

WARNING ! Failure to observe precautions can cause serious injury.
 All operators must read and understand safety information before using hole saws.

Recommended Operating Speeds for Bi-Metal Hole Saws

For carbide tipped saws multiply the Recommended Speed by 2.5

SIZE MM	SIZE INCHES	MILD STEELS	STAINLESS STEELS	CAST IRON	BRASS	ALUMINIUM
14	9/16	580	300	400	790	900
16	10/16	550	275	365	730	825
17	11/16	500	250	330	665	750
19	12/16	460	230	300	600	690
20	13/16	480	240	315	632	720
21	13/16	425	210	280	560	635
22	14/16	390	195	260	520	585
24	15/16	370	185	245	495	555
25	1	350	175	235	470	525
27	1 1/16	325	160	215	435	480
29	1 2/16	300	150	200	400	450
30	1 3/16	285	145	190	380	425
32	1 4/16	275	140	180	360	410
33	1 5/16	260	135	175	345	390
35	1 6/16	250	125	165	330	375
37	1 7/16	240	120	160	315	360
38	1 8/16	230	115	150	300	345
40	1 9/16	220	110	145	290	330
41	1 10/16	210	105	140	280	315
43	1 11/16	205	100	135	270	305
44	1 12/16	195	95	130	260	295
46	1 13/16	190	95	125	250	285
48	1 14/16	180	90	120	240	270
50	1 15/16	170	85	115	230	255
52	2 1/16	165	80	110	220	245
54	2 2/16	160	80	105	210	240
57	2 4/16	150	75	100	200	225
59	2 5/16	145	75	100	195	225
60	2 6/16	140	70	95	190	220
62	2 7/16	135	70	95	185	215
64	2 8/16	135	65	90	180	205
65	2 9/16	130	65	85	175	200
67	2 10/16	130	65	85	170	195
68	2 11/16	125	60	82	165	190
70	2 12/16	125	60	80	160	185
73	2 14/16	120	60	80	160	180
76	3	115	55	75	150	170
79	3 2/16	110	55	70	140	165
83	3 4/16	105	50	70	140	155
86	3 6/16	100	50	65	130	150
89	3 8/16	95	45	65	130	145
92	3 10/16	95	45	60	120	140
95	3 12/16	90	45	60	120	135
99	3 14/16	90	45	60	120	135
102	4	85	40	55	110	130
105	4 2/16	80	40	55	110	120
108	4 4/16	80	40	55	110	120
111	4 6/16	80	40	50	100	120
114	4 8/16	75	35	50	100	105
121	4 12/16	70	35	45	95	95
127	5	65	30	45	90	90
140	5 8/16	60	25	40	85	85
152	6	55	25	35	75	80