HOLEMAKER TECHNOLOGY

HMT

Cutting Tool Innovation

Speed up Metalworking

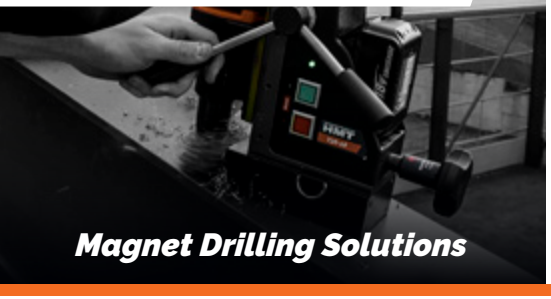
VERSADRIVE®

PATENT PROTECTED

- Plug & Play Modular Tooling System
- Impact Rated - Work 15x Faster
- Anti-Kickback for Safer Drilling

- NEW 18v Cordless Tools
- Over 200 NEW Products for 2025
- Portable drilling solutions to speed up Installation & Maintenance

STEELBOR™



Magnet Drilling Solutions

STAKIT®

Protect, organise, transport

ABOUT US

HOLEMAKER TECHNOLOGY HMT

Redefining the industry

At HMT, we don't follow trends—we set them. We were the first to recognise the unmet needs of metalworkers, realising that it wasn't just about better tools; it was about faster, safer setups and greater flexibility in the toughest environments.

Every product we create is built around real-world feedback. We listen to professionals like you, and we use your insights to drive our R&D and fuel our innovation. This constant evolution ensures our tools stay ahead of the curve.

In just 10 years, we've redefined metalworking with our patented ***VERSADRIVE***® system – the world's first modular tooling solution that's 15x faster than traditional methods. Plug-and-play with any power tool, including cordless, ***VERSADRIVE***® isn't just a tool; it's your unfair advantage on-site.

Pair ***VERSADRIVE***® with our ***STEELBOR***® mag drills, broach cutters and countersinks and our ***STAKIT***® modular storage system, and you've got the ultimate kit to take on any challenge. Together, it's a complete system for professionals who demand performance without compromise.

If you're ready to raise the standard HMT is here to lead the way

WHAT MAKES US DIFFERENT?

HOLEMAKER TECHNOLOGY HMT

Portable tooling for faster, safer metalworking

VERSADRIVE®
PATENT PROTECTED

WORK 15X FASTER

This patented system is the world's 1st modular cutting system that works seamlessly with both impact & rotary tools, making it the perfect solution for metalworking professionals who need speed, versatility, and precision.

- Quick-change, rapid-lock adapters for fast tool change
- Plug-and-play compatibility with all power tools
- 10x longer life than conventional tools

From page 18

STEELBOR™

BROACH, DRILL & COUNTERSINK

Our high-performance magnetic drills, broach cutters, and countersinks are built to deliver maximum power, accuracy, and reliability.

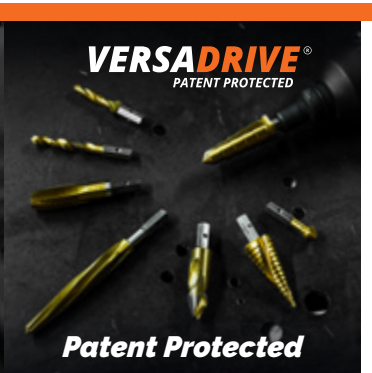
From page 60

STAKIT®

PROTECT, ORGANISE, TRANSPORT

STAKIT® ensures your tools are always organised and ready to go. The modular storage system keeps everything secure and easily accessible, so you're always prepared to get to work—wherever the job takes you.

From page 102



WHO NEEDS VERSADRIVE


Structural Fabrication


Bridge Restoration


Defence Projects


Quarry Operations


Rail Maintenance


Agricultural Engineering


M.E.P Trades


Equipment Maintenance


OffShore Energy

Trusted by global industry leaders

babcock™ Vestas SIEMENS

SPACEX EDF BAE SYSTEMS

SEE IT, BELIEVE IT

WANT TO SEE OUR TOOLS IN ACTION?

