HOLEMAKER-TECHNOLOGY.COM

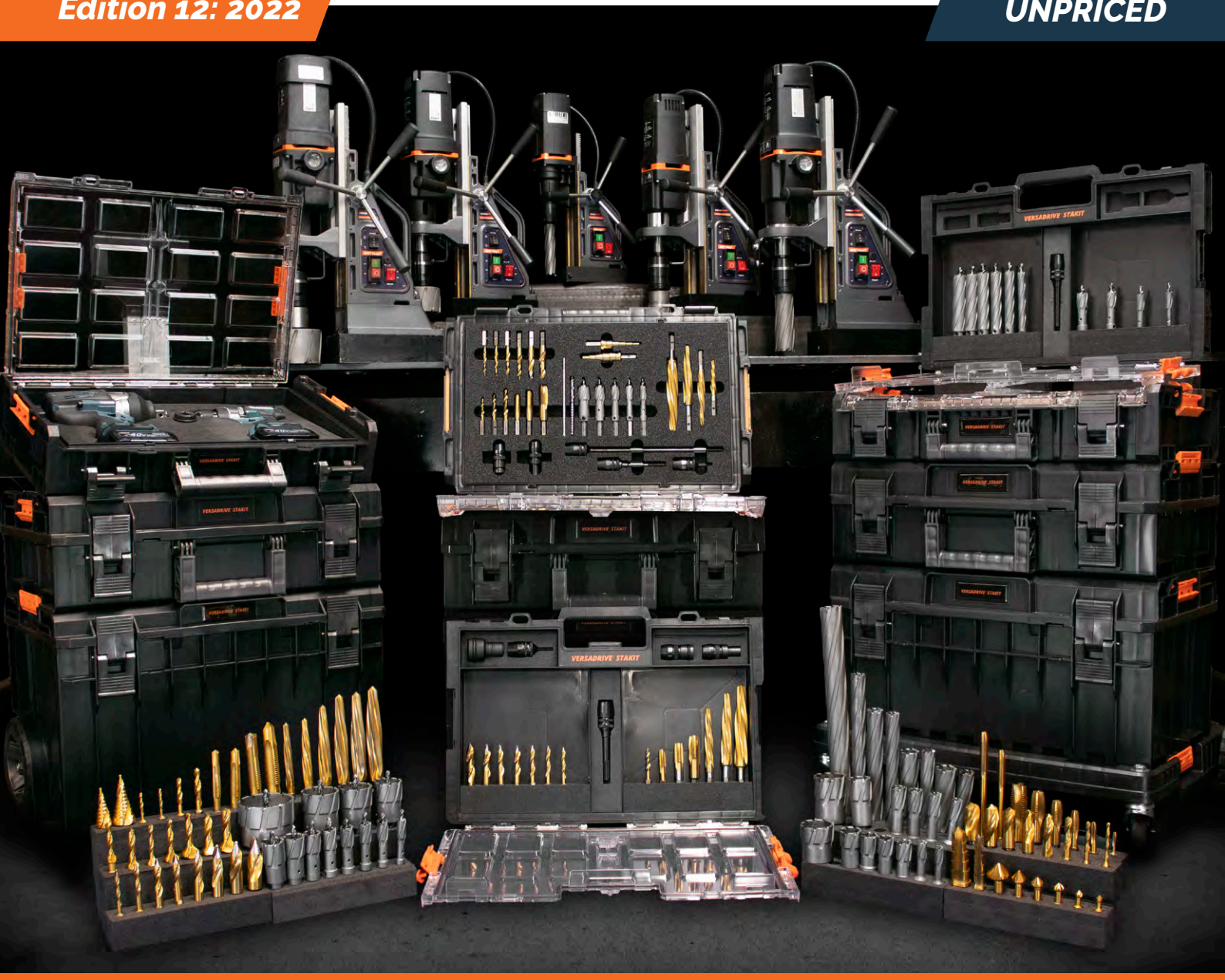
HMT

Cutting Tool Innovation

Speed up Metalworking

Edition 12: 2022

UNPRICED



VERSADRIVE®

PATENT PROTECTED

HOLEMAKER-TECHNOLOGY.COM

HMT

OUR STORY

Initially working in a small family-run welding & engineering supplies business we received a stream of requests for specialist metal drilling tools that didn't exist no matter where we looked.

As we investigated further we discovered that drilling or modifying steel connection holes when limited to the use of portable or hand-held tools seemed to be the biggest pain point in the industry. These challenges would often contribute to missed deadlines and painful project over-runs. If specifications changed at the last minute, fabrication errors were made or emergency repairs were needed, the tools needed to get the job done quickly just didn't exist in the marketplace.

The industry needed a solution so in response we formed Holemaker Technology with one aim in mind: To speed up metalworking through cutting tool innovation.

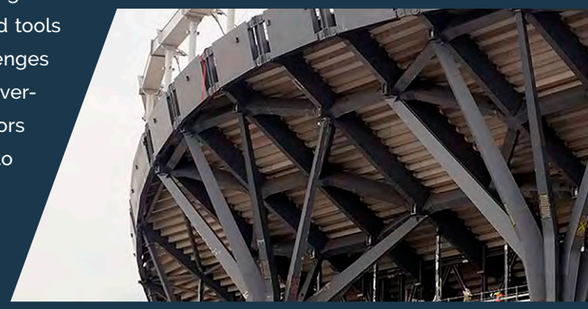
Combining our pioneering, impact rated and now patented VersaDrive system with the latest generation of high-torque cordless power tools has created a revolutionary level of drilling speed & performance, never before possible with portable tools.

8 years, around 500,000 tools and a patent or two later, these game-changing products are now sold widely in over 50 countries around the world.

There is a long way still to go and we invite you to join our journey and help us continue to improve and speed up metalworking.

Regards

Piers Crane & Hugh Crane - Co-Founders



WHAT WE DO

Holemaker Technology is a specialist manufacturer of cutting and drilling products

We make the tools that allow you to create and modify the connection holes which hold our world together.

Our specialist area is Portable Cutting & Drilling tools, for those times you have to take the tools to the job.

We focus on relentless product innovation and improvement so we can provide the metalwork and fabrication industries with unique tooling that speeds up any task involving working with connection holes.

WORKING WITH US

HOLEMAKER-TECHNOLOGY.COM
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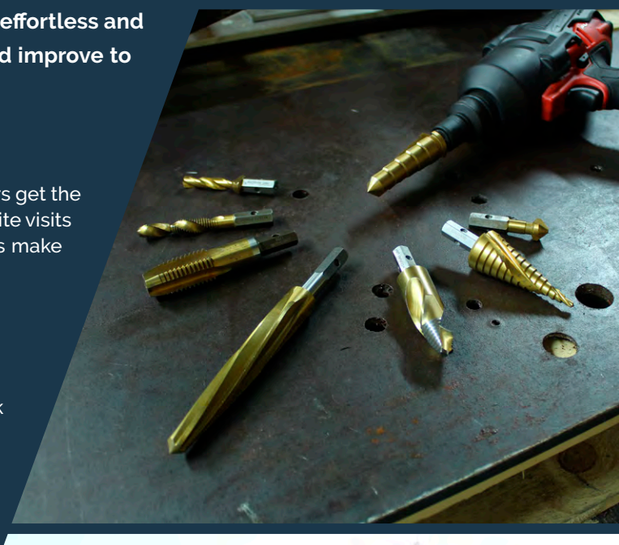
We want every experience that you have with HMT to be effortless and enjoyable. Here's the 4 pillars we constantly work on and improve to deliver this.



SUPPORT

One of our core values is "Optimise", and this means helping users get the best out of their HMT tooling, with training, demonstrations and site visits in addition to data sheets and training videos. Over 300 dealers make the products available throughout more than 50 countries.

SERVICE

With a stock holding of more than £1M we have over 95% stock availability on catalogue items meaning orders placed by 3PM will be shipped to you the same day. Your order will be processed & confirmed within 2 hours and courier tracking will be emailed on dispatch of goods. Barcoded warehousing technology ensures total picking accuracy.

PRODUCTS

The motto here is - if the products are right, then the success will follow. A relentless focus on quality control and Patent-protected innovation means that each HMT product is created to be a market leader in its own right.

TEAM

A hand picked team full of energy and enthusiasm, with industry experience drawn from market leading industrial brands.

OUR MISSION & VALUES

HMT MISSION — *To speed up metalworking through cutting tool innovation*

HMT VISION — *To be the leading brand of fabricators cutting tools*

THE 5 HMT VALUES — *Innovate, Specialise, Optimise, Be Agile and Be Nice*

VERSADRIVE©
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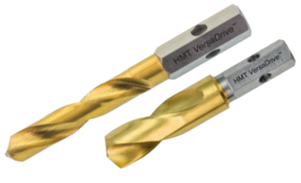

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CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

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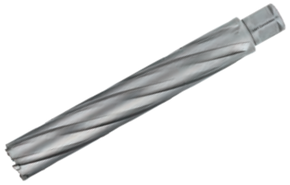

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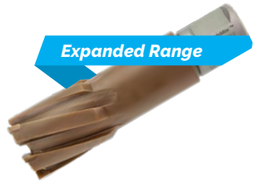

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VERSADRIVE®

PATENT PROTECTED

The world's 1st modular quick-change cutting & drilling system for use with both Impact and Rotary tools

VersaDrive by Holemaker Technology is the 1st modular cutting system in the world that allows cutting tools to be used across Impact Wrenches/Drivers as well as Rotary drills like Magnet drills, Hand-Held drills and Pillar drills.

This innovative system features a range of Impact rated and Rotary rated cutting tools as well as a collection of specially designed and custom engineered adapters to rapidly fit cutting tool to power tool, with fast tool changeover.

Tools in the range have also been specifically designed and developed to outperform and outlast the closest comparable products. With faster cuts, longer life and more holes per product VersaDrive tools save time, money & increase productivity.

IMPACT & ROTARY RATED

WHY IMPACT?

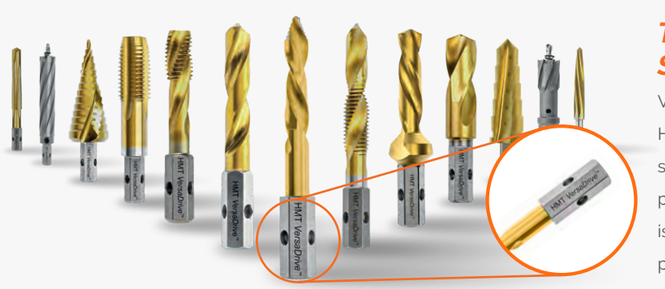
For high speed applications like drilling, reaming and tapping VersaDrive's range of Impact Rated tools and adapters offer precision performance alongside the speed, safety and controlled power offered by Impact drivers and wrenches.

Phenomenal cutting performance is achieved through the design of the tool, cutting with the double hardened edges of the cutting face rather than the tip.

WHY ROTARY?

For slow speed applications like heavy duty tapping, countersinking or broaching with a holesaw optimum performance can be achieved by cutting with the tip and flutes of the tool.

Our rotary rated range of tools have been designed to do just this and provide excellent cutting performance whilst outlasting any comparable tool on the market.



The VersaDrive Patent Protected Shank System

VersaDrive Patent-Protected Hex shank. The VersaDrive Hexagon shank design fits into all standard drill chucks. No slipping in the chuck like standard tools. Three concentric lock positions give perfect alignment and accuracy when the tooling is used in any of the modular adapters to optimise metalworking processes and increase the tools working life.

Features & Benefits

- *Up to 10x longer life*
- *Up to 15x faster than standard everyday methods*
- *Quick-change, Rapid-Lock adapters*
- *Dual hardened for Impact use*
- *High-Grade tool steel*
- *Non-Slip Hex shank fits all standard 1/2" drill chucks*
- *Safer working - minimal kickback*
- *Precision ground for accurate, clean holes*
- *GoldMax low-friction titanium coating to stop burn-out*

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NEW

VersaDrive STAKIT Impact Starter Kit

L x W x H (mm) - 540 x 390 x 95

N.B. STAKIT Mid Case required to connect Top case to Base cases

Part No	Product
STC-TOP-VSD01	***STAKIT*** Impact Starter Kit - Metric
STC-TOP-VSD02	***STAKIT*** Impact Starter Kit - Inch

The VersaDrive® ***STAKIT*** Top box is the crowning case of the ***STAKIT*** system. Available as either complete kitted sets or in 'Build Your Own' formats, the top case can hold up to 16 tools across either the VersaDrive or CarbideMax ranges, or a combination of both, plus 5 VersaDrive adapters.

The Impact Starter Kit, pictured here, features essential Impact rated tooling that solves almost all common hole making challenges on site.

Metric Sized Kit Contents:

3 x Reamers 14, 18, 22mm
3 x DrillTaps M6, M8, M10
3 x ImpactaTaps M12, M16, M20
7 x TurboTips 6.8, 8, 8.5, 10, 10.5, 12 & 14mm

• 3 x VersaDrive Rapid-Lock Adapters
1/4" Impact Driver Adapter
1/2" Impact Wrench Adapter
130mm Extension

Inch Sized Kit Contents:

3 x Reamers 9/16, 11/16, 13/16"
3 x DrillTaps 1/4-20, 5/16-18, 3/8-16 UNC
3 x ImpactaTaps 1/2-13, 5/8-11, 3/4-10 UNC
7 x TurboTips #F, 9/32, 5/16, 3/8, 27/64, 7/16, 1/2"

• 3 x VersaDrive Rapid-Lock Adapters
1/4" Impact Driver Adapter
1/2" Impact Wrench Adapter
130mm Extension

VERSADRIVE© PATENT PROTECTED

NEW

VersaDrive STAKIT Site Installation Kit

L x W x H (mm) - 582 x 387 x 131

Part No	Contents
STC-EMID-MEIK	***STAKIT*** 31pc Installation Kit - Metric
STC-EMID-INIK	***STAKIT*** 31pc Installation Kit - Inch Sizes

The ***STAKIT*** Site Installation Kit is created to combine an essential set of best-selling VersaDrive products to overcome all common site installation and steel erection holemaking challenges. Keeps the job moving when you find an unexpected challenge.

Presented in the ***STAKIT*** Mid Case and connects to all Top cases and Base cases.

Metric Sized Kit Contents:

6 x TurboTips 6, 6.35, 8.0, 10.5, 12, 14mm
5 x HoleCutters 14, 17, 18, 20 & 22mm
2 x ImpactaStep 16 & 22mm
3 x DrillTaps M6, M8 & M10
3 x ImpactaTaps M12, M16 & M20
4 x Reamers 12, 14, 18 & 22mm

• 5x Rapid lock adapters
1/4" Impact Driver Adapter
1/2" Impact Wrench Adapter
Magnet Drill Adapter
130mm Extension
300mm Extension

Inch Sized Kit Contents:

6 x TurboTips 1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
5 x HoleCutters 9/16, 5/8, 3/4, 7/8, 1"
2 x ImpactaStep 9/16, 13/16"
3 x DrillTaps 5/16, 3/8, 1/2"
3 x ImpactaTaps 1/2, 5/8, 3/4"
4 x Reamers 1/2, 9/16, 11/16, 13/16"

• 5x Rapid lock adapters
1/4" Impact Driver Adapter
1/2" Impact Wrench Adapter
Magnet Drill Adapter
130mm Extension
300mm Extension

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VersaDrive 1/4" Rapid-Lock Impact Driver Adapter

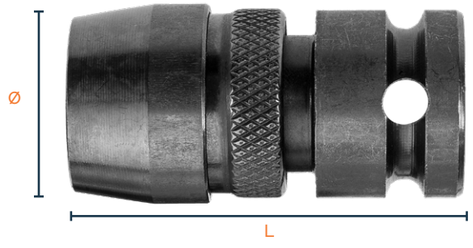
Part No	Drive Size	Ø mm	L mm
111026-014A	1/4" Hex	28	75

Adapter Benefits

This upgraded VersaDrive Impact Driver adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/4" Hex Impact Drivers.
- Converts standard 1/4" Impact Drivers for use with VersaDrive

VersaDrive 1/2" Rapid-Lock Impact Wrench Adapter



Part No	Drive Size	Ø mm	L mm
111130-012A	1/2" Drive	28	55

Adapter Benefits

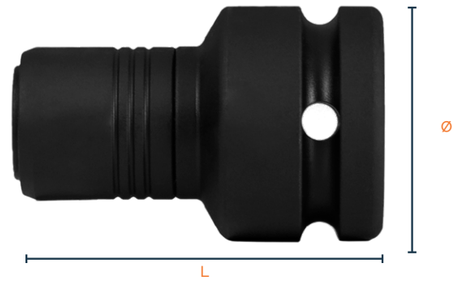
Rated to 650nm
Supplied with retention pin & ring

This upgraded VersaDrive Impact Wrench adapter features:

- New Rapid-Lock, single handed loading action
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/2" Impact Wrenches
- Converts standard 1/2" Impact Wrenches for use with VersaDrive

VERSADRIVE©
PATENT PROTECTED

VersaDrive 3/4" Heavy Duty Impact Wrench Adapter

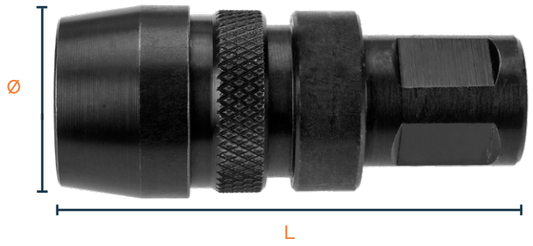


Part No	Drive Size	Ø mm	L mm
111120-012A	1/2" Drive	25	55
111120-034A	3/4" Drive	38	60

Adapter Benefits

- Impact hardened Manganese Phosphate adapter
- Heavy Duty Pull-Forward Release mechanism with hardened steel collar
- Developed to work with latest generation of high torque cordless impact wrenches capable of generating above 1,000Nm of Torque

VersaDrive Rapid-Lock Weldon Adapter



Part No	Shank Size	Ø mm	L mm
111035-01	19.05mm / 3/4"	28	66

Adapter Benefits

This upgraded VersaDrive Magnet Drill adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar mechanism preventing accidental tool release caused by vibrations or contact with the workpiece
- Fits to all standard magnet drills with 19mm (3/4") Weldon magnet drill shank

VERSADRIVE©
PATENT PROTECTED

VersaDrive Rapid-Lock SDS+ Adapter

Part No	Ø mm	L mm
112010-01	28	140

Adapter Benefits

This upgraded SDS+ VersaDrive adapter features:

- New Rapid-Lock, single handed loading action
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Converts all standard SDS+ Rotary Hammer Drills for use with VersaDrive system (Use in rotary mode only)

VersaDrive Rapid-Lock Extension Arbor - 300mm

Part No	Ø	L
111015-300	28mm	300mm

Adapter Benefits

- Extends the working reach of all VersaDrive tools
- Rapid-Lock, single handed loading action and can also be used in combination with other Versadrive adapters
- Hex shank for non-slip use in any drill chuck
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Rated for impact wrench use

VERSADRIVE©
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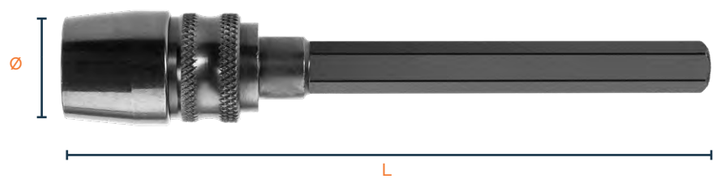
VersaDrive Rapid-Lock Extension Arbor - 130mm



Part No	Shank Size	Ø mm	L mm
111015-130	11mm	28	130mm

Adapter Benefits

- Extends the working reach of all VersaDrive tools
- Rapid-Lock, single handed loading action and can also be used in combination with other Versadrive adapters
- Hex shank for non-slip use in any drill chuck
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Rated for impact wrench use

NEW

VersaDrive Morse Taper Arbor

Part No	Shank Size	Ø mm	L mm
111045-02	MT2	28	130
111045-03	MT3	28	147

Adapter Benefits

- Ideal for workshop use with radial arm drills & pillar drills
- Rapid-Lock, single handed loading action
- Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components

IMPACT RATED

VersaDrive ImpactaStep Cutter

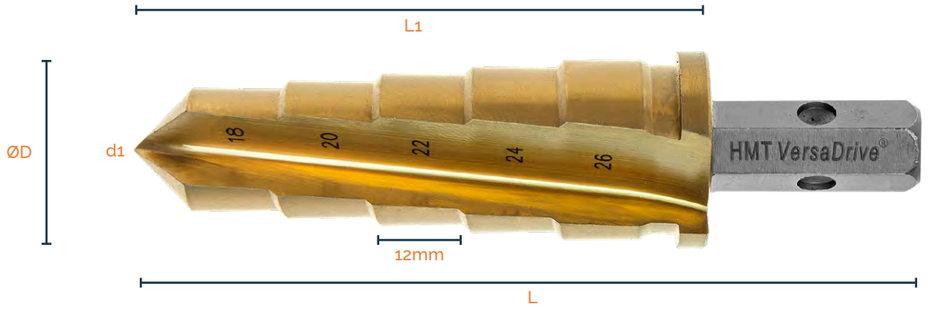
CREATES HOLES IN SECONDS

VERSADRIVE® PATENT PROTECTED

A Versadrive exclusive innovation, the ImpactaStep Cutter offers combined drilling and reaming on materials up to 12mm thick..

Featuring 5 individual cutting diameters and a straight flute design for strength and easy resharpening, the ImpactaStep Cutter is optimised for use with Impact Drivers and Impact Wrenches as well as the latest range of VersaDrive Premium Magnet Drills.

VersaDrive ImpactaStep Cutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- *5 drill bits in one*
- *Create & enlarge holes in material up to 12mm thick*
- *Safety breakthrough collar to prevent injury & damage*
- *Fast, smooth drilling & reaming with minimal kickback*
- *Specially hardened for impact wrench use*
- *GoldMax low-friction titanium coating to stop burn out*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

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Use with any standard drill chuck

Magnet Drill Adapter
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SDS+ Adapter
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Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Pilot drilling is recommended for a faster operation and to enhance tool life*
- *When used for reaming, tool should be rotating before starting cut with steady pressure*

Watch the video & find more info online

VersaDrive ImpactaStep Cutter

	Part No	Ø D mm	d1 mm	l1 mm	L mm	Step Diameters	Step Depth
Metric	**506010-0160**	**16**	8	79	107	8 - 10 - 12 - 14 - 16mm	12mm
	506010-0220	**22**	14	82	110	14 - 16 - 18 - 20 - 22mm	12mm
	506010-0260	**26**	18	84	112	18 - 20 - 22 - 24 - 26mm	12mm
	506010-0320	**32**	24	87	115	24 - 26 - 28 - 30 - 32mm	12mm
Inch	**506030-0010**	**9/16"**	5/16"	12	4 3/16"	5/16 - 3/8 - 7/16 1/2 - 9/16"	12mm
	506030-0020	**13/16"**	9/16"	12	4 5/16"	9/16 - 5/8 - 11/16 3/4 - 13/16"	12mm
	506030-0030	**1 1/16"**	13/16"	12	4 7/16"	13/16 - 7/8 - 15/16 1 - 1 1/16"	12mm

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	○	○	●	●	●
●	○	×	●	●	●
●	×	×	○	●	●
●	×	×	○	●	●

● ***Optimal*** ○ ***Possible (Refer to data sheet)***
× ***Not Recommended***

ImpactaStep Sets

Part No:	Set Contents
506010-SET1	HMT VersaDrive IMPACTASTEP Cutter Set 16, 22, 26mm
506030-SET1	VersaDrive IMPACTASTEP Cutter Set, 9/16, 13/16, 1-1/16"

"My favourite tool must be the new ImpactaStep cutter. Being able to carry just a few TurboTip drill bits & the cutter means most work can be tackled. Often used with 12v impact tools."

