

Cobalt Vari-Pitch Holesaw



USER INSTRUCTIONS

- Wear appropriate Personal Protective Equipment (P.P.E) when using holesaws.
- Ensure holesaw is correctly attached to the relevant adaptor for your machine.
- Use holesaw at the recommended speeds for the material being drilled as shown in the chart.
- Use as appropriate cutting lubricant when drilling in steel.
- After producing a hole, remove the "slug" of the material from the throat of the holesaw before commencing another hole.
- After pilot drill penetration be careful not to "bang" the holesaw onto the surface of the material to be drilled. This could damage or break the cutting teeth.

MATERIAL RECOMMENDATIONS

| | | |
|-----------------|---|-----------------|
| Mild Steel | ● | ● Very suitable |
| Stainless Steel | ● | ● Suitable |
| Cast Iron | ● | |
| Aluminium | ● | |
| Brass | ● | |
| Wood | ● | |
| Plastic | ● | |

OPERATIONAL SPEED CHART

| Diameter | Mild Steel | Stainless Steel | Aluminium | Cast Iron | Brass | Wood | Drive arbors mm |
|----------|------------|-----------------|-----------|-----------|-------|------|-------------------|
| 16 | 550 | 275 | 825 | 365 | 730 | 3000 | Use with 14 - 29 |
| 20 | 425 | 210 | 635 | 280 | 560 | 3000 | Use with 14 - 29 |
| 22 | 390 | 195 | 585 | 260 | 520 | 3000 | Use with 14 - 29 |
| 25 | 350 | 175 | 525 | 235 | 470 | 2700 | Use with 14 - 29 |
| 32 | 275 | 140 | 410 | 180 | 360 | 2400 | Use with 32 - 152 |
| 35 | 250 | 125 | 375 | 165 | 330 | 2400 | Use with 32 - 152 |
| 38 | 230 | 115 | 345 | 150 | 300 | 2400 | Use with 32 - 152 |
| 40 | 215 | 110 | 315 | 140 | 280 | 2100 | Use with 32 - 152 |
| 44 | 195 | 95 | 295 | 130 | 260 | 2100 | Use with 32 - 152 |
| 51 | 170 | 85 | 255 | 115 | 230 | 2000 | Use with 32 - 152 |
| 54 | 160 | 80 | 240 | 105 | 210 | 2000 | Use with 32 - 152 |
| 57 | 150 | 75 | 225 | 100 | 200 | 2000 | Use with 32 - 152 |
| 60 | 140 | 70 | 220 | 95 | 190 | 2000 | Use with 32 - 152 |
| 64 | 135 | 65 | 205 | 90 | 180 | 1850 | Use with 32 - 152 |
| 65 | 135 | 60 | 205 | 90 | 180 | 1850 | Use with 32 - 152 |
| 67 | 130 | 65 | 195 | 85 | 170 | 1800 | Use with 32 - 152 |
| 70 | 125 | 60 | 185 | 80 | 160 | 1800 | Use with 32 - 152 |
| 73 | 120 | 60 | 180 | 80 | 160 | 1800 | Use with 32 - 152 |
| 76 | 115 | 55 | 170 | 75 | 150 | 1800 | Use with 32 - 152 |
| 79 | 110 | 55 | 165 | 70 | 140 | 1500 | Use with 32 - 152 |
| 83 | 105 | 50 | 155 | 70 | 140 | 1500 | Use with 32 - 152 |
| 86 | 100 | 50 | 145 | 65 | 130 | 1500 | Use with 32 - 152 |
| 89 | 95 | 45 | 145 | 65 | 130 | 1200 | Use with 32 - 152 |
| 95 | 90 | 45 | 135 | 60 | 120 | 1200 | Use with 32 - 152 |
| 102 | 85 | 40 | 130 | 55 | 110 | 1000 | Use with 32 - 152 |
| 111 | 75 | 35 | 110 | 50 | 100 | 900 | Use with 32 - 152 |
| 114 | 75 | 35 | 105 | 50 | 100 | 900 | Use with 32 - 152 |
| 127 | 65 | 30 | 90 | 40 | 80 | 800 | Use with 32 - 152 |
| 152 | 55 | 25 | 80 | 35 | 70 | 800 | Use with 32 - 152 |



Thickness of cut: 3mm
- 25mm (50mm when
cut from both sides)



Use in power
tools with a 3
jaw chuck



Use in portable
drilling machine



Wear eye
protection



Wear hearing
protection



Wear a face mask



Wear hand
protection