



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, pre-drill 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