



Operating Speeds for Bi-Metal Hole Saws

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Size mm	Size Inch	Mild Steel RPM	Tool Steel & Stainless RPM	Cast Iron RPM	Copper Brass Bronze RPM	Alum. RPM	Wood RPM
14	9/16	580	300	400	790	900	800
16	5/8	550	275	365	730	825	760
17	11/16	500	250	330	665	750	720
19	3/4	460	230	300	600	690	680
20	25/32	445	220	290	580	660	640
21	13/16	425	210	280	560	530	600
22	7/8	390	195	260	520	585	560
24	15/16	370	185	245	494	555	520
25	1	350	175	235	470	525	500
27	1.1/16	325	160	215	435	480	500
29	1.1/8	300	150	200	400	450	450
30	1.3/16	285	145	190	380	425	430
32	1.1/4	275	140	180	360	410	410
33	1.5/16	260	135	175	345	390	390
35	1.3/8	250	125	165	330	375	370
37	1.7/16	240	120	160	315	360	350
38	1.1/2	230	115	150	300	345	330
40	1.9/16	220	110	145	290	330	310
41	1.5/8	210	105	140	280	315	290
43	1.11/16	205	110	135	270	305	270
44	1.3/4	195	95	130	260	295	250
46	1.13/16	190	95	125	250	285	230
48	1.7/8	180	90	120	240	270	210
51	2	170	85	115	230	255	200
52	2.1/16	165	80	110	220	245	200
54	2.1/8	160	80	105	210	240	190
56	2.3/16	155	75	100	205	230	190
57	2.1/4	150	75	100	200	225	185
59	2.5/16	145	75	100	195	225	185

Size mm	Size Inch	Mild Steel RPM	Tool Steel & Stainless RPM	Cast Iron RPM	Copper Brass Bronze RPM	Alum. RPM	Wood RPM
60	2.3/8	140	70	95	190	220	180
64	2.1/2	135	65	90	180	205	180
65	2.9/16	130	65	85	175	200	175
67	2.5/8	130	65	85	170	195	170
68	2.11/16	130	65	85	165	190	165
70	2.3/4	125	60	80	160	185	160
73	2.7/8	120	60	80	160	180	155
76	3	115	55	75	150	170	150
79	3.1/8	110	55	70	140	165	150
83	3.1/4	105	50	70	140	155	140
86	3.3/8	100	50	65	130	150	135
89	3.1/2	95	45	65	130	145	130
92	3.5/8	95	45	60	120	140	125
95	3.3/4	90	45	60	120	135	120
98	3.7/8	90	45	60	120	135	115
102	4	85	40	55	110	130	100
105	4.1/8	80	40	55	110	120	100
108	4.1/4	80	40	55	110	120	95
111	4.3/8	80	40	50	100	120	90
114	4.1/2	75	35	50	100	105	90
121	4.3/4	70	35	45	90	95	85
127	5	65	30	40	85	90	85
133	5.1/4	65	30	40	85	90	80
140	5.1/2	60	30	35	80	85	80
152	6	55	25	35	75	85	75
160	6.5/16	55	25	35	75	80	70
168	6.5/8	50	25	35	70	75	65
177	6.31/32	45	20	30	65	70	60
210	8.9/32	40	20	25	60	65	55