HMT offers onsite demos & training sessions through our network of dealers.

Learn directly from the experts and get hands-on experience with our products to see how they can work for you.

FIND AN EVENT NEAR YOU

WORK WITH US

HOLEMAKER TECHNOLOGY HMT

Your success, our priority

TECHNICAL SUPPORT

Selecting the right tool is just the beginning.

That's why we offer comprehensive, expert technical support when you need guidance on tool set up, maintenance or troubleshooting.

Our online technical library is also packed with data sheets, user guides, manuals, and best practice advice that you can access whenever you need it, 24/7.

Online Technical Guidance:

Call:

03330 110 382

NO QUIBBLE WARRANTY

The quality and innovative design of every HMT product ensures you're investing in reliable tools. That's why we offer a no-quibble warranty on consumables*. If something goes wrong, we make it right - quickly and easily with a 3 step process

1. TELL US ABOUT THE ISSUE

Complete a quick form online – it only takes a minute!

2. WE'LL ADVISE AND REPLACE

We'll review your claim, provide advice to improve results, and send a replacement tool directly to you*.

3. GET BACK TO WORK

Your new tool arrives fast, with guidance to keep you moving forward.

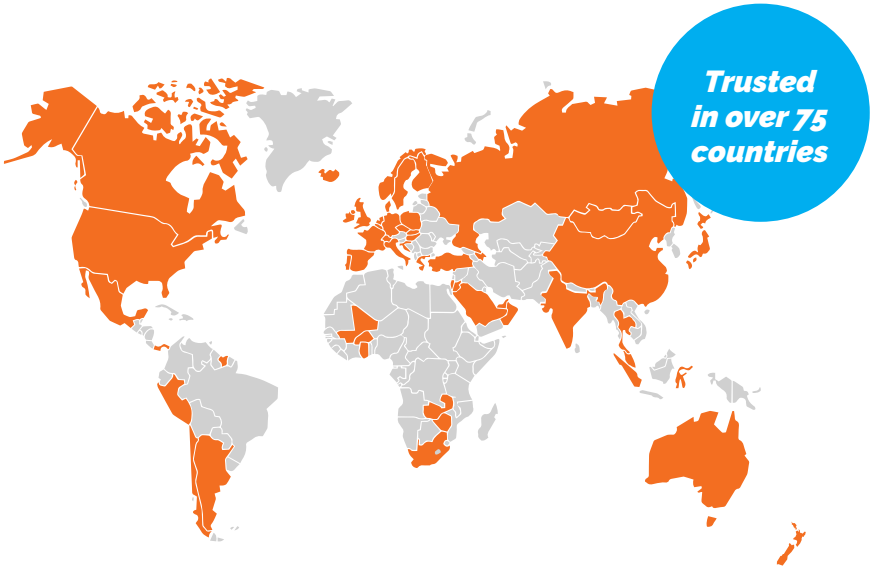
*Please refer to website for Terms and conditions and details of powertool warranty

WHERE TO BUY

HOLEMAKER TECHNOLOGY HMT

Trusted worldwide, available locally

At HMT, our tools are trusted by metalworkers across the globe. With a worldwide network of distributors & resellers, we ensure that you have access to the tooling you need, when you need it.



Find your local dealer online:

UK

USA

VERSADRIVE®

PATENT PROTECTED

The Fastest Way to Get the Job Done

VERSADRIVE® by Holemaker Technology is the world's 1st modular tooling system that works seamlessly with both impact & rotary tools.

Whether you're drilling, tapping, reaming or countersinking, ***VERSADRIVE®*** delivers unmatched speed and versatility. Its plug-and-play design works seamlessly with all power tools, including cordless giving you the flexibility to perform more tasks with fewer tools.

