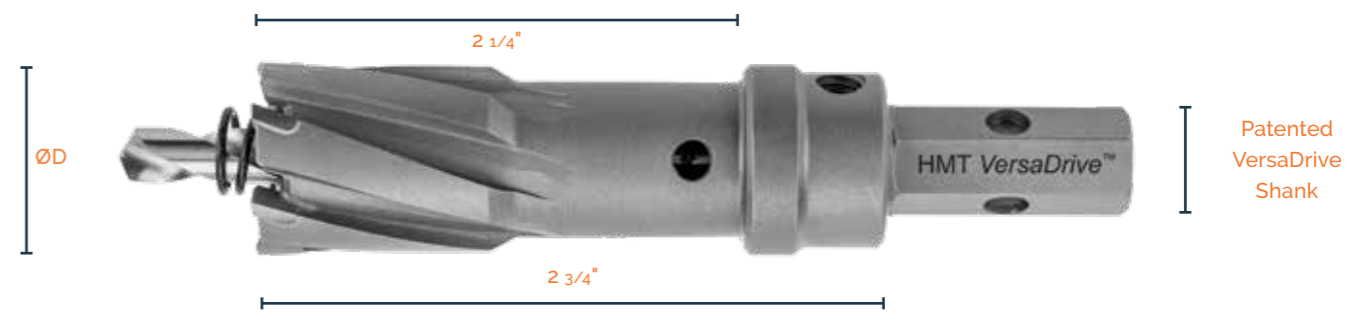


Adapt to MultiSink

VersaDrive TCT HoleCutters are a high performance solution for cutting larger diameter holes quickly and effectively. Premium grade Tungsten carbide teeth provide ultimate cutting performance in a wide range of Structural steels including Stainless Steel and Cast Iron.

These are rapidly becoming the go-to, alternative solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and possibly safer than a Magnetic drill.

VersaDrive TCT HoleCutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

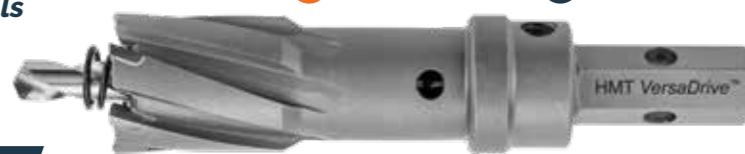
- Massive 2 3/4" reach with 2 1/4" depth of cut
- Premium quality Tungsten Carbide teeth
- Perfect for drilling heavy steel in remote locations
- Use in standard 1/2" drill chuck or with magnet drill adapter
- One piece design includes arbor & (replaceable) pilot drill
- Combine with multisink to broach & countersink in 1 pass

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
HMT MultiSink
Pillar Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



Use with any standard 1/2" drill chuck



Magnet Drill Adapter
111035-01
Page 13



SDS+ Adapter
112010-01
Page 14



Extension - 12"
111015-300
Page 14

Quick Guide

- Optimum life and performance when used with rotary pistol drills
- Good results can be achieved with SDS Drills when used in Rotary Only mode
- Replace supplied pilot drill with 101030P-0003 ejector pin to use with Magnet Drill/MultiSink
- Suitable for use on Stainless Steel
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



| Part No | Ø D Inch | Ø D mm |
|-------------|----------|--------|
| 101030-0120 | | 12mm |
| 101030-0130 | | 13mm |
| 101030-0140 | 9/16" | 14mm |
| 101030-0150 | | 15mm |
| 101030-0160 | 5/8" | 16mm |
| 101030-0170 | 11/16" | 17mm |
| 101030-0175 | | 17.5mm |
| 101030-0180 | | 18mm |
| 101030-0190 | 3/4" | 19mm |
| 101030-0200 | | 20mm |
| 101030-0210 | 13/16" | 21mm |
| 101030-0220 | 7/8" | 22mm |
| 101030-0230 | | 23mm |
| 101030-0240 | 15/16" | 24mm |
| 101030-0250 | 1" | 25mm |
| 101030-0260 | | 26mm |
| 101030-0270 | 1-1/16" | 27mm |
| 101030-0280 | | 28mm |
| 101030-0290 | 1-1/8" | 29mm |
| 101030-0300 | 1-3/16" | 30mm |
| 101030-0310 | | 31mm |
| 101030-0320 | 1-1/4" | 32mm |
| 101030-0330 | 1-5/16" | 33mm |
| 101030-0340 | | 34mm |

| Part No | Ø D Inch | Ø D mm |
|-------------|----------|--------|
| 101030-0350 | 1-3/8" | 35mm |
| 101030-0360 | | 36mm |
| 101030-0370 | 1-7/16" | 37mm |
| 101030-0380 | 1-1/2" | 38mm |
| 101030-0390 | 1-9/16" | 39mm |
| 101030-0400 | | 40mm |
| 101030-0410 | 1-5/8" | 41mm |
| 101030-0420 | | 42mm |
| 101030-0430 | 1-11/16" | 43mm |
| 101030-0440 | 1-3/4" | 44mm |
| 101030-0450 | | 45mm |
| 101030-0460 | 1-13/16" | 46mm |
| 101030-0470 | | 47mm |
| 101030-0480 | 1-7/8" | 48mm |
| 101030-0490 | | 49mm |
| 101030-0500 | | 50mm |
| 101030-0510 | 2" | 51mm |
| 101030-0520 | 2-1/16" | 52mm |
| 101030-0550 | 2-5/32" | 55mm |
| 101030-0600 | 2-3/8" | 60mm |
| 101030-0650 | 2-9/16" | 65mm |
| 101030-0700 | 2-3/4" | 70mm |
| 101030-0750 | | 75mm |
| 101030-0800 | 3-5/32" | 80mm |

VersaDrive TCT HoleCutter Sets

| Part No | Contents |
|---------------|--|
| 101030-INSET1 | HMT VersaDrive TCT HoleCutter Set 9/16, 11/16, 13/16" |
| 101030-INSET2 | HMT VersaDrive TCT HoleCutter Set 9/16, 11/16, 13/16, 15/16, 1-1/16" |



Pilot Drill Bits & Pilot Pins

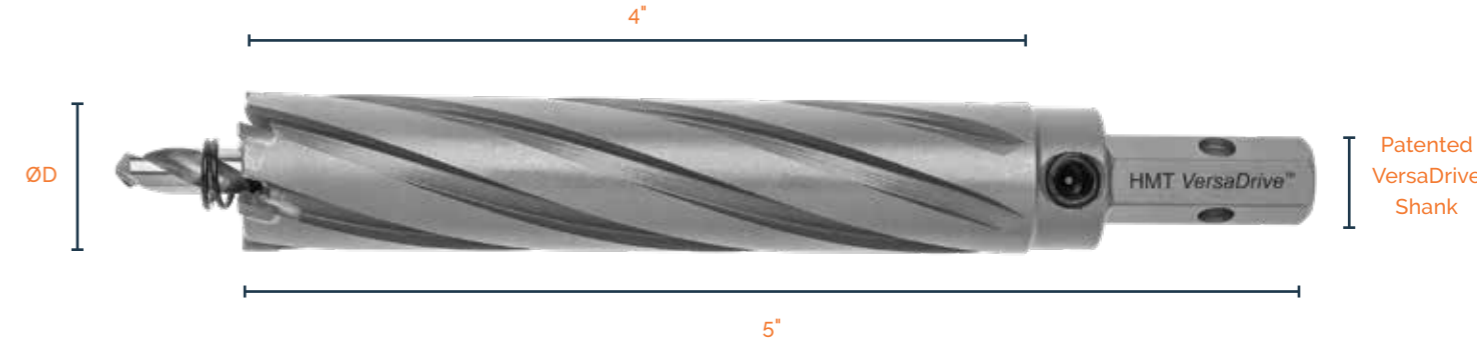
| Part No | Contents |
|--------------|---|
| 101030P-0130 | HoleCutter Pilot Drill for 12 & 13mm HoleCutters - Pack of 2 (Supplied WITHOUT ejection spring) |
| 101030P-0001 | HoleCutter Pilot Drill for 9/16 - 3-5/32" HoleCutters Pack of 2 (Supplied WITH ejection spring) |
| 101030P-0003 | VersaDrive HoleCutter Magnet Broaching/MultiSink Pilot Pin, Pk2 |



Extra Long reach version of the popular VersaDrive HoleCutter. Perfect for small diameter drilling through steelwork using a pistol drill where a separate extension isn't practical.

Ideal for applications where a metal plate is encountered amongst wood joists or where both sides of a steel beam require drilling.

These are rapidly becoming the go-to solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and safe than a Magnetic drill.



Features & Benefits

- 5" reach with 4" depth of cut
- Premium quality Tungsten Carbide teeth
- Perfect for drilling box section with inaccessible sides
- Use with standard 1/2" drill chuck or magnet drill adapter
- One piece design includes arbor & (replaceable) pilot drill
- Use with other VersaDrive adapters for ultimate flexibility

RECOMMENDED FOR USE WITH:

Rotary Drills
Cordless Drills
SDS Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS



Use with any standard 1/2" drill chuck



Magnet Drill Adapter
111035-01
Page 13



SDS+ Adapter
112010-01
Page 14



Extension - 12"
111015-300
Page 14

Quick Guide

- Optimum life and performance when used with rotary pistol drills
- Good results can be achieved with SDS Drills when used in Rotary Only mode
- Replace supplied pilot drill with 101035P-02 ejector pin for use with Magnet Drill/MultiSink
- Suitable for use on Stainless Steel
- Use appropriate lubrication and correct RPM to achieve long tool life

Watch the video & find more info online



| Part No | Ø D Inch | Ø D mm |
|-------------|----------|--------|
| 101035-0140 | 9/16" | 14mm |
| 101035-0170 | 11/16" | 17mm |
| 101035-0180 | | 18mm |
| 101035-0200 | | 20mm |
| 101035-0210 | 13/16" | 21mm |
| 101035-0220 | 7/8" | 22mm |
| 101035-0240 | 15/16" | 24mm |
| 101035-0260 | | 26mm |

VersaDrive Extra Long HoleCutter Sets

| Part No | Contents |
|-------------|---|
| 101035-SET2 | HMT VersaDrive TCT HoleCutter Extra Long Series Set, 9/16, 11/16, 13/16, 7/8, 15/16" + Pilots |



Pilot Drill Bits

| Part No | Contents |
|------------|--|
| 101035P-01 | HMT VersaDrive Extra Long TCT HoleCutter Pilot Drills, 1/4" x 6 1/2", Pk 2 |
| 101035P-02 | HMT Extra Long VersaDrive HoleCutter Guide Pin, 1/4" x 8 1/32", Pk 2 |



VERSADRIVE® STAKIT

Total jobsite productivity with VersaDrive **STAKIT**.

Keep the job moving and overcome unexpected job site challenges with these modular kits to speed up metalworking for install and maintenance teams.

VersaDrive® **STAKIT** is a new modular system of robust stacking site kits that give fast and easy transportation of your VersaDrive tooling and power tools to the jobsite.

Modular clip-together system so you can plug and play to choose the right package for your needs, or to start small and add more kits over time.

Each case can be used individually or interlocked for fast use in the field, on the jobsite or in the workshop.



Features & Benefits

- Waterproof & Dustproof
- Store VersaDrive tooling
- Protect your investment
- Stacking & Interlocking
- Store Magnet Drills
- Easy equipment transportation
- Durable, reinforced, injection moulded plastic
- Store cordless power tools
- Compatible with complete VersaDrive Range



VERSADRIVE®
PATENT PROTECTED

NEW

VersaDrive **STAKIT** - HoleCutter Pro Kit

NEW



Contents:

- 5x VersaDrive HoleCutters 9/16, 11/16, 13/16, 15/16, 1-1/16"
- 4x Extra Long HoleCutters 9/16, 11/16, 13/16, 15/16"
- 1x VersaDrive 5" Extension Adapter

L x W x H - 21.5" x 15.5" x 4"

| Part No | Product |
|---------------|----------------------------------|
| STC-TOP-VHC03 | STAKIT HoleCutter Pro Kit |

STAKIT Top Case

NEW

VersaDrive **STAKIT** - Impact Starter Kit



Inch Sized Kit Contents:

- 3 x Reamers 9/16, 11/16, 13/16"
- 3 x DrillTaps 1/4-20, 5/16-18, 3/8-16 UNC
- 3 x ImpactaTaps 1/2-13, 5/8-11, 3/4-10 UNC
- 7 x TurboTips #F, 9/32, 5/16, 3/8, 27/64, 7/16, 1/2"

Metric Sized Kit Contents:

- 3x Reamers 14, 18, 22mm
- 3x DrillTaps M6, M8, M10
- 3x ImpactaTaps M12, M16, M20
- 7x TurboTips 6.8, 8, 8.5, 10, 10.5, 12, 14mm

- 3 x VersaDrive Rapid-Lock Adapters
- 1/4" & 1/2" Impact Adapter & 5" Extension

| Part No | Product |
|---------------|---|
| STC-TOP-VSD02 | STAKIT Impact Starter Kit - Inch |
| STC-TOP-VSD01 | STAKIT Impact Starter Kit - Metric |

VersaDrive **STAKIT** - Rotary Starter Kit

NEW



Contents:

- 4x CarbideMax Cutters 9/16, 11/16, 13/16, 15/16"
- 4x Pilot Pins
- 5x VersaDrive HoleCutters 9/16, 11/16, 13/16, 15/16, 1-1/16"

| Part No | Product |
|---------------|----------------------------------|
| STC-TOP-VCM02 | STAKIT Rotary Starter Kit |

NEW

VersaDrive **STAKIT** - Build Your Own



| Part No | Product |
|--------------|--|
| STC-ETOP-F01 | Empty toolcase + Inserts for 16 x VersaDrive Tools + 5 VersaDrive Adapters |
| STC-ETOP-F02 | Empty toolcase + Inserts for 16 x CarbideMax / Broach Cutters |
| STC-ETOP-F03 | Empty toolcase + Inserts for 8 x Broach Cutters, 8 x VersaDrive Tools + 3 VSD Adapters |

N.B. STAKIT Mid Case required to connect Top case to Base cases

Find a dealer at us.holemaker-technology.com

STAKIT 31pc Site Installation Kit

The **STAKIT** Site Installation Kit is created to combine an essential set of best-selling VersaDrive products to overcome all common site installation and steel erection holmaking challenges. Keeps the job moving when you find an unexpected challenge.

