



**Revolutions per minute (Rotary)**

Drill Bit Diameter	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
3- 4MM	3400-2550	1700-1250	850-700	3400-2550	2000-1300	4300-2000	5200-3500
5 - 9MM	2100-1140	1020-575	760-420	2050-1130	1200-600	1750-1040	3400-1550
10-15MM	1030-660	520-350	385-225	1020-660	550-340	1025-620	1500-950
16-20MM	640-490	335-230	220-195	640-510	330-250	600-470	975-745
21-25MM	460-330	220-140	190-150	500-410	240-200	460-350	730-500
26-32MM	310-250	140-110	150-120	320-275	200-175	335-320	400-315



Impact wrench / Impact Driver Required Nm Torque										
6mm	6.8mm	7mm	8mm	8.5mm	9mm	10mm	11mm	12mm	13mm	14mm
140 Nm	170 Nm	195 Nm	240 Nm	270 Nm	360 Nm	375 Nm	405 Nm	420 Nm	435 Nm	440 Nm

**Best Practice Advice**

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

<b>1</b> 	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	<b>4</b> 	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
<b>2</b> 	Apply firm, steady feed pressure throughout the cut	<b>5</b> 	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
<b>3</b> 	Avoid lateral movement or tilting which can cause damage to the tool	<b>6</b> 	VersaDrive Drill Bits up to 10mm diameter can be driven by an Impact wrench (in rotary mode only)

**Quick Guide**

<b>1</b>	<i>Drill Bit - Optimum life and performance when used with rotary pistol drills</i>
<b>2</b>	<i>Drill Bit - Up to 10mm can be used on impact wrench &amp; impact drivers for fast cutting performance</i>
<b>3</b>	<i>Drill Bit - Suitable for harder materials such as stainless steel when used at reduced RPM</i>
<b>4</b>	<i>Turbo Tip - For fastest performance use on impact wrenches &amp; impact drivers</i>
<b>5</b>	<i>Turbo Tip - For optimum life and accuracy use with pistol drills and magnet drills</i>
<b>6</b>	<i>Turbo Tip - Suitable for use on standard construction grade steels such as Structural or Stainless Steel.</i>
<b>7</b>	<i>Use appropriate lubrication and correct RPM to achieve long tool life</i>