

# 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



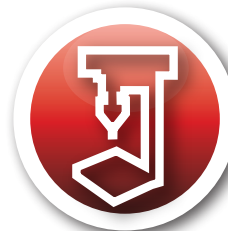
When drilling steel



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