Presented in the **STAKIT** Mid Case and connects to all Top cases and Base cases.

Inch Sized Kit Contents:

- 6 x TurboTips 1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
- 5 x HoleCutters 9/16, 5/8, 3/4, 7/8, 1"
- 2 x ImpactaStep 9/16, 13/16
- 3 x DrillTaps 5/16, 3/8, 1/2"
- 3 x ImpactaTaps 1/2, 5/8, 3/4
- 4 x Reamers 1/2, 9/16, 11/16, 13/16"

Metric Sized Kit Contents:

- 6 x TurboTips 6, 6.35, 8, 10.5, 12, 14mm
- 5 x HoleCutters 14, 17, 18, 20 & 22mm
- 2 x ImpactaStep 16 & 22mm
- 3 x DrillTaps M6, M8 & M10
- 3 x ImpactaTaps M12, M16 & M20
- 4 x Reamers 12, 14, 18 & 22mm

+ 5x Rapid lock adapters

- 1/4" Impact Driver Adapter, 1/2" Impact Wrench Adapter, Magnet Drill Adapter, 5" Extension, 12" Extension

L x W x H - 23" x 15.5" x 5.5"

| Part No | Contents |
|---------------|--|
| STC-EMID-INIK | STAKIT 31pc Installation Kit - Inch Sizes |
| STC-EMID-MEIK | STAKIT 31pc Installation Kit - Metric |



V60T Magnet Drill & STAKIT 350 Case

The **STAKIT** Base 350 is a large capacity protective site case that features a top handle for short distance carrying and can be connected directly to the **STAKIT** SiteCart for longer distance transportation.

It is available in two versions. Firstly as the included sitecase for the VersaDrive V60T Magnet Drill. Like this it comes complete with interior moulded foam, that protects and secures the V60T and accessories whilst in transit, and 2 external compartments for storing additional tooling and equipment.

Secondly it is available as a standalone case perfect for larger equipment storage or for holding all your handheld drive tools in one place. No foam inserts or dividers means this case offers the most flexibility of use and can be filled with whatever is needed for the job.

L x W x H - 23" x 15.5" x 12.5"

| Part No | Product |
|----------------|---|
| 850060-P-110US | HMT V60T VersaDrive Magnetic Drill Pro Kit - 110v with STAKIT 350 Case |
| MKC-EBASE-350 | STAKIT Base 350 Case |



V35 Magnet Drill & STAKIT Base 200 Case

The Base 200 case is a durable protective site case featuring top and side handles for easy carrying. It can also be clipped directly to the **STAKIT** SiteCart for manoeuvring with the rest of the system or longer distance transportation.

It is available in two versions. Firstly as the included sitecase for the VersaDrive V35 Magnet Drill. Like this it comes complete with interior moulded foam that protects and secures the V35 whilst in transit, 2 internal organiser boxes and 2 external compartments for storing tooling, handles and accessories.

Secondly it is available as a standalone case with 6 reconfigurable internal organiser boxes and 2 accessory organisers in the lid. In this format the case is perfect for holding cordless powertools, batteries, chargers and other essential portable equipment.

In both configurations the Base 200 seamlessly integrates into the **STAKIT** system for easy transportation & use on a jobsite or in the field.

L x W x H - 23" x 15.5" x 7.5"

| Part No | Contents |
|---------------|---|
| 850035-110US | HMT V35 VersaDrive Magnetic Drill 110v |
| MKC-EBASE-200 | STAKIT Base 200 Replacement Case |



STAKIT SiteCart

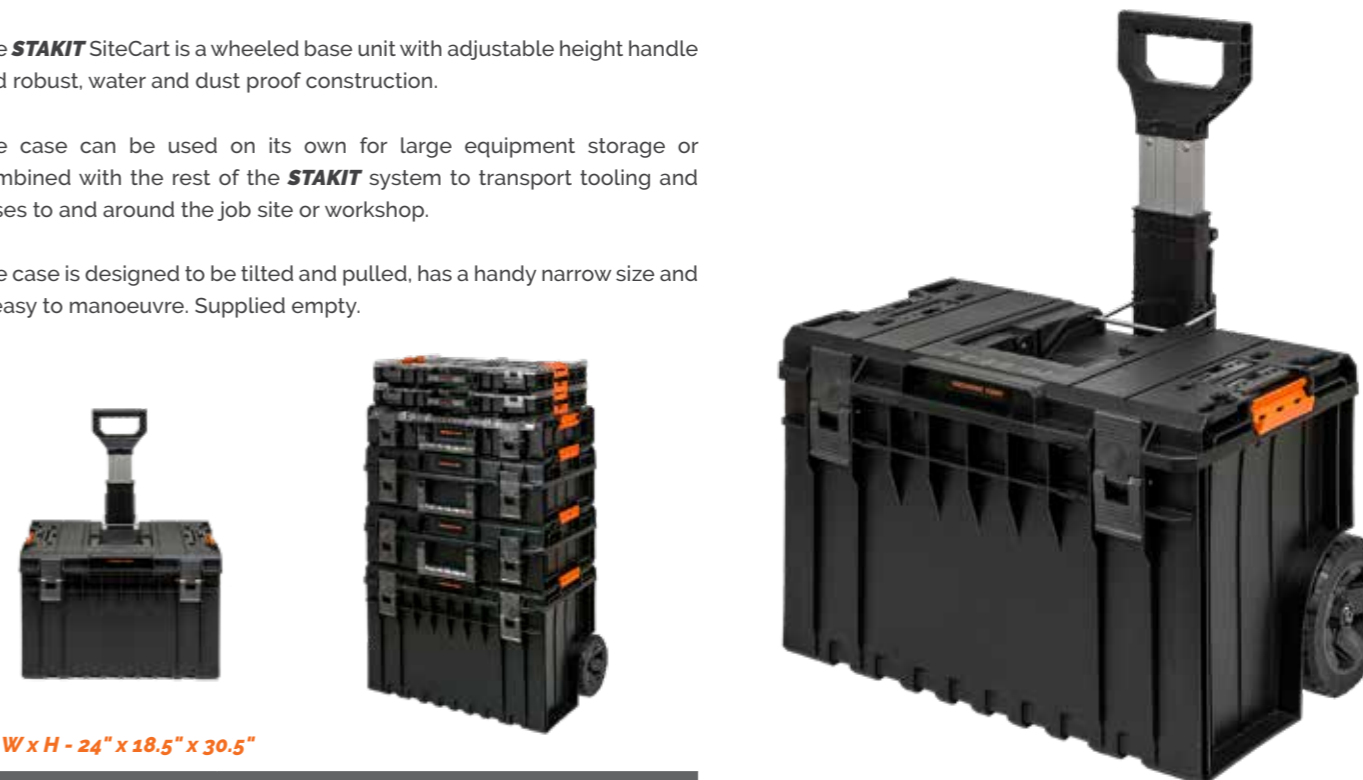
The **STAKIT** SiteCart is a wheeled base unit with adjustable height handle and robust, water and dust proof construction.

The case can be used on its own for large equipment storage or combined with the rest of the **STAKIT** system to transport tooling and cases to and around the job site or workshop.

The case is designed to be tilted and pulled, has a handy narrow size and is easy to manoeuvre. Supplied empty.

L x W x H - 24" x 18.5" x 30.5"

| Part No | Product |
|--------------|------------------------|
| STC-SITECART | STAKIT SiteCart |



Unique benefits from a unique range.

From the lightest, most compact machine on the market to machines with variable speed, variable torque and forward/reverse as standard, VersaDrive magnet drills have been custom engineered to optimise performance.

Designed and built in our Sheffield factory by the expert HMT team, all machines with tapping capacity are powered by a legendary Eibenstock motor and combine with the Patented VersaDrive modular tooling system to extend consumable life and enhance performance for all kinds of broaching, drilling, threading, countersinking and more.

When registered, products are protected by a

2 YEAR WARRANTY

UK Built 



V35

V60T

V85T

V100T

V125T

| Model | Max Cutter Diameter | Fitting | Weight (lbs) | Stroke | Drilling | Tapping | Countersinking |
|-------|---------------------|---------|--------------|----------|----------|---------|----------------|
| V35 | 1 3/8" | 3/4" | 20.95 | 5 1/2" | 1/2" | N/A | 1" |
| V60T | 2 3/8" | MT2 | 39.5 | 8 5/8" | 3/4" | 3/4" | 1 1/2" |
| V85T | 3 1/4" | MT3 | 45 | 8 5/8" | 1 1/16" | 1" | 2" |
| V100T | 4" | MT3 | 54 | 11 1/32" | 1 1/4" | 1 1/4" | 2" |
| V125T | 5" | MT3 | 55 | 11 1/32" | 1 1/4" | 1 1/4" | 2 9/16" |



Supplied with a quick change VersaDrive adapter

UK Built 

Technical Specifications

| | |
|----------------------|--------------------------|
| CUTTER SIZE RANGE | 1/2" - 1 3/8" |
| MAX CUTTER CAPACITY | 1 3/8" |
| MAX CUTTER LENGTH | 4 3/8" |
| TWIST DRILL CAPACITY | 1/2" |
| COUNTERSINKING | 1" |
| REAMING | N/A |
| MAX TAP CAPACITY | N/A |
| LENGTH | 8 5/8" |
| WIDTH (Inc Handles) | 6 6/8" |
| HEIGHT (Min-Max) | 12" - 17 3/4" |
| STROKE | 5.5" |
| WEIGHT | 20.95 lb |
| MAGNET (L X W) | 6 3/8" x 3 1/4" |
| MAGNETIC ADHESION | 2200 lb |
| MOTOR POWER | 850W |
| TOTAL POWER | 900W |
| SPEED RPM (No Load) | 750 |
| SPINDLE | 3/4" Weldon |
| ARBOR | Integral 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 2 Year (When registered) |



Supplied in **STAKIT Base 200 case**

The HMT VersaDrive V35 is the first UK Built portable drilling machine designed for high-performance, low-maintenance, industrial quality drilling up to 1 3/8" diameter. It delivers constant performance in the most challenging drilling environments and fabrication conditions.

This machine fills a gap in the market for extremely light weight, high drilling speed, and long stroke to accept a wide range of VersaDrive Tooling such as twist drills, countersinks, drillsinks, step drills and more.

Supplied with handles, restraint strap, heavy duty metal guard system, VersaDrive Rapid-Lock adapter, site case and gravity fed coolant system.

| Part No | Contents |
|--------------|--|
| 850035-110US | HMT V35 VersaDrive Magnetic Drill 110v |

MOST VERSATILE COMPACT MACHINE ON THE MARKET

Find a dealer at us.holemaker-technology.com

VersaDrive V60T Magnet Drill



Supplied with two quick change adapters

VersaDrive V85T Magnet Drill



Supplied with two quick change adapters

UK Built

UK Built

Supplied in **STAKIT Base 350** case



Technical Specifications

| | |
|----------------------|--------------------------|
| CUTTER SIZE RANGE | 7/16" - 2 3/8" TCT |
| MAX CUTTER CAPACITY | 2 3/8" TCT |
| MAX CUTTER LENGTH | 6" |
| TWIST DRILL CAPACITY | 3/4" |
| COUNTERSINKING | 1 1/2" |
| REAMING | 3/4" |
| MAX TAP CAPACITY | 3/4" |
| LENGTH | 12 1/2" |
| WIDTH (Inc Handles) | 8 1/2" |
| HEIGHT (Min-Max) | 15 - 24" |
| STROKE | 8 1/2" |
| WEIGHT | 39.5 lb |
| MAGNET (L X W) | 8" x 4" |
| MAGNETIC ADHESION | 3860 lb |
| MOTOR POWER | 1150w |
| TOTAL POWER | 1270w |
| SPEED RPM (No Load) | 100 - 250 / 180 - 450 |
| SPINDLE | MT2 |
| ARBOR | 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 2 Year (When registered) |

The HMT VersaDrive V60T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 2 3/8" diameter with a powerful forward and reverse, variable speed motor that will tap holes up to 3/4" diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

MARKET LEADING PERFORMANCE

| Part No | Contents |
|----------------|---|
| 850060-P-110US | HMT V60T VersaDrive Magnetic Drill Pro Kit - 110v |

Technical Specifications

| | |
|----------------------|--------------------------|
| CUTTER SIZE RANGE | 7/16" - 3 1/4" TCT |
| MAX CUTTER CAPACITY | 3 1/4" TCT |
| MAX CUTTER LENGTH | 6" |
| TWIST DRILL CAPACITY | 1 1/16" |
| COUNTERSINKING | 2" |
| REAMING | 15/16" |
| MAX TAP CAPACITY | 1" |
| LENGTH | 12 1/2" |
| WIDTH (Inc Handles) | 9 1/2" |
| HEIGHT (Min-Max) | 16 1/2" - 25 1/2" |
| STROKE | 8 1/2" |
| WEIGHT | 45 lb |
| MAGNET (L X W) | 8" x 4" |
| MAGNETIC ADHESION | 3860 lb |
| MOTOR POWER | 1800w |
| TOTAL POWER | 1920w |
| SPEED RPM (No Load) | 60 - 140 / 200 - 470 |
| SPINDLE | MT3 |
| ARBOR | 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 2 Year (When registered) |

