



## Impact Torque

## Revolutions per minute- RPM (Rotary)

Step Drill Diameter	Impact Torque		RPM Range						
	Nm Torque	Ft Lbs Torque	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics	
<b>Metric</b>	3-12 mm	280	185	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
	14-22 mm	400	270	597-430	390-270	200-145	600-440	245-180	380-275
	24-30 mm	485	350	420-330	260-215	140-110	420-330	175-135	275-180
	32-40 mm	750	590	260-230	160-145	85-75	260-230	95-85	150-140
<b>Inch</b>	3/16-1/2"	280	185	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
	3/16-7/8"	400	270	597-430	390-270	200-145	600-440	245-180	380-275
	1/4-1-3/8"	540	405	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
2. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
3. Avoid lateral movement or tilting which can cause damage to the tool
4. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
5. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
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

- For fastest performance use on Impact Wrenches & Impact Drivers
- Excellent life and performance when used with Rotary Pistol Drills or Pillar Drills
- Suitable for stainless and harder materials if used at low RPM
- Use appropriate lubrication and correct RPM to achieve long tool life

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