James Sinclair
Dexta Moors

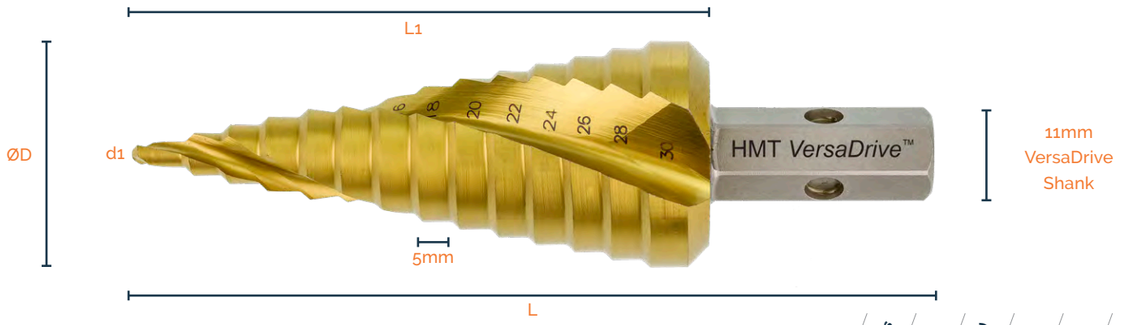
VersaDrive Impact Step Drills

VERSADRIVE® PATENT PROTECTED

The first step drill optimised for use with impact wrenches & impact drivers allowing the user to create holes in seconds.

Featuring a spiral flute design with self-starting drill tip, for fast, smooth drilling with a rotary drill or impact wrench and market leading 5mm thick drilling capacity.

VersaDrive Step Drills have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

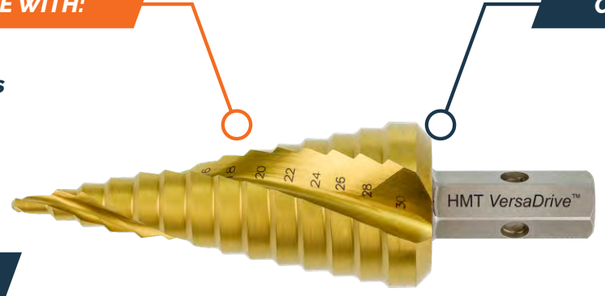
- *Market Leading 5mm thick drilling capacity*
- *Fast, smooth drilling with minimal kickback*
- *Specially hardened for impact wrench use*
- *Precision ground flutes with easy chip clearance*
- *118° split point angle for easy starting & accuracy*
- *GoldMax low-friction titanium coating to stop burn out*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS

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Impact Wrench Adapter
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Use with any standard drill chuck

SDS+ Adapter
112010-01
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Extension - 300mm
111015-300
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Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Excellent life and performance when used with rotary pistol drills or drill presses*
- *Suitable for stainless and harder materials if used at low RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive Step Drill

	Part No	Ø D	l1	L	Step Diameters	Step Depth
Metric	505020-0120	12mm	47mm	75mm	4, 6, 8, 10, 12mm	5mm
	505020-0220	22mm	58mm	86mm	4, 6, 8, 10, 12, 14, 16, 18, 22mm	5mm
	505020-0300	30mm	77mm	105mm	4, 6, 8, 10, 12, 14, 16, 18, 22, 24, 26, 28, 30mm	5mm
	505020-0400	40mm	72mm	101mm	6, 8, 10, 12, 16, 20, 25, 29, 32, 36, 40mm	6mm
	Electrical Step Drill 4-32.5mm					
	505040-0320	32.5mm	70mm	99mm	4, 6, 8.5, 10.5, 12.5, 14.5, 16, 18.5, 20.5, 23.5, 25, 30.5, 32.5mm	5mm
Inch	505030-0010	1/2"	1-1/2"	2-43/64	3/16, 1/4, 5/16, 3/8, 7/16, 1/2"	3/16"
	505030-0020	7/8"	2-9/32"	3-15/32	3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8"	3/16"
	505030-0030	1 3/8"	1-31/32	3 5/32	1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1-1/8, 1-1/4, 1-3/8"	3/16"

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
○	×	○	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Step Drill Sets

Part No:	Set Contents
505020-SET1	3 piece Set: 12, 22, 30mm Step Drills
505020-SET2	4 piece Set: 12, 22, 30, 40mm Step Drills
505030-SET1	3 piece Set: 1/2, 7/8, 1-3/8" Step Drills

VersaDrive Impact Reamers

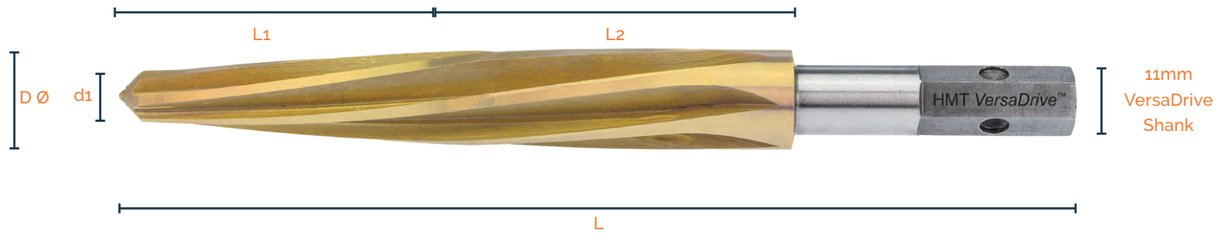
ENLARGE OR ALIGN EXISTING HOLES WITH AN IMPACT WRENCH

VERSADRIVE® PATENT PROTECTED

VersaDrive reamers are the perfect hole alignment and enlarging tool for metalworkers & steel erectors for keeping the job moving when a hole is misaligned or the incorrect size for the fixing.

Featuring a specially designed 6 flute cutting geometry and Titanium coating, VersaDrive Reamers are fully Impact rated and perform fastest when used with an Impact wrench providing ultimate cutting performance with virtually no powertool kickback.

VersaDrive Reamers have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- *Precision 6-flute design for smooth cutting*
- *Safer reaming with minimal kickback*
- *Specially hardened for impact wrench use*
- *High grade tool steel for high accuracy and long life*
- *Goldmax low-friction titanium coating to stop burn-out*
- *High strength, non-slip shank design*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

SDS+ Adapter Extension Arbor

ADAPTERS

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

Magnet Drill Adapter
111035-01
Page 13

Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Not recommended for impact use with Flame or Plasma cut holes. Use with a Magnet Drill*
- *Reamer should be rotating before starting the cut & steady feed pressure used throughout*
- *For materials thicker than 20mm use of ImpactaMag reamers is recommended - see p.83*

Watch the video & find more info online

VersaDrive Reamers

	Part No.	D Ø mm	d1 Ø mm	l1 mm	l2 mm	L mm	Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
							Powertool Recommendations (Mild Steel Material)					
Metric	501030-0080	8mm	4.4	34	36	108	●	●	○	●	●	○
	501030-0100	10mm	6	34	36	108	●	●	○	●	●	○
	501030-0120	12mm	7.1	43	59	144	●	●	○	●	●	○
	501030-0140	14mm	7.5	52	50	144	●	●	×	○	●	○
	501030-0160	16mm	8.0	58	56	152	●	●	×	○	●	○
	501030-0180	18mm	9.4	58	56	170	●	○	×	○	●	○
	501030-0200	20mm	11.2	61	65	178	●	○	×	○	●	○
	501030-0210	21mm	12.3	61	66	185	●	○	×	○	●	○
	501030-0220	22mm	13.2	61	66	185	●	○	×	○	●	○
	501030-0240	24mm	15.1	62	66	185	●	○	×	○	●	○
	501030-0260	26mm	15.9	63	66	185	●	○	×	○	●	○
Inch	501040-0040	1/2" (12.7mm)	19/64"	1-15/16"	2-1/16"	5 1/2"	●	●	●	●	●	○
	501040-0050	9/16" (14.3mm)	9/32"	2-1/16"	1-15/16"	5 1/2"	●	●	●	●	●	○
	501040-0060	5/8" (15.9mm)	5/16"	2-11/64"	2-21/64"	6"	●	●	×	●	●	○
	501040-0070	11/16" (17.5mm)	3/8"	2-1/4"	2-1/4"	6"	●	○	×	●	●	○
	501040-0080	3/4" (19.05mm)	13/32"	2-31/64"	2-33/64"	7"	●	○	×	○	●	○
	501040-0085	13/16" (20.63mm)	15/32"	2-33/64"	2-31/64"	7"	●	○	×	○	●	○
	501040-0090	7/8" (22.2mm)	17/32"	2-19/32"	2-13/32"	7"	●	○	×	○	●	○
	501040-0100	15/16" (23.8mm)	19/32"	2-43/64"	2-21/64"	7"	●	○	×	○	●	○
	501040-0110	1" (25.4mm)	5/8"	2-43/64"	2-21/64"	7"	●	○	×	○	●	○
	501040-0120	1-1/16" (27mm)	45/64"	2-9/16"	2-7/16"	7"	●	○	×	○	●	○

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Reamer Sets

Part No:	Set Contents
501030-3SET	Set contains: 14, 18, 22mm VersaDrive Reamers
501030-SET	Set contains: 12, 14, 18, 22, 26mm VersaDrive Reamers
501040-3SET	Set contains: 1/2, 5/8, 3/4" VersaDrive Reamers
501040-5SET	Set contains: 1/2, 5/8, 3/4, 7/8, 1 1-16" VersaDrive Reamers

IMPACT RATED

VersaDrive TurboTip® Drill Bits

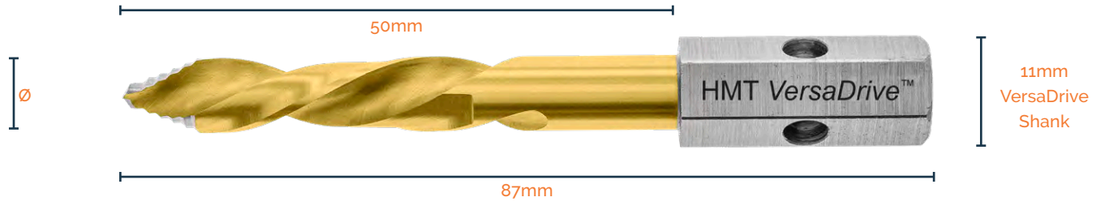
DRILLS AT 2X THE SPEED WITH NO PILOT DRILLING NEEDED

VERSADRIVE® PATENT PROTECTED

VersaDrive TurboTip Impact drill bits are stepped tip bits that drill at twice the speed of standard bits without the need for pilot drilling while cutting a perfectly round hole.

Turbocharge your drilling performance by using this revolutionary tool with an impact wrench or impact driver. Double hardened and titanium coated for faster drilling & reduced wear.

VersaDrive TurboTip drill bits have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- *Patented Drill Point*
- *50% Faster Drilling with 30% less pressure*
- *Incredible Finished Hole quality*
- *Instant drill start with no slipping*
- *No 'snatch' when drill bit breaks through*
- *Fully Impact Rated on structural steel*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

Magnet Drills
SDS+ Adapter
Extension Arbor

ADAPTERS

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 13

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *For optimum life and accuracy use with pistol drills and magnet drills*
- *Suitable for use on Stainless Steel and harder materials if used at low RPM in rotary tools*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive TurboTips

	Part No.	Ø D mm	Tap Size 308010 ImpactaTap		Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
					Powertool Recommendations (Mild Steel Material)					
Metric	209015-0060	6.0mm			●	●	●	●	●	●
	209015-0068	6.8mm	M8		●	●	●	●	●	●
	209015-0070	7.0mm			●	●	●	●	●	●
	209015-0080	8.0mm			●	●	●	●	●	●
	209015-0085	8.5mm	M10		●	●	●	●	●	●
	209015-0090	9.0mm			●	●	●	●	●	●
	209015-0100	10mm			●	●	●	●	●	●
	209015-0105	10.5mm	M12		●	●	●	●	●	●
	209015-0110	11mm			●	●	●	●	●	●
	209015-0120	12mm	M14		●	●	●	●	●	●
	209015-0130	13mm			●	●	●	●	●	●
	209015-0140	14mm	M16		●	○	●	●	●	●
	209015-0160	16mm			○	×	○	●	●	●
	209015-0180	18mm			○	×	○	○	●	○
	209015-0200	20mm			○	×	○	○	●	○
	209015-0220	22mm			○	×	○	○	●	○
Inch	209016-0010	3/16"	4.8mm		●	●	●	●	●	●
	209016-0020	#7	5.1mm		●	●	●	●	●	●
	209016-0030	7/32"	5.6mm	1/4-20 UNC	●	●	●	●	●	●
	209016-0040	1/4"	6.4mm		●	●	●	●	●	●
	209016-0050	#F	6.6mm	5/16-18 UNC	●	●	●	●	●	●
	209016-0060	9/32"	7.1mm		●	●	●	●	●	●
	209016-0070	5/16"	7.9mm	3/8-16 UNC	●	●	●	●	●	●
	209016-0080	11/32"	8.7mm		●	●	●	●	●	●
	209016-0090	3/8"	9.5mm		●	●	●	●	●	●
	209016-0100	27/64"	10.7mm	1/2-13 UNC	●	●	●	●	●	●
	209016-0120	7/16"	11.1mm		●	●	●	●	●	●
	209016-0130	1/2"	12.7mm		●	●	●	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

TurboTip Drill Bit Sets

Part No	Contents
209015-SET1	4 piece TurboTip Drill Bit Set contains: 6, 8, 10, 12mm
209015-SET2	7 piece TurboTip Drill Bit Set contains: 6, 7, 8, 9, 10, 11, 12mm
209015-SET3	7 piece TurboTip Drill Bit Set contains: 6.8, 8, 8.5, 10, 10.5, 12, 14mm
209015-SET4	7 piece TurboTip Drill Bit Set contains: 6, 8, 10, 12, 14, 18 & 22mm
209016-SET1	TurboTip Impact Drill Bit Set, 3/16, 1/4, 5/16, 1/2"
209016-SET2	TurboTip Tapping Size Impact Drill Bit Set, #7, F, 5/16, 27/64

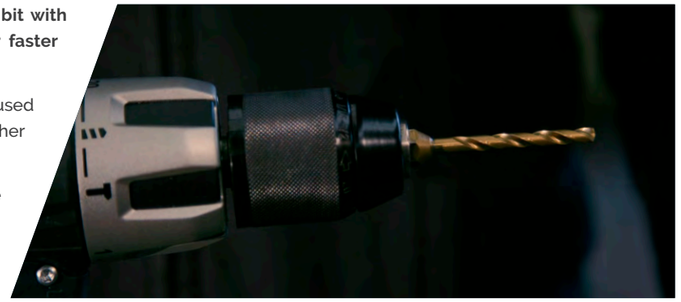
VersaDrive Cobalt Drill Bits

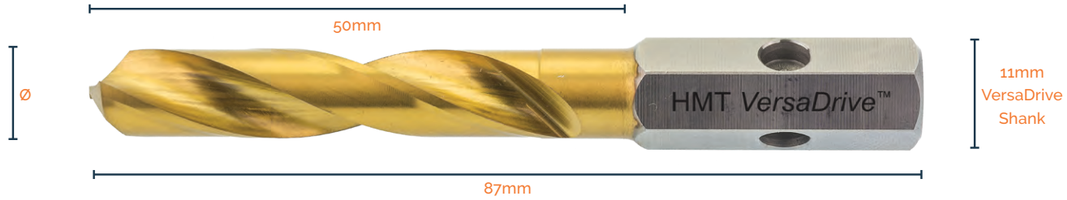
VERSADRIVE® PATENT PROTECTED

VersaDrive Cobalt Drills are a premium grade 8% Cobalt drill bit with fully ground flutes, 135˚ Split point and Titanium coating for faster drilling & reduced wear.

Suitable for heavy fabrication use, this Cobalt drill bit can also be used to drill stainless steel, mild steel, cast iron and a wide range of other structural materials.

VersaDrive Drill Bits have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.





Features & Benefits

- *Fast drilling with minimal kickback*
- *Dual hardened for impact wrench use up to 10mm*
- *Precision Ground Flutes with easy chip clearance*
- *135° Split Point for easy starting and high accuracy*
- *8% Cobalt for long life and endurance*
- *GoldMax low-friction titanium coating to stop burn out*

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
MultiSink

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers (4.2 - 10.5mm)
SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
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VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Up to 10mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive Cobalt Drill Bits

	Part No	Ø D mm	Tap Size (Metric Coarse)	Length in Magnet Drill Adapter	Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
					Powertool Recommendations (Mild Steel Material)					
Metric	209010-0042	4.2mm	M5	98mm	○	○	○	●	●	●
	209010-0050	5.0mm	M6	98mm	○	○	○	●	●	●
	209010-0055	5.5mm	-	98mm	○	○	○	●	●	●
	209010-0060	6.0mm	-	98mm	○	○	○	●	●	●
	209010-0065	6.5mm	-	98mm	○	○	○	●	●	●
	209010-0068	6.8mm	M8	98mm	○	○	○	●	●	●
	209010-0070	7.0mm	-	98mm	○	○	○	●	●	●
	209010-0075	7.5mm	-	98mm	○	○	○	●	●	●
	209010-0080	8.0mm	-	98mm	○	○	○	●	●	●
	209010-0085	8.5mm	M10	98mm	○	○	○	●	●	●
	209010-0090	9.0mm	-	98mm	○	○	○	●	●	●
	209010-0095	9.5mm	-	98mm	○	○	○	●	●	●
	209010-0100	10mm	-	98mm	○	○	○	●	●	●
	209010-0102	10.2mm	M12	98mm	○	○	○	●	●	●
	209010-0105	10.5mm	-	98mm	○	○	○	●	●	●
	209010-0115	11.5mm	-	98mm	×	×	○	●	●	●
	209010-0120	12mm	M14	98mm	×	×	○	●	●	●
	209010-0125	12.5mm	-	98mm	×	×	○	●	●	●
	209010-0130	13mm	-	98mm	×	×	○	●	●	●
	209010-0140	14mm	M16	98mm	×	×	○	●	●	●
	209010-0160	16mm	-	98mm	×	×	○	●	●	●
	209010-0180	18mm	-	98mm	×	×	○	●	●	○
	209010-0200	20mm	-	98mm	×	×	○	●	●	○
	209010-0210	21mm	M24	98mm	×	×	○	●	●	○
	209010-0220	22mm	-	98mm	×	×	○	●	●	○

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

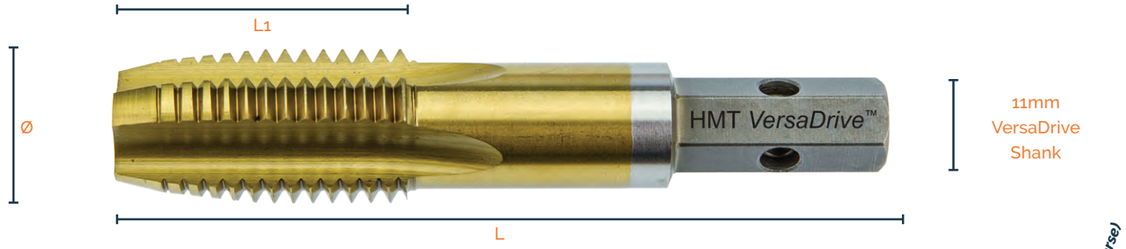
VersaDrive Drill Bit Sets

Part No	Contents
209010-SET1	4 piece VersaDrive Drill Bit Set contains: 6.0, 8.0, 10.0, 12.0mm
209010-SET2	4 Piece VersaDrive Drill Bit Set contains: 5.0, 6.8, 8.5, 10.2mm
209010-SET3	7 piece VersaDrive Drill Bit Set contains: 5.0, 6.0, 6.8, 8.0, 8.5, 10, 10.2mm
209010-SET4	7 Piece VersaDrive Drill Bit Set contains: 12, 13, 14, 16, 18, 20, 22mm

VersaDrive ImpactaTaps are the first and only range of taps that are suitable to be driven by impact wrenches and impact drivers, providing at least 15x faster performance than tapping by hand.

With a specially designed twin-lead, cutting geometry - the dual hardening process with Titanium coating provides a fantastic solution for tapping holes in steel.

VersaDrive ImpactaTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills (up to M10) or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills. They can even be used by hand in a socket wrench.