The HMT VersaDrive V85T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 3 1/4" diameter with a powerful forward and reverse, variable speed motor that will tap holes up to 1" diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

MARKET LEADING PERFORMANCE

| Part No | Contents |
|----------------|---|
| 850085-P-110US | HMT V85T VersaDrive Magnetic Drill Pro Kit - 110v |

Find a dealer at us.holemaker-technology.com

VersaDrive V100T Magnet Drill



Supplied with two quick change adapters

VersaDrive V125T Magnet Drill



Supplied with two quick change adapters

UK Built

UK Built



The HMT VersaDrive V100T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 4" diameter with a powerful forward and reverse, variable speed motor that will tap holes up to 1 1/4" diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V100T can also be used with the VersaDrive blind hole tapping system up to 1 1/4" diameter.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

MARKET LEADING PERFORMANCE

Technical Specifications

| | |
|----------------------|--------------------------|
| CUTTER SIZE RANGE | 7/16" - 4" TCT |
| MAX CUTTER CAPACITY | 4" TCT |
| MAX CUTTER LENGTH | 8" |
| TWIST DRILL CAPACITY | 1 1/4" |
| COUNTERSINKING | 2" |
| REAMING | 1 1/16" |
| MAX TAP CAPACITY | 1 1/4" |
| LENGTH | 13 1/2" |
| WIDTH (Inc Handles) | 9 1/2" |
| HEIGHT (Min-Max) | 17 1/2" - 29" |
| STROKE | 11" |
| WEIGHT | 54 lb |
| MAGNET (L X W) | 8 1/2" x 4 1/2" |
| MAGNETIC ADHESION | 4850 lb |
| MOTOR POWER | 1800w |
| TOTAL POWER | 1900w |
| SPEED RPM (No Load) | 60 - 140 / 200 - 470 |
| SPINDLE | MT3 |
| ARBOR | 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 2 Year (When registered) |

| Part No | Contents |
|----------------|--|
| 850100-P-110US | HMT V100T VersaDrive Magnetic Drill Pro Kit - 110v |

Technical Specifications

| | |
|----------------------|--------------------------------------|
| CUTTER SIZE RANGE | 7/16" - 5" TCT |
| MAX CUTTER CAPACITY | 5" TCT |
| MAX CUTTER LENGTH | 8" |
| TWIST DRILL CAPACITY | 1 1/4" |
| COUNTERSINKING | 2 9/16" |
| REAMING | 1 1/4" |
| MAX TAP CAPACITY | 1 1/4" |
| LENGTH | 13 1/2" |
| WIDTH (Inc Handles) | 9 1/2" |
| HEIGHT (Min-Max) | 18 1/2" - 29 1/2" |
| STROKE | 11" |
| WEIGHT | 55 lb |
| MAGNET (L X W) | 8 1/2" x 4 1/2" |
| MAGNETIC ADHESION | 4850 lb |
| MOTOR POWER | 1800w |
| TOTAL POWER | 1900w |
| SPEED RPM (No Load) | 60-140 / 100-220 / 140-310 / 210-490 |
| SPINDLE | MT3 |
| ARBOR | 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 2 Year (When registered) |

| Part No | Contents |
|----------------|--|
| 850125-P-110US | HMT V125T VersaDrive Magnetic Drill Pro Kit - 110v |



The HMT VersaDrive V125T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 5" diameter with a powerful forward and reverse, variable speed motor that will tap holes up to 1 1/4" diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V125T can also be used with the VersaDrive blind hole tapping system up to 1 1/4" diameter.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

MARKET LEADING PERFORMANCE

OverReach Fixed System

The HMT OverReach system is a range of magnetic base units that are designed to reach over obstructions such as plates or rivet heads to position a drilling unit where it would have not been previously possible. The powerful electromagnet can be positioned further away from the hole and a magnet drill can be placed on the fixed projecting steel plate to give more positioning options.

Technical Specifications

| | |
|----------------------|--|
| CUTTER CAPACITY | 1 3/16" |
| PLATE THICKNESS | 3/8" |
| PLATE AREA | 8" x 4 1/2" |
| WEIGHT | 16.8 lb |
| MAGNET POWER | 2430 lb |
| MAGNET DIMENSIONS | 4 9/16" x 4 9/16" |
| MAX WEIGHT SUPPORTED | 26 1/2" |
| USE WITH | V35, MAX30, MAX40V Magnet Drills |
| MINIMUM BASE | 3/8" thick, clean, flat, paint & rust free |
| MATERIAL REQUIRED | |



CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

UK Built

861010-110US HMT OverReach Magnet Base Clamp Fixed V Plate, 110 Volt

RTQ40 Magnet Drill

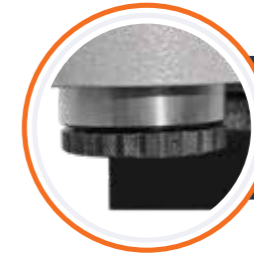


Integrated lubricant system and feed hose



Technical Specifications

| | |
|----------------------|--------------------------|
| CUTTER SIZE RANGE | 7/16" - 1 9/16" |
| MAX CUTTER CAPACITY | 1 9/16" |
| TWIST DRILL CAPACITY | 1/2" |
| LENGTH | 12" |
| WIDTH | 5" |
| HEIGHT | 7" |
| STROKE | 1.57" |
| WEIGHT | 24 lb |
| MAGNET (L x W x H) | 6 3/8" x 3 1/4" x 1 1/2" |
| MAGNETIC FORCE | 2650 lb |
| MOTOR POWER | 1050W |
| TOTAL POWER | 1100W |
| SPEED RPM (No Load) | 700RPM |
| SPINDLE | 3/4" Weldon |
| COOLANT SYSTEM | Gravity Oil Fed |
| WARRANTY | 1 Year |



The new HMT RTQ40 is a low profile Magnet drill for tight access applications, being designed to fit into any space greater than 7 1/4". Suitable for use with any standard broaching cutters while optimised to work with the high-performance CarbideMax 40 cutters.

- Ratchet drive can be mounted on either side of the machine.
- Powerful motor and magnet gives excellent stability.
- Quick-change 3/4" arbor for all standard broaching cutters

Each machine comes in a plastic case with hex keys, restraint strap., ratchet, and removable coolant system

IDEAL FOR TIGHT ACCESS APPLICATIONS

| Part No | Contents |
|--------------|---|
| 803084-110US | HMT RTQ40 Low Profile Magnetic Drill 110V |

OverReach Swivel System

The HMT OverReach Swivel system extends the reach of the fixed base unit. An adjustable arm mounted to the magnetic base allows magnet drills to be positioned up to 11 3/4" from the fixed unit giving greater flexibility and overcoming otherwise impractical or impossible drilling challenges.

Technical Specifications

| | |
|----------------------|--|
| CUTTER CAPACITY | 1 3/16" |
| PLATE THICKNESS | 3/4" |
| PLATE AREA | 15 3/4" x 5 1/2" |
| WEIGHT | 27.8 lb |
| TRAVEL | 11 3/4" |
| MAGNET POWER | 2430 lb |
| MAGNET DIMENSIONS | 4 9/16" x 4 9/16" |
| MAX WEIGHT SUPPORTED | 26 lb |
| USE WITH | V35, MAX30, MAX40V Magnet Drills |
| MINIMUM BASE | 3/8" thick, clean, flat, paint & rust free |
| MATERIAL REQUIRED | |



CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

UK Built

861020-110US HMT OverReach Magnet Base Clamp with Slide Plate, 110 Volt

Cut more holes, more quickly, for longer with CARBIDEMAX ULTIMATE VALUE FOR MONEY

CarbideMax TCT Broach cutters by Holemaker Technology are a new generation of broach cutter proven to more than halve the cost of hole broaching compared with traditional HSS cutters.

CarbideMax TCT cutters also offer a life expectancy up to 10x that of standard HSS cutters and cutting speeds up to 64% faster thanks to their individually brazed Tungsten Carbide cutting teeth and elaborate tool geometry.

This specialist construction also results in quieter, easier drilling, with smooth, accurate holes and chatter free performance throughout the cut.

The CarbideMax range - stronger and faster for longer, the ultimate value for money.



A NEW GENERATION OF LONG-LIFE CUTTER

UP TO 10X LONGER LIFE

Tungsten Carbide is one of the hardest materials available for use in cutting tools.

The HMT CarbideMax range uses Premium Grade Sandvik Tungsten Carbide teeth meaning that cutters are capable of drilling the toughest steels whilst maintaining strength & cutting surface for up to 10x longer than traditional HSS cutters.

This leads to greater efficiency and fewer stops as fewer tools are reordered and replaced.

UP TO 64% FASTER CUTS

The elaborate geometry of CarbideMax broach cutters means the teeth of the cutter do all the work.

This reduces strain on the tool body and means that a strong but thin flexible alloy can be used for its construction.

Thinner walls means CarbideMax tools need to remove less material from the work piece resulting in a faster cut and quieter, easier drilling.



Standard Weldon Shank suitable for all magnet drills



Tool body made from flexible steel alloy which results in fewer breakages & faster cut



Highest performance teeth suitable for cutting the hardest steels

Sizes available

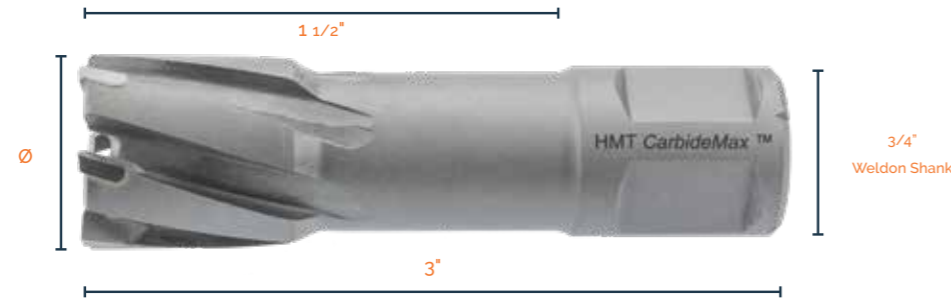
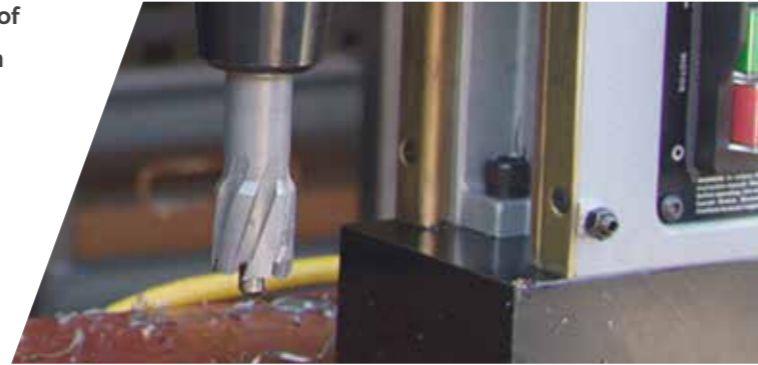
| | Extreme Drilling Depth | | | | Ultra Large Diameter | | | |
|---|------------------------|----------------|------------|-----------------|----------------------|-----------|-------|-------|
| Ø | 7/16" - 2" | 7/16" - 2 3/8" | 9/16" - 2" | 9/16" - 2 7/16" | 3/4" - 2" | 3/4" - 2" | to 6" | to 6" |
| L | 1 1/2" | 2" | 3" | 4" | 6" | 8" | 2" | 4" |

Features & Benefits - The world's largest range of in-stock & available TCT products

- Up to 10x the life of standard HSS cutters
- Up to 64% faster than HSS cutters
- Premium Sandvik Tungsten Carbide teeth
- Fits all standard 3/4" Weldon shanks
- Works well in Stainless Steel & Cast Iron
- Elaborate tool geometry for a smooth cut
- More than halves the cost of hole broaching
- Reduced thickness tool made from flexible alloy steel results in fewer breakages

The CarbideMax™ 40 Series will broach up to 1 1/2" thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance

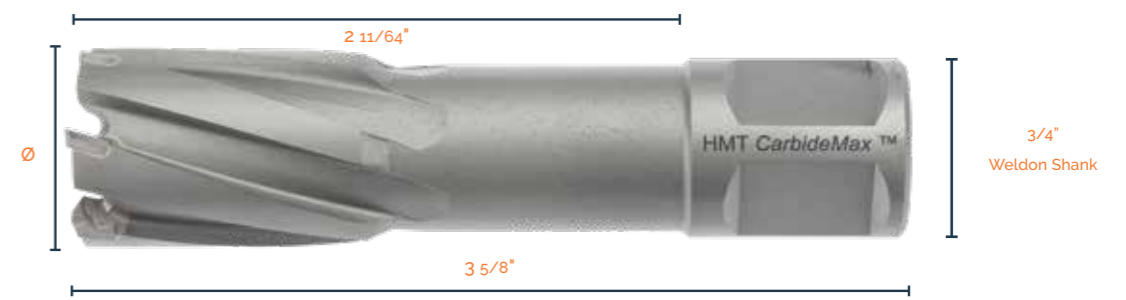


| Part No | D Ø |
|-------------|---------|
| 109015-0030 | 1/2" |
| 109015-0050 | 9/16" |
| 109015-0060 | 5/8" |
| 109015-0080 | 11/16" |
| 109015-0090 | 3/4" |
| 109015-0110 | 13/16" |
| 109015-0120 | 7/8" |
| 109015-0130 | 15/16" |
| 109015-0140 | 1" |
| 109015-0150 | 1-1/16" |
| 109015-0160 | 1-1/8" |
| 109015-0170 | 1-3/16" |
| 109015-0180 | 1-1/4" |

| Part No | D Ø |
|-------------|----------|
| 109015-0190 | 1-5/16" |
| 109015-0200 | 1-3/8" |
| 109015-0210 | 1-7/16" |
| 109015-0220 | 1-1/2" |
| 109015-0230 | 1-9/16" |
| 109015-0240 | 1-5/8" |
| 109015-0250 | 1-11/16" |
| 109015-0260 | 1-3/4" |
| 109015-0270 | 1-13/16" |
| 109015-0280 | 1-7/8" |
| 109015-0290 | 1-15/16" |
| 109015-0300 | 2" |

