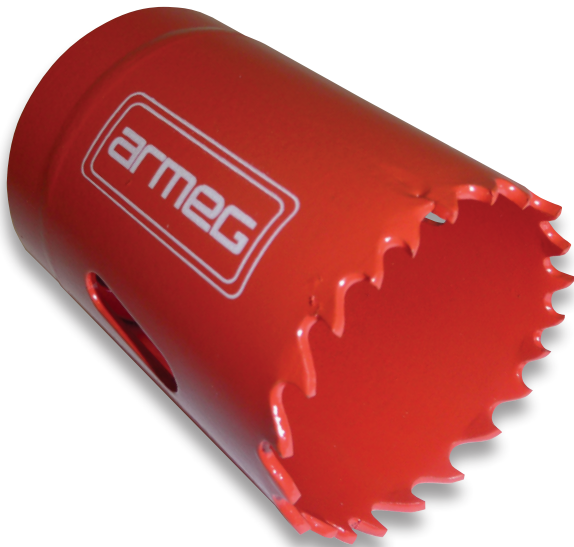




# Cobalt Vari-Pitch Holesaw

*It. Just. Keeps. Going*



## Safety 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 an 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.

## Operation Speed Chart

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

