Technical Data Sheet

ACCELER 8% MAX

USER INSTRUCTIONS

- Insert the hole Cutter into the electric drill.
- Secure the drill chuck jaws on three flats of the hole cutter shank.
- Begin drilling using light feed pressure until the hole cutter has begun drilling.
- Apply medium feed pressure once the cutter has engaged in material.
- After pilot drill penetration, be careful not to "bang" the holesaw onto the surface. This could damage or break the cutting teeth.
- Always use rotation hand drills with no impact or with a rotation only mode.



CAUTION

- Always wear eye protection when drilling.
- Properly prepare the work environment prior to drilling.
- Never touch moving cutter. Keep hands clear of any moving parts.
- Do not touch the cutter, chips or plug immediately after drilling as these may be extremely hot.
- Carefully read the instruction manual of the electric drill prior to use.

TECH TIP

Using cutting oil will extend product life and is imperative in stainless steel. Try our cutting compound (ECC002).

MATERIAL RECOMMENDATIONS

Mild Steel	●
Stainless Steel	●
Cast Iron	●
Aluminium	●
Brass	●
Wood	□
Plastic	●

● Very suitable
□ Not suitable

OPERATIONAL SPEED CHART

Short Series RPM

Diameter (mm)	Overall Length (mm)	Working Length (mm)	Stainless Steel & Alloy Steel	Mild Steel	Copper Plate & Brass Plate	Plastic & F R P
14	65	5	470	630	790	950
16	65	5	390	550	700	840
20	65	5	310	470	630	790
22	65	5	290	410	590	720
25	65	5	250	380	510	630
32	65	5	200	280	420	530

armeg

OPERATIONAL SPEED CHART

Long Series RPM

Diameter (mm)	Overall Length (mm)	Working Length (mm)	Stainless Steel & Alloy Steel	Mild Steel	Copper Plate & Brass Plate	Plastic & F R P
14	80	25	700	1000	1135	1590
16	80	25	600	875	995	1390
18	80	25	530	780	885	1235
19	80	25	500	735	835	1170
20	80	25	475	700	795	1110
22	80	25	450	635	725	1010
25	80	25	380	560	635	890
28	80	25	340	530	575	795
30	80	25	320	500	530	740
32	80	25	300	480	500	700
35	80	25	270	430	455	635
38	80	25	250	380	420	585
40	80	25	240	350	400	560
45	80	25	210	310	355	495
50	80	25	190	280	320	445

All speeds are approximate, appropriate lubrication should be used where required.



Use in power tools with a 3 jaw chuck 10 & 13mm



Use in a portable drilling machine - up to 50mm



Use in a fixed drilling machine - 14-50mm



Cutting Lubricant recommended



Wear eye protection



Wear hearing protection



Wear hand protection



Wear a face mask



Screw thread dimension M6x6



Allen key size 3mm