

# Technical Data Sheet



*It. Just. Keeps. Going*

## USER INSTRUCTIONS

- Wear appropriate Personal Protective Equipment (P.P.E) when using holesaws.
- Ensure holesaw is correctly attached to the relevant adaptor for your machine.
- Use holesaw at the recommended speeds for the material being drilled as shown in the chart.
- Use as appropriate cutting lubricant when drilling in steel.
- After producing a hole, remove the “slug” of the material from the throat of the holesaw before commencing another hole.
- After pilot drill penetration be careful not to “bang” the holesaw onto the surface of the material to be drilled. This could damage or break the cutting teeth.

## MATERIAL RECOMMENDATIONS

Mild Steel	●	● Very suitable
Stainless Steel	●	● Suitable
Cast Iron	●	
Aluminium	●	
Brass	●	
Wood	●	
Plastic	●	

### DID YOU KNOW?

M42 Steel (8% Cobalt) has excellent “hot hardness” properties. Therefore the cutting teeth don't wear as quickly as other lower grades of HSS when working at higher temperatures



### TECH TIP!

Our holesaws fit standard adaptors - see below for a tip on how to correctly fit your holesaw to your adaptor

## OPERATIONAL SPEED CHART

Diameter	Mild Steel	Stainless Steel	Aluminium	Cast Iron	Brass	Wood	Drive arbors mm
16	550	275	825	365	730	3000	Use with 14 - 29
20	425	210	635	280	560	3000	Use with 14 - 29
22	390	195	585	260	520	3000	Use with 14 - 29
25	350	175	525	235	470	2700	Use with 14 - 29
32	275	140	410	180	360	2400	Use with 32 - 152
35	250	125	375	165	330	2400	Use with 32 - 152
38	230	115	345	150	300	2400	Use with 32 - 152
40	215	110	315	140	280	2100	Use with 32 - 152
44	195	95	295	130	260	2100	Use with 32 - 152
51	170	85	255	115	230	2000	Use with 32 - 152
54	160	80	240	105	210	2000	Use with 32 - 152
57	150	75	225	100	200	2000	Use with 32 - 152
60	140	70	220	95	190	2000	Use with 32 - 152
64	135	65	205	90	180	1850	Use with 32 - 152
65	135	60	205	90	180	1850	Use with 32 - 152
67	130	65	195	85	170	1800	Use with 32 - 152
70	125	60	185	80	160	1800	Use with 32 - 152
73	120	60	180	80	160	1800	Use with 32 - 152
76	115	55	170	75	150	1800	Use with 32 - 152
79	110	55	165	70	140	1500	Use with 32 - 152
83	105	50	155	70	140	1500	Use with 32 - 152
86	100	50	145	65	130	1500	Use with 32 - 152
89	95	45	145	65	130	1200	Use with 32 - 152
95	90	45	135	60	120	1200	Use with 32 - 152
102	85	40	130	55	110	1000	Use with 32 - 152
111	75	35	110	50	100	900	Use with 32 - 152
114	75	35	105	50	100	900	Use with 32 - 152
127	65	30	90	40	80	800	Use with 32 - 152
152	55	25	80	35	70	800	Use with 32 - 152

## TECHNICAL ICONS



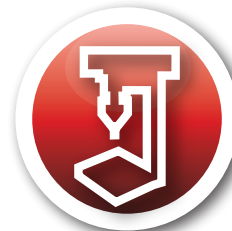
When drilling steel



Please refer to data table for relevant adaptors



Use in a portable drilling machine



Use in a fixed drilling machine



Wear eye protection



Wear hearing protection



Wear a face mask



Wear hand protection



Use in SDS Plus power tools