The CarbideMax™ 55 Series will broach up to 2" thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance



| Part No | Diameter | Tap Size | Shank Size |
|-------------|----------|----------|-------------|
| 109020-0010 | 7/16" | 1/2-13 | 3/4" Weldon |
| 109020-0030 | 1/2" | | 3/4" Weldon |
| 109020-0040 | 17/32" | 5/8-11 | 3/4" Weldon |
| 109020-0050 | 9/16" | | 3/4" Weldon |
| 109020-0060 | 5/8" | | 3/4" Weldon |
| 109020-0070 | 21/32" | 3/4-10 | 3/4" Weldon |
| 109020-0080 | 11/16" | | 3/4" Weldon |
| 109020-0090 | 3/4" | | 3/4" Weldon |
| 109020-0100 | 49/64" | 7/8-9 | 3/4" Weldon |
| 109020-0110 | 13/16" | | 3/4" Weldon |
| 109020-0120 | 7/8" | 1-8 | 3/4" Weldon |
| 109020-0130 | 15/16" | | 3/4" Weldon |
| 109020-0140 | 1" | | 3/4" Weldon |
| 109020-0150 | 1-1/16" | | 3/4" Weldon |
| 109020-0160 | 1-1/8" | | 3/4" Weldon |
| 109020-0170 | 1-3/16" | | 3/4" Weldon |
| 109020-0180 | 1-1/4" | | 3/4" Weldon |
| 109020-0190 | 1-5/16" | | 3/4" Weldon |

| Part No | Diameter | Shank Size |
|-------------|----------|-------------|
| 109020-0200 | 1-3/8" | 3/4" Weldon |
| 109020-0210 | 1-7/16" | 3/4" Weldon |
| 109020-0220 | 1-1/2" | 3/4" Weldon |
| 109020-0230 | 1-9/16" | 3/4" Weldon |
| 109020-0240 | 1-5/8" | 3/4" Weldon |
| 109020-0250 | 1-11/16" | 3/4" Weldon |
| 109020-0260 | 1-3/4" | 3/4" Weldon |
| 109020-0270 | 1-13/16" | 3/4" Weldon |
| 109020-0280 | 1-7/8" | 3/4" Weldon |
| 109020-0290 | 1-15/16" | 3/4" Weldon |
| 109020-0300 | 2" | 3/4" Weldon |
| 109020-0310 | 2-1/16" | 3/4" Weldon |
| 109020-0320 | 2-1/8" | 3/4" Weldon |
| 109020-0330 | 2-3/16" | 3/4" Weldon |
| 109020-0340 | 2-1/4" | 3/4" Weldon |
| 109020-0350 | 2-5/16" | 3/4" Weldon |
| 109020-0360 | 2-3/8" | 3/4" Weldon |
| 109020-0370 | 2-7/16" | 3/4" Weldon |

Pilot Pins



| For 1/2 - 5/8" cutters | Dia Ø | Length | Unit of sale |
|------------------------|-------|----------|--------------|
| 108030P-0170 | 1/4" | 3-35/64" | Pack 2 |
| 108030P-0170-P10 | 1/4" | 3-35/64" | Pack 10 |
| For 11/16 - 2" cutters | Dia Ø | Length | Unit of sale |
| 108030P-0600 | 5/16" | 3-35/64" | Pack 2 |
| 108030P-0600-P10 | 5/16" | 3-35/64" | Pack 10 |

Kitted Sets

| Part No | Contents |
|-------------|---|
| 109015-SET1 | 9/16, 11/16, 13/16" + 2 Pilot Pins |
| 109015-SET2 | 9/16, 11/16, 13/16, 15/16, 1-1/16" + 2 Pilot Pins |



Pilot Pins



| For 1/2" - 5/8" cutters | Dia Ø | Length | Unit of sale |
|------------------------------|-------|---------|--------------|
| 108020P-0170 | 1/4" | 4-1/16" | Pack 2 |
| 108020P-0170-P10 | 1/4" | 4-1/16" | Pack 10 |
| For 11/16" - 2 7/16" cutters | Dia Ø | Length | Unit of sale |
| 108020P-0600 | 5/16" | 4-1/16" | Pack 2 |
| 108020P-0600-P10 | 5/16" | 4-1/16" | Pack 10 |

Kitted Sets

| Part No | Set Contains |
|-------------|---|
| 109020-SET1 | 9/16, 11/16, 13/16, 15/16, 1-1/16" + Pilots |
| 109020-SET2 | 1/2, 5/8, 3/4, 7/8, 1" Cutters + 2 Pilots |
| 109020-TSET | 7/16, 17/32, 21/32, 49/64, 7/8" Tap Size Cutters + 2 Pilots |



WELDON SHANK

CarbideMax 110 Broach Cutter

1 1/4" WELDON SHANK

CarbideMax XL55 Broach Cutter

The CarbideMax™ 110 Series will broach up to 4" thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance



Ultra large diameter drilling with CarbideMax XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL™ range offers cutters from 2 7/16" right up to 6" diameter with 2" cutting depth as standard.

These high quality TCT cutters have a reinforced 1 1/4" diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 1 1/4" shank for use with standard 3/4" weldon shank magnet drills.



| Part No | Diameter | Shank Size |
|-------------|----------|-------------|
| 109040-0010 | 9/16" | 3/4" Weldon |
| 109040-0020 | 5/8" | 3/4" Weldon |
| 109040-0030 | 11/16" | 3/4" Weldon |
| 109040-0040 | 3/4" | 3/4" Weldon |
| 109040-0050 | 13/16" | 3/4" Weldon |
| 109040-0060 | 7/8" | 3/4" Weldon |
| 109040-0070 | 15/16" | 3/4" Weldon |
| 109040-0080 | 1" | 3/4" Weldon |
| 109040-0090 | 1-1/16" | 3/4" Weldon |
| 109040-0100 | 1-1/8" | 3/4" Weldon |
| 109040-0110 | 1-3/16" | 3/4" Weldon |
| 109040-0120 | 1-1/4" | 3/4" Weldon |
| 109040-0130 | 1-5/16" | 3/4" Weldon |
| 109040-0140 | 1-3/8" | 3/4" Weldon |
| 109040-0150 | 1-7/16" | 3/4" Weldon |
| 109040-0160 | 1-1/2" | 3/4" Weldon |

| Part No | Diameter | Shank Size |
|-------------|----------|-------------|
| 109040-0170 | 1-9/16" | 3/4" Weldon |
| 109040-0180 | 1-5/8" | 3/4" Weldon |
| 109040-0190 | 1-11/16" | 3/4" Weldon |
| 109040-0200 | 1-3/4" | 3/4" Weldon |
| 109040-0210 | 1-13/16" | 3/4" Weldon |
| 109040-0220 | 1-7/8" | 3/4" Weldon |
| 109040-0230 | 1-15/16" | 3/4" Weldon |
| 109040-0240 | 2" | 3/4" Weldon |
| 109040-0250 | 2-1/16" | 3/4" Weldon |
| 109040-0260 | 2-1/8" | 3/4" Weldon |
| 109040-0270 | 2-3/16" | 3/4" Weldon |
| 109040-0280 | 2-1/4" | 3/4" Weldon |
| 109040-0290 | 2-5/16" | 3/4" Weldon |
| 109040-0300 | 2-3/8" | 3/4" Weldon |
| 109040-0310 | 2-7/16" | 3/4" Weldon |

| Part No | D Ø | Shank Size |
|-------------|----------|---------------|
| 109020-0370 | 2-7/16" | 1 1/4" Weldon |
| 109020-0380 | 2-1/2" | 1 1/4" Weldon |
| 109020-0390 | 2-9/16" | 1 1/4" Weldon |
| 109020-0400 | 2-5/8" | 1 1/4" Weldon |
| 109020-0410 | 2-11/16" | 1 1/4" Weldon |
| 109020-0420 | 2-3/4" | 1 1/4" Weldon |
| 109020-0430 | 2-13/16" | 1 1/4" Weldon |
| 109020-0440 | 2-7/8" | 1 1/4" Weldon |
| 109020-0450 | 2-15/16" | 1 1/4" Weldon |
| 109020-0460 | 3" | 1 1/4" Weldon |
| 109020-0470 | 3-1/16" | 1 1/4" Weldon |
| 109020-0480 | 3-1/8" | 1 1/4" Weldon |
| 109020-0490 | 3-3/16" | 1 1/4" Weldon |
| 109020-0500 | 3-1/4" | 1 1/4" Weldon |
| 109020-0510 | 3-5/16" | 1 1/4" Weldon |
| 109020-0520 | 3-3/8" | 1 1/4" Weldon |
| 109020-0530 | 3-7/16" | 1 1/4" Weldon |
| 109020-0540 | 3-1/2" | 1 1/4" Weldon |
| 109020-0550 | 3-9/16" | 1 1/4" Weldon |
| 109020-0560 | 3-5/8" | 1 1/4" Weldon |

| Part No | D Ø | Shank Size |
|-------------|----------|---------------|
| 109020-0570 | 3-11/16" | 1 1/4" Weldon |
| 109020-0580 | 3-3/4" | 1 1/4" Weldon |
| 109020-0590 | 3-13/16" | 1 1/4" Weldon |
| 109020-0600 | 3-7/8" | 1 1/4" Weldon |
| 109020-0610 | 3-15/16" | 1 1/4" Weldon |
| 109020-0620 | 4" | 1 1/4" Weldon |
| 109020-0630 | 4-1/8" | 1 1/4" Weldon |
| 109020-0640 | 4-3/16" | 1 1/4" Weldon |
| 109020-0650 | 4-5/16" | 1 1/4" Weldon |
| 109020-0660 | 4-3/8" | 1 1/4" Weldon |
| 109020-0670 | 4-1/2" | 1 1/4" Weldon |
| 109020-0680 | 4-5/8" | 1 1/4" Weldon |
| 109020-0690 | 4-3/4" | 1 1/4" Weldon |
| 109020-0700 | 4-13/16" | 1 1/4" Weldon |
| 109020-0710 | 4-7/8" | 1 1/4" Weldon |
| 109020-0720 | 5" | 1 1/4" Weldon |
| 109020-0730 | 5-5/16" | 1 1/4" Weldon |
| 109020-0740 | 5-3/8" | 1 1/4" Weldon |
| 109020-0750 | 5-13/16" | 1 1/4" Weldon |
| 109020-0760 | 6" | 1 1/4" Weldon |

Pilot Pins

| For 9/16" - 5/8" cutters | Dia Ø | Length | Unit of sale |
|------------------------------|-------|---------|--------------|
| 108040P-0171 | 1/4" | 6-2/16" | Pack 2 |
| For 11/16" - 2 7/16" cutters | Dia Ø | Length | Unit of sale |
| 108040P-0600 | 5/16" | 6-2/16" | Pack 2 |

1 1/4" to 3/4" Weldon Shank Adapter & Pilot

Adapts 1 1/4" Shank XL55 & XL110 cutters to 3/4" standard Magnet Drill fitting; includes pilots

| Part No | Details |
|-----------------|--|
| 103091-1932-55 | 3/4" Male to 1 1/4" Female Weldon Adapter + Pilot for 2" cutters |
| 103091-1932-110 | 3/4" Male to 1 1/4" Female Weldon Adapter + Pilot for 4" cutters |



1 1/4" WELDON SHANK

CarbideMax XL110 Broach Cutter

Ultra large diameter drilling with CarbideMax XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL™ range offers cutters from 2 1/2" right up to 6" diameter with 4" cutting depth as standard.

