



45 B-Metal

RECOMMENDED HOLE SAW SPEED REFERENCE CHART

SPEEDS SHOWN ARE ONLY A GUIDELINE OR SUGGESTION TO OPTIMIZE THE BASIC PERFORMANCE OF COMMON HOLESAWS.

SIZE INCHES	MILD STEEL	TOOL STEEL & STAINLESS	CAST IRON	BRASS	ALUMINUM
2-1/4"	150	75	100	200	230
2-5/16"	145	75	100	195	225
2-3/8"	140	70	95	190	220
2-1/2"	135	70	90	180	205
2-9/16"	130	65	85	175	200
2-5/8"	130	65	85	170	195
2-3/4"	125	60	80	160	185
2-7/8"	120	60	80	160	180
3"	115	55	75	150	170
3-1/8"	110	55	70	145	165
3-1/4"	105	50	70	140	155
3-3/8"	100	50	65	130	150
3-1/2"	95	45	60	125	145
3-5/8"	95	45	60	120	140
3-3/4"	90	45	60	120	135
3-7/8"	90	45	60	115	130
4"	85	40	55	115	125
4-1/8"	85	40	55	110	120
4-1/4"	80	40	55	110	115
4-3/8"	80	40	50	100	110
4-1/2"	75	35	50	100	105
4-3/4"	70	35	45	90	95
5"	65	30	40	85	90
5-1/2"	60	30	35	80	85
5-3/4"	55	25	35	75	80
6"	55	25	35	75	80

DON'T	Run a holesaw too fast- it will cut faster at a slower speed than it does at speed higher than recommended. If it runs too fast, it will not cut, but wear out.
DON'T	Allow tooth points to rub over the work without digging in to take a chip. Rubbing the tooth points dulls them so they can't cut.
DON'T	Set the pilot drill point beyond the tooth points more than the thickness of the work. If the drill pierces the work before the saw teeth are in contact, the saw can hit the work with sufficient shock to break the saw or the teeth.
DON'T	Operate hole saws without cutting oil (except in cast iron) or the abrasion will cause enough heat to damage the cutting ability of the saw.
DON'T	Chuck too loosely or off center. An improperly chucked hole saw will cause damaging vibrations.
DON'T	Try to saw holes at an angle to the work surface. When teeth do not contact the work evenly the hole saw will be twisted out of round and will break.
DON'T	Allow hole saw and drive unit to wobble or orbit around the pilot drill, as this sets up damaging stresses to strip the teeth or break the saw.
DON'T	Begin sawing with arbor so loose in cap that it will (1) Tear our threads in saw cap, or (2) become inseparable (too tightly screwed in).
DON'T	Allow drive pins to retract from holes while saw is in operation. Loose drive pins can grind a hole in the cap.
DON'T	Let loose clothing or long hair get near a revolving hole saw.