



Impact Torque

Revolutions per minute- RPM (Rotary)

Diameter	Impact Torque			Impact Torque			Structural Steel <500 Mpa	Structural Steel <1000 Mpa	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
	Nm Torque			Ft Lb Torque			RPM Range						
Metric													
6MM	140	170	280	104	126	207	2040	1070	710	1820	1045	1630	2850
7MM	160	195	300	119	144	222	1780	1020	625	1560	810	1410	2240
8MM	220	270	380	163	200	281	1580	840	550	1340	725	1220	1765
9MM	295	360	520	219	267	385	1210	750	420	1130	600	1040	1550
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
12MM	350	430	635	259	319	470	860	440	310	825	405	860	1280
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
Inch													
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
1/4"	150	180	290	111	133	215	1945	1040	680	1715	940	1540	2625
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
11/32"	260	330	470	193	244	348	1390	800	515	1435	660	1200	1660
3/8"	300	375	545	222	278	404	1140	665	400	1095	590	1020	1510
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
1/2"	365	440	650	270	326	481	780	410	375	780	400	805	1210

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. VersaDrive TurboTips can be used without piloting at all sizes

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 standard construction grade steels such as Structural or Stainless Steel
- Use appropriate lubrication and correct RPM to achieve long tool life

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