These high quality TCT cutters have a reinforced 1 1/4" diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 1 1/4" shank for use with standard 3/4" weldon shank magnet drills.



| Part No | D Ø | Shank Size |
|-------------|----------|---------------|
| 109040-0320 | 2-1/2" | 1 1/4" Weldon |
| 109040-0330 | 2-9/16" | 1 1/4" Weldon |
| 109040-0340 | 2-5/8" | 1 1/4" Weldon |
| 109040-0350 | 2-11/16" | 1 1/4" Weldon |
| 109040-0360 | 2-3/4" | 1 1/4" Weldon |
| 109040-0370 | 2-13/16" | 1 1/4" Weldon |
| 109040-0380 | 2-7/8" | 1 1/4" Weldon |
| 109040-0390 | 2-15/16" | 1 1/4" Weldon |
| 109040-0400 | 3" | 1 1/4" Weldon |
| 109040-0410 | 3-1/16" | 1 1/4" Weldon |
| 109040-0420 | 3-1/8" | 1 1/4" Weldon |
| 109040-0430 | 3-3/16" | 1 1/4" Weldon |
| 109040-0440 | 3-1/4" | 1 1/4" Weldon |
| 109040-0450 | 3-5/16" | 1 1/4" Weldon |
| 109040-0460 | 3-3/8" | 1 1/4" Weldon |
| 109040-0470 | 3-7/16" | 1 1/4" Weldon |
| 109040-0480 | 3-1/2" | 1 1/4" Weldon |
| 109040-0490 | 3-9/16" | 1 1/4" Weldon |
| 109040-0500 | 3-5/8" | 1 1/4" Weldon |

| Part No | D Ø | Shank Size |
|-------------|----------|---------------|
| 109040-0510 | 3-11/16" | 1 1/4" Weldon |
| 109040-0520 | 3-3/4" | 1 1/4" Weldon |
| 109040-0530 | 3-13/16" | 1 1/4" Weldon |
| 109040-0540 | 3-7/8" | 1 1/4" Weldon |
| 109040-0550 | 3-15/16" | 1 1/4" Weldon |
| 109040-0560 | 4" | 1 1/4" Weldon |
| 109040-0570 | 4-1/8" | 1 1/4" Weldon |
| 109040-0580 | 4-3/16" | 1 1/4" Weldon |
| 109040-0590 | 4-5/16" | 1 1/4" Weldon |
| 109040-0600 | 4-3/8" | 1 1/4" Weldon |
| 109040-0610 | 4-1/2" | 1 1/4" Weldon |
| 109040-0620 | 4-5/8" | 1 1/4" Weldon |
| 109040-0630 | 4-3/4" | 1 1/4" Weldon |
| 109040-0640 | 4-13/16" | 1 1/4" Weldon |
| 109040-0650 | 4-7/8" | 1 1/4" Weldon |
| 109040-0660 | 5" | 1 1/4" Weldon |
| 109040-0670 | 5-5-16" | 1 1/4" Weldon |
| 109040-0680 | 5-3/8" | 1 1/4" Weldon |
| 109040-0690 | 5-13/16" | 1 1/4" Weldon |
| 109040-0700 | 6" | 1 1/4" Weldon |

1 1/4" Weldon Shank Morse Taper Arbor & Pilot (Spring loaded for cutter slug ejection)

| Part No | Arbor Size | Shank Size |
|-----------------|---|------------|
| 103013-0323 | MT3 | 1-1/4" |
| 103013-0324 | MT4 | 1-1/4" |
| 108020P-1500 | CarbideMax 55 Pilot Pin, 2 7/16" - 6", Pk 2 | |
| 108040P-1500-2P | CarbideMax 110 2 Piece Pilot Pin 2 1/2" - 6", Pk2 | |



CarbideMax ULTRA Range

HMT have developed a generation of ULTRA cutting tools for use in the most challenging applications.

The specialist ULTRA coating is proven to significantly increase tool life, making ULTRA products the perfect solution in situations requiring high performance durability, prolonged use or machining extremely hard materials.

They are produced from premium grade materials and coated using a range of state of the art, high-temperature surface coatings.



- Use for increased durability
 - Cuts material 5x harder than S275 Structural Steel
 - Use on Wear Plate & Armour Plate
 - Use on Stainless Steel
 - Perfect for use on heavy equipment & machinery
 - Use with BioCut Blue & SpeedLube lubricants
- Ideal for use on HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

Premium, long-life tooling for use in the most challenging applications

Capable of providing a service life in excess of **9X longer than uncoated TCT tools.**



MACHINING WEAR PLATE

The extreme hardness and resistance of wear plate makes machining it extremely challenging. Good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, like the VersaDrive Series, and ample lubrication - BioCut Blue cutting fluid when broaching or Speedlube Aerosol spray when countersinking. Using an incorrect or poorly maintained Magnet drill with unstable drilling operation, poor magnet hold, excessive pressure or inadequate lubrication is likely to result in rapid tool failure.

Even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It not only requires the correct setup but also experienced operators with the time necessary to proceed with caution.

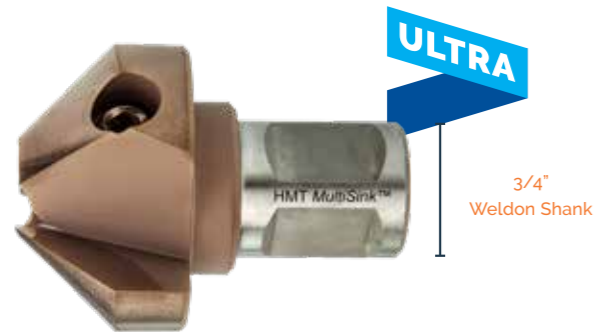
Ultra coated MultiSink for increased wear resistance and long-life performance whilst countersinking the most challenging applications, including materials like Hardox, Inconel and Armor plate.

The MultiSink is a worldwide unique new Combination Countersink Tool designed & developed by HMT for use with Magnetic Drills.



Features & Benefits

- Innovative Combination Countersinking Tool.
- Save Time Completing Countersunk Holes.
- Suitable for holes of 9/16" and above
- For holes <5/8" see 1 1/4" Ultra countersink



Ultra Coated MultiSink

| Part No | D Ø | Point Angle | Shank |
|-------------|--------|-------------|-------------|
| 601058-0010 | 1-1/2" | 82° | 3/4" Weldon |
| 601058-0020 | 2-1/4" | 82° | 3/4" Weldon |



MultiSink Pilots

| Part No | ØD | length |
|-------------|--------|--------|
| 601051-0010 | 9/16" | 2" |
| 601051-0020 | 11/16" | 2" |
| 601051-0030 | 13/16" | 2" |
| 601051-0040 | 15/16" | 2" |

CarbideMax ULTRA 82° Countersink 1 1/4"

Premium countersink with 3X heavy duty tungsten carbide Tips for maximum life in challenging materials. Plus ULTRA high-temperature surface coating to optimise cutting performance. Standard 3/4" Weldon shank for use in all standard magnet drills. Use with a 103013 Morse taper arbor to use in a pillar drill press or radial drill



| Part No | Size |
|-------------|---------------------------------|
| 601038-0010 | 1-1/4" ULTRA Coated Countersink |

CarbideMax Ultra cutters are specifically designed for long-life performance in the toughest broaching jobs on the planet, including Hardox steel.

- Individually brazed, highest quality carbide cutting teeth
- ULTRA coated for optimum performance & lifespan
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance when used correctly



CarbideMax ULTRA 55 - Special sizes available on request

| | Part No | D Ø |
|------|-------------|--------|
| Inch | 109070-0040 | 5/8" |
| | 109070-0050 | 11/16" |
| | 109070-0060 | 3/4" |
| | 109070-0070 | 13/16" |
| | 109070-0080 | 7/8" |
| | 109070-0090 | 15/16" |
| | 109070-0100 | 1" |

| | Part No | D Ø |
|--------|-------------|------|
| Metric | 108070-0160 | 16mm |
| | 108070-0180 | 18mm |
| | 108070-0200 | 20mm |
| | 108070-0220 | 22mm |
| | 108070-0240 | 24mm |
| | 108070-0260 | 26mm |

Kitted Sets

| Part No | Set Contains |
|------------|---|
| 109070-SET | 5 piece set 5/8, 11/16, 3/4, 13/16, 15/16" + 2 pilot pins |

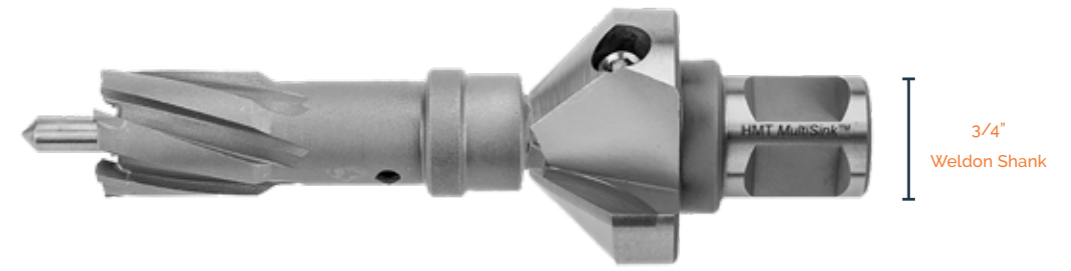
Pilot Pins

| Part No | D Ø | Length | Cutter Size | Qty |
|--------------|-------|---------|--------------|------|
| 108020P-0170 | 1/4" | 4-1/16" | 5/8 - 11/16" | Pk 2 |
| 108020P-0600 | 5/16" | 4-1/16" | 3/4 - 1" | Pk 2 |

The MultiSink is a worldwide unique new Combination Countersink Tool designed and developed by HMT for use with Magnetic Drills.

The tool is designed to combine with the VersaDrive product range to Broach & Countersink, Drill & Countersink, Tap & Countersink or even Drill, Tap & Countersink in one operation - providing huge time-saving benefits.

The MultiSink is available in HSS and Tungsten Carbide Tipped versions. The HSS MultiSink features a GoldMax titanium coating to stop burn-out whilst the TCT version is specifically designed for countersinking Inox and the hardest structural steels.



Features & Benefits

- Innovative Combination Countersinking Tool
- Save Time Completing Countersunk Holes
- Broach & Countersink in one operation
- Drill & Countersink in one operation
- Tap & Countersink in one operation
- Drill-Tap & Countersink in one operation

RECOMMENDED FOR USE WITH:

Magnet Drills

CAN ALSO BE USED WITH:

Pillar Drills
Radial Arm Drills



Piloted Countersink



Broach & Countersink in one operation
5/8" - 1 1/6"



Tap & Countersink in one operation
M16-M24



Drill, Tap & Countersink in one operation
M16-M24



CarbideMax TCT MultiSink

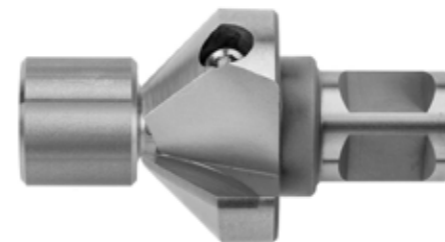
| Part No | D Ø | Ø d2 | Point Angle | Shank |
|-------------|----------|-------|-------------|-------------|
| 601057-0100 | 1-1/2" | 35/64 | 82° | 3/4" Weldon |
| 601057-0200 | 2-11/64" | 35/64 | 82° | 3/4" Weldon |



MultiSink Pilot

For countersinking bolt holes from 9/16" to 15/16" diameter. Use MultiSink with variable speed magnet drill. The speed must be reduced when countersinking.

| Part No | d1 Ø | length |
|-------------|-------|--------|
| 601051-0010 | 9/16 | 2" |
| 601051-0020 | 11/16 | 2" |
| 601051-0030 | 13/16 | 2" |
| 601051-0040 | 15/16 | 2" |



MultiSink Ejector Pilot Pin

For use with VersaDrive HoleCutter

| Part No | d1 Ø | l1 | Unit of sale |
|--------------|------|-------|--------------|
| 101030P-0003 | 1/4 | 5-1/2 | Pack 2 |

Quick Guide

- Operations involving tapping require a Magnet Drill with variable speed & reverse features
- For predrilled holes, the MultiSink should always be used with a pilot to avoid damage
- When used to drill or broach & countersink or for multiple operations eg Drill/Tap/Countersink it is important to use the correct RPM for each separate operation

Watch the video & find more info online



Weldon Shank - Morse Taper Arbor 3/4"



Spring loaded for cutter slug ejection

| Part No | Arbor Size | Shank Size |
|-------------|------------|------------|
| 103013-0192 | MT2 | 3/4" |
| 103013-0193 | MT3 | 3/4" |
| 103013-0194 | MT4 | 3/4" |

Spring Loaded Extension Arbor



Spring Loaded extension arbor for very deep drilling using multiple extension arbors in series. The spring loaded design means only the bottom extension needs to be piloted, with standard cutter pilot pin. Will pass through hole diameters greater than 1-3/8".

| Part No | Extension Length | Shank Size |
|-------------|------------------|------------|
| 103095-1000 | 4" | 3/4" |

1 1/4" to 3/4" Weldon Shank Adapter & Pilot



Adapts 1-1/4" Shank cutters to 3/4" standard Magnet Drill fitting

| Part No | Details |
|-----------------|--|
| 103091-1932-55 | 3/4" Male to 1-1/4" Female Weldon Adapter + Pilot for 2" cutters |
| 103091-1932-110 | 3/4" Male to 1-1/4" Female Weldon Adapter + Pilot for 4" cutters |

Standard Weldon Shank Extension Arbor



- Select appropriate pilot pin from box below
- Will pass through hole diameters greater than 1-3/8"

| Part No | Extension Length | Shank Size |
|-------------|------------------|------------|
| 103090-0500 | 2" | 3/4" |
| 103090-0750 | 3" | 3/4" |
| 103090-1000 | 4" | 3/4" |

Replacement Grub Screws



| Part No | Thread Size | Hex Key Size | Unit of sale |
|-------------|-------------|--------------|--------------|
| 103060-0606 | M6 x 6 | 1/8" | Pack 10 |
| 103060-0808 | M8 x 8 | 5/32" | Pack 10 |
| 103060-1010 | M10 x 10 | 13/64" | Pack 10 |
| 103060-1212 | M12 x 12 | 15/64" | Pack 10 |

1-1/4" Weldon Shank Morse Taper Arbor & Pilot



Spring loaded for cutter slug ejection

| Part No | Arbor Size | Shank Size |
|-------------|------------|------------|
| 103013-0323 | MT3 | 1-1/4" |
| 103013-0324 | MT4 | 1-1/4" |

Morse Taper Sleeve



Morse Taper sleeve reducers have a smaller internal taper size than the machine (drive) end, to allow a smaller morse taper to be fitted. Hardened and ground high precision specification.

| Part No | Size |
|------------|-------------------------|
| 103615-R21 | MT2 outside, MT1 Inside |
| 103615-R32 | MT3 outside, MT2 Inside |
| 103615-R43 | MT4 outside, MT3 Inside |

Morse Taper Drifts



Tapered steel drifts for simple removal of Morse Taper arbors, drill bits and tooling from MT2, MT3 or MT4 machine spindles

| Part No | Suits |
|-------------|-----------|
| 103012-0002 | MT1 & MT2 |
| 103012-0003 | MT3 |
| 103012-0004 | MT4 |

Magnetic Swarf Lifter



| Part No | Total Length | Magnet Length |
|-------------|--------------|---------------|
| 103011-0001 | 15-3/4" | 7-3/32" |

Morse Taper Extension



Morse Taper Extensions have an Internal and an External Morse Taper and are used to extend the reach of Magnet Drill Arbors and enable the use of tooling with different size shanks. Hardened and ground high precision specification.

| Part No | Size |
|-------------|-------------------------|
| 103616-E32 | MT3 outside, MT2 inside |
| 103616-E33 | MT3 outside, MT3 inside |
| 103616-E34 | MT3 outside, MT4 inside |
| 103616E-E43 | MT4 outside, MT3 inside |
| 103616-E44 | MT4 outside, MT4 inside |

Magnet Drill Chuck & Adapter



| Part No | Description | Fitting Type |
|---------|---------------|--------------|
| 103017 | Chuck Adapter | 3/4" |
| 103070 | Keyed Chuck | B16 |

Weldon Quick Change Morse Taper Magnet Drill Arbor



Weldon Morse Taper Arbor with a smooth action, rotating collar and push-release action to allow rapid tool or adapter loading and unloading without the need for fiddly, time consuming grub screws or Allen keys. Takes 3/4" Magnet Drill Weldon fitting.

| Part No | Description |
|-------------|------------------------|
| 103016-0192 | MT2 Quick change arbor |
| 103016-0193 | MT3 Quick change arbor |

Metal Cutting Lubricants

SpeedLube™ is a high performance foaming lubricant suitable for a wide variety of metal drilling applications across a range of materials including stainless steel.