Features & Benefits

- *Ground Flutes create the perfect tapped hole*
- *Safer tapping with minimal kickback*
- *Specially hardened for impact wrench use*
- *High grade tool steel for high accuracy & long life*
- *Goldmax low friction titanium coating to stop burn out*
- *Wide range of sizes*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Magnet Drills

CAN ALSO BE USED WITH:

Extension Arbor

ADAPTERS

Impact Driver Adapter
111026-014A
Page 12

Impact Wrench Adapter
111130-012A
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Magnet Drill Adapter
111035-01
Page 13

Extension - 300mm
111015-300
Page 14

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Check the minimum torque requirement - p.94*
- *Tapping Stainless Steel requires higher impact torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive ImpactaTaps - Metric Coarse

	Part No	M Thread Size & Pitch	L mm	l1 mm	Shank mm	Tap Hole Size (Metric Coarse thread)	Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
							Powertool Recommendations (Mild Steel Material)					
Metric	308010-0050	M5 x 0.80	55	18	11.0	4.2mm	●	●	×	●	●	●
	308010-0060	M6 x 1.00	55	20	11.0	5.0mm	●	●	×	●	●	●
	308010-0080	M8 x 1.25	60	22	11.0	6.8mm	●	●	×	●	●	●
	308010-0100	M10 x 1.50	70	24	11.0	8.5mm	●	●	×	○	●	●
	308010-0120	M12 x 1.75	80	29	11.0	10.2mm	●	●	×	○	●	●
	308010-0140	M14 x 2.00	90	32	11.0	12.0mm	●	○	×	×	●	●
	308010-0160	M16 x 2.00	90	32	11.0	14.0mm	●	○	×	×	●	●
	308010-0180	M18 x 2.50	100	37	11.0	15.5mm	●	×	×	×	●	●
	308010-0200	M20 x 2.50	100	37	11.0	17.5mm	●	×	×	×	●	●
	308010-0240	M24 x 3.00	110	45	11.0	21.0mm	●	×	×	×	●	●
	308010-0270	M27 x 3.00	130	48	11.0	24.0mm	●	×	×	×	●	●
	308010-0300	M30 x 3.50	130	48	11.0	26.5mm	●	×	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

ImpactaTap® Sets

Part No	Contents
308010-SET1	5 piece Set contains: M6, M8, M10, M12, M16 VersaDrive ImpactaTaps
308010-SET2	4 piece Set contains: M12, M16, M20, M24 VersaDrive ImpactaTaps

ImpactaTap® & TurboTip Set

Part No	Contents
328015-SET1	TurboTip Drill Bit, 6.8, 8.5, 10.5, 14mm & ImpactaTaps, M8, M10, M12, M16 c.w 1/2" Impact Adapter

VERSADRIVE© PATENT PROTECTED

ImpactaTaps® UNC Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size mm	Tap Hole Size Inch
308050-0010	1/4 x 20 UNC	58	20	5.10mm	#7
308050-0020	5/16 x 18 UNC	60	22	6.60mm	#F
308050-0030	3/8 x 16 UNC	70	24	8.00mm	5/16
308050-0040	1/2 x 13 UNC	80	29	10.80mm	27/64
308050-0050	5/8 x 11 UNC	90	32	13.50mm	17/32
308050-0060	3/4 x 10 UNC	100	37	16.50mm	21/32
308050-0065	7/8 x 9 UNC	105	40	19.50mm	49/64
308050-0070	1 x 8 UNC	110	45	22.25mm	7/8

Sets	Contents
308050-SET1	HMT VersaDrive ImpactaTap Set, 1/4, 5/16, 3/8, 1/2, 5/8 UNC
308050-SET2	HMT VersaDrive ImpactaTap Set, 1/2, 5/8, 3/4, 1"

ImpactaTaps® Metric Fine Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size
308030-0060	M6 x 0.75 MF	60	19	5.2mm
308030-0800	M8 x 1.00 MF	70	22	7.0mm
308030-0100	M10 x 1.25 MF	70	24	8.8mm
308030-0120	M12 x 1.50 MF	80	29	10.5mm
308030-0160	M16 x 1.50 MF	90	32	14.5mm
308030-0180	M18 x 1.50 MF	100	37	16.5mm
308030-0200	M20 x 1.50 MF	100	37	18.5mm
308030-0240	M24 x 1.50 MF	120	92	22.5mm

ImpactaTaps® BSP Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size
308070-0010	1/8 x 28 BSP	70	24	8.8mm
308070-0020	1/4 x 19 BSP	90	32	11.8mm
308070-0030	3/8 x 19 BSP	90	32	15.25mm
308070-0040	1/2 x 14 BSP	100	37	19mm
308070-0050	5/8 x 14 BSP	100	37	21mm
308070-0060	3/4 x 14 BSP	100	37	24.5mm
308070-0070	1 x 11 BSP	110	45	30.75mm

ImpactaTaps® BSW Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size
308060-0010	1/4 x 20 BSW	58	20	5.1mm
308060-0015	5/16 x 18 BSW	60	22	6.5mm
308060-0020	3/8 x 16 BSW	70	24	7.9mm
308060-0030	1/2 x 12 BSW	80	29	10.5mm
308060-0040	5/8 x 11 BSW	90	32	13.5mm
308060-0050	3/4 x 10 BSW	100	37	16.25mm
308060-0060	1 x 8 BSW	110	45	22mm

VERSADRIVE© PATENT PROTECTED

ImpactaTaps® Long Series - Metric Coarse

Spiral Point Taps for fast chip ejection in through holes.

Part No	M Thread Size & Pitch	L mm	l1 mm	l2 mm	Tap Hole Size
308015-0080	M8 x 1.25	140	45	112	6.8mm
308015-0100	M10 x 1.50	155	50	127	8.5mm
308015-0120	M12 x 1.75	180	55	152	10.2mm
308015-0160	M16 x 2.0	200	65	172	14.0mm
308015-0200	M20 x 2.5	230	70	202	17.5mm
308015-0240	M24 x 3.0	260	75	232	21.0mm

Metric Coarse Oversized ImpactaTaps®

For use with Galvanised Fixings

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size (Metric Coarse thread)
308020-0050	M5.4 x 0.80mm	55	18	4.2
308020-0060	M6.4 x 1.00mm	55	20	5.0
308020-0080	M8.4 x 1.25mm	60	22	6.8
308020-0100	M10.4 x 1.50mm	70	24	8.5
308020-0120	M12.4 x 1.75mm	80	29	10.2
308020-0160	M16.4 x 2.00mm	90	32	14.0
308020-0200	M20.4 x 2.50mm	100	37	17.5
308020-0240	M24.4 x 3.00mm	110	45	21.0
308020-0300	M30.4 x 3.50mm	130	48	26.5

Sets	Contents
308020-SET1	VersaDrive Oversize Galv ImpactaTap 6 Pc Set: M5, M6, M8, M10, M12, M16

FarrierTap - BSW Thread

FarrierTap - BSW Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size
308060-0015	5/16 x 18 BSW	60	22	6.5mm
308060-0020	3/8 x 16 BSW	70	24	7.9mm

FarrierTap Combi DrillTap

Part No	M Thread Size & Pitch	d1	L	l1	Max tapping depth with impact wrench
301127-0030	3/8-16 BSW	7.9mm	92mm	22mm	8.5mm

FarrierTap Kit

Part No:	Set Contents
301127-SET1	Set contains: 3/8 BSW FarrierTap, 3/8 BSW Combi Drill Tap, 1/4" VersaDrive Impact Adapter

IMPACT RATED

Clutched Tap Collet for Blind Hole Tapping

The HMT VersaDrive Clutched tap collet system is a unique method of effectively threading blind holes.

One collet works with the range of Patented VersaDrive taps. When the tap comes to the bottom of the hole, the clutch system will engage and stop the tap from breaking. The tap is then reversed out of the completed hole.

This system fits a 19.05mm (3/4") magnet drill arbor, or can be adapted for use with a 1/2" or 3/4" impact wrench.

Features & Benefits

- *Quick change system accepts all VersaDrive taps*
- *Collets are pre-set to the appropriate clutch settings*
- *Further Clutch adjustment options available*
- *For blind hole tapping with VersaDrive Spiral Flute Taps*
- *For use with variable speed, reversible magnet drill, pillar drill, or impact wrench*

CLUTCHED TAP REPLACEMENT COLLET

120010 COLLET HOLDER

Part No	Description
120010	Weldon Shank Tap Collet Holder, 19.05mm / 3/4

121015-M12	Clutched Blind Hole Tap Collet M6-M12 Capacity
121015-M24	Clutched Blind Hole Tap Collet M16-M24 Capacity

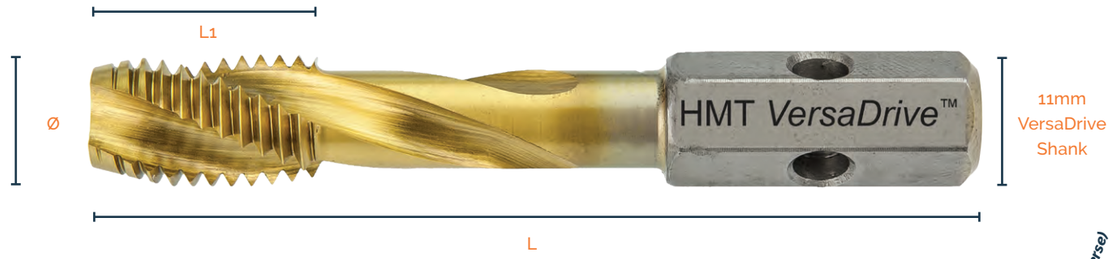
00200-12A-19	1/2" Drive Impact Adapter for Blind Hole Tapping
00200-34A-19	3/4" Drive Impact Adapter for Blind Hole Tapping

121015-SET12	Blind Hole Tapping Kit M6-M24 Capacity includes 1/2" Impact Adapter
121015-SET34	Blind Hole Tapping Kit M6-M24 Capacity includes 3/4" Impact Adapter

N.B. Assembled length of Clutched adapter with fitted tap is up to 250mm - ensure you select a mag drill with adequate stroke e.g. V100T & V125T VersaDrive Magnet Drills

VERSADRIVE©
PATENT PROTECTED

VersaDrive Spiral Flute Taps



VersaDrive Spiral Flute Taps

	Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size (mm)	Tap Hole Size (")
Metric Coarse	309010-0060	M6 x 1.00	58	20	5.0	-
	309010-0080	M8 x 1.25	60	22	6.8	-
	309010-0100	M10 x 1.50	70	24	8.5	-
	309010-0120	M12 x 1.75	80	29	10.2	-
	309010-0160	M16 x 2.00	90	32	14.0	-
	309010-0200	M20 x 2.50	100	37	17.5	-
	309010-0240	M24 x 3.00	110	45	21.0	-
	309010-0300	M30 x 3.50	130	48	26.5	-
Inch	309020-0010	1/4 x 20 UNC	58	20	5.1	#7
	309020-0020	5/16 x 18 UNC	60	22	6.6	#F
	309020-0030	3/8 x 16 UNC	70	24	8	5/16
	309020-0040	1/2 x 13 UNC	80	29	10.8	27/64
	309020-0050	5/8 x 11 UNC	90	32	13.5	17/32
	309020-0060	3/4 x 10 UNC	100	37	16.5	21/32
	309020-0065	7/8 x 9 UNC	105	40	19.5	49/64
	309020-0070	1 x 8 UNC	110	45	22.25	7/8
	309020-0110	1-1/4 x 7 UNC	128	41	28.17	1-7/64

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
○	○	×	○	●	●
○	○	×	○	●	●
○	○	×	○	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	○	×	○	●	●
○	○	×	○	●	●
○	○	×	○	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Spiral Flute Tap Sets

Part No:	Set Contents
309010-SET1	Spiral Flute ImpactaTap Set M6, M8, M10, M12, M16
309010-SET2	Spiral Flute ImpactaTap Set M12, M16, M20, M24
309020-SET1	Spiral Flute ImpactaTap Set 1/4, 5/16, 3/8, 1/2, 5/8" UNC
309020-SET2	Spiral Flute ImpactaTap Set 1/2, 3/4, 1" UNC

IMPACT RATED

VersaDrive Impacta Drill Taps

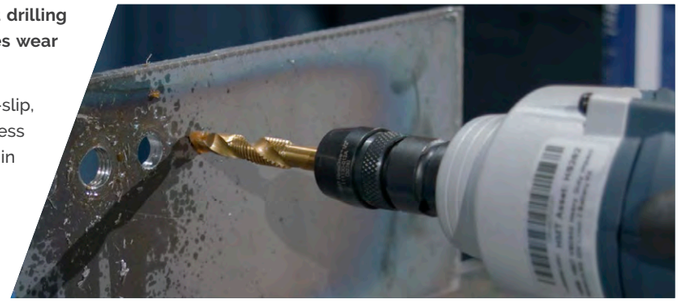
DRILL & TAP IN ONE EASY OPERATION - WITH AN IMPACT WRENCH

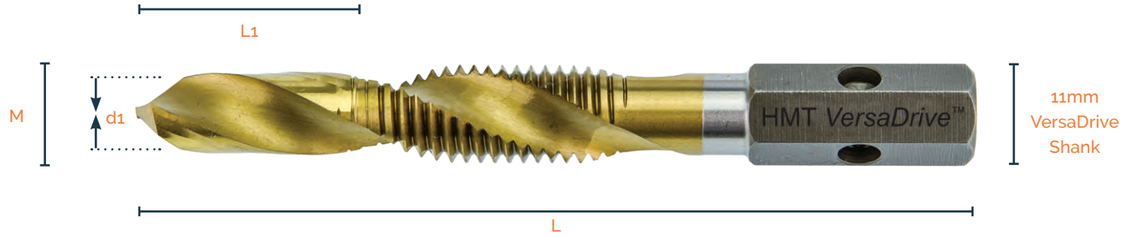
VERSADRIVE® PATENT PROTECTED

VersaDrive Combi Drill Taps are a time saving solution for pilot drilling & tapping in one easy operation. The Titanium coating provides wear resistance and faster cutting performance.

VersaDrive Sheet Metal Impacta-DrillTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Recommended for use with Impact Drivers for high drilling and tapping productivity.





Features & Benefits

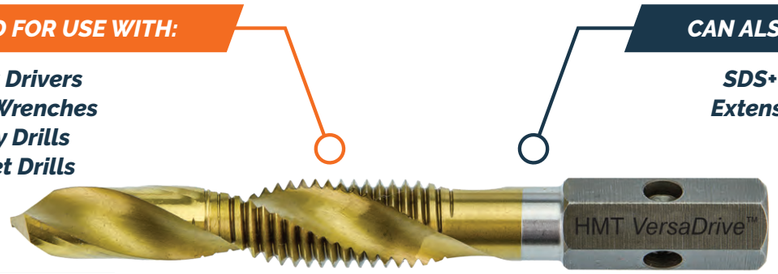
- *Ground flute twist drill creates the perfect tapping hole*
- *Safer tapping with minimal kickback*
- *Specially hardened for impact wrench use*
- *High grade tool steel for high accuracy & long life*
- *Goldmax low friction titanium coating to stop burn out*
- *Drill & Tap in one easy operation*

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

Magnet Drill Adapter
111035-01
Page 13

Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *For fastest performance use on impact wrenches & drivers (Check torque requirement - p.95)*
- *Maximum tapping thickness is the thread diameter of the drill-tap*
- *Tapping Stainless Steel requires higher impact torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive Drill Taps

	Part No	M Thread Size & Pitch	d1	L	l1	Max Tapping Depth
Metric	301125-0030	M3 x 0.50	2.5mm	55mm	6mm	3mm
	301125-0040	M4 x 0.70	3.3mm	60mm	9mm	4mm
	301125-0050	M5 x 0.80	4.2mm	71mm	13mm	5mm
	301125-0060	M6 x 1.00	5.0mm	75mm	17mm	6mm
	301125-0080	M8 x 1.25	6.8mm	82mm	20mm	8mm
	301125-0100	M10 x 1.50	8.5mm	92mm	25mm	10mm
	301125-0120	M12 x 1.75	10.2mm	103mm	31mm	12mm
Inch	301126-0010	4-40 UNC	3/32"	2-11/64"	15/64"	3/32"
	301126-0020	6-32 UNC	7/64"	2-23/64"	23/64"	1/8"
	301126-0030	8-32 UNC	9/64"	2-23/64"	23/64"	5/32"
	301126-0040	10-24 UNC	5/32"	2-51/64"	33/64"	13/64"
	301126-0050	1/4-20 UNC	13/64"	2-61/64"	19/32"	1/4"
	301126-0060	5/16-18 UNC	1/4"	3-15/64"	45/64"	5/16"
	301126-0070	3/8-16 UNC	5/16"	3-5/8"	55/64"	3/8"
	301126-0080	1/2-13 UNC	27/64"	4/16"	1-7/64"	1/2"

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	○	●	●
●	○	×	○	●	●
●	○	×	○	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
●	●	×	○	●	●
●	○	×	○	●	●
●	○	×	○	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

VersaDrive Drill-Tap Sets

Part No:	Set Contents
301125-SET1	Set contains: M5, M6, M8, M10, M12 Combi Drill-Taps
301126-SET1	Set contains: : 1/4, 5/16, 3/8, 1/2" UNC Combi Drill Taps

"This impact drilltap combo is amazing! No risk of snagging wrists etc and jamming up of the drill when used in the impact gun. Keep it lubed up and the performance is great."

Tim Berry
AnyWeld

ROTARY RATED

Heavy Duty Impacta Drill Taps

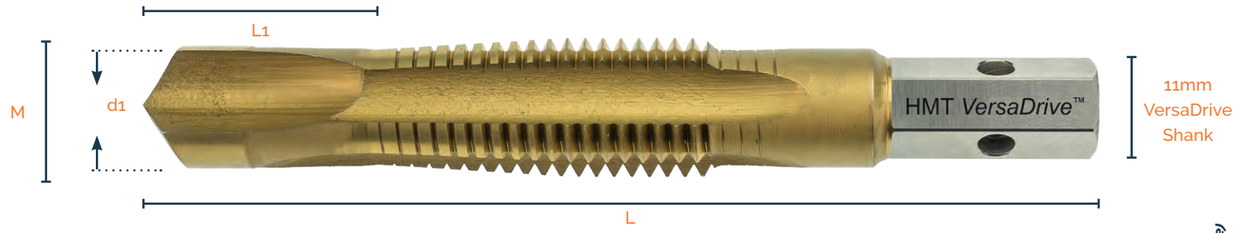
DRILL & TAP IN ONE EASY OPERATION

VERSADRIVE® PATENT PROTECTED

VersaDrive Heavy Duty Impacta-Drill Taps are an industrial metalwork or fabrication tool for drilling and tapping heavy steel in one easy operation.

Primarily they are designed to be used with a reversible Magnet drill, although they can also be adapted for use with an impact wrench to enlarge and tap existing holes.

With a drill point optimised for use in fixed drilling machines like Magnetic Drills or Pillar drills, these are not recommended for use in a pistol drill. Where they are to used with an impact wrench to enlarge and tap holes pilot drilling is recommended with a separate drill bit.



Features & Benefits

- *Fast Tapping with Minimal Kickback*
- *Specially hardened for impact wrench use*
- *High grade tool steel for high accuracy & long life*
- *Goldmax low friction titanium coating to stop burn out*
- *Unique Dual-Point Starting Angle for easy alignment & fast cut*
- *Automatic chip clearance when Impact Tapping*

RECOMMENDED FOR USE WITH:

Magnet Drills
MultiSink

CAN ALSO BE USED WITH:

Impact Wrench
Extension Arbor
Morse Taper Drills

ADAPTERS

Magnet Drill Adapter
111035-01
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MultiSink
601050-
Page 80

Impact Wrench Adapter
111130-012A
Page 12

Extension - 300mm
111015-300
Page 14

Morse Taper Arbor
111045-
Page 15

Quick Guide

- *Correct RPM is critical for good performance on larger drill taps*
- *Ideal for use in drill presses and magnet drills*
- *For impact wrench use, pilot drilling the hole with a separate drill bit is necessary*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive Heavy Duty Drill Taps

	Part No	M Thread Size & Pitch	d1 mm	L mm	l1 mm	Max Tapping Depth
Metric	301130-0080	M8 x 1.25	6.8	100	30	20mm
	301130-0100	M10 x 1.50	8.5	105	30	20mm
	301130-0120	M12 x 1.75	10.2	117	35	25mm
	301130-0160	M16 x 2.00	14	117	37	25mm
	301130-0200	M20 x 2.50	17.5	135	40	35mm
	301130-0240	M24 x 3.00	21	148	45	40mm
Inch	301140-0001	1/2-13 UNC	27/64	4 -23/32	1-3/8	1
	301140-0002	5/8-11 UNC	17/32	5-1/8	1-29/64	1
	301140-0003	3/4-10 UNC	21/32	5-33/64	1-37/64	1-3/8
	301140-0005	1-8 UNC	7/8	6-19/64	1-49/64	1-37/64

Powertool Recommendations (Mild Steel Material)					
Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
○	○	×	○	●	●
○	○	×	○	●	●
○	×	×	○	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
●	●	×	○	●	●
●	●	×	×	●	●
●	●	×	×	●	●
●	●	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

VersaDrive Heavy Duty Drill-Tap Sets

Part No:	Set Contents
301130-SET1	Set contains: M12, M16, M20, M24 Heavy Duty Combi Drill-Taps
301140-SET1	Set contains: : 1/2, 5/8, 3/4, 1" UNC Combi Drill Taps

ROTARY RATED

VersaDrive DrillSink Tool

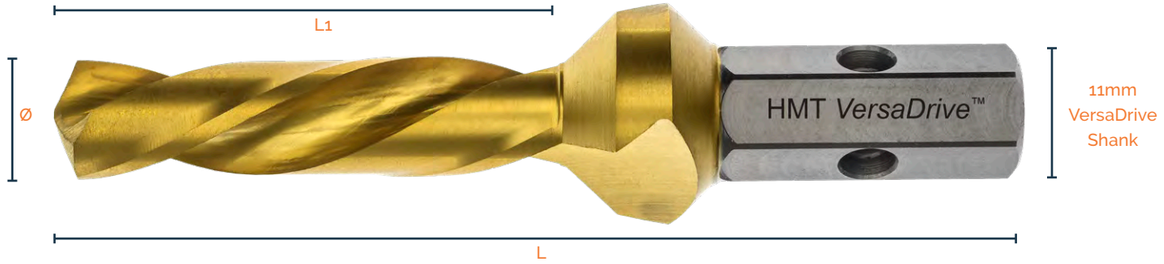
ULTIMATE PRECISION FOR COUNTERSUNK HOLES

VERSADRIVE® PATENT PROTECTED

The VersaDrive Drillsink is an innovative combined drilling & countersinking tool to save metalworkers time & increase hole accuracy by drilling & then countersinking fixing holes in one operation.

This combination tool provides perfect countersinking accuracy every time by locating the drilled hole in perfect alignment to the countersink. This helps prevent tool chatter and blunting commonly found with standard countersinks.

VersaDrive DrillSinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

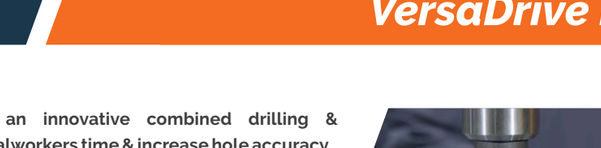
- *Drill & Countersink in one easy operation*
- *Perfect concentricity creates the perfect Countersink*
- *Ground flutes for high accuracy and long life*
- *High-Grade tool steel*
- *GoldMax low-friction titanium coating to stop burn-out*
- *Prevents the chattering of standard countersinks*

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers (up to 16.5mm)
SDS+ Adapter
Extension Arbor



ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 13

Impact Wrench Adapter
111130-012A
Page 12

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *Optimum life and performance when used with rotary pistol drills or drill presses*
- *Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive DrillSink

	Part No	Ø Drill Size	Countersink Size	l1 mm	L mm	Countersunk Screw	Point Angle
Clearance Hole Sizes	603070-08124	8mm	12.4mm	47mm	96mm	M6	90°
	603070-10165	10mm	16.5mm	47mm	85mm	M8	90°
	603070-11205	11mm	20.5mm	47mm	88mm	M10	90°
	603070-12205	12mm	20.5mm	47mm	88mm	M10	90°
	603070-13250	13mm	25mm	47mm	92mm	M12	90°
	603070-14250	14mm	25mm	47mm	92mm	M12	90°
Tap Hole Sizes	603070-68165	6.8mm	16.5mm	47mm	85mm	M8 (Tapped)	90°
	603070-85205	8.5mm	20.5mm	47mm	89mm	M10 (Tapped)	90°
	603070-102250	10.2mm	25mm	47mm	93mm	M12 (Tapped)	90°

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
○	○	○	●	●	●
○	○	○	●	●	●
×	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
●	○	○	●	●	●
○	○	○	●	●	●
×	○	○	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

DrillSink Set

Part No	Contents
603070-SET4	Set contains: 8/12.4mm, 10/16.5mm, 12/20.5, 14/25mm VersaDrive DrillSink Bits

"Saved so much time with not only having to switch tooling but also the way in which these tools cut through the metal with such ease. Even after 40+ holes still going strong."

