



Revolutions per minute- RPM (Rotary)

Diameter	Structural Steel <500 Mpa Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa 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
	RPM Range								
13-17MM	1350-850	840-585	500-360	2210-1575	900-625	780-705	1350-850	900-640	1495-1010
18-25MM	850-625	580-420	350-250	1575-1125	600-455	700-520	850-625	620-450	990-895
26-31MM	620-500	415-325	240-195	1080-885	435-345	500-405	620-500	440-345	895-850
32-39MM	480-410	320-275	195-160	875-740	330-285	400-330	480-410	345-280	850-740
40-46MM	390-340	270-220	160-145	730-620	285-240	315-275	390-340	175-235	740-610
47-53MM	335-300	220-180	140-120	615-545	235-215	275-245	335-300	235-215	600-505
54-60MM	295-260	180-165	115-100	525-485	210-180	240-215	295-260	210-185	500-460
61-70MM	260-225	165-155	100-90	475-415	180-160	205-185	260-225	180-160	455-400
71-80MM	220-195	155-140	90-75	410-365	155-140	180-160	220-195	155-140	395-360

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
- 2.** Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage
- 3.** Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
- 4.** Avoid lateral movement or tilting which can cause damage to the tool
- 5.** Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
- 6.** Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
- 7.** When using a Magnet Drill regularly check that slides, handles, arbors and movable parts have not vibrated loose over time
- 8.** Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling
- 9.** For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
- 10.** For thicker materials, predrill 6.35mm pilot hole first and use then sprung pilot drill or pilot pin as a guide

QUICK GUIDE

- Optimum life & performance when used with Rotary Pistol Drills
- Good results from SDS Drills when used in Rotary-Only mode
- For best results pre-drill the pilot hole
- Use appropriate lubrication and correct RPM to achieve long tool life

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