



Bi-Metal

RECOMMENDED HOLE SAW SPEED REFERENCE CHART
SPEEDS SHOWN ARE ONLY A GUIDELINE / SUGGESTION TO HELP OPTIMIZE THE PERFORMANCE OF BI-METAL HOLESAWS.

SIZE INCHES	MILD STEEL	TOOL STEEL & STAINLESS	CAST IRON	BRASS	ALUMINUM
9/16"	550	300	400	790	900
5/8"	530	275	365	730	825
11/16"	500	250	330	665	750
3/4"	460	230	300	600	690
13/16"	425	210	280	560	630
15/16"	370	185	245	495	555
1"	350	175	235	470	525
1-1/16"	325	160	215	435	480
1-1/8"	300	150	200	400	450
1-3/16"	285	145	190	380	425
1-1/4"	275	140	180	360	410
1-3/8"	250	125	165	330	375
1-1/2"	230	115	150	300	345
1-1/4"	275	140	180	360	410
1-5/16"	260	135	175	345	390
1-3/8"	250	125	165	330	375
1-7/16"	240	120	160	315	360
1-1/2"	230	115	150	300	345
1-9/16"	220	110	145	290	330
1-5/8"	210	105	140	280	315
1-11/16"	205	100	135	270	305
1-3/4"	195	95	130	260	295
1-13/16"	190	95	125	250	285
1-7/8"	180	90	120	240	270
2"	170	85	115	230	255
2-1/16"	165	80	110	220	245
2-1/8"	160	80	105	210	240

DO	Operate holesaw at the recommended speed. See RPM table.
DO	Apply sufficient feed pressure when sawing, about 80 to 100 pounds per inch of hole saw diameter. (More for harder materials, less for softer.) Drive Plates to reinforce the back of the Holesaw may be suggested on larger diameter holesaws.
DO	Set pilot drill point about 1/8" beyond the tooth points enough to establish and hold a center. Better yet, drill pilot hole with 1/4" drill bit and use 1/4" drill rod for pilot. This is the way the professional does it.
DO	Use a good grade of cutting oil to assure cleaner cut and longer blade life. (To those who think WD-40 is a cutting oil - it is not)
DO	Chuck the holesaw properly.
DO	Hold saw perpendicular to the surface of material being cut.
DO	Hold hole saw and drive until steady - drill press or lathe is best when possible.
DO	Be sure to fix arbor to holesaw firmly. Drive pins should be fully engaged in drive pin holes.
DO	Keep drive pins locked into drive pin holes with threaded retainer.
DO	Wear safety glasses and keep idle hands away from the sawing operation.