








STEP DRILL RPM DATA







RECOMMENDATIONS FOR HMT VERSADRIE STEP DRILLS

VERSADRIE
PATENT PENDING®



							
Step Drill Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics	Impact Torque
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Nm Torque
3-8 mm	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650	200-280
9-15 mm	1050-640	700-400	360-215	1065-640	450-245	650-380	260-340
16-22 mm	597-430	390-270	200-145	600-440	245-180	380-275	330-400
23-29 mm	420-330	260-215	140-110	420-330	175-135	275-180	400-485
30-36 mm	320-265	200-165	105-85	320-260	135-95	180-150	480-600
37-42 mm	260-230	160-145	85-75	260-230	95-85	150-140	610-750

BEST PRACTICE ADVICE

	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage		Ensure constant supply of quality cooling lubricant, especially when drilling thick or hardened materials.
	Apply firm, steady feed pressure throughout the cut		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
	Avoid lateral movement or tilting which can cause damage to the tool		When drilling into box section ensure the tip of the Step-Drill is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool.

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

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