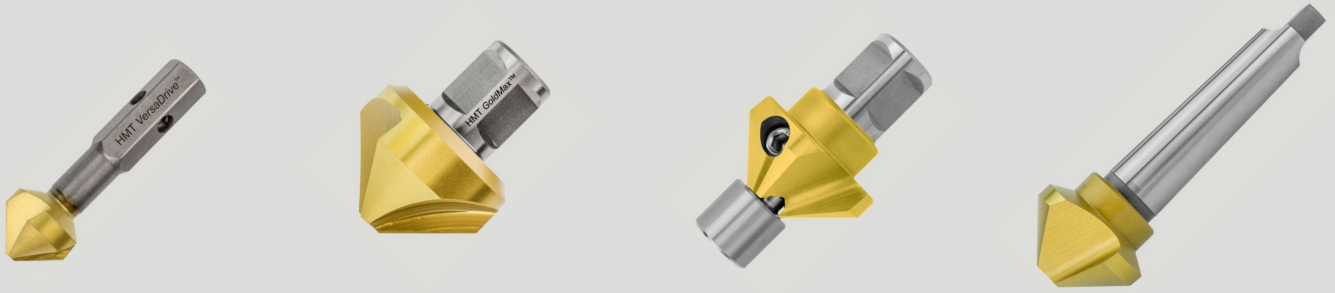














# COUNTERSINK RPM DATA

RECOMMENDATIONS FOR HMT MORSE TAPER, WELDON, & VERSADRIVE COUNTERSINK BITS



						
Countersink Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
6.3 mm	765	505	265	1250	500	850
8.3 mm	565	375	190	955	405	705
10.4 mm	460	300	145	765	315	530
12.4 mm	385	255	110	635	265	480
16.5 mm	295	185	80	485	210	345
20.5 mm	230	155	50	385	165	280
25 mm	185	130	50	315	130	225
30 mm	155	105	35	265	105	185
40 mm	120	80	30	205	80	140
55 mm	95	60	25	145	70	120
63 mm	80	55	20	130	55	90
80 mm	65	40	20	100	45	75

## BEST PRACTICE ADVICE

	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage		Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
	Apply firm, steady feed pressure throughout the cut		Use at highest possible Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
	Avoid lateral movement or tilting which can cause damage to the tool		Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use at correct RPM (if unsure use tachometer to check drill speed)
	Ensure constant supply of quality cooling lubricant, especially when drilling thick or hardened materials.		Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant		

\* GUIDELINE PARAMETERS ONLY, ACTUAL PARAMETERS MAY VARY DEPENDING ON OPERATING CONDITIONS

**FOR SALES & TECHNICAL SUPPORT CALL:** UK: 03330 110 382  
INT: 0044 1622 740812