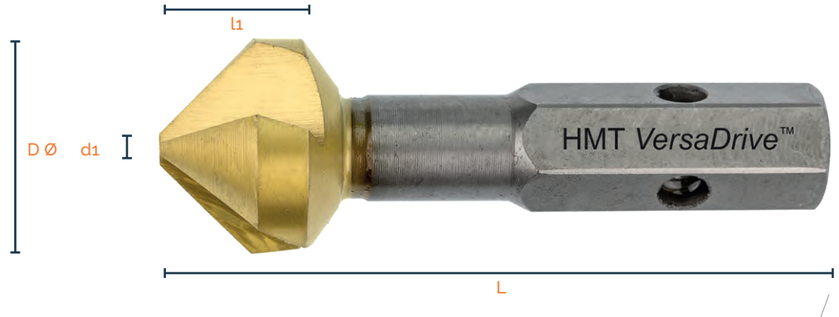
Jon Powell
J P Fabrications

VersaDrive Countersinks

The VersaDrive Countersink is a premium quality countersink with fully ground flutes and Titanium coating to help reduce wear and blunting.

VersaDrive Countersinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Utilise the convenience and power of an impact wrench to quickly debur and countersink holes up to 16.5mm with minimal torque kick-back against the operator.



Features & Benefits

- *For Countersunk Bolt Heads*
- *Safer use with minimal kickback*
- *Specially hardened for impact wrench use up to 16.5mm*
- *High-Grade Tool Steel for high accuracy & long life*
- *GoldMax low friction Titanium Coating to stop burn out*
- *1st Impact rated countersinks on the market*

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
Pillar Drills

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers (up to 16.5mm)
SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
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VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 12

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *Optimum life and performance when used with rotary pistol drills or drill presses*
- *Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Not for use on plasma cut or flame cut holes*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VersaDrive Countersinks

	Part No	D Ø mm	Ø d1 mm	l1 mm	L mm	Countersunk Screw	Point Angle
Metric - 90°	603060-0063	6.3mm	1.5	17	45	M3	90°
	603060-0083	8.3mm	2.0	22	50	M4	90°
	603060-0104	10.4mm	2.5	22	50	M5	90°
	603060-0124	12.4mm	2.8	28	56	M6	90°
	603060-0165	16.5mm	3.2	32	60	M8	90°
	603060-0205	20.5mm	3.5	35	63	M10	90°
	603060-0250	25mm	3.8	39	67	M12	90°
	603060-0310	31mm	4.2	43	71	M16	90°
Inch - 82°	603065-0100	1/4"	1/16	7/64	1-27/32	-	82°
	603065-0200	3/8"	7/64	5/32	2-3/64	-	82°
	603065-0300	1/2"	7/64	7/32	2-9/32	-	82°
	603065-0400	5/8"	1/8	9/32	2-7/16	-	82°
	603065-0500	3/4"	1/8	11/32	2-9/16	-	82°
	603065-0600	1"	11/64	31/64	2-23/32	-	82°

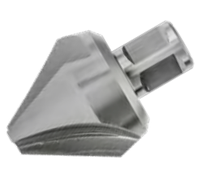
Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	●	○	●	●	●
●	●	○	●	●	●
●	●	○	●	●	●
●	●	○	●	●	●
○	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
○	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

VersaDrive Countersink Set

Part No:	Set Contents
603060-5SET	Set contains: 12.4, 16.5, 20.5, 25, 31mm VersaDrive 90° Countersink Bits
603065-5SET	Set contains: 3/8", 1/2", 5/8", 3/4", 1" VersaDrive 82° Countersink Bits

COMPLETE COUNTERSINK RANGE - P78



TCT HOLECUTTER®

TUNGSTEN CARBIDE TECHNOLOGY

SPRING LOADED PILOT DRILL

Centres and stabilises cutter during drilling & ejects metal slug upon completion

RAPID-LOCK SHANK

VersaDrive Hex shank fits all standard drill chucks, Rapid-lock adapters and extension arbors, offering the greatest flexibility & applications from a single tool.

TUNGSTEN CARBIDE TEETH

Premium grade Sandvik Tungsten Carbide teeth for the highest performance cutting & 10x greater life than standard holesaws.

Fast, efficient & cost effective
Outperforms & outlasts traditional HSS holesaws by up to 10 times!

VersaDrive TCT HoleCutters offer a fast, efficient and cost effective holemaking solution that outperform and outlast traditional HSS holesaws by up to 10 times!

Highly versatile and perfect for heavy duty applications VersaDrive HoleCutters are compatible with the VersaDrive system of extensions and adapters and feature cutting teeth manufactured from premium-grade Tungsten Carbide, one of the strongest materials for cutting tools. This ensures the highest levels of performance and durability, with faster cuts and increased life spans.

A complete hole cutting solution, the range offers Standard HoleCutters, Extra Long HoleCutters & the HMT exclusive HoleCutter and MultiSink combination.

THE RANGE

THE COMPLETE SOLUTION

VersaDrive HoleCutters offer the widest range of hole cutting solutions on the market.
Our flagship TCT HoleCutter is the ideal choice for inaccessible and heavy duty holemaking challenges.
For specialist jobs that require extended depth drilling our innovative Extra Long HoleCutters offer a 100mm cutting depth.
Meanwhile all VersaDrive HoleCutters can be combined with the HMT exclusive multiSink system, allowing you to broach and countersink in one pass, as well as the complete range of VersaDrive Rotary adapters for use on Magnetic & SDS+ drills.

SIZES AVAILABLE

Standard HoleCutter:

Diameter (Ø) :	*12mm - 80mm*
Cutting Length (L) :	*55mm*
Total Length:	*100mm*

Extra Long HoleCutter:

Diameter (Ø) :	*14mm - 26mm*
Cutting Length (L) :	*100mm*
Total Length:	*149mm*

HoleCutter & MultiSink:

HoleCutter (Ø) :	*16mm - 32mm*
MultiSink (Ø):	*40 / 55mm*
Total Length:	*109mm*

REPLACING MAGNET DRILLS

Many steel erectors and fabricators tell us that they are able to replace heavy and awkward magnetic drills with a standard cordless drill fitted with a VersaDrive hole cutter.

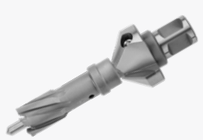
- No risk of a heavy magnet drill falling from height
- Quick to position and drill
- Carry less equipment, saving weight and increasing mobility

HoleCutter products available

Standard HoleCutter

Extra Long HoleCutter

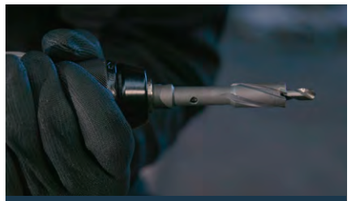
HoleCutter with HSS MultiSink



HoleCutter with TCT MultiSink

1 HOLECUTTER - 3 SOLUTIONS

·When using with a magnet drill adapter or multiSink tool replace supplied pilot drill with 101030P-0003 ejector pin



Use in Pistol Drill

Adapt for Magnet Drill Use

Adapt to MultiSink

ROTARY RATED

VersaDrive TCT HoleCutters

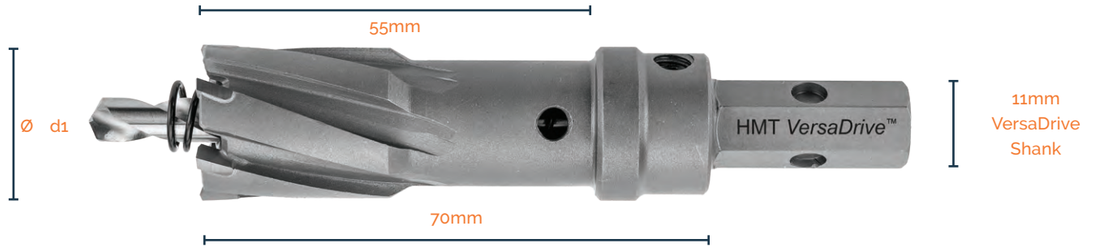
10X LONGER LIFE THAN STANDARD HOLESAWS

VERSADRIVE® PATENT PROTECTED

VersaDrive TCT HoleCutters are a high performance solution for cutting larger diameter holes quickly and effectively. Premium grade Tungsten carbide teeth provide ultimate cutting performance in a wide range of Structural steels including Stainless Steel and Cast Iron.

These are rapidly becoming the go-to, alternative solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and possibly safer than a Magnetic drill.

VersaDrive TCT HoleCutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.



Features & Benefits

- *Massive 70mm reach with 55mm depth of cut*
- *Premium quality Tungsten Carbide teeth*
- *Perfect for drilling heavy steel in remote locations*
- *Use in standard 1/2" drill chuck or with magnet drill adapter*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Combine with multisink to broach & countersink in 1 pass*

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
HMT MultiSink
Pillar Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard 1/2" drill chuck

Magnet Drill Adapter
111035-01
Page 13

MultiSink Tool
601050-
Page 80

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Good results can be achieved with SDS Drills when used in Rotary Only mode*
- *Replace supplied pilot drill with 101030P-0003 ejector pin to use with Magnet Drill/MultiSink*
- *Suitable for use on Stainless Steel*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

Part No	Ø D mm	Ø D Inch
101030-0120	12mm	
101030-0130	13mm	
101030-0140	14mm	9/16”
101030-0150	15mm	
101030-0160	16mm	5/8”
101030-0170	17mm	11/16”
101030-0175	17.5mm	
101030-0180	18mm	
101030-0190	19mm	3/4”
101030-0200	20mm	
101030-0210	21mm	13/16”
101030-0220	22mm	7/8”
101030-0230	23mm	
101030-0240	24mm	15/16”
101030-0250	25mm	1”
101030-0260	26mm	
101030-0270	27mm	1-1/16”
101030-0280	28mm	
101030-0290	29mm	1-1/8”
101030-0300	30mm	1-3/16”
101030-0310	31mm	
101030-0320	32mm	1-1/4”
101030-0330	33mm	1-5/16”
101030-0340	34mm	

Part No	Ø D mm	Ø D Inch
101030-0350	35mm	1/3-8”
101030-0360	36mm	
101030-0370	37mm	1-7/16”
101030-0380	38mm	1-1/2”
101030-0390	39mm	1-9/16”
101030-0400	40mm	
101030-0410	41mm	1-5/8”
101030-0420	42mm	
101030-0430	43mm	1-11/16”
101030-0440	44mm	1-3/4”
101030-0450	45mm	
101030-0460	46mm	1-13/16”
101030-0470	47mm	
101030-0480	48mm	1-7/8”
101030-0490	49mm	
101030-0500	50mm	
101030-0510	51mm	2”
101030-0520	52mm	2-1/16”
101030-0550	55mm	2-5/32”
101030-0600	60mm	2-3/8”
101030-0650	65mm	2-9/16”
101030-0700	70mm	2-3/4”
101030-0750	75mm	
101030-0800	80mm	3-5/32”

VersaDrive TCT HoleCutter Sets

Part No	Contents
101030-SET1	3 piece Set: 14, 18, 22mm HoleCutters
101030-SET2	5 piece Set: 14, 17, 18, 21, 22mm HoleCutters

Pilot Drill Bits & Pilot Pins

Part No	Contents
101030P-0130	HoleCutter Pilot Drill for 12 & 13mm HoleCutters - Pack of 2 (Supplied WITHOUT ejection spring)
101030P-0001	HoleCutter Pilot Drill for 14-80mm HoleCutters Pack of 2 (Supplied WITH ejection spring)
101030P-0003	VersaDrive HoleCutter Magnet Broaching/MultiSink Pilot Pin, Pk2

101030P-0001

101030P-0003

Technical data sheet & RPM Guide - Page 89

ROTARY RATED

VersaDrive Extra Long HoleCutters

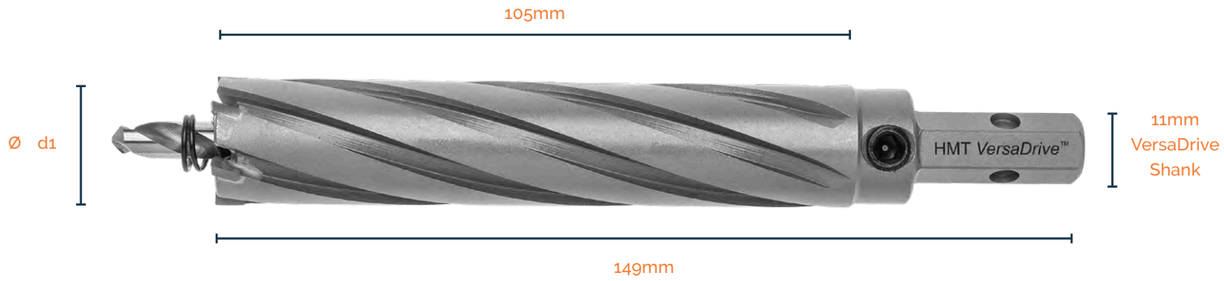
EXTRA LONG CUTTING CAPABILITY

VERSADRIVE® PATENT PROTECTED

Extra Long reach version of the popular VersaDrive HoleCutter. Perfect for small diameter drilling through steelwork using a pistol drill where a separate extension isn't practical.

Ideal for applications where a metal plate is encountered amongst wood joists or where both sides of a steel beam require drilling.

These are rapidly becoming the go-to solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and safe than a Magnetic drill.



Features & Benefits

- *120mm reach with 100mm depth of cut*
- *Premium quality Tungsten Carbide teeth*
- *Perfect for drilling box section with inaccessible sides*
- *Use with standard 1/2" drill chuck or magnet drill adapter*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Use with other VersaDrive adapters for ultimate flexibility*

Part No	Ø D mm	Ø D Inch
101035-0140	14mm	9/16"
101035-0170	17mm	11/16"
101035-0180	18mm	
101035-0200	20mm	
101035-0210	21mm	13/16"
101035-0220	22mm	7/8"
101035-0240	24mm	15/16"
101035-0260	26mm	

RECOMMENDED FOR USE WITH:

Rotary Drills
Cordless Drills
SDS Drills

CAN ALSO BE USED WITH:

SDS+ Adapter Extension Arbor

ADAPTERS

Use with any standard 1/2" drill chuck

Magnet Drill Adapter
111035-01
Page 13

SDS+ Adapter
112010-01
Page 14

Extension - 300mm
111015-300
Page 14

VersaDrive Extra Long HoleCutter Sets

Part No	Contents
101035-SET1	HMT VersaDrive TCT HoleCutter Extra Long Series Set, 14, 18, 20, 24, 26mm + Pilots

Pilot Drill Bits

Part No	Contents
101035P-01	HMT VersaDrive Extra Long TCT HoleCutter Pilot Drills, 6.35x165mm, Pk 2
101035P-02	HMT Extra Long VersaDrive HoleCutter Guide Pin, 6.35x205mm, Pk 2

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Good results can be achieved with SDS Drills when used in Rotary Only mode*
- *Replace supplied pilot drill with 101035P-02 ejector pin for use with Magnet Drill/MultiSink*
- *Suitable for use on Stainless Steel*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

Watch the video & find more info online

VERSADRIVE® STAKIT

Total jobsite productivity with VersaDrive *STAKIT*.

Keep the job moving and overcome unexpected job site challenges with these modular kits to speed up metalworking for install and maintenance teams.

VersaDrive® ***STAKIT*** is a new modular system of robust stacking site kits that give fast and easy transportation of your VersaDrive tooling and power tools to the jobsite.

Modular clip-together system so you can plug and play to choose the right package for your needs, or to start small and add more kits over time.

Each case can be used individually or interlocked for fast use in the field, on the jobsite or in the workshop.

Features & Benefits

- *Waterproof & Dustproof*
- *Stacking & Interlocking*
- *Durable, reinforced, injection moulded plastic*
- *Store VersaDrive tooling*
- *Store Magnet Drills*
- *Store cordless power tools*
- *Protect your investment*
- *Easy equipment transportation*
- *Compatible with complete VersaDrive Range*

VERSADRIVE© PATENT PROTECTED

STAKIT Top Case

VersaDrive STAKIT - HoleCutter Pro Kit

NEW

Contents:

5x VersaDrive HoleCutters 12, 14, 18, 20 & 22mm
6x Extra Long HoleCutters 14, 18, 20, 22, 24 &26mm
1x VersaDrive 130mm Extension Adapter

L x W x H (mm) - 540 x 390 x 95

Part No	Product
STC-TOP-VHC02	***STAKIT*** HoleCutter Pro Kit

VersaDrive STAKIT - Impact Starter Kit

NEW

Metric Sized Kit Contents:

3x Reamers 14, 18, 22mm
3x DrillTaps M6, M8, M10
3x ImpactaTaps M12, M16, M20
7x TurboTips 6.8, 8, 8.5, 10, 10.5, 12, 14mm

Inch Sized Kit Contents:

3 x Reamers 9/16, 11/16, 13/16"
3 x DrillTaps 1/4-20, 5/16-18, 3/8-16 UNC
3 x ImpactaTaps 1/2-13, 5/8-11, 3/4-10 UNC
7 x TurboTips #F, 9/32, 5/16, 3/8, 27/64, 7/16, 1/2"

• 3 x VersaDrive Rapid-Lock Adapters

1/4" & 1/2" Impact Adapter & 130mm Extension

Part No	Product
STC-TOP-VSD01	***STAKIT*** Impact Starter Kit - Metric
STC-TOP-VSD02	***STAKIT*** Impact Starter Kit - Inch

VersaDrive STAKIT - Rotary Starter Kit

NEW

Contents:

5x CarbideMax Cutters 12, 14, 18, 22 & 26mm
4x Pilot Pins
6x VersaDrive HoleCutters 14, 16, 18, 20, 22 & 26mm

Part No	Product
STC-TOP-VCM01	***STAKIT*** Rotary Starter Kit

VersaDrive STAKIT - Build Your Own

NEW

Part No	Product
STC-ETOP-F01	Empty toolcase + Inserts for 16 x VersaDrive Tools + 5 VersaDrive Adapters
STC-ETOP-F02	Empty toolcase + Inserts for 16 x CarbideMax / Broach Cutters
STC-ETOP-F03	Empty toolcase + Inserts for 8 x Broach Cutters, 8 x VersaDrive Tools + 3 VSD Adapters

N.B. STAKIT Mid Case required to connect Top case to Base cases

VERSADRIVE© PATENT PROTECTED

NEW

STAKIT Mid Toolcase - Lubricant Insert

The VersaDrive ***STAKIT*** Mid Case is a flexible tool and equipment storage case that also serves to connect the Top Toolcase to Base Cases or the ***STAKIT*** trolley.

The EMID-100-L version comes complete with:
Foam insert for 1 x SpeedLube Aerosol Lubricant
1 x Aeropaste Aerosol Lubricant
2 x BioCut Paste Lubricant
8 x Organiser boxes for tooling & accessories

The EMID-100-LF version includes the above plus lubricant.

L x W x H (mm) - 582 x 387 x 131

Part No	Contents
STC-EMID-100-L	***STAKIT*** Mid Case w. Lubricant Insert & 8 x Organiser boxes (Lubricant not included)
STC-EMID-100-LF	***STAKIT*** Mid Case w. Lubricant Insert, 8 x Organiser boxes & Lubricant

NEW

STAKIT Mid Toolcase - Customisable Foam Insert

The MKC-EMID-200 version of the ***STAKIT*** Mid Case is completely self-customisable. It comes with removable foam inserts that fill the case and can be cut to hold power tools, batteries, chargers, tooling and anything else you will need on site.

Once cut to shape, the foam will hold and protect items inside, offering peace of mind and preventing damage to vital equipment in transit.

L x W x H (mm) - 582 x 387 x 131

Part No	Product
MKC-EMID-200	***STAKIT*** Self-Customisable Mid Case

VERSADRIVE© PATENT PROTECTED

NEW

STAKIT 31pc Site Installation Kit

The ***STAKIT*** Site Installation Kit is created to combine an essential set of best-selling VersaDrive products to overcome all common site installation and steel erection holemaking challenges. Keeps the job moving when you find an unexpected challenge.

Presented in the ***STAKIT*** Mid Case and connects to all Top cases and Base cases.

Metric Sized Kit Contents:
6 x TurboTips 6, 6.35, 8, 10.5, 12, 14mm
5 x HoleCutters 14, 17, 18, 20 & 22mm
2 x ImpactaStep 16 & 22mm
3 x DrillTaps M6, M8 & M10
3 x ImpactaTaps M12, M16 & M20
4 x Reamers 12, 14, 18 & 22mm

Inch Sized Kit Contents:
6 x TurboTips 1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
5 x HoleCutters 9/16, 5/8, 3/4, 7/8, 1"
2 x ImpactaStep 9/16, 13/16
3 x DrillTaps 5/16, 3/8, 1/2"
3 x ImpactaTaps 1/2, 5/8, 3/4
4 x Reamers 1/2, 9/16, 11/16, 13/16"

+ 5x Rapid lock adapters
1/4" Impact Driver Adapter, 1/2" Impact Wrench Adapter, Magnet Drill Adapter, 130mm Extension, 300mm Extension

L x W x H (mm) - 582 x 387 x 131

Part No	Contents
STC-EMID-MEIK	***STAKIT*** 31pc Installation Kit - Metric
STC-EMID-INIK	***STAKIT*** 31pc Installation Kit - Inch Sizes

NEW

V35 Magnet Drill & STAKIT Base 200 Case

The Base 200 case is a durable protective site case featuring top and side handles for easy carrying. It can also be clipped directly to the ***STAKIT*** SiteCart for manoeuvring with the rest of the system or longer distance transportation.

It is available in two versions. Firstly as the included sitecase for the VersaDrive V35 Magnet Drill. Like this it comes complete with interior moulded foam that protects and secures the V35 whilst in transit, 2 internal organiser boxes and 2 external compartments for storing tooling, handles and accessories.

Secondly it is available as a standalone case with 6 reconfigurable internal organiser boxes and 2 accessory organisers in the lid. In this format the case is perfect for holding cordless powertools, batteries, chargers and other essential portable equipment.

In both configurations the Base 200 seamlessly integrates into the ***STAKIT*** system for easy transportation & use on a jobsite or in the field.

L x W x H (mm) - 585 x 385 x 190

Part No	Contents
850035-110	HMT V35 VersaDrive Magnetic Drill 110v
850035-230	HMT V35 VersaDrive Magnetic Drill 230v
MKC-EBASE-200	***STAKIT*** Base 200 Replacement Case

VERSADRIVE© PATENT PROTECTED

NEW

V60T Magnet Drill & STAKIT 350 Case

The ***STAKIT*** Base 350 is a large capacity protective site case that features a top handle for short distance carrying and can be connected directly to the ***STAKIT*** SiteCart for longer distance transportation.