Aerosol propellant ensures the lubricant foams on contact to ensure maximum tool coverage and heat dissipation. Easy one-handed application provides fast, efficient lubricant coverage and minimises the amount of applications needed during the drilling process. Unique 360° valve which enables Speedlube to be sprayed from all angles.

| Part No | Aerosol Size | Unit of Sale |
|-----------------|--------------|--------------|
| 701010-0002 | 17.5oz | Each |
| 701010-0002-P12 | 17.5oz | Pack of 12 |

SpeedLube™ Lubricant Spray



BioCut Blue is an ultra high-performance cutting fluid designed for metal fabrication broaching, cutting, and drilling tasks

- Water-soluble fluid supplied ready-for-use.
- Inherently bio-degradable, can be 100% removed with water.
- Synthetic based, chlorine free, with zero mineral oils.
- No adverse affects for welding and galvanising.
- Excellent performance on Stainless Steel & Hardox type materials

| Part No | Bottle Size | Unit of Sale |
|-----------------|-------------|--------------|
| 704010-0001 | 1 Gallon | Each |
| 704010-0001-P4 | 1 Gallon | Box of 4 |
| 704010-0002 | 17oz Bottle | Each |
| 704010-0002-P20 | 17oz Bottle | Box of 20 |

BioCut Blue Neat Broaching Oil



BioCut Drilling & BioCut cutting paste is specifically formulated for superb performance when used with HMT Impact wrench cutting tools. Extreme pressure concentration provides accurate hole lubrication. Excellent general purpose paste lubricant when drilling, tapping, taps, countersinks, reamers and broach cutters. Chlorine Free for safer use. Suitable for use with all grades of steel including Stainless Steel & Aluminium

| Part No | Size | Unit of Sale |
|-----------------|-----------|--------------|
| 704030-0001 | 0.5lb Tin | Each |
| 704030-0001-P16 | 0.5lb Tin | Pack of 16 |

BioCut Paste - Drilling & Tapping Paste



VersaDrive DrillSink Tool

The VersaDrive Drillsink is an innovative combined drilling & countersinking tool to save metalworkers time & increase hole accuracy by drilling & then countersinking fixing holes in one operation.

This combination tool provides perfect countersinking accuracy every time by locating the drilled hole in perfect alignment to the countersink. This helps prevent tool chatter and blunting commonly found with standard countersinks.

VersaDrive DrillSinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

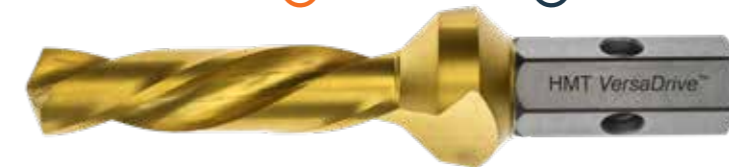
- Drill & Countersink in one easy operation
- Perfect concentricity creates the perfect Countersink
- Ground flutes for high accuracy and long life
- High-Grade tool steel
- GoldMax low-friction titanium coating to stop burn-out
- Prevents the chattering of standard countersinks

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers
(up to 5/8")
SDS+ Adapter
Extension Arbor



ADAPTERS

Use with any
standard drill
chuck

Magnet Drill Adapter
111035-01
Page 13

Impact Wrench Adapter
111130-012A
Page 12

SDS+ Adapter
112010-01
Page 14












Extension - 12"
111015-300
Page 14



| |  |  |  |  |  |
|---------------------|---|---|---|--|---|
| Cutter Diameter | Structural Steel <500Nm (S275, S355) 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 | Cast Iron-Grey | Aluminium |
| Diameter Ø | RPM Range | RPM Range | RPM Range | RPM Range | RPM Range |
| 7/16" - 3/4" | 1265-850 | 850-580 | 530-350 | 925-615 | 2200-1560 |
| 49/64" - 1" | 840-650 | 550-410 | 345-255 | 610-440 | 1480-1140 |
| 1 1/16" - 1 1/4" | 545-460 | 410-315 | 250-200 | 430-335 | 1125-890 |
| 1 5/16" - 1 9/16" | 460-395 | 315-265 | 195-170 | 330-280 | 885-730 |
| 1 5/8" - 1 13/16" | 405-340 | 265-250 | 165-140 | 280-235 | 720-620 |
| 1 7/8" - 2 1/16" | 335-300 | 250-195 | 135-120 | 235-205 | 615-545 |
| 2 1/8" - 2 3/8" | 295-265 | 195-180 | 120-105 | 200-180 | 540-475 |
| 2 7/16" - 2 3/4" | 260-230 | 180-140 | 105-90 | 180-160 | 475-415 |
| 2 13/16" - 3 3/16" | 230-200 | 140-130 | 90-70 | 160-145 | 410-365 |
| 3 1/4" - 3 3/4" | 195-180 | 130-115 | 70-65 | 140-125 | 350-325 |
| 3 13/16" - 3 15/16" | 180-160 | 115-100 | 60-55 | 125-110 | 320-280 |
| 4" - 4 3/8" | 160-140 | 100-90 | 55-50 | 110-100 | 280-250 |
| 4 1/2" - 4 7/8" | 140-120 | 90-85 | 50-48 | 100-90 | 250-235 |
| 5" - 5 3/8" | 120-110 | 85-75 | 48-45 | 90-80 | 230-205 |
| 5 13/16" - 6" | 110-100 | 70-65 | 45-40 | 80-75 | 205-190 |

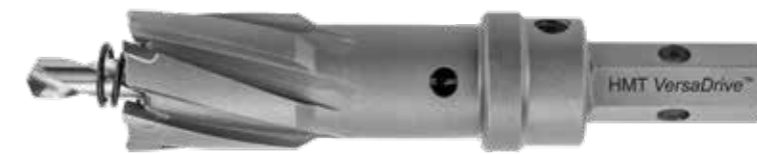
Best Practice Advice

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

| | | | |
|--|--|---|---|
| 1  | Centre punch or pilot drill the surface for accurate hole start. | 7  | Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time. |
| 2  | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage. | 8  | Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling. |
| 3  | Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the start of the cut. | 9  | For drilling holes in steel thicker than 1" it is recommended to ventilate the hole frequently to clear the swarf. |
| 4  | Avoid lateral movement or tilting which can cause damage to the cutter. | 10  | When drilling multiple layers of steel CarbideMax Stack Laminate cutters are designed with a special tooth geometry to avoid stuck slugs. |
| 5  | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. | 11  | Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task. |
| 6  | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant. | | |

Quick Guide











| | |
|----------|--|
| 1 | Adjust RPM to match the material hardness |
| 2 | Slowly and cautiously begin cutting before increasing pressure |
| 3 | For best results and swarf clearance always select a cutter longer than the material thickness |
| 4 | For hard materials and wear plates like Hardox use Ultra coated cutters. See page 63 |



| |  |  |  |  |  |  |  |  |  |
|-------------------|---|---|---|---|---|---|---|---|---|
| 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 |
| 9/16" - 11/16" | 1350-850 | 840-585 | 500-360 | 2210-1575 | 900-625 | 780-705 | 1350-850 | 900-640 | 1495-1010 |
| 3/4" - 1" | 850-625 | 580-420 | 350-250 | 1575-1125 | 600-455 | 700-520 | 850-625 | 620-450 | 990-895 |
| 1 1/16" - 1 3/16" | 620-500 | 415-325 | 240-195 | 1080-885 | 435-345 | 500-405 | 620-500 | 440-345 | 895-850 |
| 1 1/4" - 1 9/16" | 480-410 | 320-275 | 195-160 | 875-740 | 330-285 | 400-330 | 480-410 | 345-280 | 850-740 |
| 1 5/8" - 1 13/16" | 390-340 | 270-220 | 160-145 | 730-620 | 285-240 | 315-275 | 390-340 | 175-235 | 740-610 |
| 1 7/8" - 2 1/16" | 335-300 | 220-180 | 140-120 | 615-545 | 235-215 | 275-245 | 335-300 | 235-215 | 600-505 |
| 2 5/32" - 2 3/8" | 295-260 | 180-165 | 115-100 | 525-485 | 210-180 | 240-215 | 295-260 | 210-185 | 500-460 |
| 2 9/16" - 2 3/4" | 260-225 | 165-155 | 100-90 | 475-415 | 180-160 | 205-185 | 260-225 | 180-160 | 455-400 |

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

Quick Guide

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



| Impact Torque Ft Lbs | | | Nm | | Revolutions per minute (Rotary) | | | | | | |
|-------------------------|-------------------|-----------------|-------------------|-------------------|---------------------------------|-------------------------|--------------------------|----------------------|-------|------------------|-----------|
| Impact Torque | | | Impact Torque | | Impact Torque | | | | | | |
| Reamer Diameter | <1/2" Thick Steel | <1" Thick Steel | <12mm Thick Steel | <25mm Thick Steel | Reamer Diameter | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Brass | Cast Iron (Grey) | Aluminium |
| Diameter Ø | Ft Lb Torque | | Nm Torque | | Diameter Ø | RPM Range | | | | | |
| 8 mm | 160 | 290 | 200 | 380 | 8 mm | 940 | 540 | 410 | 1020 | 550 | 1365 |
| 10 mm | 175 | 300 | 220 | 400 | 10 mm | 900 | 510 | 380 | 1005 | 530 | 1290 |
| 12 mm | 185 | 305 | 280 | 420 | 12 mm | 875 | 490 | 370 | 995 | 520 | 1200 |
| 1/2" | 205 | 310 | 300 | 445 | 1/2" | 875 | 490 | 370 | 520 | 510 | 1185 |
| 14 mm | 220 | 330 | 320 | 480 | 14 mm | 690 | 360 | 305 | 700 | 500 | 1100 |
| 9/16" | 235 | 355 | 330 | 490 | 9/16" | 690 | 360 | 305 | 450 | 450 | 1025 |
| 5/8" | 250 | 375 | 335 | 505 | 5/8" | 640 | 335 | 225 | 340 | 340 | 975 |
| 16 mm | 260 | 390 | 340 | 510 | 16 mm | 640 | 335 | 225 | 660 | 340 | 920 |
| 11/16" | 265 | 400 | 350 | 525 | 11/16" | 535 | 290 | 210 | 305 | 305 | 860 |
| 18 mm | 270 | 410 | 360 | 540 | 18 mm | 535 | 290 | 210 | 550 | 305 | 800 |
| 3/4" | 280 | 420 | 370 | 550 | 3/4" | 490 | 230 | 195 | 250 | 280 | 745 |
| 20 mm | 285 | 425 | 380 | 570 | 20 mm | 490 | 230 | 195 | 510 | 250 | 745 |
| 22 mm | 300 | 435 | 400 | 600 | 22 mm | 460 | 210 | 180 | 470 | 235 | 690 |
| 7/8" | 310 | 440 | 425 | 630 | 7/8" | 460 | 210 | 180 | 235 | 235 | 675 |
| 15/16" | 380 | 575 | 460 | 695 | 15/16" | 360 | 150 | 140 | 215 | 215 | 540 |
| 24 mm | 385 | 600 | 520 | 780 | 24 mm | 360 | 150 | 140 | 430 | 215 | 490 |
| 1" | 390 | 620 | 530 | 805 | 1" | 310 | 140 | 135 | 200 | 200 | 410 |
| 26 mm | 405 | 640 | 545 | 840 | 26 mm | 310 | 140 | 135 | 375 | 200 | 400 |
| 1-1/16" | 440 | 660 | 575 | 875 | 1-1/16" | 295 | 130 | 125 | 190 | 385 | 380 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

| | | | |
|---|--|---|--|
| 1 | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage | 4 | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. |
| 2 | Apply firm, steady feed pressure throughout the cut | 5 | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant |
| 3 | Avoid lateral movement or tilting which can cause damage to the tool | 6 | When drilling into box section ensure the tip of the tool is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool. |
| 7 | Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive Reamer. | | |

