ImpactaStep Cutter - Data Sheet

VERSADRIVE® PATENT PROTECTED

	Diameter	Impact Torque <12mm Thick Steel Nm Torque	Impact Torque <1/2" Thick Steel Ft Lb Torque	Revolutions per minute- RPM (Rotary) Structural Steel <500 Mpa 32m/Min RPM Range	Structural Steel <1000 Mpa 18m/Min RPM Range	Stainless Steel INOX 12m/Min RPM Range	Brass 32m/Min RPM Range	Cast Iron (Grey) 16m/Min RPM Range	Aluminium 45m/Min RPM Range
Metric	8MM	200	160	940	540	410	1020	550	1365
	10MM	220	175	900	510	380	1005	530	1290
	12MM	280	185	875	490	370	995	520	1200
	14MM	320	220	690	360	305	700	500	1100
	16MM	340	260	640	335	225	660	340	920
	18MM	360	270	535	290	210	550	305	800
	20MM	380	285	490	230	195	510	250	745
	22MM	400	300	460	210	180	470	235	690
	24MM	520	385	360	150	140	430	215	490
	26MM	545	405	310	140	135	375	200	400
	32MM	575	430	290	130	125	340	180	355
Inch	1/2"	300	205	875	490	370	520	510	1185
	9/16"	330	235	690	360	305	450	450	1025
	5/8"	335	250	640	335	225	340	340	975
	11/16"	350	265	535	290	210	305	305	860
	3/4"	370	280	490	230	195	250	280	745
	7/8"	425	310	460	210	180	235	235	675
	15/16"	460	380	360	150	140	215	215	540
	1"	530	390	310	140	135	200	200	410
	1-1/16"	575	440	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*
2. *Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut*
3. *Avoid lateral movement or tilting which can cause damage to the tool*
4. *Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials*
5. *Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant*
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

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Excellent life and performance when used with Rotary Pistol Drills or Pillar Drills*
- *Suitable for stainless and harder materials if used at low RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

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