DrillSink - Data Sheet

VERSADRIVE® PATENT PROTECTED

Countersink Diameter	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
	RPM Range					
12.4mm	385	255	110	635	265	480
16.5mm	295	185	80	485	210	345
20.5mm	230	155	50	385	165	280
25mm	185	130	50	315	130	225
31mm	155	105	35	265	105	185

Refer to Page 114 for Pilot Hole Drilling Speeds

BEST PRACTICE ADVICE

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

1. *Use with a variable speed motor. Drill and countersink operations should be run at the appropriate speed for each process*
2. *Apply firm, steady feed pressure throughout the 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. *Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling*
7. *Use at highest available Gear setting (for maximum torque).*
8. *Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set*
9. *Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling*
10. *Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage*

QUICK GUIDE

- *Optimum life and performance when used with Rotary Pistol Drills or Pillar Drills*
- *Up to 16.5mm can be used on Impact Wrench & Impact Drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO

VersaDrive® Countersinks - Data Sheet

VERSADRIVE® PATENT PROTECTED

	Countersink Diameter	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
		RPM Range					
Metric	6.3mm	765	505	265	1250	500	850
	8.3mm	535	355	195	865	340	585
	10.4mm	460	300	145	765	315	530
	12.4mm	385	255	110	635	265	480
	16.5mm	295	185	80	485	210	345
	20.5mm	230	155	50	385	165	280
	25mm	185	130	50	315	130	225
	31mm	155	105	35	265	105	185
Inch	1/4"	765	505	265	1250	500	850
	3/8"	460	300	145	765	315	530
	1/2"	385	255	110	635	265	480
	5/8"	295	185	80	485	210	345
	3/4"	230	155	50	385	165	280
	1"	185	130	50	315	130	225

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*
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. *Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling*
7. *Use at highest available Gear setting (for maximum torque)*
8. *Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set*

QUICK GUIDE

- *Optimum life and performance when used with Magnet Drills or Pillar Drills*
- *Up to 16.5mm can be used on Impact Wrench & Impact Drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO