


















IMPACT REAMER RPM & FEED DATA

RECOMMENDATIONS FOR HMT IMPACTACUT, IMPACTAMAG & VERSADRIVE REAMERS



									
Reamer Diameter	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min	Impact Torque <12MM Thick Steel	Impact Torque <25MM Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Nm Torque	Nm Torque
12MM	875	490	370	995	520	980	1275	280	420
14MM	690	360	305	700	450	695	1025	320	480
16MM	640	335	225	660	340	600	975	340	510
18MM	535	290	210	550	305	545	860	360	540
20MM	490	230	195	510	250	470	745	380	570
22MM	460	210	180	470	235	445	675	400	600
24MM	360	150	140	430	215	395	540	520	780
26MM	310	140	135	375	200	330	410	520	840
28MM	295	130	125	340	190	285	385	600	900
30MM	275	120	110	290	180	260	340	650	975
32MM	250	110	100	275	170	220	315	680	1020

BEST PRACTICE ADVICE

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

* GUIDELINE PARAMETERS ONLY. ACTUAL PARAMETERS MAY VARY DEPENDING ON OPERATING CONDITIONS