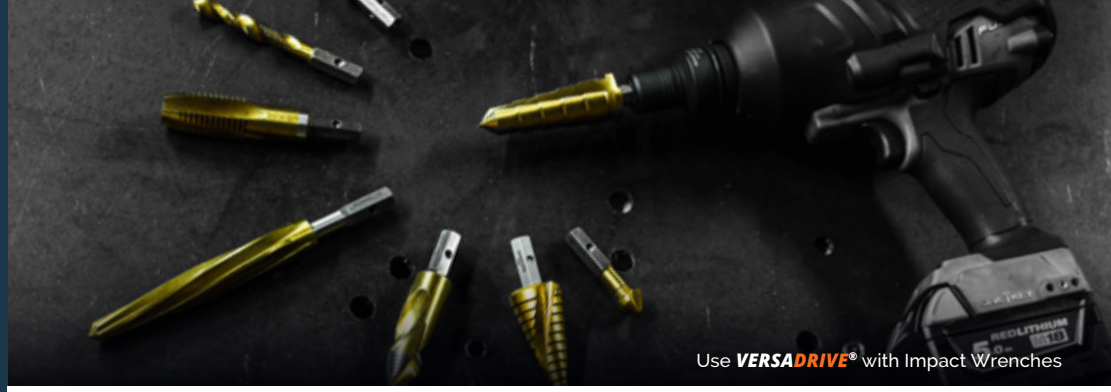
WHY CHOOSE VERSADRIVE®

- ***Save Time:*** 15x Faster than traditional tools
- ***Work Safer:*** Anti-kickback technology enhances workplace safety
- ***Plug-&-Play:*** Flexible, modular system works with any power tool
- ***Boost Productivity:*** Quick-change, rapid-lock adapters reduce downtime

KEY FEATURES

- The only Impact-Wrench rated, double-hardened cutting tools
- Modular system offering a choice of drive methods and adapters
- Robust 11mm hex shank on all tools for durable, non-slip operation
- Compatible with all standard drill chucks for pistols and pillar drills
- Made from high-grade tool steel with an optimised design for durability

With faster cutting, longer life and more holes per product VERSADRIVE® tools save time, money & increase productivity.

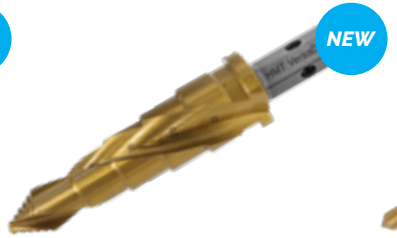


Use ***VERSADRIVE®*** with Impact Wrenches

Use ***VERSADRIVE®*** with handheld Rotary Drills

Use ***VERSADRIVE®*** with Magnetic Drills & Pillar Drills

VERSADRIVE® kitted sets from Page 22



FOR TECHNICAL DATA & USER ADVICE SEE P.111 ONWARDS

VersaDrive® Contents

FOR TECHNICAL DATA & USER ADVICE SEE P.111 ONWARDS

STEELBOR™

The world's most comprehensive range of magnet drilling solutions

Magnet Drills

From the most compact & lightweight cordless machines, to industrial rated workhorse units with all day drilling capacity

All machines with tapping capacity are hand built in our Sheffield factory with the legendary Eibenstock motor

Broach Cutters

- ***HSS:*** New for 2025 & offer an economical range of everyday cutters
- ***TCT:*** High spec cutters offering up to 10X longer life & 65% faster cutting
- ***ULTRA:*** High performance cutters for wear plates & armoured vehicle applications

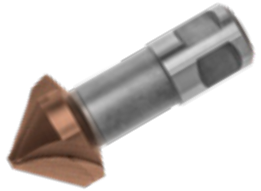
Countersinks & Multisink

A comprehensive range of countersinking solutions with Weldon shank for magnetic drill use

