Recommended Operating Speeds by material (r/mim)

Dia.	Mild Steel	Stainless Steels	Cast Iron	Brass	Aluminum	Wood	CODE
14	580	300	400	790	900	3000	
16	550	275	365	730	825	3000	XRS0016
17	500	250	330	665	750	3000	XRS0017
19	460	230	300	600	690	3000	XRS0019
20	435	240	290	580	660	3000	XRS0020
21	425	210	280	560	635	3000	XRS0021
22	390	195	260	520	585	3000	XRS0022
24	370	185	245	495	555	3000	XRS0024
25	350	175	235	470	525	2700	XRS0025
27	325	160	215	435	480	2700	XRS0027
29	300	150	200	400	450	2700	XRS0029
30	285	145	190	380	425	2400	XRS0030
32	275	140	180	360	410	2400	XRS0032
33	260	135	175	345	390	2400	XRS0033
35	250	125	165	330	375	2400	XRS0035
37	240	120	160	315	360	2400	XRS0037
38	230	115	150	300	345	2400	XRS0038
40	220	110	145	290	330	2100	XRS0040
41	210	105	140	280	315	2100	XRS0041
43	205	100	135	270	305	2100	XRS0043
44	195	95	130	260	295	2100	XRS0044
46	190	95	125	250	285	2100	XRS0046
48	180	90	120	240	270	2100	XRS0048
51	170	85	115	230	255	2000	XRS0051
52	165	80	110	220	245	2000	XRS0052
54	160	80	105	210	240	2000	XRS0054
57	150	75	100	200	225	2000	XRS0057
59	145	75	100	195	225	2000	XRS0059
60	140	70	95	190	220	2000	XRS0060
64	135	65	90	180	205	1800	XRS0064
65	130	65	85	175	200	1800	XRS0065
67	130	65	85	170	195	1800	XRS0067
68	130	65	85	170	195	1800	XRS0068
70	125	60	80	160	185	1800	XRS0070
73	120	60	80	160	180	1800	XRS0073
76	115	55	75	150	170	1500	XRS0076
79	110	55	70	140	165	1500	XRS0079
83	105	50	70	140	155	1500	XRS0083
86	100	50	65	130	150	1200	XRS0086
89	95	45	65	130	145	1200	XRS0089
92	95	45	60	120	140	1200	XRS0092
95	90	45	60	120	135	1200	XRS0095
98	90	45	60	120	135	1200	XRS0098
102	85	40	55	110	130	1000	XRS0102
105	80	40	55	110	120	1000	XRS0105
108	80	40	55	110	120	900	XRS0108
111	80	40	50	100	120	900	XRS0111
114	75	35	50	100	105	900	XRS0114
121	70	35	45	95	95	900	XRS0121
127	65	30	45	90	90	800	XRS0127
133	65	30	45	90	90	800	XRS0133
140	60	25	40	85	85	800	XRS0140
146	60	25	40	85	85	800	XRS0146
152	55	25	35	75	75	800	XRS0152

For sale use of Hole Saws use the correct rotation speed. The correct speed for each size is given in the table.

For longer saw life and lower operating costs, the following recommendations need to be observed.

1 . Use the correct arbor for the size saw to be used.

2. Use pin-type arbor for Hole Saws larger than 32. When mounting, lift up the disc with the plus and then screw the arbor down Into the hole saw as far as it will go. Fit the drive pins into the pin holes In the hole saw by tum lug the hole saw backwards. Push the pins in check that they are securely locked.

3. Check regularly to make sure the drive plus are in the right position.

4. Check that the arbor shank is securely inserted in the chuck on the drive unit tighten with chuck key.

5. Cutting oil should be used when sawing steel. Do not use cutting oil when sawing cast iron. The cutting pressure should, however, be high so that each tooth cuts deep. Paraffin can be used when sawing aluminum.

6. Use the correct rotation speed! Too high or too low a speed will decrease the life of the cutting edge.

7. If the hole saw vibrates during sawing, the teeth may become damaged and break. The result is often a rough, imperfect hole.

8. Apply the Hole Saw perpendicular to the work piece. If the Hole Saw is titled, this will cause uneven loading and abnormal wear on both the saw teeth and the grilling machine Moreover, the dimensional accuracy of the Hole saw can be affected.

9. Clear away chips and slugs frequently in-order to prevent over-heating.