It is available in two versions. Firstly as the included sitecase for the VersaDrive V60T Magnet Drill. Like this it comes complete with interior moulded foam, that protects and secures the V60T and accessories whilst in transit, and 2 external compartments for storing additional tooling and equipment.

Secondly it is available as a standalone case perfect for larger equipment storage or for holding all your handheld drive tools in one place. No foam inserts or dividers means this case offers the most flexibility of use and can be filled with whatever is needed for the job.

L x W x H (mm) - 585 x 385 x 320

Part No	Product
850060-P-110	HMT V60T VersaDrive Magnetic Drill Pro Kit - 110v with ***STAKIT*** 350 Case
850060-P-230	HMT V60T VersaDrive Magnetic Drill Pro Kit - 230v with ***STAKIT*** 350 Case
MKC-EBASE-350	***STAKIT*** Base 350 Case

NEW

STAKIT SiteCart

The ***STAKIT*** SiteCart is a wheeled base unit with adjustable height handle and robust, water and dust proof construction.

The case can be used on its own for large equipment storage or combined with the rest of the ***STAKIT*** system to transport tooling and cases to and around the job site or workshop.

The case is designed to be tilted and pulled, has a handy narrow size and is easy to manoeuvre. Supplied empty.

L x W x H (mm) - 600 x 460 x 765

Part No	Product
STC-SITECART	***STAKIT*** SiteCart

VERSADRIVE© PATENT PROTECTED

NEW

STAKIT Starter Kit

The VersaDrive ***STAKIT*** Starter Kit contains everything needed to get underway on site and overcome all the most common metalworking challenges. Whether you need to create holes, alter them or tap them, the starter kit contains the tooling and lubricant needed to complete the job quickly and efficiently.

A compact but high power V35 VersaDrive Magnet Drill is part of the kit, ensuring that wherever you go, you have access to lightweight, portable broaching and drilling capabilities.

The included SiteCart features rugged, all-terrain wheels and an integrated handle to allow the equipment stack to be tilted and pulled with ease whilst the contents remain organised and protected.

Contents:

1 x ***STAKIT*** Rotary Starter Kit (p.47)
1 x ***STAKIT*** Impact Starter Kit (p.47)
1 x ***STAKIT*** Mid Case with Lubricant & organiser boxes (p.48)
1 x V35 VersaDrive Magnet Drill (p.53)
1 x ***STAKIT*** Base 200 Case (p.49)
1 x ***STAKIT*** SiteCart (p.50)

Part No	Product
STC-KIT-S1-110	***STAKIT*** Starter Kit Complete 110v
STC-KIT-S1-230	***STAKIT*** Starter Kit Complete 230v

NEW

STAKIT Pro Kit

The VersaDrive ***STAKIT*** Pro Kit dominates when it comes to improving efficiency, speeding up jobs and overcoming serious metalworking obstacles.

All the essential tooling and equipment needed to drill, broach, ream & tap the most common holes sizes is available where & when it is needed.

Easy access, kitted sets contain all the VersaDrive and CarbideMax tooling required, whilst a powerful V60T VersaDrive magnet drill offers hole cutting up to 60mm diameter and 150mm depth, reaming up to 20mm, tapping up to M20 and countersinking to 40mm.

In addition the fully customisable Mid Case allows transportation and storage of additional drive tools like Impact Wrenches & Cordless drills.

Contents:

1 x ***STAKIT*** Rotary Starter Kit (p.47)
1 x ***STAKIT*** Impact Starter Kit (p.47)
1 x ***STAKIT*** Mid Case with Lubricant & organiser boxes (p.48)
1 x ***STAKIT*** Customisable Mid Case (p.48)
1 x V60T VersaDrive Magnet Drill (p.54)
1 x ***STAKIT*** Base 350 Case (p.50)
1 x ***STAKIT*** SiteCart (p.50)

Part No	Product
STC-KIT-P1-110	***STAKIT*** Pro Kit Complete 110v
STC-KIT-P1-230	***STAKIT*** Pro Kit Complete 230v

VERSADRIVE®
PATENT PROTECTED

VersaDrive Magnet Drill Range

Unique benefits from a unique range.

From the lightest, most compact machine on the market to machines with variable speed, variable torque and forward/reverse as standard, VersaDrive magnet drills have been custom engineered to optimise performance.

Designed and built in our Sheffield factory by the expert HMT team, all machines with tapping capacity are powered by a legendary Eibenstock motor and combine with the Patented VersaDrive modular tooling system to extend consumable life and enhance performance for all kinds of broaching, drilling, threading, countersinking and more.

When registered, products are protected by a
2 YEAR WARRANTY

UK Built

Model	Max Cutter Diameter	Fitting	Weight (Kg)	Stroke	Drilling	Tapping	Countersinking
V35	35mm	19.05mm (3/4")	9.5kg	140mm	12mm	N/A	25mm
V60T	60mm	MT2	18kg	220mm	20mm	M20	40mm
V85T	85mm	MT3	20.5kg	220mm	27mm	M27	55mm
V100T	100mm	MT3	24.5kg	280mm	30mm	M30	55mm
V125T	125mm	MT3	25kg	280mm	32mm	M32	65mm

VERSADRIVE©
PATENT PROTECTED

VersaDrive V35 Magnet Drill

UK CA Approved

Supplied with a quick change VersaDrive adapter

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 35mm
MAX CUTTER CAPACITY	35mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	12mm
COUNTERSINKING	25mm
REAMING	N/A
MAX TAP CAPACITY	N/A
LENGTH	220mm
WIDTH (Inc Handles)	173mm
HEIGHT (Min-Max)	305 - 445mm
STROKE	140mm
WEIGHT	9.5kg
MAGNET (L X W)	160 x 80mm
MAGNETIC ADHESION	1000kg
MOTOR POWER	850W
TOTAL POWER	900W
SPEED RPM (No Load)	750 min^{-1}
SPINDLE	3/4" Weldon
ARBOR	Integral 3/4" Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

Coming Q2 2021

Part No	Contents
850035-110	HMT V35 VersaDrive Magnetic Drill 110v
850035-230	HMT V35 VersaDrive Magnetic Drill 230v

Supplied in STAKIT Base 200 case

The HMT VersaDrive V35 is the first UK Built portable drilling machine designed for high-performance, low-maintenance, industrial quality drilling up to 35mm diameter. It delivers constant performance in the most challenging drilling environments and fabrication conditions.

This machine fills a gap in the market for extremely light weight, high drilling speed, and long stroke to accept a wide range of VersaDrive Tooling such as twist drills, countersinks, drillsinks, step drills and more.

Supplied with handles, restraint strap, heavy duty metal guard system,, VersaDrive Rapid-Lock adapter, site case and gravity fed coolant system.

MOST VERSATILE COMPACT MACHINE ON THE MARKET

VERSADRIVE©
PATENT PROTECTED

VersaDrive V60T Magnet Drill

Supplied with two quick change adapters

UK Built

Supplied in **STAKIT** Base 350 case

Technical Specifications

CUTTER SIZE RANGE	12 - 60mm TCT
MAX CUTTER CAPACITY	60mm TCT
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
LENGTH	315mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	385 - 605mm
STROKE	220mm
WEIGHT	18 kg
MAGNET (L X W)	200 x 100mm
MAGNETIC ADHESION	1750 kgs
MOTOR POWER	1150w
TOTAL POWER	1270w
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V60T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 60mm diameter with a powerful forward and reverse, variable speed motor that will tap holes up to M20 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Part No	Contents
850060-P-110	HMT V60T VersaDrive Magnetic Drill Pro Kit - 110v
850060-P-230	HMT V60T VersaDrive Magnetic Drill Pro Kit - 230v

MARKET LEADING PERFORMANCE

VERSADRIVE©
PATENT PROTECTED

VersaDrive V85T Magnet Drill

Supplied with two quick change adapters

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 85mm TCT
MAX CUTTER CAPACITY	85mm TCT
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	27mm
COUNTERSINKING	55mm
REAMING	24mm
MAX TAP CAPACITY	M27
LENGTH	325mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	425 - 645mm
STROKE	220mm
WEIGHT	20.5 kg
MAGNET (L X W)	200 x 100mm
MAGNETIC ADHESION	1750 kgs
MOTOR POWER	1800w
TOTAL POWER	1920w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V85T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 85mm diameter with a powerful forward and reverse, variable speed motor that will tap holes up to M27 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Part No	Contents
850085-P-110	HMT V85T VersaDrive Magnetic Drill Pro Kit - 110v
850085-P-230	HMT V85T VersaDrive Magnetic Drill Pro Kit - 230v

MARKET LEADING PERFORMANCE

VERSADRIVE©
PATENT PROTECTED

VersaDrive V100T Magnet Drill

Supplied with two quick change adapters

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 100mm TCT
MAX CUTTER CAPACITY	100mm TCT
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	55mm
REAMING	26mm
MAX TAP CAPACITY	M30
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	450 - 730mm
STROKE	280mm
WEIGHT	24.5 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC ADHESION	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V100T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 100mm diameter with a powerful forward and reverse, variable speed motor that will tap holes up to M30 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V100T can also be used with the VersaDrive blind hole tapping system up to M30 diameter.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Part No	Contents
850100-P-110	HMT V100T VersaDrive Magnetic Drill Pro Kit - 110v
850100-P-230	HMT V100T VersaDrive Magnetic Drill Pro Kit - 230v

MARKET LEADING PERFORMANCE

VERSADRIVE©
PATENT PROTECTED

VersaDrive V125T Magnet Drill

Supplied with two quick change adapters

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 125mm TCT
MAX CUTTER CAPACITY	125mm TCT
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	60mm
REAMING	32mm
MAX TAP CAPACITY	M32
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	470 - 750mm
STROKE	280mm
WEIGHT	25 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC ADHESION	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60-140 / 100-220 / 140-310 / 210-490
SPINDLE	MT3
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V125T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 125mm diameter with a powerful forward and reverse, variable speed motor that will tap holes up to M32 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V125T can also be used with the VersaDrive blind hole tapping system up to M30 diameter.

Supplied with handles, restraint strap, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Part No	Contents
850125-P-110	HMT V125T VersaDrive Magnetic Drill Pro Kit - 110v
850125-P-230	HMT V125T VersaDrive Magnetic Drill Pro Kit - 230v

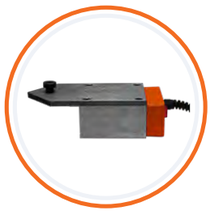
MARKET LEADING PERFORMANCE

OverReach Fixed System

The HMT OverReach system is a range of magnetic base units that are designed to reach over obstructions such as plates or rivet heads to position a drilling unit where it would have not been previously possible. The powerful electromagnet can be positioned further away from the hole and a magnet drill can be placed on the fixed projecting steel plate to give more positioning options.

Technical Specifications

CUTTER CAPACITY	30mm
PLATE THICKNESS	10mm
PLATE AREA	212 x 115mm
WEIGHT	7.6kg
MAGNET POWER	1100kgs
MAGNET DIMENSIONS	115 x 115mm
MAX WEIGHT SUPPORTED	12kg
USE WITH	V35, MAX30, MAX40V Magnet Drills
MINIMUM BASE MATERIAL REQUIRED	10mm thick, clean, flat, paint & rust free



CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

UK Built

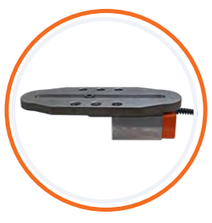
861010	HMT OverReach Magnet Base Clamp Fixed V Plate, 110 Volt

OverReach Swivel System

The HMT OverReach Swivel system extends the reach of the fixed base unit. An adjustable arm mounted to the magnetic base allows magnet drills to be positioned up to 300mm from the fixed unit giving greater flexibility and overcoming otherwise impractical or impossible drilling challenges.

Technical Specifications

CUTTER CAPACITY	30mm
PLATE THICKNESS	20mm
PLATE AREA	400 x 140mm
WEIGHT	12.6kg
TRAVEL	300mm
MAGNET POWER	1100kgs
MAGNET DIMENSIONS	115 x 115mm
MAX WEIGHT SUPPORTED	12kg
USE WITH	V35, MAX30, MAX40V Magnet Drills
MINIMUM BASE MATERIAL REQUIRED	10mm thick, clean, flat, paint & rust free



CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

UK Built

861020	HMT OverReach Magnet Base Clamp with Slide Plate, 110 Volt

RTQ40 Magnet Drill

Integrated lubricant system and feed hose

Technical Specifications

CUTTER SIZE RANGE	12-40mm
MAX CUTTER CAPACITY	40mm
TWIST DRILL CAPACITY	13mm
LENGTH	310mm
WIDTH	135mm
HEIGHT	180mm
STROKE	40mm
WEIGHT	10.8kg
MAGNET (L x W x H)	160x80x37mm
MAGNETIC FORCE	1200kg
MOTOR POWER	1050W
TOTAL POWER	1100W
SPEED RPM (No Load)	700RPM
SPINDLE	19.05mm 3/4" Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	1 Year

Part No	Contents
803084-110	HMT RTQ40 Low Profile Magnetic Drill 110V
803084-230	HMT RTQ40 Low Profile Magnetic Drill 230V

The new HMT RTQ40 is a low profile Magnet drill for tight access applications, being designed to fit into any space greater than 180mm. Suitable for use with any standard broaching cutters while optimised to work with the high-performance CarbideMax 40 cutters.

- Ratchet drive can be mounted on either side of the machine.
- Powerful motor and magnet gives excellent stability.
- Quick-change 19.05mm 3/4" arbor for all standard broaching cutters

Each machine comes in a plastic case with hex keys, restraint strap, ratchet, and removable coolant system.

IDEAL FOR TIGHT ACCESS APPLICATIONS

HMT MAX40V Magnet Drill

Metal guard system supplied as part of a comprehensive kit package

The MAX40V offers a 145mm stroke and comfortably accommodates cutters up to 110mm for deep broaching. It also accepts the VersaDrive Rapid-Lock Weldon Adapter with VersaDrive tooling, opening up 1,000s of time saving solutions from the whole VersaDrive system.

Technical Specifications

CUTTER SIZE RANGE	12 - 40mm TCT
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	16mm
COUNTERSINKING	25mm
REAMING	12mm
LENGTH	264mm
WIDTH (Inc Handles)	180mm
HEIGHT (Min-Max)	360 - 440mm
STROKE	145mm
WEIGHT	10.5 kg
MAGNET (L X W)	160 x 80mm
MAGNETIC ADHESION	1500 kgs
MOTOR POWER	1150w
SPEED RPM (No Load)	600 RPM
SPINDLE	19.05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

MARKET LEADING PERFORMANCE

Part No	Contents
803046-110	HMT MAX40V Magnetic Drill - 110V
803046-230	HMT MAX40V Magnetic Drill - 230V

MAX200 Magnet Drill

Compatible with the largest CarbideMax XL broach cutters

Technical Specifications

CUTTER SIZE RANGE	12-200mm
MAX CUTTER LENGTH	200mm
TWIST DRILL RANGE	12-50mm
TAPPING RANGE	N/A
COUNTERSINKING	80mm
REAMING	39mm
LENGTH	480mm
WIDTH INC HANDLES	260mm
HEIGHT	660-840mm
STROKE	280mm
WEIGHT	53kg
MAGNET SIZE (L x W)	330x110mm
MAGNETIC FORCE	3900kg
MOTOR POWER	3800W
SPEED RPM (No Load)	1) 70-150 2)170-410 RPM
SPINDLE	MT4
ARBOR	Weldon XL 32mm 1 1/4"
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The Ultimate Magnetic Drill for the largest possible broaching, drilling and Countersinking tasks. Fantastic power and magnetic adhesion make this Mag Drill a world beater for heavy duty engineering tasks.

- Designed for heavy portable engineering works
- Huge Power 3800 Watt Motor
- High precision Twin column slideway system
- Up to 200mm Broach Capacity

Each machine comes in a metal, heavy duty, wheeled case with MT4 broaching arbor, hex keys, restraint strap, and internal coolant system.

HUGE POWER AND MAGNET HOLD TO MAKE LIGHT WORK OF HEAVY ENGINEERING TASKS

Part No	Contents
803095-0001	HMT MAX200 Magnet Drill Kit - 110v
803095-0002	HMT MAX200 Magnet Drill Kit - 230v

CARBIDEMAX®

TUNGSTEN CARBIDE TECHNOLOGY

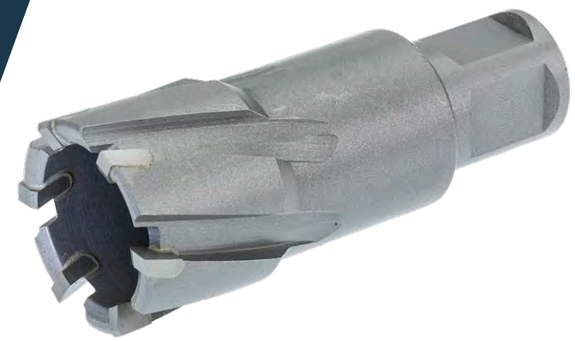
Cut more holes, more quickly, for longer with CARBIDEMAX
ULTIMATE VALUE FOR MONEY

CarbideMax TCT Broach cutters by Holemaker Technology are a new generation of broach cutter proven to more than halve the cost of hole broaching compared with traditional HSS cutters.

CarbideMax TCT cutters also offer a life expectancy up to 10x that of standard HSS cutters and cutting speeds up to 64% faster thanks to their individually brazed Tungsten Carbide cutting teeth and elaborate tool geometry.

This specialist construction also results in quieter, easier drilling, with smooth, accurate holes and chatter free performance throughout the cut.

The CarbideMax range - stronger and faster for longer, the ultimate value for money.



A NEW GENERATION OF LONG-LIFE CUTTER

UP TO 10X LONGER LIFE

Tungsten Carbide is one of the hardest materials available for use in cutting tools.
The HMT CarbideMax range uses Premium Grade Sandvik Tungsten Carbide teeth meaning that cutters are capable of drilling the toughest steels whilst maintaining strength & cutting surface for up to 10x longer than traditional HSS cutters.

This leads to greater efficiency and fewer stops as fewer tools are reordered and replaced.

UP TO 64% FASTER CUTS

The elaborate geometry of CarbideMax broach cutters means the teeth of the cutter do all the work.
This reduces strain on the tool body and means that a strong but thin flexible alloy can be used for its construction.
Thinner walls means CarbideMax tools need to remove less material from the work piece resulting in a faster cut and quieter, easier drilling.

Standard Weldon Shank suitable for all magnet drills

Tool body made from flexible steel alloy which results in fewer breakages & faster cut

Highest performance teeth suitable for cutting the hardest steels

Sizes available

				Extreme Drilling Depth		Ultra Large Diameter	
Ø	12-80mm	12-65mm	12-50mm	14-60mm	18-50mm	18-50mm	65-150mm	16-120mm
L	40mm	55mm	80mm	110mm	150mm	200mm	55mm	110mm

Features & Benefits - The world's largest range of in-stock & available TCT products

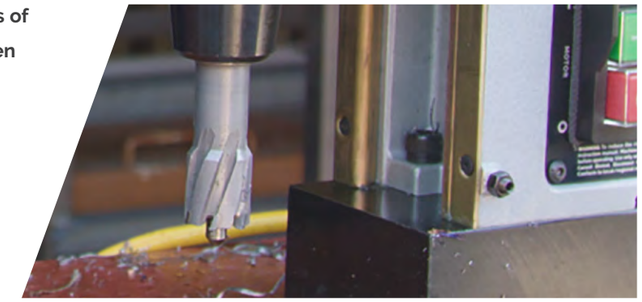
- *Up to 10x the life of standard HSS cutters*
- *Up to 64% faster than HSS cutters*
- *Premium Sandvik Tungsten Carbide teeth*
- *Fits all standard 19.05mm Weldon shanks*
- *Works well in Stainless Steel & Cast Iron*
- *Elaborate tool geometry for a smooth cut*
- *More than halves the cost of hole broaching*
- *Reduced thickness tool made from flexible alloy steel results in fewer breakages*

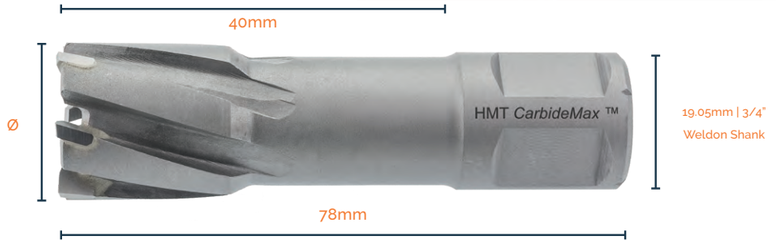
WELDON SHANK

CarbideMax 40 Broach Cutter

The CarbideMax™ 40 Series will broach up to 35mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance





Part No	D Ø mm
108030-0120	12mm
108030-0130	13mm
108030-0140	14mm
108030-0150	15mm
108030-0160	16mm
108030-0170	17mm
108030-0180	18mm
108030-0190	19mm
108030-0200	20mm
108030-0210	21mm
108030-0220	22mm
108030-0230	23mm
108030-0240	24mm
108030-0250	25mm
108030-0260	26mm
108030-0270	27mm
108030-0280	28mm
108030-0290	29mm
108030-0300	30mm
108030-0310	31mm
108030-0320	32mm
108030-0330	33mm

Part No	D Ø mm
108030-0340	34mm
108030-0350	35mm
108030-0360	36mm
108030-0370	37mm
108030-0380	38mm
108030-0390	39mm
108030-0400	40mm
108030-0410	41mm
108030-0420	42mm
108030-0430	43mm
108030-0440	44mm
108030-0450	45mm
108030-0460	46mm
108030-0470	47mm
108030-0480	48mm
108030-0490	49mm
108030-0500	50mm
108030-0550	55mm
108030-0600	60mm
108030-0650	65mm
108030-0700	70mm
108030-0750	75mm
108030-0800	80mm

Pilot Pins

For 12-17mm cutters	Dia Ø	Length	Unit of sale
108030P-0170	6.34	90	Pack 2
108030P-0170-P10	6.34	90	Pack 10
For 18-80mm cutters			
108030P-0600	7.98	90	Pack 2
108030P-0600-P10	7.98	90	Pack 10

Kitted Sets

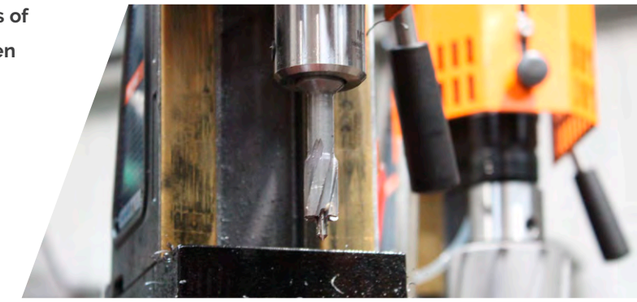
Part No	Contents
108030-SET	14, 18, 22mm + 2 Pilot Pins
108030-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