Quick Guide

| | |
|---|---|
| 1 | For fastest performance use on impact wrenches & impact drivers |
| 2 | Excellent life and performance when used with rotary pistol drills or drill presses |
| 3 | Suitable for stainless and harder materials if used at low RPM |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life |



| Inch Impact Torque Ft Lbs | | Revolutions per minute (Rotary) | | | | | | |
|------------------------------|---------------|---------------------------------|--------------------------|----------------------|-----------|------------------|-----------|----------|
| Impact Torque | | Impact Torque | | | | | | |
| Step Drill Diameter | Impact Torque | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Aluminium | Cast Iron (Grey) | Plastics | |
| Diameter Ø | Ft Lbs Torque | Diameter Ø | RPM Range | RPM Range | RPM Range | RPM Range | RPM Range | |
| 3/16-1/2" | 270-380 | 3/16-1/2" | 3100-1200 | 2000-740 | 1000-380 | 3100-1200 | 1300-450 | 1800-650 |
| 3/16-7/8" | 440-540 | 3/16-7/8" | 597-430 | 390-270 | 200-145 | 600-440 | 245-180 | 380-275 |
| 1/4-1-3/8" | 540-660 | 1/4-1-3/8" | 420-330 | 260-215 | 140-110 | 420-330 | 175-135 | 275-180 |

**Metric Impact Torque
Nm**

| Impact Torque | | Revolutions per minute (Rotary) | | | | | | |
|---------------------|---------------|---------------------------------|--------------------------|----------------------|-----------|------------------|-----------|----------|
| Impact Torque | | Impact Torque | | | | | | |
| Step Drill Diameter | Impact Torque | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Aluminium | Cast Iron (Grey) | Plastics | |
| Diameter Ø | Nm Torque | Diameter Ø | RPM Range | RPM Range | RPM Range | RPM Range | RPM Range | |
| 3-12 mm | 200-280 | 3-12 mm | 3100-1200 | 2000-740 | 1000-380 | 3100-1200 | 1300-450 | 1800-650 |
| 14-22 mm | 330-400 | 14-22 mm | 597-430 | 390-270 | 200-145 | 600-440 | 245-180 | 380-275 |
| 24-30 mm | 400-485 | 24-30 mm | 420-330 | 260-215 | 140-110 | 420-330 | 175-135 | 275-180 |
| 32-40 mm | 610-750 | 32-40 mm | 260-230 | 160-145 | 85-75 | 260-230 | 95-85 | 150-140 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

| | | | |
|---|--|---|--|
| 1 | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage | 4 | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. |
| 2 | Apply firm, steady feed pressure throughout the cut | 5 | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant |
| 3 | Avoid lateral movement or tilting which can cause damage to the tool | 6 | When drilling into box section ensure the tip of the Step-Drill is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool. |

Quick Guide

| | |
|---|---|
| 1 | For fastest performance use on impact wrenches & impact drivers |
| 2 | Excellent life and performance when used with rotary pistol drills or drill presses |
| 3 | Suitable for stainless and harder materials if used at low RPM |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life |



Impact Torque Ft Lbs

| Diameter Ø | Impact Torque | | |
|------------|------------------|------------------|----------------|
| | 1/4" Thick Steel | 1/2" Thick Steel | 1" Thick Steel |
| 3/16" | 89 | 111 | 163 |
| #7 | 93 | 115 | 178 |
| 7/32" | 100 | 119 | 193 |
| 6 mm | 104 | 126 | 207 |
| 1/4" | 111 | 133 | 215 |
| 7 mm | 119 | 144 | 222 |
| 9/32" | 130 | 163 | 237 |
| 5/16" | 141 | 181 | 259 |
| 8 mm | 163 | 200 | 281 |
| 11/32" | 193 | 244 | 348 |
| 9 mm | 219 | 267 | 385 |
| 3/8" | 222 | 278 | 404 |
| 10 mm | 237 | 293 | 430 |
| 11 mm | 241 | 300 | 441 |
| 27/64" | 244 | 304 | 452 |
| 7/16" | 252 | 311 | 463 |
| 12 mm | 259 | 319 | 470 |
| 1/2" | 270 | 326 | 481 |
| 13 mm | 274 | 330 | 500 |
| 14 mm | 278 | 337 | 511 |
| 16 mm | 337 | 430 | 652 |
| 18 mm | 430 | 533 | 830 |
| 20 mm | 507 | 626 | 922 |
| 22 mm | 533 | 667 | 1007 |

Impact Torque Nm

| Diameter Ø | Impact Torque | | |
|------------|-----------------|------------------|------------------|
| | 6mm Thick Steel | 12mm Thick Steel | 25mm Thick Steel |
| 3/16" | 120 | 150 | 220 |
| #7 | 125 | 155 | 240 |
| 7/32" | 135 | 160 | 260 |
| 6 mm | 140 | 170 | 280 |
| 1/4" | 150 | 180 | 290 |
| 7 mm | 160 | 195 | 300 |
| 9/32" | 175 | 220 | 320 |
| 5/16" | 190 | 245 | 350 |
| 8 mm | 220 | 270 | 380 |
| 11/32" | 260 | 330 | 470 |
| 9 mm | 295 | 360 | 520 |
| 3/8" | 300 | 375 | 545 |
| 10 mm | 320 | 395 | 580 |
| 11 mm | 325 | 405 | 595 |
| 27/64" | 330 | 410 | 610 |
| 7/16" | 340 | 420 | 625 |
| 12 mm | 350 | 430 | 635 |
| 1/2" | 365 | 440 | 650 |
| 13 mm | 370 | 445 | 675 |
| 14 mm | 375 | 455 | 690 |
| 16 mm | 455 | 580 | 880 |
| 18 mm | 580 | 720 | 1120 |
| 20 mm | 685 | 845 | 1245 |
| 22 mm | 720 | 900 | 1360 |

Revolutions per minute (Rotary)

| Material | RPM Range | | | | | | |
|----------|-------------------------|--------------------------|----------------------|-------|------------------|----------|-----------|
| | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Brass | Cast Iron (Grey) | Plastics | Aluminium |
| 32m/Min | 2270 | 1135 | 750 | 2215 | 1290 | 1910 | 3340 |
| 18m/Min | 2250 | 1100 | 745 | 2100 | 1220 | 1800 | 3100 |
| 12m/Min | 2125 | 1095 | 730 | 1980 | 1125 | 1710 | 3020 |
| 32m/Min | 2040 | 1070 | 710 | 1820 | 1045 | 1630 | 2850 |
| 16m/Min | 1945 | 1040 | 680 | 1715 | 940 | 1540 | 2625 |
| 16m/Min | 1780 | 1020 | 625 | 1560 | 810 | 1410 | 2240 |
| 16m/Min | 1710 | 985 | 595 | 1410 | 785 | 1355 | 2110 |
| 16m/Min | 1695 | 915 | 570 | 1355 | 760 | 1290 | 1940 |
| 16m/Min | 1580 | 840 | 550 | 1340 | 725 | 1220 | 1765 |
| 16m/Min | 1390 | 800 | 515 | 1435 | 660 | 1200 | 1660 |
| 16m/Min | 1210 | 750 | 420 | 1130 | 600 | 1040 | 1550 |
| 16m/Min | 1140 | 665 | 400 | 1095 | 590 | 1020 | 1510 |
| 16m/Min | 1030 | 520 | 385 | 1020 | 550 | 990 | 1480 |
| 16m/Min | 980 | 500 | 345 | 960 | 490 | 950 | 1365 |
| 16m/Min | 925 | 480 | 330 | 890 | 465 | 915 | 1320 |
| 16m/Min | 895 | 455 | 320 | 845 | 430 | 890 | 1305 |
| 16m/Min | 860 | 440 | 310 | 825 | 405 | 860 | 1280 |
| 16m/Min | 780 | 410 | 375 | 780 | 400 | 805 | 1210 |
| 16m/Min | 720 | 390 | 260 | 730 | 385 | 745 | 1160 |
| 16m/Min | 660 | 350 | 225 | 665 | 340 | 620 | 950 |
| 16m/Min | 535 | 290 | 200 | 610 | 310 | 510 | 875 |
| 16m/Min | 490 | 245 | 190 | 580 | 275 | 440 | 800 |
| 16m/Min | 450 | 220 | 175 | 550 | 240 | 350 | 730 |
| 16m/Min | 340 | 180 | 160 | 510 | 210 | 330 | 645 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

| | | | |
|---|--|---|--|
| 1 | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage | 4 | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. |
| 2 | Apply firm, steady feed pressure throughout the cut | 5 | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant |
| 3 | Avoid lateral movement or tilting which can cause damage to the tool | 6 | VersaDrive TurboTips can be used without pilot drilling at all sizes |

Quick Guide

| | |
|---|---|
| 1 | For fastest performance use on impact wrenches & impact drivers |
| 2 | For optimum life and accuracy use with pistol drills and magnet drills |
| 3 | Suitable for use on standard construction grade steels such as Structural or Stainless Steel. |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life |



Impact Torque Ft Lbs

| Thread Diameter | Impact Tapping Torque | | |
|-----------------|-----------------------|------------|----------|
| | 1/4" Steel | 1/2" Steel | 1" Steel |
| M3 | 80 | 120 | N/A |
| M4 | 90 | 135 | N/A |
| M5 | 100 | 150 | N/A |
| M6 | 105 | 180 | N/A |
| 1/4" | 105 | 180 | 295 |
| 5/16" | 110 | 205 | 320 |
| M8 | 115 | 210 | 330 |
| 3/8" | 125 | 220 | 355 |
| M10 | 125 | 220 | 360 |
| M12 | 135 | 235 | 400 |
| 1/2" | 135 | 235 | 375 |
| M14 | 140 | 250 | 400 |
| 5/8" | 145 | 365 | 425 |
| M16 | 150 | 265 | 425 |
| 3/4" | 230 | 295 | 470 |
| M20 | 235 | 300 | 470 |
| 7/8" | N/A | 370 | 710 |
| M24 | N/A | 440 | 720 |
| 1" | N/A | 445 | 735 |
| M27 | N/A | 545 | 875 |
| M30 | N/A | 590 | 885 |

Impact Torque Nm

| Thread Diameter | Impact Tapping Torque | | |
|-----------------|-----------------------|------------|------------|
| | 6mm Steel | 12mm Steel | 25mm Steel |
| M3 | 105 | 160 | N/A |
| M4 | 120 | 180 | N/A |
| M5 | 135 | 200 | N/A |
| M6 | 140 | 240 | 400 |
| 1/4" | 145 | 255 | 410 |
| 5/16" | 145 | 265 | 420 |
| M8 | 150 | 280 | 430 |
| 3/8" | 165 | 290 | 440 |
| M10 | 170 | 300 | 480 |
| M12 | 185 | 320 | 512 |
| 1/2" | 190 | 330 | 525 |
| M14 | 190 | 340 | 544 |
| 5/8" | 195 | 355 | 555 |
| M16 | 200 | 360 | 576 |
| 3/4" | 245 | 385 | 615 |
| M20 | 315 | 400 | 640 |
| 7/8" | N/A | 515 | 775 |
| M24 | N/A | 600 | 960 |
| 1" | N/A | 695 | 1050 |
| M27 | N/A | 740 | 1184 |
| M30 | N/A | 800 | 1200 |

Revolutions per minute (Rotary)

| Thread Diameter | RPM Range | | | | |
|-----------------|-------------------------|--------------------------|----------------------|-----------|------------------|
| | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Aluminium | Cast Iron (Grey) |
| M3 | 960 | 809 | 650 | 2700 | 1295 |
| M4 | 730 | 610 | 490 | 2060 | 975 |
| M5 | 585 | 485 | 385 | 1750 | 780 |
| M6 | 485 | 405 | 325 | 1455 | 650 |
| 1/4" | 485 | 405 | 325 | 1455 | 650 |
| 5/16" | 365 | 310 | 245 | 1095 | 485 |
| M8 | 365 | 310 | 245 | 1095 | 485 |
| 3/8" | 295 | 245 | 195 | 870 | 390 |
| M10 | 295 | 245 | 195 | 870 | 390 |
| M12 | 240 | 200 | 162 | 730 | 330 |
| 1/2" | 240 | 200 | 162 | 730 | 330 |
| M14 | 210 | 175 | 140 | 625 | 275 |
| 5/8" | 185 | 155 | 125 | 550 | 243 |
| M16 | 185 | 155 | 125 | 550 | 243 |
| 3/4" | 145 | 125 | 100 | 440 | 194 |
| M20 | 145 | 125 | 100 | 440 | 194 |
| 7/8" | 130 | 115 | 92 | 410 | 180 |
| M24 | 120 | 100 | 85 | 370 | 165 |
| 1" | 120 | 100 | 85 | 370 | 165 |
| M27 | 105 | 90 | 75 | 330 | 145 |
| M30 | 95 | 80 | 60 | 310 | 130 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

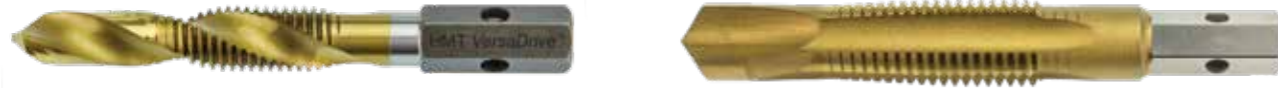
Best Practice Advice

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

| | | | |
|---|---|----|---|
| 1 | ImpactaTaps are recommended for through hole applications only. | 7 | Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials. |
| 2 | Pilot drill the exact tapping size hole for best results | 8 | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant |
| 3 | Select the correct torque power for impact wrench/drivers using the data range above. If exact match is not available select the closest torque setting above the recommendation. | 9 | Flame cut/punched holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage. |
| 4 | Apply firm, steady feed pressure throughout the cut | 10 | Tap the hole in one pass where possible, applying adequate lubrication before you start. |
| 5 | Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage. | 11 | If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing. |
| 6 | When using cordless tools, torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 3. | 12 | When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque |

