



Newton meter (Nm)  
Impact Torque

Reamer Diameter	Structural Steel <600Nm 32m/min		Structural Steel <1000Nm 18m/min		Stainless Steel INOX 12m/min		Brass 32m/min		Cast Iron 16m/min		Plastics 30m/min		Aluminium 45m/min		Impact Torque <12MM Thick Steel		Impact Torque <25MM Thick Steel	
	Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Nm Torque	Nm Torque	Nm Torque	Nm Torque
8mm	940	540	410	1020	550	1020	1320	200	380									
10mm	900	510	380	1005	530	1005	1300	220	400									
12MM	875	490	370	995	520	980	1275	280	420									
14MM	690	360	305	700	450	695	1025	320	480									
16MM	640	335	225	660	340	600	975	340	510									
18MM	535	290	210	550	305	545	860	360	540									
20MM	490	230	195	510	250	470	745	380	570									
21mm	480	225	190	500	240	460	730	390	580									
22MM	460	210	180	470	235	445	675	400	600									
24MM	360	150	140	430	215	395	540	520	780									
26MM	310	140	135	375	200	330	410	520	840									
28MM	295	130	125	340	190	285	385	600	900									
30MM	275	120	110	290	180	260	340	650	975									
32MM	250	110	100	275	170	220	315	680	1020									
33MM	240	105	95	270	165	215	310	695	1035									
36MM	215	95	80	255	150	200	295	740	1090									
39MM	195	80	65	240	135	185	280	900	1150									

**Best Practice Advice**

	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.		Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation the hole can be reamed out with a slow speed Magnet Drill with a ImpactaMag or VersaDrive reamer.
	To maximise tool life do not attempt to increase the existing hole diameter beyond 2-3mm. 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.		Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
	Avoid lateral movement or tilting which can cause damage to the tool		Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.



Foot Pound (Ft lb)  
Impact Torque

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	Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lb Torque	Ft Lb Torque	Ft Lb Torque	Ft Lb Torque
1/2"	875	490	370	995	520	980	1275	205	310									
9/16"	690	360	305	700	450	695	1025	235	355									
5/8"	640	335	225	660	340	600	975	250	375									
11/16"	535	290	210	550	305	545	860	265	400									
3/4"	490	230	195	510	250	470	745	280	420									
7/8"	460	210	180	470	235	445	675	295	440									
15/16"	360	150	140	430	215	395	540	380	575									
1"	310	140	135	375	200	330	410	390	620									
1-1/16"	295	130	125	340	190	285	385	440	660									

**\*GUIDELINE PARAMETERS ONLY.**

Actual parameters may vary depending on operating conditions

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