



Impact Torque Nm

Revolutions per minute (Rotary)

Impact Torque		
Reamer Diameter	Impact Torque	
	<12mm Thick Steel	<25mm Thick Steel
Diameter Ø	Nm Torque	
8MM	200	380
10MM	220	400
12MM	280	420
1/2"	300	445
14MM	320	480
9/16"	330	490
5/8"	335	505
16MM	340	510
11/16"	350	525
18MM	360	540
3/4"	370	550
20MM	380	570
22MM	400	600
7/8"	425	630
15/16"	460	695
24MM	520	780
1"	530	805
26MM	545	840
1-1/16"	575	875

Impact Torque	
<1/2" Thick Steel	<1" Thick Steel
160	290
175	300
185	305
205	310
220	330
235	355
250	375
260	390
265	400
270	410
280	420
285	425
300	435
310	440
380	575
385	600
390	620
405	640
440	660

Reamer Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2"	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16"	690	360	305	450	450	1025
5/8"	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16"	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4"	490	230	195	250	280	745
20MM	490	230	195	510	250	745
22MM	460	210	180	470	235	690
7/8"	460	210	180	235	235	675
15/16"	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1"	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16"	295	130	125	190	385	380

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	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	When drilling into box section ensure the tip of the tool 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.
7	Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive Reamer.		

Quick Guide

1	For fastest performance use on impact wrenches & impact drivers
2	Excellent life and performance when used with rotary pistol drills or drill presses
3	Suitable for stainless and harder materials if used at low RPM
4	Use appropriate lubrication and correct RPM to achieve long tool life