The unique Multisink system combines multiple tooling solutions into one operation

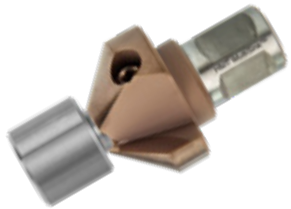
Accessories

Specialist accessories to optimise the life of HMT cutting tools and increase productivity and safety



FOR TECHNICAL DATA & USER ADVICE SEE P.111 ONWARDS

SteelBor® Contents STEELBOR



FOR TECHNICAL DATA & USER ADVICE SEE P.111 ONWARDS

STAKIT®

A modular system of robust stacking site kits to help transport, protect and organise your VERSADRIVE® tooling & power tools

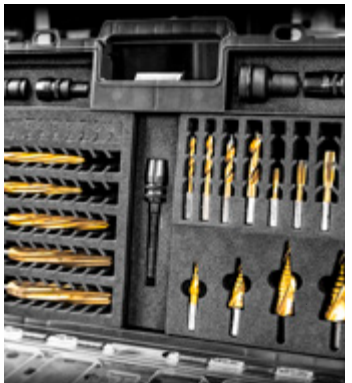
Modular, clip-together system so you can plug and play to choose the right package for your needs, or to start small and add more kits over time.

Each case can be used individually or interlocked for fast use in the field, on the jobsite or in the workshop.

Tough enough for use in the field and jobsite, being designed to be damage resistant, dustproof and weatherproof.

STAKIT® is complemented by the ***InsertFoam*** system of foam tool set cases. All HMT and ***VERSADRIVE®*** sets are supplied in InsertFoam packaging in sizes which readily fit the ***STAKIT®*** ETOP cases.

Bespoke and customised sets are readily available.



FOR TECHNICAL DATA & USER ADVICE SEE P.111 ONWARDS

VersaDrive® adapters have been custom engineered to rapidly fit VersaDrive® cutting tools to a wide range of standard site and workshop drive tools, including Impact Wrenches, Magnet Drills and cordless Combi Drills.

This unique system means that VersaDrive® tooling offers the greatest flexibility of use of any metal cutting tools as it can be used with almost any power tool using cordless, mains or air power.

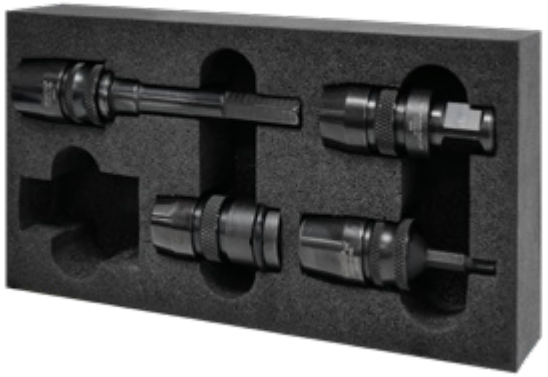
- *Rapid-Lock, single handed loading*
- *Quick Release collar for swift tool changeover*
- *Impact rated for high speed operation - up to 15x faster than traditional methods*
- *Impact rated system stops dangerous kickback when drilling with handheld drills*
- *Knurled design for easy grip in damp and greasy conditions*
- *Collar design prevents contact with work piece and accidental tool release*
- *Hardened steel components with rust resistant finish*
- *Industrial strength to easily handle the high torque of modern Impact tools*
- *Converts a wide range of powertools for use with VersaDrive®*

VersaDrive® Rapid-Lock Adapter Set

Small InsertFoam to fit ***STAKIT***® ETOP2 or ETOP4 top cases - See page 102

Contains:

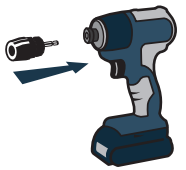
¼" VersaDrive® Impact Driver Adapter
½" VersaDrive® Impact Wrench Adapter
VersaDrive® Magnet Drill Weldon Adapter
VersaDrive® 130mm Extension Arbor