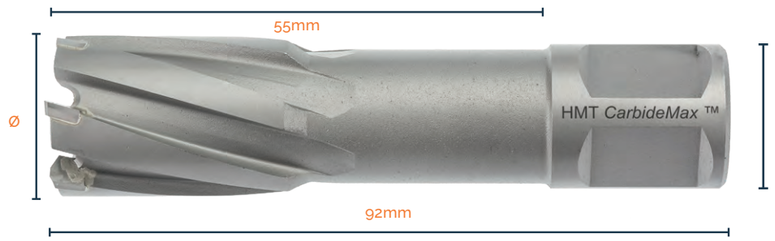
WELDON SHANK

CarbideMax 55 Broach Cutter

The CarbideMax™ 55 Series will broach up to 50mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance





Part No	D Ø mm
108020-0120	12mm
108020-0130	13mm
108020-0140	14mm
108020-0150	15mm
108020-0160	16mm
108020-0170	17mm
108020-0175	17.5mm
108020-0180	18mm
108020-0190	19mm
108020-0200	20mm
108020-0210	21mm
108020-0220	22mm
108020-0230	23mm
108020-0240	24mm
108020-0250	25mm
108020-0260	26mm
108020-0265	26.5mm
108020-0270	27mm
108020-0280	28mm
108020-0290	29mm
108020-0300	30mm
108020-0310	31mm
108020-0320	32mm
108020-0330	33mm
108020-0340	34mm

Part No	D Ø mm
108020-0350	35mm
108020-0360	36mm
108020-0370	37mm
108020-0380	38mm
108020-0390	39mm
108020-0400	40mm
108020-0410	41mm
108020-0420	42mm
108020-0430	43mm
108020-0440	44mm
108020-0450	45mm
108020-0460	46mm
108020-0470	47mm
108020-0480	48mm
108020-0490	49mm
108020-0500	50mm
108020-0510	51mm
108020-0520	52mm
108020-0530	53mm
108020-0540	54mm
108020-0550	55mm
108020-0560	56mm
108020-0570	57mm
108020-0580	58mm
108020-0590	59mm
108020-0600	60mm

Pilot Pins

For 12-17mm cutters	Dia Ø	Length	Unit of sale
108020P-0170	6.34	103	Pack 2
108020P-0170-P10	6.34	103	Pack 10
For 17.5-60mm cutters			
108020P-0600	7.98	103	Pack 2
108020P-0600-P10	7.98	103	Pack 10

Kitted Sets

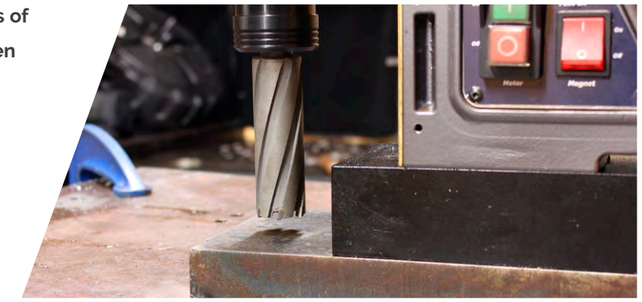
Part No	Contents
108020-SET	14, 18, 22mm + 2 Pilot Pins
108020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

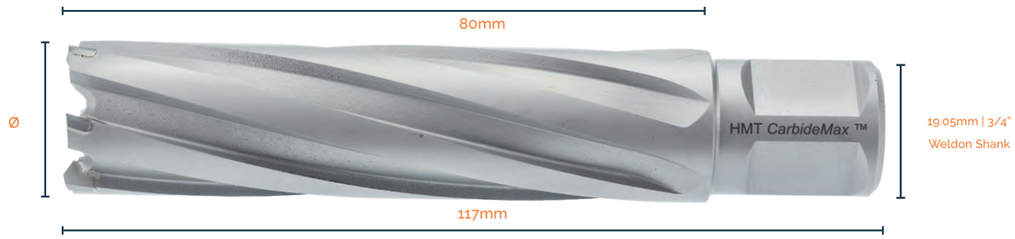
WELDON SHANK

CarbideMax 80 Broach Cutter

The CarbideMax™ 80 Series will broach up to 75mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance





Part No	D Ø mm
108010-0120	12mm
108010-0140	14mm
108010-0160	16mm
108010-0180	18mm
108010-0200	20mm
108010-0220	22mm
108010-0240	24mm
108010-0260	26mm
108010-0280	28mm
108010-0300	30mm
108010-0320	32mm

Part No	D Ø mm
108010-0330	33mm
108010-0340	34mm
108010-0350	35mm
108010-0360	36mm
108010-0380	38mm
108010-0390	39mm
108010-0400	40mm
108010-0420	42mm
108010-0450	45mm
108010-0500	50mm

Pilot Pins

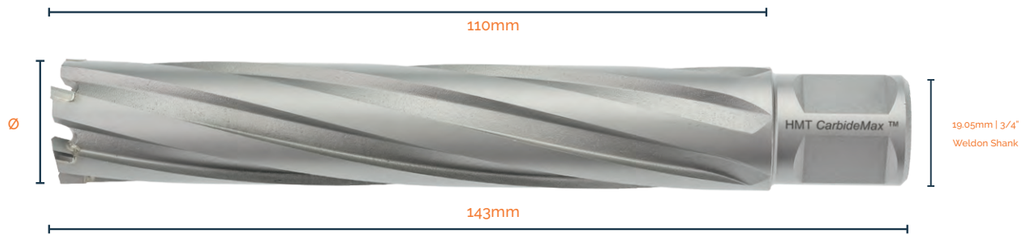
For 12-17mm cutters	Dia Ø	Length	Unit of sale
108010P-0170	6.34	130	Pack 2
For 18-60mm cutters			
108010P-0600	7.98	130	Pack 2

WELDON SHANK

CarbideMax 110 Broach Cutter

The CarbideMax™ 110 Series will broach up to 110mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- Up to 10x longer life than traditional HSS Cutters
- 64% Faster cuts than HSS cutters
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance



Part No	D Ø mm
108040-0140	14mm
108040-0160	16mm
108040-0180	18mm
108040-0190	19mm
108040-0200	20mm
108040-0210	21mm
108040-0220	22mm
108040-0230	23mm
108040-0240	24mm
108040-0250	25mm
108040-0260	26mm
108040-0270	27mm
108040-0280	28mm
108040-0290	29mm
108040-0300	30mm
108040-0320	32mm
108040-0330	33mm
108040-0340	34mm
108040-0350	35mm
108040-0360	36mm
108040-0380	38mm

Part No	D Ø mm
108040-0390	39mm
108040-0400	40mm
108040-0410	41mm
108040-0420	42mm
108040-0430	43mm
108040-0440	44mm
108040-0450	45mm
108040-0460	46mm
108040-0470	47mm
108040-0480	48mm
108040-0490	49mm
108040-0500	50mm
108040-0510	51mm
108040-0520	52mm
108040-0540	54mm
108040-0550	55mm
108040-0560	56mm
108040-0570	57mm
108040-0580	58mm
108040-0590	59mm
108040-0600	60mm

Pilot Pins

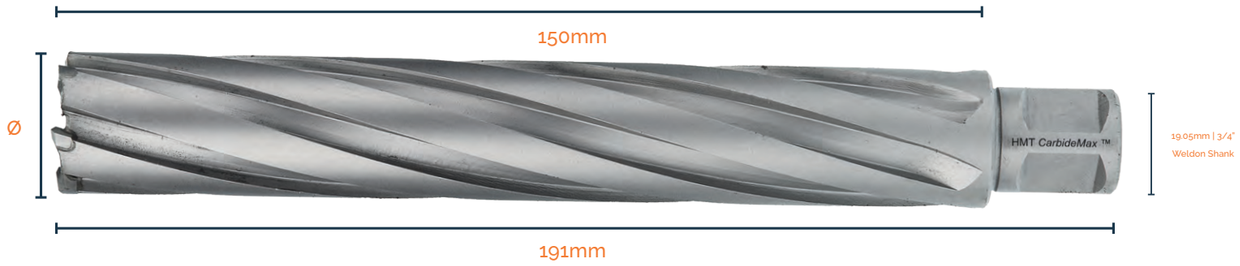
For 14-17mm cutters	Dia Ø	Length	Unit of sale
108040P-0171	6.34	155	Pack 2
For 18-60mm cutters			
108040P-0600	7.98	155	Pack 2

WELDON SHANK CarbideMax 150 Extra Long Broach Cutter

Extreme drilling depth with CarbideMax Extra Long.

For the most extreme drilling depths the CarbideMax range offers 150mm & 200mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any magnet drill with sufficient stroke.



Drill matching holes through box or H section in a single pass

Part No	D Ø mm
108045-0180	18mm
108045-0200	20mm
108045-0220	22mm
108045-0240	24mm
108045-0260	26mm
108045-0280	28mm
108045-0300	30mm
108045-0320	32mm
108045-0330	33mm
108045-0360	36mm
108045-0390	39mm
108045-0500	50mm

Pilot Pins

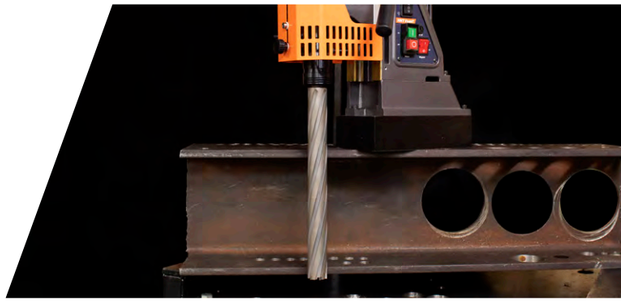
Part No	Dia Ø	Length	Unit of sale
108045P-0600	7.98	205	Pack 2

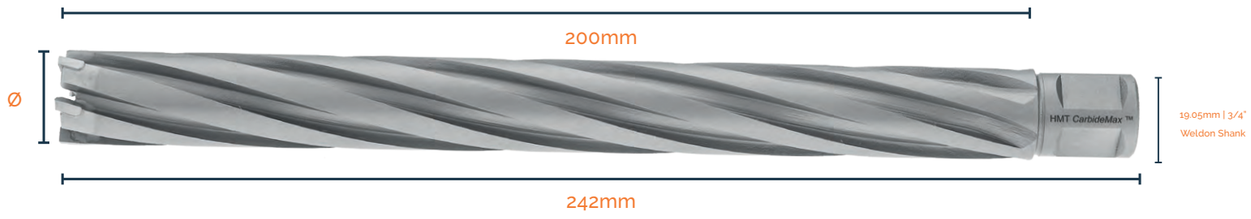
WELDON SHANK CarbideMax 200 Extra Long Broach Cutter

Extreme drilling depth with CarbideMax Extra Long.

For the most extreme drilling depths the CarbideMax range offers 150mm & 200mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any magnet drill with sufficient stroke.





Drill matching holes through box or H section in a single pass

Part No	D Ø mm
108050-0180	18mm
108050-0200	20mm
108050-0220	22mm
108050-0240	24mm
108050-0260	26mm
108050-0300	30mm
108050-0320	32mm
108050-0330	33mm
108050-0360	36mm
108050-0390	39mm
108050-0420	42mm
108050-0450	45mm
108050-0500	50mm

Pilot Pins

Part No	Dia Ø	Length	Unit of sale
108050P-0600-2P	7.98	255	Pack 2

Used when drilling material greater than 50mm thick. When the pilot pin reaches the extent to which it can retract inside the magnet drill arbor, the bottom section of the pilot can be removed to allow the hole to be completed without removing the pilot pin from the cutter.

32mm WELDON SHANK

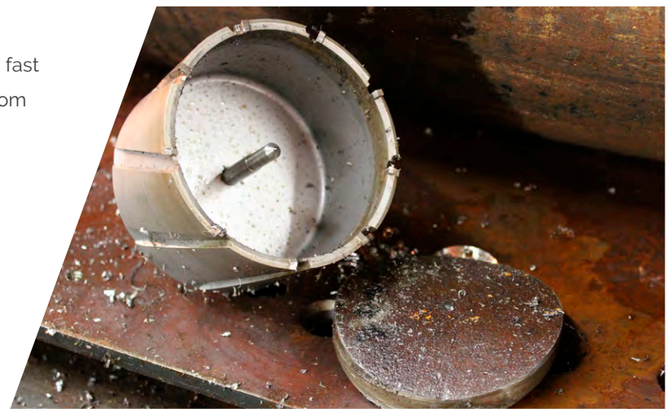
CarbideMax XL55 Broach Cutter

Ultra large diameter drilling with CarbideMax XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL55™ range offers cutters from 61mm up to 150mm diameter with a 55mm cutting depth.

These high quality TCT cutters have a reinforced 32mm diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 32mm shank for use with standard 19.05mm weldon shank magnet drills.



Part No	D Ø mm
108020-0610	61mm
108020-0620	62mm
108020-0630	63mm
108020-0640	64mm
108020-0650	65mm
108020-0660	66mm
108020-0670	67mm
108020-0680	68mm
108020-0690	69mm
108020-0700	70mm
108020-0750	75mm
108020-0800	80mm
108020-0850	85mm
108020-0900	90mm

Part No	D Ø mm
108020-0950	95mm
108020-1000	100mm
108020-1050	105mm
108020-1100	110mm
108020-1150	115mm
108020-1200	120mm
108020-1250	125mm
108020-1270	127mm
108020-1300	130mm
108020-1350	135mm
108020-1400	140mm
108020-1450	145mm
108020-1500	150mm

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL55 cutters to 19.05mm standard Magnet Drill fitting; includes pilot for 55mm Depth Cutters

Part No	Details
103091-1932-55	19.05 Male to 32mm Female Weldon Adapter + Pilot for 55mm cutters

32mm Weldon Shank Morse Taper Arbor & Pilot *(Spring loaded for cutter slug ejection)*

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4"
103013-0324	MT4	32mm / 1 1/4"
108020P-1500	CarbideMax55 Pilot Pin, 61-150mm, Pk 2	

32mm WELDON SHANK

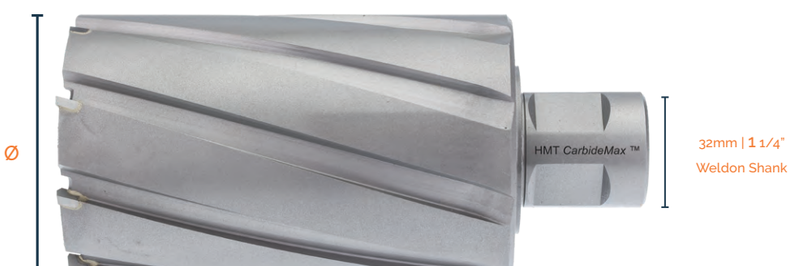
CarbideMax XL110 Broach Cutter

Ultra large diameter drilling with CarbideMax XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL110™ range offers cutters from 61mm up to 200mm diameter with a 110mm cutting depth.

These high quality TCT cutters have a reinforced 32mm diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 32mm shank for use with standard 19.05mm weldon shank magnet drills.



Part No	D Ø mm
108040-0610	61mm
108040-0620	62mm
108040-0630	63mm
108040-0640	64mm
108040-0650	65mm
108040-0660	66mm
108040-0670	67mm
108040-0680	68mm
108040-0690	69mm
108040-0700	70mm
108040-0730	73mm
108040-0750	75mm
108040-0800	80mm
108040-0850	85mm
108040-0900	90mm

Part No	D Ø mm
108040-0950	95mm
108040-1000	100mm
108040-1050	105mm
108040-1100	110mm
108040-1150	115mm
108040-1200	120mm
108040-1250	125mm
108040-1300	130mm
108040-1350	135mm
108040-1400	140mm
108040-1500	150mm
108040-1600	160mm
108040-1700	170mm
108040-1800	180mm
108040-1900	190mm
108040-2000	200mm

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL110 cutters to 19.05mm standard Magnet Drill fitting; includes pilot for 110mm Depth Cutters

Part No	Details
103091-1932-110	19.05 Male to 32mm Female Weldon Adapter + Pilot for 110mm cutters

32mm Weldon Shank Morse Taper Arbor & Pilot *(Spring loaded for cutter slug ejection)*

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4"
103013-0324	MT4	32mm / 1 1/4"
108040P-1500-2P	CarbideMax 110 2 Piece Pilot Pin 61-200mm, Pk2	

WELDON SHANK

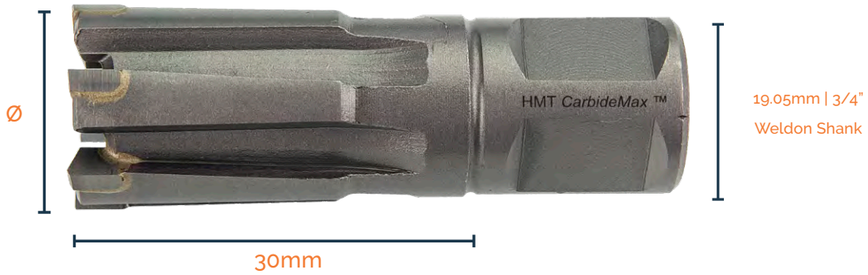
CarbideMax RAIL 30 Broach Cutter

The railways keep the country moving and regular maintenance & repair work is necessary to keep them in excellent condition.

As a Network Rail Approved supplier, HMT has developed a range of broach cutters specifically designed to speed up and reduce the costs of drilling rail track material.

Specially machined cutting geometries offer superior performance against HSS cutters and other similar alternatives with in excess of 100 holes in UIC 60 Rail achievable.

CarbideMax Rail Cutters are suitable for Cembre, Rotabroach and other similar rail track drilling machines.



Part No	Diameter mm	Shank Size
106030-0180	**18mm**	19.05mm / 3/4"
106030-0200	**20mm**	19.05mm / 3/4"
106030-0220	**22mm**	19.05mm / 3/4"
106030-0240	**24mm**	19.05mm / 3/4"
106030-0260	**26mm**	19.05mm / 3/4"
106030-0280	**28mm**	19.05mm / 3/4"
106030-0300	**30mm**	19.05mm / 3/4"
106030-0320	**32mm**	19.05mm / 3/4"
106030-0360	**36mm**	19.05mm / 3/4"

Pilot Pins

Part No	Dia Ø	Length	Unit of sale
106030P-0360	7.98	77	Pack 2

WELDON SHANK

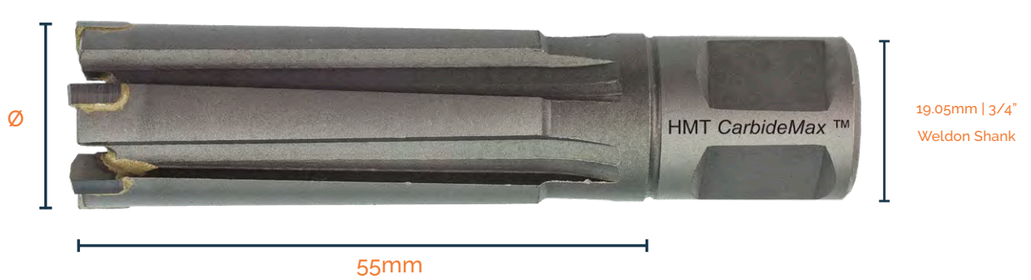
CarbideMax RAIL 55 Broach Cutter

The railways keep the country moving and regular maintenance & repair work is necessary to keep them in excellent condition.

As a Network Rail Approved supplier, HMT has developed a range of broach cutters specifically designed to speed up and reduce the costs of drilling rail track material.

Specially machined cutting geometries offer superior performance against HSS cutters and other similar alternatives with in excess of 100 holes in UIC 60 Rail achievable.

CarbideMax Rail Cutters are suitable for Cembre, Rotabroach and other similar rail track drilling machines.



Part No	Diameter mm	Shank Size
106020-0180	**18mm**	19.05mm / 3/4"
106020-0200	**20mm**	19.05mm / 3/4"
106020-0220	**22mm**	19.05mm / 3/4"
106020-0240	**24mm**	19.05mm / 3/4"
106020-0260	**26mm**	19.05mm / 3/4"
106020-0280	**28mm**	19.05mm / 3/4"
106020-0300	**30mm**	19.05mm / 3/4"
106020-0320	**32mm**	19.05mm / 3/4"
106020-0330	**33mm**	19.05mm / 3/4"
106020-0360	**36mm**	19.05mm / 3/4"

Pilot Pins

Part No	Dia Ø	Length	Unit of sale
108020P-0600	7.98	103	Pack 2

CarbideMax ULTRA Range

HMT have developed a generation of ULTRA cutting tools for use in the most challenging applications.

The specialist ULTRA coating is proven to significantly increase tool life, making ULTRA products the perfect solution in situations requiring high performance durability, prolonged use or machining extremely hard materials.

They are produced from premium grade materials and coated using a range of state of the art, high-temperature surface coatings.

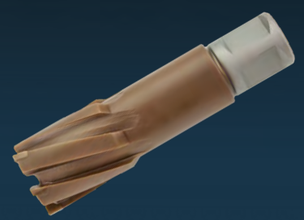
- *Use for increased durability*
- *Cuts material 5x harder than S275 Structural Steel*
- *Use on Wear Plate & Armour Plate*
- *Use on Stainless Steel*
- *Perfect for use on heavy equipment & machinery*
- *Use with BioCut Blue & SpeedLube lubricants*

Ideal for use on HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

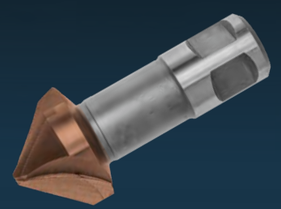
Premium, long-life tooling for use in the most challenging applications

Capable of providing a service life in excess of
9X longer than uncoated TCT tools.

CarbideMax ULTRA Coated MultiSink
601056
Page 75



CarbideMax ULTRA TCT Broach Cutter
108070
Page 76



CarbideMax ULTRA 90° Countersink 32mm
601036
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MACHINING WEAR PLATE

The extreme hardness and resistance of wear plate makes machining it extremely challenging. Good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, like the VersaDrive Series, and ample lubrication - BioCut Blue cutting fluid when broaching or Speedlube Aerosol spray when countersinking.
Using an incorrect or poorly maintained Magnet drill with unstable drilling operation, poor magnet hold, excessive pressure or inadequate lubrication is likely to result in rapid tool failure.

Even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It not only requires the correct setup but also experienced operators with the time necessary to proceed with caution.

WELDON SHANK

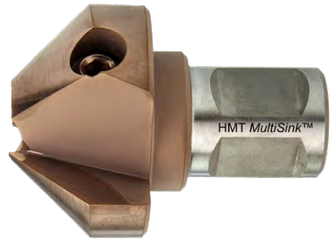
ULTRA Coated MultiSink

Ultra coated Multisink for increased wear resistance and long-life performance whilst countersinking the most challenging applications, including materials like Hardox, Inconel and Armor plate.

The MultiSink is a worldwide unique new Combination Countersink Tool designed & developed by HMT for use with Magnetic Drills.

