Impact Reamers - Data Sheet

VERSADRIVE® PATENT PROTECTED

Impact Torque

Revolutions per minute (Rotary)

	Diameter	<12mm Thick Steel	<25mm Thick Steel	<1/2" Thick Steel	<1" Thick Steel	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
						32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	45m/Min
		Nm Torque		Ft Lb Torque		RPM Range					
Metric	8MM	200	380	160	290	940	540	410	1020	550	1365
	10MM	220	400	175	300	900	510	380	1005	530	1290
	12MM	280	420	185	305	875	490	370	995	520	1200
	14MM	320	480	220	330	690	360	305	700	500	1100
	16MM	340	510	260	390	640	335	225	660	340	920
	18MM	360	540	270	410	535	290	210	550	305	800
	20MM	380	570	285	425	490	230	195	510	250	745
	21MM	390	580	290	430	480	225	190	500	240	710
	22MM	400	600	300	435	460	210	180	470	235	690
	24MM	520	780	385	600	360	150	140	430	215	490
	26MM	650	1000	405	640	310	140	135	375	200	400
	28MM	720	1080	480	750	295	130	125	340	190	360
	30MM	780	1365	520	785	275	120	110	290	180	330
	32MM	940	1410	545	820	250	110	100	275	170	305
	33MM	970	1440	560	840	240	105	95	270	165	295
	36MM	1030	1520	600	870	215	95	80	255	150	255
	39MM	1260	1610	720	920	195	80	65	240	135	220
	41MM	1340	1736	750	965	185	75	60	220	125	200
Inch	1/2”	300	445	205	310	875	490	370	520	510	1185
	9/16”	330	490	235	355	690	360	305	450	450	1025
	5/8”	335	505	250	375	640	335	225	340	340	975
	11/16”	350	525	265	400	535	290	210	305	305	860
	3/4”	370	550	280	420	490	230	195	250	280	745
	7/8”	425	630	310	440	460	210	180	235	235	675
	15/16”	460	695	380	575	360	150	140	215	215	540
	1”	530	805	390	620	310	140	135	200	200	410
	1-1/16”	575	875	440	660	295	130	125	190	385	380

BEST PRACTICE ADVICE

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

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

QUICK GUIDE

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Check the minimum torque requirement*
- *Reamer should be rotating before starting the cut*
- *Use steady feed pressure throughout the cut*

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