Quick Guide

| | |
|---|---|
| 1 | For fastest performance use on impact wrenches & impact drivers |
| 2 | Check the minimum torque requirement |
| 3 | Laser cut holes & Stainless Steel require higher torque |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life |



| Impact Torque Ft Lbs | | | | Impact Torque Nm | | | Revolutions per minute (Rotary) | | | | | |
|-----------------------|---------------|------------|----------|-----------------------|------------|------------|---------------------------------|--------------------------|----------------------|-----------|------------------|------|
| Impact Tapping Torque | | | | Impact Tapping Torque | | | RPM Range | | | | | |
| Thread Diameter | 1/4" Steel | 1/2" Steel | 1" Steel | 6mm Steel | 12mm Steel | 25mm Steel | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Aluminium | Cast Iron (Grey) | |
| Diameter Ø | Ft Lbs Torque | | | Nm Torque | | | RPM Range | | | | | |
| M3 | 75 | 120 | N/A | 105 | 160 | N/A | M3 | 960 | 809 | 650 | 2700 | 1295 |
| M4 | 90 | 130 | N/A | 120 | 180 | N/A | M4 | 730 | 610 | 490 | 2060 | 975 |
| M5 | 95 | 145 | N/A | 135 | 200 | N/A | M5 | 585 | 485 | 385 | 1750 | 780 |
| M6 | 100 | 180 | N/A | 140 | 240 | N/A | M6 | 485 | 405 | 325 | 1455 | 650 |
| 1/4" | 105 | 175 | 295 | 145 | 255 | N/A | 1/4" | 485 | 405 | 325 | 1455 | 650 |
| 5/16" | 105 | 205 | 330 | 145 | 265 | N/A | 5/16" | 365 | 310 | 245 | 1095 | 485 |
| M8 | 110 | 205 | N/A | 150 | 280 | N/A | M8 | 365 | 310 | 245 | 1095 | 485 |
| 3/8" | 115 | 220 | 355 | 160 | 290 | N/A | 3/8" | 295 | 245 | 195 | 870 | 390 |
| M10 | 125 | 220 | N/A | 170 | 300 | N/A | M10 | 295 | 245 | 195 | 870 | 390 |
| M12 | 135 | 235 | 380 | 185 | 320 | 512 | M12 | 240 | 200 | 162 | 730 | 330 |
| 1/2" | 140 | 235 | 375 | 190 | 330 | 520 | 1/2" | 240 | 200 | 162 | 730 | 330 |
| M14 | 140 | 300 | 405 | 195 | 340 | 544 | M14 | 210 | 175 | 140 | 625 | 275 |
| 5/8" | 145 | 365 | 425 | 195 | 355 | 555 | 5/8" | 185 | 155 | 125 | 550 | 243 |
| M16 | 150 | 265 | 425 | 200 | 360 | 576 | M16 | 185 | 155 | 125 | 550 | 243 |
| 3/4" | 185 | 295 | 470 | 245 | 380 | 610 | 3/4" | 145 | 125 | 100 | 440 | 194 |
| M20 | 230 | 295 | 475 | 315 | 400 | 640 | M20 | 145 | 125 | 100 | 440 | 194 |
| 7/8" | N/A | 370 | 710 | N/A | 515 | 715 | 7/8" | 130 | 115 | 92 | 410 | 180 |
| M24 | N/A | 420 | 720 | N/A | 600 | 960 | M24 | 120 | 100 | 85 | 370 | 165 |
| 1" | N/A | 445 | 735 | N/A | 675 | 1050 | 1" | 120 | 100 | 85 | 370 | 165 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

| | | | | | |
|---|--|---|----|--|--|
| 1 | | Impact Taps are recommended for through hole applications only. | 7 | | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. |
| 2 | | Pilot drill the exact tapping size hole for best results | 8 | | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant |
| 3 | | Select correct NM torque power for impact wrench applications | 9 | | Flame cut/punched holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage. |
| 4 | | Apply firm, steady feed pressure throughout the cut | 10 | | Tap the hole in one pass where possible, applying adequate lubrication before you start. |
| 5 | | Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage. | 11 | | 301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench |
| 6 | | When tapping material thicker than 5/8", to speed up the process it is advisable to pilot drill the hole first, before drill-tapping the hole | 12 | | 301130- Heavy Duty Drill Taps are designed for use with Magnet Drills/Pillar Drills, or for tapping pre-drilled holes with an impact wrench. They are not designed for drill-tapping with hand-held rotary tools |

Quick Guide - Drill Taps (301125)

Heavy Duty Drill Taps (301130)

| | | |
|---|---|--|
| 1 | For fastest performance use on impact wrenches/drivers | Ideal for use in drill presses and magnet drills |
| 2 | Check the minimum torque requirement | For impact wrench use, pilot drilling is recommended |
| 3 | Up to 3/8" (M10) can also be used on cordless drills | Correct RPM is critical for good performance on larger sizes |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life | |



| Impact Torque Ft Lbs | | | Impact Torque Nm | | Revolutions per minute (Rotary) | | | | | | |
|----------------------|-------------------|-----------------|-------------------|-------------------|---------------------------------|--------------------------|----------------------|-------|------------------|-----------|------|
| Impact Torque | | | Impact Torque | | RPM Range | | | | | | |
| Reamer Diameter | <1/2" Thick Steel | <1" Thick Steel | <12mm Thick Steel | <25mm Thick Steel | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Brass | Cast Iron (Grey) | Aluminium | |
| Diameter Ø | Ft Lb Torque | | Nm Torque | | RPM Range | | | | | | |
| 8 mm | 160 | 290 | 200 | 380 | 8 mm | 940 | 540 | 410 | 1020 | 550 | 1365 |
| 10 mm | 175 | 300 | 220 | 400 | 10 mm | 900 | 510 | 380 | 1005 | 530 | 1290 |
| 12 mm | 185 | 305 | 280 | 420 | 12 mm | 875 | 490 | 370 | 995 | 520 | 1200 |
| 1/2" | 205 | 310 | 300 | 445 | 1/2" | 875 | 490 | 370 | 520 | 510 | 1185 |
| 14 mm | 220 | 330 | 320 | 480 | 14 mm | 690 | 360 | 305 | 700 | 500 | 1100 |
| 9/16" | 235 | 355 | 330 | 490 | 9/16" | 690 | 360 | 305 | 450 | 450 | 1025 |
| 5/8" | 250 | 375 | 335 | 505 | 5/8" | 640 | 335 | 225 | 340 | 340 | 975 |
| 16 mm | 260 | 390 | 340 | 510 | 16 mm | 640 | 335 | 225 | 660 | 340 | 920 |
| 11/16" | 265 | 400 | 350 | 525 | 11/16" | 535 | 290 | 210 | 305 | 305 | 860 |
| 18 mm | 270 | 410 | 360 | 540 | 18 mm | 535 | 290 | 210 | 550 | 305 | 800 |
| 3/4" | 280 | 420 | 370 | 550 | 3/4" | 490 | 230 | 195 | 250 | 280 | 745 |
| 20 mm | 285 | 425 | 380 | 570 | 20 mm | 490 | 230 | 195 | 510 | 250 | 745 |
| 21 mm | 290 | 430 | 390 | 580 | 21 mm | 480 | 225 | 190 | 500 | 240 | 710 |
| 22 mm | 300 | 435 | 400 | 600 | 22 mm | 460 | 210 | 180 | 470 | 235 | 690 |
| 7/8" | 310 | 440 | 425 | 630 | 7/8" | 460 | 210 | 180 | 235 | 235 | 675 |
| 15/16" | 380 | 575 | 460 | 695 | 15/16" | 360 | 150 | 140 | 215 | 215 | 540 |
| 24 mm | 385 | 600 | 520 | 780 | 24 mm | 360 | 150 | 140 | 430 | 215 | 490 |
| 1" | 390 | 620 | 530 | 805 | 1" | 310 | 140 | 135 | 200 | 200 | 410 |
| 26 mm | 405 | 640 | 545 | 840 | 26 mm | 310 | 140 | 135 | 375 | 200 | 400 |
| 1-1/16" | 440 | 660 | 575 | 875 | 1-1/16" | 295 | 130 | 125 | 190 | 385 | 380 |
| 28 mm | 480 | 750 | 600 | 900 | 28 mm | 295 | 130 | 125 | 340 | 190 | 360 |
| 30 mm | 520 | 785 | 650 | 975 | 30 mm | 275 | 120 | 110 | 290 | 180 | 330 |
| 32 mm | 545 | 820 | 680 | 1020 | 32 mm | 250 | 110 | 100 | 275 | 170 | 305 |
| 33 mm | 560 | 840 | 695 | 1035 | 33 mm | 240 | 105 | 95 | 270 | 165 | 295 |
| 36 mm | 600 | 870 | 740 | 1090 | 36 mm | 215 | 95 | 80 | 255 | 150 | 255 |
| 39 mm | 720 | 920 | 900 | 1150 | 39 mm | 195 | 80 | 65 | 240 | 135 | 220 |

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

| | | | | | |
|---|--|--|---|--|--|
| 1 | | Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the start of the cut. | 5 | | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage. |
| 2 | | To maximise tool life do not attempt to increase the existing hole diameter beyond 1/8". If a larger, finished hole size is required, then the next size reamer should be used to 'step up' until the finished hole diameter is reached. | 6 | | Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive reamer. |
| 3 | | Avoid lateral movement or tilting which can cause damage to the tool | 7 | | Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling. |
| 4 | | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. | 8 | | Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time. |

Quick Guide

| | |
|---|---|
| 1 | For fastest performance use on impact wrenches & impact drivers |
| 2 | Check the minimum torque requirement |
| 3 | Reamer should be rotating before starting the cut |
| 4 | Use steady feed pressure throughout the cut |

Countersink - Data Sheet



| Countersink Diameter | Structural Steel <500Nm | Structural Steel <1000Nm | Stainless Steel INOX | Aluminium | Cast Iron (Grey) | Plastics |
|----------------------|-------------------------|--------------------------|----------------------|-----------|------------------|-----------|
| Diameter Ø | RPM Range | RPM Range | RPM Range | RPM Range | RPM Range | RPM Range |
| 6.3 mm (1/4") | 765 | 505 | 265 | 1250 | 500 | 850 |
| 10.4 mm | 460 | 300 | 145 | 765 | 315 | 530 |
| 12.4 mm (1/2") | 385 | 255 | 110 | 635 | 265 | 480 |
| 16.5 mm | 295 | 185 | 80 | 485 | 210 | 345 |
| 20.5 mm (13/16") | 230 | 155 | 50 | 385 | 165 | 280 |
| 25 mm (1") | 185 | 130 | 50 | 315 | 130 | 225 |
| 30 mm | 155 | 105 | 35 | 265 | 105 | 185 |
| 40 mm | 120 | 80 | 30 | 205 | 80 | 140 |
| 55 mm | 95 | 60 | 25 | 145 | 70 | 120 |
| 63 mm | 80 | 55 | 20 | 130 | 55 | 90 |
| 80 mm | 65 | 40 | 20 | 100 | 45 | 75 |

Best Practice Advice

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

| | | | |
|--------------|--|--------------|---|
| 1 | Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage | 6 | Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling. |
| 2 | Apply firm, steady feed pressure throughout the cut | 7 | Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications) |
| 3 | Avoid lateral movement or tilting which can cause damage to the tool | 8 | Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use at correct RPM (if unsure use tachometer to check drill speed) |
| 4 | Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials. | 9 | Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling. |
| 5 | Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant | | |

Quick Guide

| | |
|----------|---|
| 1 | Optimum life and performance when used with rotary pistol drills or drill presses |
| 2 | Up to 5/8" can be used on impact wrench & impact drivers for fast cutting performance |
| 3 | Suitable for harder materials such as stainless steel when used at reduced RPM |
| 4 | Use appropriate lubrication and correct RPM to achieve long tool life |

ULTRA Coated Cutters & Countersinks



| Diameter Ø | RPM Range |
|------------------|---------------------|
| 5/8" - 3/4" | 200 - 140 (No Load) |
| 13/16" - 1 1/16" | 140 - 85 (No Load) |

| Diameter Ø | RPM Range |
|------------|-------------------|
| 1 1/4" | 60 - 40 (No Load) |
| 1 1/2" | 60 - 30 (No Load) |
| 2 1/4" | 60 - 25 (No Load) |

Machining of Wear Plates such as HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

The extreme hardness and resistance of wear plate makes machining it extremely challenging. Good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, like the VersaDrive Series, and ample lubrication - BioCut Blue cutting fluid when broaching or Speedlube Aerosol spray when countersinking.

Using an incorrect or poorly maintained Magnet drill with unstable drilling operation, poor magnet hold, excessive pressure or inadequate lubrication is likely to result in rapid tool failure.

Even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It not only requires the correct setup but also experienced operators with the time necessary to proceed with caution.

Broaching Best Practice Advice

| | |
|--|--|
| 1 | Cautious & Gentle feed pressure should be used at all times, especially during the start of the cut and exiting the material |
| 2 | Generous application of BioCut Blue cutting fluid should be used during the cut & applied frequently during the cut with through cutter coolant supply if possible |
| 3 | Backing off the cutter & applying more BioCut Blue is necessary for increasing tool life |
| 4 | Swarf removal from the cutter can assist with longer tool life |
| 5 V100T V125T | For best results, use a powerful magnet drill with high torque and low gear speed such as the V100T and V125T machines |

Countersinking Best Practice Advice

| | |
|--|---|
| 1 | For best results the Countersink should be piloted where possible |
| 2 | Do not allow the countersink to vibrate over swarf while cutting as this will cause chatter, ultimately causing the cutting edges to chip & blunt |
| 3 | Regular Speedlube application & regular swarf removal on countersinking is essential |
| 4 | A hand brush works better than mag stick to clean cutter and material surface |
| 5 V100T V125T | For best results, use a powerful magnet drill with high torque and low gear speed such as the V100T and V125T machines |

N.B.

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

When using a geared drilling machine, use low gears to provide maximum torque
When using a Mag Drill with Electronic Torque Control, i.e., V85T - V125T, speed should be lowered

For general broaching best practice advice, see further points on page 88
For general countersinking best practice advice, please see further points on the opposite page

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