Part No	Product
111005-SET1	VersaDrive® Rapid-Lock Adapter InsertFoam Set 4pc

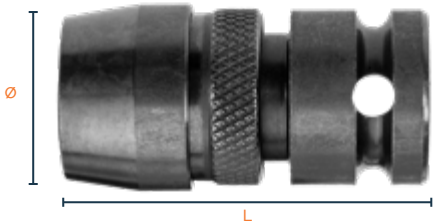
VersaDrive® Rapid-Lock ¼" Impact Driver Adapter

Converts standard ¼" Impact Drivers for use with VersaDrive®



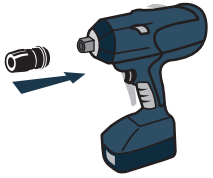
Part No	Ø (mm)	L (mm)
111027-014A	28	75

VersaDrive® Rapid-Lock ½" Impact Wrench Adapter



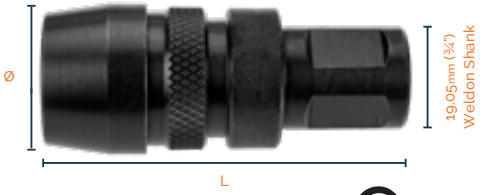
Rapid-Lock VersaDrive® adapter to convert ½" Impact Wrenches for use with VersaDrive®

Supplied with retention pin & securing ring



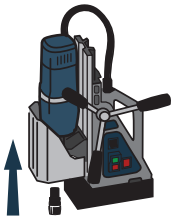
Part No	Ø (mm)	L (mm)
111130-012A	28	55

VersaDrive® Rapid-Lock Magnet Drill Adapter



Converts Magnet Drills for use with VersaDrive®

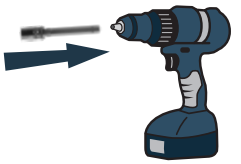
Fits all standard Magnet Drills with 19.05mm (3/4") Weldon arbor



Part No	Ø (mm)	L (mm)
111035-01	28	66

VersaDrive® Rapid-Lock Extension Arbor 130mm

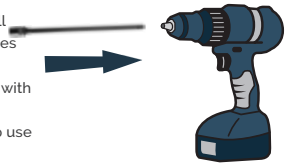
Extends working reach of all VersaDrive® tools & bypasses obstacles
Can be used in conjunction with other VersaDrive® adapters
11mm Hex shank for non-slip use in drill chucks
Rated for Impact and Rotary use



Part No	Ø (mm)	L (mm)
111016-130	28	130

VersaDrive® Rapid-Lock Extension Arbor 300mm

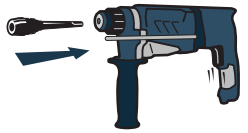
Extends working reach of all VersaDrive® tools & bypasses obstacles
Can be used in conjunction with other VersaDrive® adapters
11mm Hex shank for non-slip use in drill chucks
Rated for Impact and Rotary use



Part No	Ø (mm)	L (mm)
111016-300	28	300

VersaDrive® Rapid-Lock SDS+ Adapter

Converts standard SDS+ Drills for use with VersaDrive®
(Use in Rotary mode only)



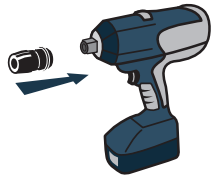
Part No	Ø (mm)	L (mm)
112010-01	28	140

VersaDrive® Heavy Duty ⅜" Impact Wrench Adapter

Heavy Duty VersaDrive® adapter to convert high-power ⅜" Impact Wrenches for use with VersaDrive®

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring



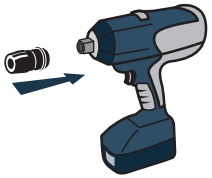
Part No	Ø (mm)	L (mm)
111120-038A	25	50

VersaDrive® Heavy-Duty ½" Impact Wrench Adapter

Heavy Duty VersaDrive® adapter to convert high-power ½" Impact Wrenches for use with VersaDrive®

