









	
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
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
31 mm	155	105	35	265	105	185

**Refer to Page 86 for Pilot Hole Drilling Speeds**

**Best Practice Advice**

**GUIDELINE PARAMETERS ONLY** - Actual parameters may vary depending on operating conditions

<b>1</b> 	The DrillSink should be used with a Variable speed motor, and the drill and countersink operations should be run at the appropriate speed for each process	<b>6</b> 	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
<b>2</b> 	Apply firm, steady feed pressure throughout the cut	<b>7</b> 	Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
<b>3</b> 	Avoid lateral movement or tilting which can cause damage to the tool	<b>8</b> 	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)
<b>4</b> 	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	<b>9</b> 	Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
<b>5</b> 	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant	<b>10</b> 	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage

**Quick Guide**

<b>1</b>	<i>Optimum life and performance when used with rotary pistol drills or drill presses</i>
<b>2</b>	<i>Up to 16.5mm can be used on impact wrench &amp; impact drivers for fast cutting performance</i>
<b>3</b>	<i>Suitable for harder materials such as stainless steel when used at reduced RPM</i>
<b>4</b>	<i>Use appropriate lubrication and correct RPM to achieve long tool life</i>