

RECOMMENDED OPERATING SPEEDS FOR BI-METAL HOLESAWS

HOLESAW SIZE (INCHES)	HOLESAW SIZE (MM)	MILD STEELS (R.P.M)	STAINLESS STEELS (R.P.M)	CAST IRON (R.P.M)	BRASS (R.P.M)	ALU. (R.P.M)	HOLESAW SIZE (INCHES)	HOLESAW SIZE (MM)	MILD STEELS (R.P.M)	STAINLESS STEELS (R.P.M)	CAST IRON (R.P.M)	BRASS (R.P.M)	ALU. (R.P.M)
9/16"	14	580	300	400	790	900	2 1/4"	57	150	75	100	200	225
5/8"	16	550	275	365	730	825	2 5/16"	59	145	75	100	195	225
1 1/16"	17	500	250	330	665	750	2 3/8"	60	140	70	95	190	220
3/4"	19	460	230	300	600	690	2 7/16"	62	135	70	95	185	215
25/32"	20	480	240	315	632	720	2 1/2"	64	135	65	90	180	205
13/16"	21	425	210	280	560	635	2 9/16"	65	130	65	85	175	200
7/8"	22	390	195	260	520	585	2 5/8"	67	130	65	82	170	195
15/16"	24	370	185	245	495	555	2 11/16"	68	125	60	80	165	190
1"	25	350	175	235	470	525	2 3/4"	70	125	60	80	160	185
1 1/16"	27	325	160	215	435	480	2 7/8"	73	120	60	75	160	180
1 1/8"	29	300	150	200	400	450	3"	76	115	55	70	150	170
1 3/16"	30	285	145	190	380	425	3 1/8"	79	110	55	70	140	165
1 1/4"	32	275	140	180	360	410	3 1/4"	83	105	50	65	140	155
1 5/16"	33	260	135	175	345	390	3 3/8"	86	100	50	65	130	150
1 3/8"	35	250	125	165	330	375	3 1/2"	89	95	45	60	130	145
1 7/16"	37	240	120	160	315	360	3 5/8"	92	95	45	60	120	140
1 1/2"	38	230	115	150	300	345	3 3/4"	95	90	45	60	120	135
1 9/16"	40	220	110	145	290	330	3 7/8"	99	90	45	55	120	135
1 5/8"	41	210	105	140	280	315	4"	102	85	40	55	110	130
1 11/16"	43	205	100	135	270	305	4 1/8"	105	80	40	55	110	120
1 3/4"	44	195	95	130	260	295	4 1/4"	108	80	40	55	110	120
1 13/16"	46	190	95	125	250	285	4 3/8"	111	80	40	50	100	120
1 7/8"	48	180	90	120	240	270	4 1/2"	114	75	35	50	100	105
2"	50	170	85	115	230	255	4 3/4"	121	70	35	45	95	95
2 1/16"	52	165	80	110	220	245	5"	127	65	30	45	90	90
2 1/8"	54	160	80	105	210	240	5 1/2"	140	60	25	40	85	85
							6"	152	55	25	35	75	80

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