

RECOMMENDED OPERATING SPEEDS FOR BI-METAL HOLESAWS

HOLESAW SIZE (INCHES)	HOLESAW SIZE (MM)	MILD STEELS (R.P.M)	STAINLESS STEELS (R.P.M)	CAST IRON (R.P.M)	BRASS (R.P.M)	ALU. (R.P.M)
9/16"	14	580	300	400	790	900
5/8"	16	550	275	365	730	825
11/16"	17	500	250	330	665	750
3/4"	19	460	230	300	600	690
25/32"	20	480	240	315	632	720
13/16"	21	425	210	280	560	635
7/8"	22	390	195	260	520	585
15/16"	24	370	185	245	495	555
1"	25	350	175	235	470	525
1 1/16"	27	325	160	215	435	480
1 1/8"	29	300	150	200	400	450
1 3/16"	30	285	145	190	380	425
1 1/4"	32	275	140	180	360	410
1 5/16"	33	260	135	175	345	390
1 3/8"	35	250	125	165	330	375
1 7/16"	37	240	120	160	315	360
1 1/2"	38	230	115	150	300	345
1 9/16"	40	220	110	145	290	330
1 5/8"	41	210	105	140	280	315
1 11/16"	43	205	100	135	270	305
1 3/4"	44	195	95	130	260	295
1 13/16"	46	190	95	125	250	285
1 7/8"	48	180	90	120	240	270
2"	50	170	85	115	230	255
2 1/16"	52	165	80	110	220	245
2 1/8"	54	160	80	105	210	240

HOLESAW SIZE (INCHES)	HOLESAW SIZE (MM)	MILD STEELS (R.P.M)	STAINLESS STEELS (R.P.M)	CAST IRON (R.P.M)	BRASS (R.P.M)	ALU. (R.P.M)
2 1/4"	57	150	75	100	200	225
2 5/16"	59	145	75	100	195	225
2 3/8"	60	140	70	95	190	220
2 7/16"	62	135	70	95	185	215
2 1/2"	64	135	65	90	180	205
2 9/16"	65	130	65	85	175	200
2 5/8"	67	130	65	82	170	195
2 11/16"	68	125	60	80	165	190
2 3/4"	70	125	60	80	160	185
2 7/8"	73	120	60	75	160	180
3"	76	115	55	70	150	170
3 1/8"	79	110	55	70	140	165
3 1/4"	83	105	50	65	140	155
3 3/8"	86	100	50	65	130	150
3 1/2"	89	95	45	60	130	145
3 5/8"	92	95	45	60	120	140
3 3/4"	95	90	45	60	120	135
3 7/8"	99	90	45	55	120	135
4"	102	85	40	55	110	130
4 1/8"	105	80	40	55	110	120
4 1/4"	108	80	40	55	110	120
4 3/8"	111	80	40	50	100	120
4 1/2"	114	75	35	50	100	105
4 3/4"	121	70	35	45	95	95
5"	127	65	30	45	90	90
5 1/2"	140	60	25	40	85	85
6"	152	55	25	35	75	80