

Recommended Operating Speeds

Blu-Mol® and Power-Hex® Bi-Metal Hole Saws

Speeds in RPM

Dia. inches	Dia. mm	Mild Steel	Tool Stainless	Cast Iron	Brass	Aluminium
9/16	14	580	300	400	790	900
5/8	16	550	275	365	730	825
11/16	17	500	250	330	665	750
3/4	19	460	230	300	600	690
-	20	440	220	290	580	660
13/16	21	425	210	280	560	635
7/8	22	390	195	260	520	585
15/16	24	370	185	245	495	555
1	25	350	175	235	470	525
1-1/16	27	325	160	215	435	480
1-1/8	29	300	150	200	400	450
1-3/16	30	285	145	190	380	425
1-1/4	32	275	140	180	360	410
1-5/16	33	260	135	175	345	390
1-3/8	35	250	125	165	330	375
1-7/16	37	240	120	160	315	360
1-1/2	38	230	115	150	300	345
1-9/16	40	220	110	145	290	330
1-5/8	41	210	105	140	280	315
1-11/16	43	205	100	135	270	305
1-3/4	44	195	95	130	260	295
1-3/16	46	190	95	125	250	285
1-7/8	48	180	90	120	240	270
2	51	170	85	115	230	255
2-1/16	52	165	80	110	220	245
2-1/8	54	160	80	105	210	240
2-1/4	57	150	75	100	200	225
2-5/16	59	145	75	95	195	225
2-3/8	60	140	70	90	190	220
2-1/2	64	135	65	85	180	205
2-9/16	65	130	65	85	175	200
2-5/8	67	130	65	85	170	195
-	68	130	65	80	175	190
2-3/4	70	125	60	80	160	185
2-7/8	73	120	60	75	160	180
3	76	115	55	70	150	170
3-1/8	79	110	55	70	140	165
3-1/4	83	105	50	65	140	155
3-3/8	86	100	50	65	130	150
3-1/2	89	95	45	60	130	145
3-5/8	92	90	45	60	120	140
3-3/4	95	90	45	60	120	135
3-7/8	98	90	45	60	120	135
4	102	85	40	55	110	130
4-1/8	104	80	40	55	110	120
4-1/4	108	80	40	55	110	120
4-3/8	111	80	40	50	100	120
4-1/2	114	75	35	50	100	105
4-3/4	121	75	35	50	92	95
5	127	65	30	45	90	90
5-1/2	140	60	25	40	85	85
5-3/4	146	55	25	35	75	75
6	152	55	25	35	75	75

RemGrit® Carbide Grit Hole Saws

Speeds in RPM

Dia. inches	Dia. mm	Brick Ceramic	Slate	Reinforced Plastics	Fibre
-	16	620	1540	2140	920
3/4	19	510	1280	1790	770
-	20	470	1180	1660	715
7/8	22	430	1090	1530	660
1	25	380	960	1340	580
1-1/8	29	340	850	1190	510
1-1/4	32	310	770	1070	460
1-3/8	35	280	700	980	420
1-1/2	38	260	640	890	390
1-3/4	44	220	550	770	330
1-7/8	48	200	510	720	310
2	51	190	480	670	290
2-1/8	54	180	450	630	280
2-1/4	57	170	430	600	270
2-3/8	60	160	400	570	250
2-1/2	64	150	380	540	230
2-3/4	70	140	350	500	210
3	76	130	320	450	190
3-1/4	83	120	295	415	180
3-3/8	86	115	285	400	175
3-3/4	95	102	255	350	160
4	102	95	240	330	150
4-1/2	114	82	215	290	125

Hints and Tips for Best Hole Saw Use

- The pilot drill must extend beyond the edge of the hole saw teeth by 1/8" (3mm).
- Always secure the material to be cut to ensure the turning action of the hole saw does not cause the workpiece to spin or slip.
- Start the hole saw square to the workpiece with steady feed pressure. Unbalanced tooth engagement will result in erratic hole saw action and tooth strippage.
- Follow the recommended standard hole saw operating speeds shown on this page.
- When working at the upper ranges of the hole saws' capacity, they should be worked in and out to help clear chips.
- Use a cutting oil whenever possible, except with cast iron or wood, to help clear chips and lubricate the blade for longer life.
- Occasionally check the mandrel's drive pins to prevent them from vibrating out of the hole saw's drive pin holes.
- Always wear eye protection.