

HOLE SAW SPEEDS & FEEDS



BI-METAL CONSTANT PITCH & DUAL PITCH HOLE SAWS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM				
MM	INCH	MILD STEEL	STAINLESS & TOOL STEEL	CAST IRON	BRASS & ALUMINIUM	WOOD
14 - 25	9/16 - 1	580-350	300-175	400-235	790-470	800-500
27 - 51	1.1/16 - 2	325-170	160-85	215-115	435-230	500-200
52 - 76	2.1/16 - 3	165-115	80-55	110-75	220-150	200-150
79 - 102	3.1/8 - 4	110-85	55-40	70-55	140-110	150-100
105 - 210	4.1/8 - 8.9/32	80-40	40-20	55-25	110-60	100-60



BI-METAL CORDLESS SMOOTH CUTTING HOLE SAWS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM		
MM	INCH	MILD STEEL	STAINLESS & TOOL STEEL	WOOD, PLASTIC & ALUMINIUM
16 - 20	5/8 - 25/32	500	230	700
22 - 29	7/8 - 1.1/8	400	185	550
30 - 38	1.3/16 - 1.1/2	330	150	450



TCT FAST CUT MULTI PURPOSE HOLE SAWS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM
MM	INCH	ALL MATERIALS
19 - 27	3/4 - 11/16	1700 - 1300
29 - 51	1.1/8 - 2	1100 - 650
54 - 76	2.1/8 - 3	600 - 425
79 - 102	3.1/8 - 4	400 - 325
111 - 159	4.3/8 - 6.1/4	300 - 210



TCT STAINLESS STEEL HOLE SAWS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM	
MM	INCH	MILD STEEL	STAINLESS & TOOL STEEL
15 - 25	19/32 - 1	800-640	460-370
26 - 39	1.1/32 - 1.17/32	590-460	320-270
40 - 55	1.9/16 - 2.5/32	400-320	220-170
60 - 85	2.3/8 - 3.23/64	265-200	140-105
90 - 100	3.9/16 - 4.23/32	175-130	90-65



DIAMOND CERAMIC & ABRASIVE MATERIAL HOLE SAWS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM (ALWAYS USE COOLANT)	
MM	INCH	MINIMUM SPEED	MAXIMUM SPEED
5 - 12	3/16 - 1/2	400	
14 - 25	9/16 - 1	500	1000
27 - 51	1.1/16 - 2	250	500
52 - 83	2.1/16 - 3.1/4	150	300
86 - 152	3.3/8 - 6	100	200



DIAMOND BRICK AND MASONRY DRI-CORE DRILLS

SAW DIAMETER		RECOMMENDED CUTTING SPEEDS - RPM	
MM	INCH	MINIMUM SPEED	MAXIMUM SPEED
22 - 52	9/16 - 1	250	500
65 - 78	2.9/16 - 3.1/16	150	300
102 - 152	4 - 6	100	200