Features & Benefits

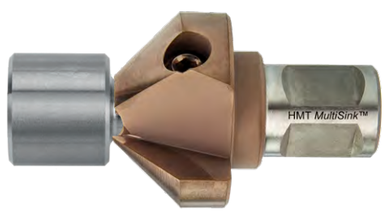
- *Innovative Combination Countersinking Tool*
- *Save Time Completing Countersunk Holes*
- *Suitable for holes of 16mm and above*
- *For holes <16mm, see the 32mm Ultra countersink - P.78*



19.05mm 3/4"
Weldon Shank

Ultra Coated MultiSink

Part No	D Ø mm	Point Angle	Shank mm
601056-0400	**40mm**	90°	19.05mm / 3/4”
601056-0550	**55mm**	90°	19.05mm / 3/4”



MultiSink Pilot

For countersinking bolt holes from 16 - 26mm diameter. Use Multisink with variable speed magnet drill. The speed must be reduced when countersinking.

Part No	d1 Ø	length mm	Shank mm
601050-0160	**16mm**	52	11.0
601050-0180	**18mm**	52	11.0
601050-0200	**20mm**	52	11.0
601050-0220	**22mm**	52	11.0
601050-0240	**24mm**	52	11.0
601050-0260	**26mm**	52	11.0

WELDON SHANK

ULTRA CarbideMax 55

CarbideMax Ultra cutters are specifically designed for long-life performance in the toughest broaching jobs on the planet, including Hardox steel.

- Individually brazed, highest quality carbide cutting teeth
- ULTRA coated for optimum performance & lifespan
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance when used correctly

Part No	D Ø mm
108070-0160	16mm
108070-0170	17mm
108070-0175	17.5mm
108070-0180	18mm
108070-0190	19mm
108070-0200	20mm
108070-0210	21mm
108070-0220	22mm
108070-0230	23mm
108070-0240	24mm
108070-0250	25mm
108070-0260	26mm
108070-0265	26.5mm
108070-0270	27mm
108070-0280	28mm
108070-0290	29mm
108070-0300	30mm
108070-0310	31mm
108070-0320	32mm
108070-0330	33mm
108070-0340	34mm
108070-0350	35mm
108070-0360	36mm
108070-0370	37mm

Part No	D Ø mm
108070-0380	38mm
108070-0390	39mm
108070-0400	40mm
108070-0410	41mm
108070-0420	42mm
108070-0430	43mm
108070-0440	44mm
108070-0450	45mm
108070-0460	46mm
108070-0470	47mm
108070-0480	48mm
108070-0490	49mm
108070-0500	50mm
108070-0510	51mm
108070-0520	52mm
108070-0530	53mm
108070-0540	54mm
108070-0550	55mm
108070-0560	56mm
108070-0570	57mm
108070-0580	58mm
108070-0590	59mm
108070-0600	60mm

Pilot Pins

Part No	D Ø	Length	Cutter Size	Qty
108020P-0170	6.34	103	12-17mm	Pack 2
108020P-0600	7.98	103	18-60mm	Pack 2

Kitted Sets

Part No	Set Contains
108070-SET2	5 piece set 18, 20, 22, 24 & 26mm

WELDON SHANK

ULTRA CarbideMax 110

CarbideMax Ultra cutters are specifically designed for long-life performance in the toughest broaching jobs on the planet, including Hardox steel.

- Individually brazed, highest quality carbide cutting teeth
- ULTRA coated for optimum performance & lifespan
- Elaborate cutting geometry for faster, quieter drilling
- Chatter free performance when used correctly

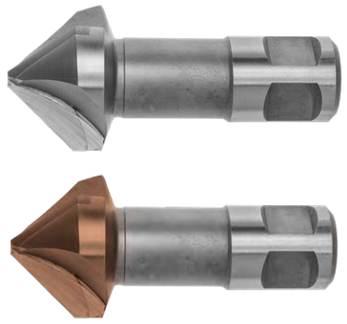
Part No	D Ø mm
108090-0160	16mm
108090-0180	18mm
108090-0190	19mm
108090-0200	20mm
108090-0210	21mm
108090-0220	22mm
108090-0230	23mm
108090-0240	24mm
108090-0250	25mm
108090-0260	26mm
108090-0270	27mm
108090-0280	28mm
108090-0290	29mm
108090-0300	30mm
108090-0320	32mm
108090-0330	33mm
108090-0340	34mm
108090-0350	35mm
108090-0360	36mm
108090-0380	38mm
108090-0390	39mm

Part No	D Ø mm
108090-0400	40mm
108090-0410	41mm
108090-0420	42mm
108090-0430	43mm
108090-0440	44mm
108090-0450	45mm
108090-0460	46mm
108090-0470	47mm
108090-0480	48mm
108090-0490	49mm
108090-0500	50mm
108090-0510	51mm
108090-0520	52mm
108090-0540	54mm
108090-0550	55mm
108090-0560	56mm
108090-0570	57mm
108090-0580	58mm
108090-0590	59mm
108090-0600	60mm

Pilot Pins

For 14-17mm cutters	Dia Ø	Length	Unit of sale
108040P-0171	6.34	155	Pack 2
For 18-60mm cutters			
108040P-0600	7.98	155	Pack 2

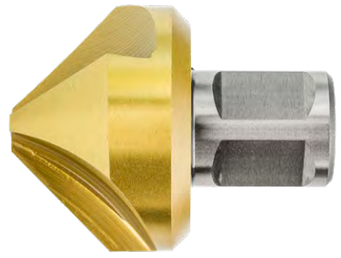
HMT Weldon Shank TCT Countersink & ULTRA Coated TCT Countersink, 32mm 90°



Premium countersink with 3X heavy duty tungsten carbide inserts for maximum life in challenging materials.
Standard 19.05mm Weldon shank for use in all standard magnet drills. Use with a 103013 Morse taper arbor to use in a pillar drill press or radial drill. ULTRA coated version available for use on materials like Hardox & other wear plate.

Part No	Size
601035-0320	32mm TCT Countersink
601036-0320	32mm ULTRA Countersink

GoldMax HSS Weldon Countersink - 90°



Specially coated for increased tool life.

Standard 19.05mm Weldon shank for use in all standard magnet drills.

Part No	Size
601025-0300	30mm
601025-0400	40mm
601025-0550	55mm

VersaDrive Countersinks

The VersaDrive Countersink is a premium quality countersink with fully ground flutes and Titanium coating to help reduce wear and blunting.

VersaDrive Countersinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Utilise the convenience and power of an impact wrench to quickly debur and countersink holes up to 16.5mm with minimal torque kick-back against the operator.

Refer to P38 for more information.

VersaDrive DrillSink 90°

The VersaDrive Drillsink is an innovative combined drilling & countersinking tool to save metalworkers time & increase hole accuracy by drilling & then countersinking fixing holes in one operation.

This combination tool provides perfect countersinking accuracy every time by locating the drilled hole in perfect alignment to the countersink. This helps prevent tool chatter and blunting commonly found with standard countersinks.

VersaDrive DrillSinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

Refer to P36 for more information.

HMT 90° Carbide Indexable Countersink 76mm

76mm heavy-duty large countersink with Morse Taper shank. Each countersink is supplied with Premium replaceable carbide inserts for cost effective performance in structural metals. Supplied with set of 3 tips which are double sided for extended use.

Part No	Product
602040-0760	MT3 Carbide Indexable Countersink
602040-0760R	Single Tungsten Carbide Tip - 2 sided

HMT Magnet Drill Countersink - 50mm, 60°

High Speed Steel material with precision ground flutes. Standard 19.05mm Weldon shank for use in all standard magnet drills.

Part No	Size
601040-0500	50mm

	Part No	D Ø mm	Ø d1 mm	Countersunk Screw
Metric - 90°	603060-0063	6.3mm	1.5	M3
	603060-0083	8.3mm	2.0	M4
	603060-0104	10.4mm	2.5	M5
	603060-0124	12.4mm	2.8	M6
	603060-0165	16.5mm	3.2	M8
	603060-0205	20.5mm	3.5	M10
	603060-0250	25mm	3.8	M12
	603060-0310	31mm	4.2	M16
Inch - 82°	603065-0100	1/4"	1/16	-
	603065-0200	3/8"	7/64	-
	603065-0300	1/2"	7/64	-
	603065-0400	5/8"	1/8	-
	603065-0500	3/4"	1/8	-
	603065-0600	1"	11/64	-

	Part No	Ø Drill Size	Countersink Size	Countersunk Screw
Clearance Hole Sizes	603070-08124	8mm	12.4mm	M6
	603070-10165	10mm	16.5mm	M8
	603070-11205	11mm	20.5mm	M10
	603070-12205	12mm	20.5mm	M10
	603070-13250	13mm	25mm	M12
	603070-14250	14mm	25mm	M12
Tap Hole Sizes	603070-68165	6.8mm	16.5mm	M8 (Tapped)
	603070-85205	8.5mm	20.5mm	M10 (Tapped)
	603070-102250	10.2mm	25mm	M12 (Tapped)

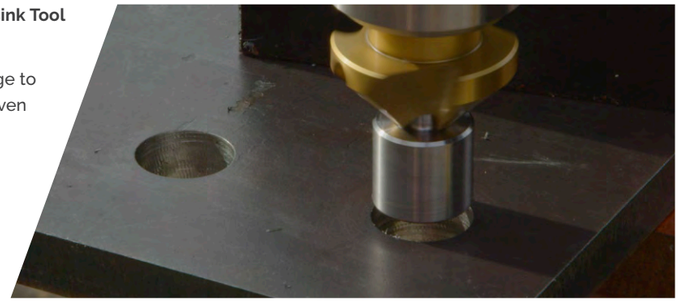
The VersaDrive MultiSink® System

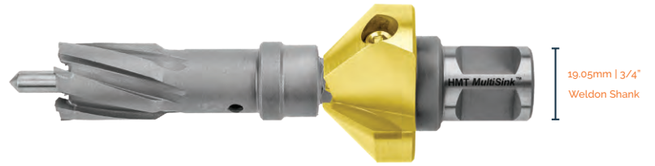
VERSADRIVE® PATENT PROTECTED

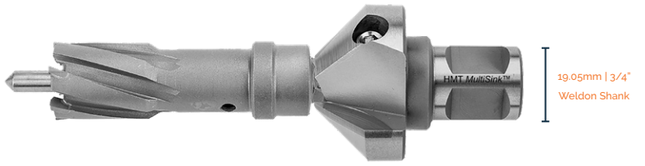
The MultiSink is a worldwide unique new Combination Countersink Tool designed and developed by HMT for use with Magnetic Drills.

The tool is designed to combine with the VersaDrive product range to Broach & Countersink, Drill & Countersink, Tap & Countersink or even Drill, Tap & Countersink in one operation - providing huge time-saving benefits.

The MultiSink is available in HSS and Tungsten Carbide Tipped versions. The HSS Multisink features a GoldMax titanium coating to stop burn-out whilst the TCT version is specifically designed for countersinking Inox and the hardest structural steels.







Features & Benefits

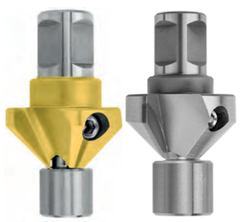
- *Innovative Combination Countersinking Tool*
- *Save Time Completing Countersunk Holes*
- *Broach & Countersink in one operation*
- *Drill & Countersink in one operation*
- *Tap & Countersink in one operation*
- *Drill-Tap & Countersink in one operation*

RECOMMENDED FOR USE WITH:

Magnet Drills

CAN ALSO BE USED WITH:

Pillar Drills
Radial Arm Drills



Piloted Countersink

Broach & Countersink in one operation 16-26mm

Drill & Countersink in one operation 16-22mm

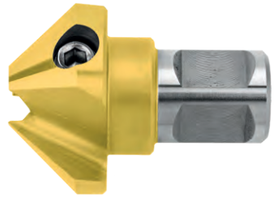
Tap & Countersink in one operation M16-M24

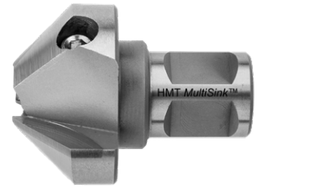
Drill, Tap & Countersink in one operation M16-M24

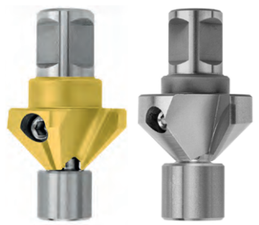
Quick Guide

- *Operations involving tapping require a Magnet Drill with variable speed & reverse features*
- *For predrilled holes, the MultiSink should always be used with a pilot to avoid damage*
- *When used to drill or broach & countersink or for multiple operations eg Drill/Tap/Countersink it is important to use the correct RPM for each separate operation*

Watch the video & find more info online







The HSS MultiSink® Tool

Part No	D Ø mm	Ø d2 mm	L	Point Angle	Shank mm
601050-0400	**40mm**	14mm	100mm	90°	19.05mm / 3/4"
601050-0550	**55mm**	14mm	109mm	90°	19.05mm / 3/4"

CarbideMax TCT MultiSink®

Part No	D Ø mm	Ø d2 mm	L	Point Angle	Shank mm
601055-0400	**40mm**	14mm	100mm	90°	19.05mm / 3/4"
601055-0550	**55mm**	14mm	109mm	90°	19.05mm / 3/4"

MultiSink® Pilot

For countersinking bolt holes from 16 - 26mm diameter. Use Multisink with variable speed magnet drill. The speed must be reduced when countersinking.

Part No	d1 Ø	length mm	Shank mm
601050-0160	**16mm**	52	11.0
601050-0180	**18mm**	52	11.0
601050-0200	**20mm**	52	11.0
601050-0220	**22mm**	52	11.0
601050-0240	**24mm**	52	11.0
601050-0260	**26mm**	52	11.0

MultiSink® Ejector Pilot Pin

For use with VersaDrive HoleCutters

Part No	d1 Ø	l1 mm	Unit of sale
101030P-0003	**6.35**	145	Pack 2

WELDON SHANK

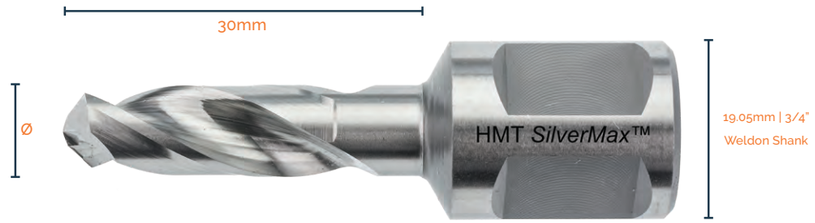
Weldon Shank Twist Drill Bits

HSS-XE twist drill bits with integrated Weldon shank for simple and accurate drilling in steel and fast tool changing. Removes the need for using a separate drill chuck in a magnet drill.

Where drilling smaller holes or tapping size holes has been a long and time consuming job in the past, fitting the SilverMax Weldon Shank Twist Drills into a magnet drill can suddenly make the job far quicker and safer than struggling with a pistol drill and jobber drills.

Features & Benefits

- *Integrated Weldon shank*
- *Simple & Accurate drilling in steel*
- *No need for a tool chuck when using a magnet drill*
- *Fast tool changing*
- *Quicker and safer than struggling with a pistol drill*
- *Fits 19.05mm arbors - use with any standard mag drill*



Part No	Diameter mm	Shank Size	Tap Size (Metric Coarse)
201070-0050	**5.0mm**	19.05mm / 3/4"	M6
201070-0060	**6.0mm**	19.05mm / 3/4"	-
201070-0068	**6.8mm**	19.05mm / 3/4"	M8
201070-0070	**7.0mm**	19.05mm / 3/4"	-
201070-0080	**8.0mm**	19.05mm / 3/4"	-
201070-0085	**8.5mm**	19.05mm / 3/4"	M10
201070-0090	**9.0mm**	19.05mm / 3/4"	-
201070-0100	**10.0mm**	19.05mm / 3/4"	-
201070-0102	**10.2mm**	19.05mm / 3/4"	M12
201070-0110	**11.0mm**	19.05mm / 3/4"	-
201070-0120	**12.0mm**	19.05mm / 3/4"	-

Weldon Drill Bit Sets

Part No	Contents
201070-SET	4 piece Set contains: 6, 8, 10, 12mm Weldon Drill Bits
201070-TSET	4 piece Set contains: 5.0, 6.8, 8.5, 10.2mm Weldon Drill Bits Tap Sizes

IMPACT RATED

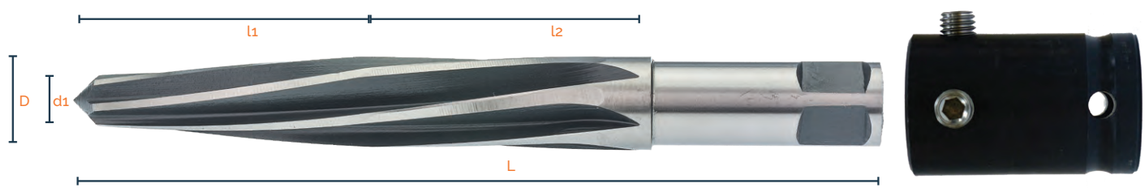
ImpactaMag Reamers

The ImpactaMag™ HSS reamer is a unique double-use reamer for enlarging and aligning holes in metals and hard materials.

Specially designed cutting geometry allows the tool to be used in an Impact wrench or a Magnet drill. When used in an Impact wrench it is secured into a special adapter meaning the tool is easier to control, apply correct feed rate, and withdraw from the finished hole, enhancing tool life. This reamer will also fit into a standard Weldon magnet drill arbor.

Features & Benefits

- *Ideal for steel erection & bridge work*
- *Ideal for modifying & enlarging holes*
- *Secured directly to the Impact Wrench*
- *Can be used with any standard Magnet Drill*
- *Unique 6 flute design for faster, smoother cut*
- *Prepare holes ready for TCB & friction grip bolts*



Part No	Max Diameter mm (D)	Shank Size	d1 mm	L mm	l1 mm	l2 mm	Minimum torque to Ream 15mm steel
501020-0140	**14mm**	19.05mm / 3/4"	7	140	52	50	340 Nm
501020-0180	**18mm**	19.05mm / 3/4"	9	165	61	53	360 Nm
501020-0200	**20mm**	19.05mm / 3/4"	11	178	62	65	380 Nm
501020-0220	**22mm**	19.05mm / 3/4"	13	178	62	65	400 Nm
501020-0240	**24mm**	19.05mm / 3/4"	15	178	63	63	520 Nm
501020-0260	**26mm**	19.05mm / 3/4"	16	178	67	60	520 Nm
501020-0280	**28mm**	19.05mm / 3/4"	19	178	67	60	600 Nm
501020-0300	**30mm**	19.05mm / 3/4"	21	178	64	63	650 Nm
501020-0320	**32mm**	19.05mm / 3/4"	22.5	178	64	63	650 Nm
501020-0330	**33mm**	19.05mm / 3/4"	23	200	70	57	650 Nm
501020-0360	**36mm**	19.05mm / 3/4"	26	200	71	57	800 Nm
501020-0390	**39mm**	19.05mm / 3/4"	29	200	70	56	1000 Nm

ImpactaMag® Reamer Sets

Part No	Set Contains
501020-3SET	14, 18, 22mm ImpactaMag Reamers
501020-SET-WO	14, 18, 22, 26, 32mm ImpactaMag Reamers

• Sets do not include adapter

ImpactaMag® Impact Adapter

Part No	Square Drive Size	Shank Size
00200-12A-19	**1/2"**	19.05mm / 3/4"
00200-34A-19	**3/4"**	19.05mm / 3/4"

• Supplied with retention pin & ring.

Weldon Shank - Morse Taper Arbor 19.05mm

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0192	MT2	19.05mm / 3/4”
103013-0193	MT3	19.05mm / 3/4”
103013-0194	MT4	19.05mm / 3/4”

Spring Loaded Extension Arbor

Spring Loaded extension arbor for very deep drilling using multiple extension arbors in series. The spring loaded design means only the bottom extension needs to be piloted, with standard cutter pilot pin. Will pass through hole diameters greater than 35mm.

Part No	Extension Length	Shank Size
103095-1000	100mm	19.05mm / 3/4”

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-55	19.05 Male to 32mm Female Weldon Adapter + Pilot for 55mm cutters
103091-1932-110	19.05 Male to 32mm Female Weldon Adapter + Pilot for 110mm cutters

Standard Weldon Shank Extension Arbor

• Will pass through hole diameters greater than 35mm

Part No	Extension Length	Shank Size
103090-0500	50mm	19.05mm / 3/4”
103090-0750	75mm	19.05mm / 3/4”
103090-1000	100mm	19.05mm / 3/4”

Replacement Grub Screws

Part No	Thread Size	Hex Key Size	Unit of sale
103060-0606	M6 x 6	3mm	Pack 10
103060-0808	M8 x 8	4mm	Pack 10
103060-1010	M10 x 10	5mm	Pack 10
103060-1212	M12 x 12	6mm	Pack 10

32mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4”
103013-0324	MT4	32mm / 1 1/4”

Morse Taper Sleeve

Morse Taper sleeve reducers have a smaller internal taper size than the machine (drive) end, to allow a smaller morse taper to be fitted. Hardened and ground high precision specification.

Part No	Size
103615-R21	MT2 outside, MT1 Inside
103615-R32	MT3 outside, MT2 Inside
103615-R43	MT4 outside, MT3 Inside

Morse Taper Drifts

Tapered steel drifts for simple removal of Morse Taper arbors, drill bits and tooling from MT2, MT3 or MT4 machine spindles

Part No	Suits
103012-0002	MT1 & MT2
103012-0003	MT3
103012-0004	MT4

Magnetic Swarf Lifter

Part No	Total Length	Magnet Length
103011-0001	400mm	180mm

Morse Taper Extension

Morse Taper Extensions have an Internal and an External Morse Taper and are used to extend the reach of Magnet Drill Arbors and enable the use of tooling with different size shanks. Hardened and ground high precision specification.

Part No	Size
103616-E32	MT3 outside, MT2 inside
103616-E33	MT3 outside, MT3 inside
103616-E34	MT3 outside, MT4 inside
103616E-E43	MT4 outside, MT3 inside
103616-E44	MT4 outside, MT4 inside

Magnet Drill Chuck & Adapter

Part No	Description	Fitting Type
103017	Chuck Adapter	19.05mm / 3/4”
103070	Keyed Chuck	B16

Weldon Quick Change Morse Taper Magnet Drill Arbor

Weldon Morse Taper Arbor with a smooth action, rotating collar and push-release action to allow rapid tool or adapter loading and unloading without the need for fiddly, time consuming grub screws or Allen keys. Takes 19.05mm (3/4”) Magnet Drill Weldon fitting.