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring

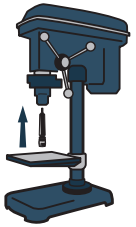


Part No	Ø (mm)	L (mm)
111120-012A	25	55

VersaDrive® Rapid-Lock Morse Taper Arbor

Ideal for workshop use with Morse Taper Pillar Drills & Magnet Drills

Available in Morse Taper 2 & 3



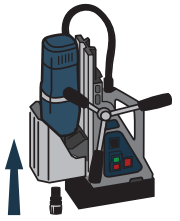
Part No	Drive	Ø (mm)	L (mm)
111045-02	MT2	28	130
111045-03	MT3	28	147

VersaDrive® Magnet Drill Adapter - 19.05mm

Converts Magnet Drills for use with VersaDrive®

Recommended for use drilling very hard materials when high precision with minimal runout is required

Fits all standard Magnet Drills with 19.05mm (3/4") Weldon arbor



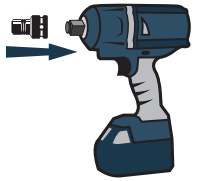
Part No	Ø (mm)	L (mm)
111030-0002	26	60.5

VersaDrive® Heavy Duty ¾" Impact Wrench Adapter

Heavy Duty VersaDrive® adapter to convert high-power ¾" Impact Wrenches for use with VersaDrive®

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring



Part No	Ø (mm)	L (mm)
111120-034A	38	60

VersaDrive® Heavy Duty Adapter Set 4pc

Small InsertFoam to fit ***STAKIT***® ETOP2 or ETOP4 top cases.

Contains:
VersaDrive® ½" Heavy Duty Impact Wrench Adapter
VersaDrive® ¾" Heavy Duty Impact Wrench Adapter
VersaDrive® Rapid-Lock Magnet Drill Adapter
VersaDrive® 130mm Extension Arbor

Part No	Size
111005-SET2	VersaDrive® HD Adapter InsertFoam Set 4pc

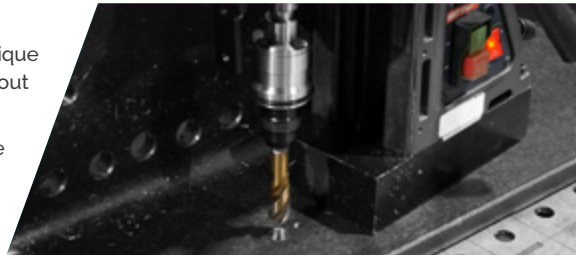
VersaDrive® Morse Taper Clutched Adapters

VERSADRIVE® PATENT PROTECTED

Tap blind holes without breaking the tap.

The VersaDrive® clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-power, reversible Morse Taper magnetic drill, insert a VersaDrive® Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.



- *Quick change system accepts all VersaDrive® Taps*
- *Adapters pre-set to appropriate clutch settings*
- *Collar design prevents accidental tool release*
- *Options for tapping blind holes from M8 - M24*
- *Optimised for use with VersaDrive® Spiral Flute Taps*
- *Collar finished in rust resistant Manganese Phosphate*

Part No	Drive size	For hole sizes (Metric Coarse)	For hole sizes (" UNC)	d1 (mm)	D (mm)	L (mm)
132002-0812	MT2	M8 - M12	5/16" - 1/2"	29	47	186
132002-1216	MT2	M12 - M16	1/2" - 5/8"	29	61	194
132002-1620	MT2	M16 - M20	5/8" - 3/4"	29	61	194
132003-2024	MT3	M20 - M24	3/4" - 1"	29	61	220
Sets						
132000-SET2	MT2 Clutched Adapter (M8 - M12) + MT2 Clutched Adapter (M12 - M16) + MT2 Clutched Adapter (M16 - M20) + M8 - M20 VersaDrive® Spiral Flute Taps					
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) + MT2 Clutched Adapter (1/2" - 5/8" UNC) + MT3 Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps					

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® Impact Wrench Clutched Adapters

VERSADRIVE® PATENT PROTECTED

Impact Tap blind holes without breaking the tap.

