

PRODUCT INSTRUCTIONS (page 1 of 2)

IMPORTANT :

Always wear safety goggles when drilling.
Using the correct cutting speed will ensure a longer life for your holesaw.

ESSENTIAL LUBRICANTS :

When cutting mild steel† (incl. aluminium, copper, brass, zinc, plastics, wood) no lubricant is necessary.
When cutting cast iron use paraffin. When cutting stainless steel use Cutting Compound‡.

HELPFUL HINTS :

When cutting thick materials frequently withdraw hole saw from work to ensure swarf clearance
To retain slug (e.g. holes in enclosed tanks), pull off stainless steel ejector spring
No need to use centre punch (twist drills are HSS split point for easy starting) – exert pressure behind tool when starting.

RECOMMENDED CUTTING SPEEDS :

When using a two speed drill, use the lower speed

Fitted shanks for ½" drill chucks One Piece Type 6 tpi					†mild steel	cast iron	stainless steel
Code	mm	Use			rpm	rpm	rpm
1832H	16	16mm Conduit			450	290	220
1833K	19	-			450	290	220
1834N	20	20mm Conduit			390	260	195
1848E	22	½" BSP			390	260	195

Fitted shanks for ½" drill chucks One Piece Type		Mandrel required American Type							mild steel†	cast iron	stainless steel
6tpi	10tpi	6tpi	10tpi						rpm	rpm	rpm
		AT020		20	20mm Conduit				390	260	195
		AT022		22	½" BSP				390	260	195
1835Q		AT025		25	25mm Conduit				300	200	150
1849H		AT028		28	¾" BSP				300	200	150
1837W		AT032		32	32mm Conduit				245	165	125
1850L		AT035		35	1" BSP				245	165	125
1838Z	1879W	AT038	1888Y	38	38mm Conduit				230	150	105
1839C		AT040		40	-				230	150	105
1840G		AT042		42	-				190	130	95
1851O		AT045		45	1¼" BSP				190	130	95
1841J	1880A	AT048	1889B	48	-				160	105	90
1852R	1881D	AT050	1890F	50	1½" BSP				160	105	90
1843P		AT054		54	-				160	105	90
1844S	1882G	AT057	1891I	57	-				140	95	70
1845V	1883J	AT060	1892L	60	-				140	95	70
1853U	1884M	AT064	1896X	64	2" BSP				130	85	65
1855A		AT066		66	2¼" BSP				130	85	65
1857G	1885P	AT070	1893O	70	2¾" BSP Soffit Board Ventilator				115	75	55
1859M	1886S	AT073	1894R	73					115	75	55
1854X	1887V	AT076	1895U	76	2½" BSP				95	65	45
1858J		AT082		82					95	65	45
1861T		AT088		88					80	55	40
1860Q		AT101		101					80	55	40
		ATM01		20 to 101mm	Mandrel 5/8"				UNF Thread (no retaining pins)		
		ATM02		32 to 101mm	Mandrel 5/8"				UNF Thread with spring loaded retaining pins		

‡ CUTTING COMPOUND :

Product Code: 1856D

Product Description : 5g Tube of Holesaw Cutting Compound



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Fitted shanks for ½" drill chucks
One Piece Type 6 tpi

Code	mm	Uses
1832H	16 16mm Conduit	
1833K	19 -	
1834N	20 20mm Conduit	
1848E	22 ½" BSP	

Fitted shanks for ½" drill chucks		Mandrel required	
One Piece Type		American Type	
6tpi	10tpi	6tpi	10tpi

				mm	Uses
		AT020		25	25mm Conduit
		AT022		28	¾" BSP
1835Q		AT025		25	25mm Conduit
1849H		AT028		28	¾" BSP
1837W		AT032		32	32mm Conduit, Polypipe Boss Drilling
1850L		AT035		35	1" BSP
1838Z	1879W	AT038	1888Y	38	38mm Conduit; Bartol S105 Clip Boss; Bartol Polypropylene Domestic Gully Horizontal Inlet
1839C		AT040		40	Polypipe Boss Drilling
1840G		AT042		42	-
1851O		AT045		45	1¼" BSP, Bartol S106 Clip Boss, Bartol Polypropylene Domestic Gully Horizontal Inlet
1841J	1880A	AT048	1889B	48	Terrain 112/125, 113, 114 Bosses; Terrain 135.3 Access Door
1852R	1881D	AT050	1890F	50	1½" BSP, Terrain 116, 117, 130 Waste to Soil Connectors. Polypipe Boss Drilling
1843P		AT054		54	Terrain 114 Boss; Hunter S610, S343, S437, S360 Strap on Bosses
1844S	1882G	AT057	1891I	57	Terrain 112/15, 113 Boss; Osma 3S/4S 319 Strap Boss; Bartol Patch Bosses S95/3, S96/3, S97/3
1845V	1883J	AT060	1892L	60	Terrain 112 Boss; Bartol Trapped Floor Gully Inlets; Bartol S101, S102, S103 Boss Adaptors; Hepworth Plastics Deep Seal Floor Gully Inlets
1853U	1884M	AT064	1896X	64	2" BSP; Terrain 112 Boss, 115 Boss
1855A		AT066		66	2¼" BSP; Immersion Heater Size; Terrain 114 Boss; Barton S95 Patch Boss
1857G	1885P	AT070	1893O	70	2¾" BSP Soffit Board Ventilator; Terrain 112/2, 113 Boss
1859M	1886S	AT073	1894R	73	Terrain 135.4, 135.6 Access Doors
1854X	1887V	AT076	1895U	76	2½" BSP; Terrain 122 Boss
1858J		AT082		82	
1861T		AT088		88	
1860Q		AT101		101	