Part No	Description
103016-0192	MT2 Quick change arbor
103016-0193	MT3 Quick change arbor

GoldMax Tungsten Carbide Burrs

GoldMax TCT Burr - Flame

Standard 6mm Shank

Part No	Head Dimension	Total Length
402050-0060	6 x 16mm	60mm
402050-0120	12 x 25mm	70mm

GoldMax TCT Burr - Cylinder End Cut

Standard 6mm Shank

Part No	Head Dimension	Total Length
402040-0060	6 x 16mm	60mm
402040-0120	12 x 25mm	69mm

GoldMax TCT Burr - Ball Nose

Standard 6mm Shank

Part No	Head Dimension	Total Length
402020-0060	6 x 16mm	60mm
402020-0120	12 x 25mm	69mm

GoldMax TCT Burr - Ball

Standard 6mm Shank

Part No	Head Dimension	Total Length
402010-0060	6 x 6mm	50mm
402010-0120	12 x 10mm	55mm

GoldMax TCT Burr - Tree

Standard 6mm Shank

Part No	Head Dimension	Total Length
402060-0060	6 x 16mm	60mm
402060-0120	12 x 25mm	69mm

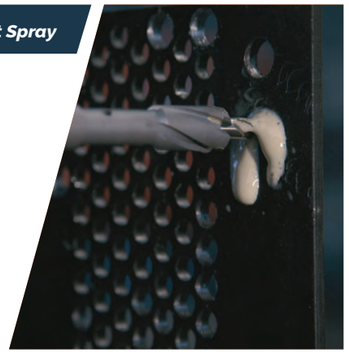
GoldMax TCT Burr - 4 Piece Set

4 Piece set contains Flame, Cylinder, Ball Nose and Tree Burrs in 12mm head diameter

Part No	Head Dimension
4020-SET1	12mm

Metal Cutting Lubricants

SpeedLube™ Lubricant Spray



SpeedLube™ is a high performance foaming lubricant suitable for a wide variety of metal drilling applications across a range of materials including stainless steel.
Aerosol propellant ensures the lubricant foams on contact to ensure maximum tool coverage and heat dissipation. Easy one-handed application provides fast, efficient lubricant coverage and minimises the amount of applications needed during the drilling process. Unique 360° valve which enables Speedlube to be sprayed from all angles.

Part No	Aerosol Size	Unit of Sale
701010-0002	500ml	Each
701010-0002-P12	500ml	Pack of 12

AeroPaste™ Lubricant Spray

AeroPaste™ is an aerosol applied paste-type, metalworking lubricant for hole broaching, tapping, reaming & drilling applications. Ideal for overhead or positional application, the high viscosity of AeroPaste allows it to cling directly to the cutting tool or steel it is applied to, without fluid run-off.
Ideal for use in environmentally sensitive areas such as above water. Using AeroPaste minimises repainting or galvanising issues caused by conventional soluble lubricants and reduces mess and slipping hazards.

Part No	Aerosol Size	Unit of Sale
701010-0001	500ml	Each
701010-0001-P12	500ml	Pack of 12

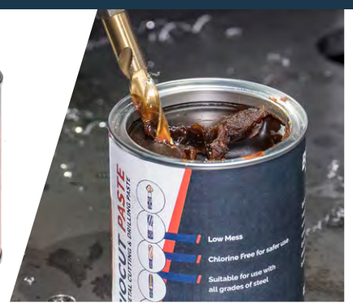
BioCut Blue Neat Broaching Oil

BioCut Blue is a ultra high-performance cutting fluid designed for metal fabrication broaching, cutting, and drilling tasks.

- Water-soluble fluid supplied ready-for-use.
- Inherently bio-degradable, can be 100% removed with water.
- Synthetic based, chlorine free, with zero mineral oils.
- No adverse affects for welding and galvanising.
- Excellent performance on Stainless Steel & Hardox type materials

Part No	Bottle Size	Unit of Sale
704010-0001	5 Litres	Each
704010-0001-P4	5 Litres	Box of 4
704010-0002	500ml Bottle	Each
704010-0002-P20	500ml Bottle	Box of 20

BioCut Paste - Drilling & Tapping Paste

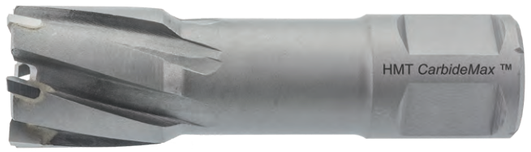


BioCut Drilling & Cutting paste is specifically formulated for superb performance when used with HMT Impact wrench cutting tools. Extreme pressure concentration provides accurate hole lubrication. Excellent general purpose paste lubricant when drilling, tapping, countersinking, reaming and broaching. Chlorine Free for safer use. Suitable for use with all grades of steel including Stainless Steel & Aluminium.

Part No	Aerosol Size	Unit of Sale
704030-0001	250g	Each
704030-0001-P16	250g	Pack of 16

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

TCT Broach Cutter - Data Sheet



Cutter Diameter	Structural Steel <500Nm (S275, S355) Based on mm/R Feed of 0.10	Structural Steel <1000Nm Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Cast Iron-Grey	Aluminium
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
12-19 mm	1265-850	850-580	530-350	925-615	2200-1560
20-25 mm	840-650	550-410	345-255	610-440	1480-1140
26-32 mm	545-460	410-315	250-200	430-335	1125-890
33-39 mm	460-395	315-265	195-170	330-280	885-730
40-46 mm	405-340	265-250	165-140	280-235	720-620
47-53 mm	335-300	250-195	135-120	235-205	615-545
54-60 mm	295-265	195-180	120-105	200-180	540-475
61-70 mm	260-230	180-140	105-90	180-160	475-415
71-80 mm	230-200	140-130	90-70	160-145	410-365
81-90 mm	195-180	130-115	70-65	140-125	350-325
91-100 mm	180-160	115-100	60-55	125-110	320-280
101-112 mm	160-140	100-90	55-50	110-100	280-250
113-124 mm	140-120	90-85	50-48	100-90	250-235
125-136 mm	120-110	85-75	48-45	90-80	230-205
137-150 mm	110-100	70-65	45-40	80-75	205-190

Best Practice Advice

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

1	Centre punch or pilot drill the surface for accurate hole start.	6	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
2	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.	7	Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.
3	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.	8	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Avoid lateral movement or tilting which can cause damage to the cutter.	9	For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf.
5	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	10	Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task.

Quick Guide

1	*Adjust RPM to match the material hardness*
2	*Slowly and cautiously begin cutting before increasing pressure*
3	*For best results and swarf clearance always select a cutter longer than the material thickness*
4	*For hard materials and wear plates like Hardox use Ultra coated cutters. See page 76*

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TCT HoleCutter - Data Sheet

Holesaw Diameter	Structural Steel <500Nm Based on mm/R Feed of 0.10	Structural Steel <1000Nm Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Aluminium	Cast Iron (Grey)	Fibreglass	Composite	Plastics	Wood
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
13-17MM	1350-850	840-585	500-360	2210-1575	900-625	780-705	1350-850	900-640	1495-1010
18-25MM	850-625	580-420	350-250	1575-1125	600-455	700-520	850-625	620-450	990-895
26-31MM	620-500	415-325	240-195	1080-885	435-345	500-405	620-500	440-345	895-850
32-39MM	480-410	320-275	195-160	875-740	330-285	400-330	480-410	345-280	850-740
40-46MM	390-340	270-220	160-145	730-620	285-240	315-275	390-340	175-235	740-610
47-53MM	335-300	220-180	140-120	615-545	235-215	275-245	335-300	235-215	600-505
54-60MM	295-260	180-165	115-100	525-485	210-180	240-215	295-260	210-185	500-460
61-70MM	260-225	165-155	100-90	475-415	180-160	205-185	260-225	180-160	455-400
71-80MM	220-195	155-140	90-75	410-365	155-140	180-160	220-195	155-140	395-360

Best Practice Advice

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

1	Centre punch or pilot drill the surface for accurate hole start	6	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
2	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	7	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time.
3	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut	8	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Avoid lateral movement or tilting which can cause damage to the tool	9	For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf.
5	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	10	For thicker materials, predrill 6.35mm pilot hole first and use then sprung pilot drill or pilot pin as a guide.

Quick Guide

1	*Optimum life and performance when used with rotary pistol drills*
2	*Good results from SDS Drills when used in Rotary-Only mode*
3	*For best results pre-drill the pilot hole*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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ImpactaStep Cutter - Data Sheet

Impact Torque Nm

Reamer Diameter	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel
Diameter Ø	Nm Torque	
8MM	200	380
10MM	220	400
12MM	280	420
1/2”	300	445
14MM	320	480
9/16”	330	490
5/8”	335	505
16MM	340	510
11/16”	350	525
18MM	360	540
3/4”	370	550
20MM	380	570
22MM	400	600
7/8”	425	630
15/16”	460	695
24MM	520	780
1”	530	805
26MM	545	840
1-1/16”	575	875

Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel
Ft Lb Torque	
160	290
175	300
185	305
205	310
220	330
235	355
250	375
260	390
265	400
270	410
280	420
285	425
300	435
310	440
380	575
385	600
390	620
405	640
440	660

Revolutions per minute (Rotary)

Reamer Diameter	Structural Steel <500Nm 32m/Min	Structural Steel <1000Nm 18m/Min	Stainless Steel INOX 12m/Min	Brass 32m/Min	Cast Iron (Grey) 16m/Min	Aluminium 45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2”	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16”	690	360	305	450	450	1025
5/8”	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16”	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4”	490	230	195	250	280	745
20MM	490	230	195	510	250	745
22MM	460	210	180	470	235	690
7/8”	460	210	180	235	235	675
15/16”	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1”	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16”	295	130	125	190	385	380

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	When drilling into box section ensure the tip of the tool is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool.
7	Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive Reamer.		

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Excellent life and performance when used with rotary pistol drills or drill presses*
3	*Suitable for stainless and harder materials if used at low RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Step Drill - Data Sheet

Metric

Impact Torque Nm

Step Drill Diameter	Impact Torque
Diameter Ø	Nm Torque
3-12 mm	200-280
14-22 mm	330-400
24-30 mm	400-485
32-40 mm	610-750

Revolutions per minute (Rotary)

Step Drill 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
3-12 mm	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
14-22 mm	597-430	390-270	200-145	600-440	245-180	380-275
24-30 mm	420-330	260-215	140-110	420-330	175-135	275-180
32-40 mm	260-230	160-145	85-75	260-230	95-85	150-140

Inch

Impact Torque Ft Lbs

Step Drill Diameter	Impact Torque
Diameter Ø	Ft Lbs Torque
3/16-1/2”	270-380
3/16-7/8”	440-540
1/4-1-3/8”	540-660

Revolutions per minute (Rotary)

Step Drill 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
3/16-1/2”	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
3/16-7/8”	597-430	390-270	200-145	600-440	245-180	380-275
1/4-1-3/8”	420-330	260-215	140-110	420-330	175-135	275-180

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	When drilling into box section ensure the tip of the Step-Drill is not contacting the far side of the box section at the same time it is drilling the outside wall. This may cause breakage to the tool.

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Excellent life and performance when used with rotary pistol drills or drill presses*
3	*Suitable for stainless and harder materials if used at low RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Drill Bit - Data Sheet

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

Best Practice Advice

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

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

Quick Guide

1	*Optimum life and performance when used with rotary pistol drills*
2	*Up to 10mm can be used on impact wrench & impact drivers for fast cutting performance*
3	*Suitable for harder materials such as stainless steel when used at reduced RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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TurboTips - Data Sheet

	Impact Torque			Impact Torque			Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Brass	Cast Iron (Grey)	Plastics	Aluminium
	6mm Thick Steel	12mm Thick Steel	25mm Thick Steel	1/4" Thick Steel	1/2" Thick Steel	1" Thick Steel	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	30m/Min	45m/Min
Diameter Ø	**Nm Torque**			**Ft Lb Torque**			**RPM Range**						
3/16"	120	150	220	89	111	163	2270	1135	750	2215	1290	1910	3340
#7	125	155	240	93	115	178	2250	1100	745	2100	1220	1800	3100
7/32"	135	160	260	100	119	193	2125	1095	730	1980	1125	1710	3020
6MM	140	170	280	104	126	207	2040	1070	710	1820	1045	1630	2850
1/4"	150	180	290	111	133	215	1945	1040	680	1715	940	1540	2625
7MM	160	195	300	119	144	222	1780	1020	625	1560	810	1410	2240
9/32"	175	220	320	130	163	237	1710	985	595	1410	785	1355	2110
5/16"	190	245	350	141	181	259	1695	915	570	1355	760	1290	1940
8MM	220	270	380	163	200	281	1580	840	550	1340	725	1220	1765
11/32"	260	330	470	193	244	348	1390	800	515	1435	660	1200	1660
9MM	295	360	520	219	267	385	1210	750	420	1130	600	1040	1550
3/8"	300	375	545	222	278	404	1140	665	400	1095	590	1020	1510
10MM	320	395	580	237	293	430	1030	520	385	1020	550	990	1480
11MM	325	405	595	241	300	441	980	500	345	960	490	950	1365
27/64"	330	410	610	244	304	452	925	480	330	890	465	915	1320
7/16"	340	420	625	252	311	463	895	455	320	845	430	890	1305
12MM	350	430	635	259	319	470	860	440	310	825	405	860	1280
1/2"	365	440	650	270	326	481	780	410	375	780	400	805	1210
13MM	370	445	675	274	330	500	720	390	260	730	385	745	1160
14MM	375	455	690	278	337	511	660	350	225	665	340	620	950
16MM	455	580	880	337	430	652	535	290	200	610	310	510	875
18MM	580	720	1120	430	533	830	490	245	190	580	275	440	800
20MM	685	845	1245	507	626	922	450	220	175	550	240	350	730
22MM	720	900	1360	533	667	1007	340	180	160	510	210	330	645

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	VersaDrive TurboTips can be used without piloting at all sizes

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*For optimum life and accuracy use with pistol drills and magnet drills*
3	*Suitable for use on standard construction grade steels such as Structural or Stainless Steel.*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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ImpactaTaps - Data Sheet

Impact Torque Nm

Thread Diameter	Impact Tapping Torque 6mm Steel	12mm Steel	25mm Steel	Impact Tapping Torque 1/4" Steel	1/2" Steel	1" Steel
Diameter Ø	Nm Torque			Ft Lbs Torque		
M3	105	160	N/A	80	120	N/A
M4	120	180	N/A	90	135	N/A
M5	135	200	N/A	100	150	N/A
M6	140	240	400	105	180	N/A
1/4"	145	255	410	105	180	295
5/16"	145	265	420	110	205	320
M8	150	280	430	115	210	330
3/8"	165	290	440	125	220	355
M10	170	300	480	125	220	360
M12	185	320	512	135	235	400
1/2"	190	330	525	135	235	375
M14	190	340	544	140	250	400
5/8"	195	355	555	145	365	425
M16	200	360	576	150	265	425
3/4"	245	385	615	230	295	470
M20	315	400	640	235	300	470
7/8"	N/A	515	775	N/A	370	710
M24	N/A	600	960	N/A	440	720
1"	N/A	695	1050	N/A	445	735
M27	N/A	740	1184	N/A	545	875
M30	N/A	800	1200	N/A	590	885

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165
M27	105	90	75	330	145
M30	95	80	60	310	130

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	ImpactaTaps are recommended for through hole applications only.	7	Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials.
2	Pilot drill the exact tapping size hole for best results	8	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Select the correct torque power for impact wrench/drivers using the data range above. If exact match is not available select the closest torque setting above the recommendation.	9	Flame cut/punched holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage.
4	Apply firm, steady feed pressure throughout the cut	10	Tap the hole in one pass where possible, applying adequate lubrication before you start.
5	Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage.	11	If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing.
6	When using cordless tools, torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 3.	12	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Laser cut holes & Stainless Steel require higher torque*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Combi Drill Taps - Data Sheet

Impact Torque Nm

Thread Diameter	Impact Tapping Torque 6mm Steel	12mm Steel	25mm Steel	Impact Tapping Torque 1/4" Steel	1/2" Steel	1" Steel
Diameter Ø	Nm Torque			Ft Lbs Torque		
M3	105	160	N/A	75	120	N/A
M4	120	180	N/A	90	130	N/A
M5	135	200	N/A	95	145	N/A
M6	140	240	N/A	100	180	N/A
1/4"	145	255	N/A	105	175	295
5/16"	145	265	N/A	105	205	330
M8	150	280	N/A	110	205	N/A
3/8"	160	290	N/A	115	220	355
M10	170	300	N/A	125	220	N/A
M12	185	320	512	135	235	380
1/2"	190	330	520	140	235	375
M14	195	340	544	140	300	405
5/8"	195	355	555	145	365	425
M16	200	360	576	150	265	425
3/4"	245	380	610	185	295	470
M20	315	400	640	230	295	475
7/8"	N/A	515	715	N/A	370	710
M24	N/A	600	960	N/A	420	720
1"	N/A	675	1050	N/A	445	735

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	Impact DrillTaps are recommended for through hole applications only.	7	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Pilot drill the exact tapping size hole for best results	8	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Select correct NM torque power for impact wrench applications	9	Flame cut/punched holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage.
4	Apply firm, steady feed pressure throughout the cut	10	Tap the hole in one pass where possible, applying adequate lubrication before you start.
5	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.	11	301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench
6	When tapping material thicker than 15-20mm, to speed up the process it is advisable to pilot drill the hole first, before drill-tapping the hole	12	301130- Heavy Duty Drill Taps are designed for use with Magnet Drills/Pillar Drills, or for tapping pre-drilled holes with an impact wrench. They are not designed for drill-tapping with hand-held rotary tools

Quick Guide - Drill Taps (301125)

Heavy Duty Drill Taps (301130)

1	*For fastest performance use on impact wrenches/drivers*	*Ideal for use in drill presses and magnet drills*
2	*Check the minimum torque requirement*	*For impact wrench use, pilot drilling is recommended*
3	*Up to M10 (3/8") can also be used on cordless drills*	*Correct RPM is critical for good performance on larger sizes*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*	

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Impact Reamers - Data Sheet

Impact Torque Nm

Reamer Diameter	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel	Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel
Diameter Ø	Nm Torque		Ft Lb Torque	
8MM	200	380	160	290
10MM	220	400	175	300
12MM	280	420	185	305
1/2"	300	445	205	310
14MM	320	480	220	330
9/16"	330	490	235	355
5/8"	335	505	250	375
16MM	340	510	260	390
11/16"	350	525	265	400
18MM	360	540	270	410
3/4"	370	550	280	420
20MM	380	570	285	425
21MM	390	580	290	430
22MM	400	600	300	435
7/8"	425	630	310	440
15/16"	460	695	380	575
24MM	520	780	385	600
1"	530	805	390	620
26MM	545	840	405	640
1-1/16"	575	875	440	660
28MM	600	900	480	750
30MM	650	975	520	785
32MM	680	1020	545	820
33MM	695	1035	560	840
36MM	740	1090	600	870
39MM	900	1150	720	920

Revolutions per minute (Rotary)

Reamer Diameter	Structural Steel <500Nm 32m/Min	Structural Steel <1000Nm 18m/Min	Stainless Steel INOX 12m/Min	Brass 32m/Min	Cast Iron (Grey) 16m/Min	Aluminium 45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2"	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16"	690	360	305	450	450	1025
5/8"	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16"	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4"	490	230	195	250	280	745
20MM	490	230	195	510	250	745
21MM	480	225	190	500	240	710
22MM	460	210	180	470	235	690
7/8"	460	210	180	235	235	675
15/16"	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1"	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16"	295	130	125	190	385	380
28MM	295	130	125	340	190	360
30MM	275	120	110	290	180	330
32MM	250	110	100	275	170	305
33MM	240	105	95	270	165	295
36MM	215	95	80	255	150	255
39MM	195	80	65	240	135	220

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

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

1	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.	5	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
2	To maximise tool life do not attempt to increase the existing hole diameter beyond 2-3mm. If a larger, finished hole size is required, then the next size reamer should be used to 'step up' until the finished hole diameter is reached.	6	Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive reamer.
3	Avoid lateral movement or tilting which can cause damage to the tool	7	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	8	Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Reamer should be rotating before starting the cut*
4	*Use steady feed pressure throughout the cut*

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DrillSink - Data Sheet

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 92 for Pilot Hole Drilling Speeds

Best Practice Advice

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

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

Quick Guide

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

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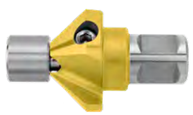
Countersink - Data Sheet


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
6.3 mm (1/4")	765	505	265	1250	500	850
10.4 mm	460	300	145	765	315	530
12.4 mm (1/2")	385	255	110	635	265	480
16.5 mm	295	185	80	485	210	345
20.5 mm (13/16")	230	155	50	385	165	280
25 mm (1")	185	130	50	315	130	225
30 mm	155	105	35	265	105	185
40 mm	120	80	30	205	80	140
55 mm	95	60	25	145	70	120
63 mm	80	55	20	130	55	90
80 mm	65	40	20	100	45	75

Best Practice Advice

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

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

Quick Guide

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

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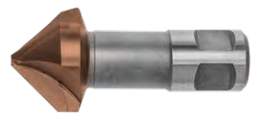
ULTRA Coated Cutters & Countersinks



	Hardox 400 / 500
Diameter Ø	RPM Range
16 - 18mm	200 - 140 (No Load)
20 - 26mm	140 - 85 (No Load)

	Hardox 400 / 500
Diameter Ø	RPM Range
32mm	60 - 40 (No Load)
40mm	60 - 30 (No Load)
55mm	60 - 25 (No Load)

Machining of Wear Plates such as HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

The extreme hardness and resistance of wear plate makes machining it extremely challenging. Good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, like the VersaDrive Series, and ample lubrication - BioCut Blue cutting fluid when broaching or Speedlube Aerosol spray when countersinking.

Using an incorrect or poorly maintained Magnet drill with unstable drilling operation, poor magnet hold, excessive pressure or inadequate lubrication is likely to result in rapid tool failure.

Even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It not only requires the correct setup but also experienced operators with the time necessary to proceed with caution.

Broaching Best Practice Advice

1	Cautious & Gentle feed pressure should be used at all times, especially during the start of the cut and exiting the material
2	Generous application of BioCut Blue cutting fluid should be used during the cut & applied frequently during the cut with through cutter coolant supply if possible
3	Backing off the cutter & applying more BioCut Blue is necessary for increasing tool life
4	Swarf removal from the cutter can assist with longer tool life
5	**V100T V125T** For best results, use a powerful magnet drill with high torque and low gear speed such as the V100T and V125T machines

Countersinking Best Practice Advice

1	For best results the Countersink should be piloted where possible
2	Do not allow the countersink to vibrate over swarf while cutting as this will cause chatter, ultimately causing the cutting edges to chip & blunt
3	Regular Speedlube application & regular swarf removal on countersinking is essential
4	A hand brush works better than mag stick to clean cutter and material surface
5	**V100T V125T** For best results, use a powerful magnet drill with high torque and low gear speed such as the V100T and V125T machines

N.B.

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

When using a geared drilling machine, use low gears to provide maximum torque
When using a Mag Drill with Electronic Torque Control, i.e.. V85T – V125T, speed should be lowered

For general broaching best practice advice, see further points on page 88
For general countersinking best practice advice, please see further points on the opposite page

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