The VersaDrive® clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-torque Impact Wrench, insert a VersaDrive® Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.

- *Quick change system accepts all VersaDrive® Taps*
- *Adapters pre-set to appropriate clutch settings*
- *Collar design prevents accidental tool release*
- *Collar finished in rust resistant Manganese Phosphate*
- *Options for tapping blind holes from M8 - M24*
- *Optimised for use with VersaDrive® Spiral Flute Taps*
- *Supplied with retention pin & securing ring*

Part No	Drive size	For hole sizes (Metric Coarse)	For hole sizes (" UNC)	d1 (mm)	D (mm)	L (mm)
131012-0812	½"	M8 - M12	5/16" - 1/2"	29	47	101
131012-1216	½"	M12 - M16	1/2" - 5/8"	29	61	116
131034-2024	¾"	M20 - M24	3/4" - 1"	29	61	125
Sets						
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) + 1/2" Impact Wrench Clutched Adapter (M12 - M16) + 3/4" Impact Wrench Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps					
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) + 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) + 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps					

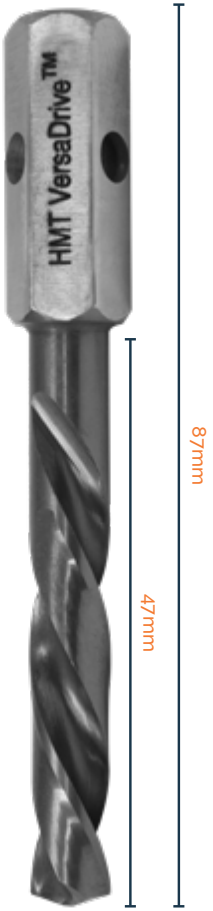
FOR TECHNICAL DATA & USER ADVICE SEE P.124

ImpactaBite Left Hand Drill Bits

Premium specification drill bits with left-handed spiral flute. 8% Cobalt with advanced TiAln coating to reduce friction and heat generation. Can be used both on Rotary and Impact settings.

To be used for drilling the pilot holes in broken bolts and seized studs ready for VersaDrive® Bolt extractors. Designed to run in reverse to help loosen the seized item at the same time as creating the pilot hole.

- *Premium 8% Cobalt with advanced TiAln coating*
- *For use on hardened bolts & studs*
- *Loosen seized or sheared bolts and studs*
- *Impact Rated for high speed operation*
- *Drill pilot holes ready for ImpactaBite bolt extractors to be inserted*
- *VersaDrive patented shank & adapters provide multiple modular solutions*
- *Use on impact to prevent dangerous kickback caused by handheld rotary tools*



Part No.	Pilot Drill No.	Use with bolt sizes	Use with bolt sizes
209011-030	3	M5 - M6	7/32 - 9/32"
209011-040	4	M8 - M10	5/16 - 3/8"
209011-050	5	M12 - M14	1/2 - 9/16"
209011-060	6	M16 - M20	5/8 - 3/4"
209011-070	7	M22 - M26	7/8 - 1-1/8"

Pilot Drill & Bolt Extractor Combination Set

Part No.	Pcs.	Contents	Suitable for
2040EX-SET1	8 pcs	ImpactaBite Left Hand Pilot Drill Bits #3, #4, #5, #6 ImpactaBite Bolt Extractors #3, #4, #5, #6	Extract bolts M5 - M20 & 7/32 - 7/8"

FOR TECHNICAL DATA & USER ADVICE SEE P.114

ImpactaBite Bolt Extractors

Extract broken bolts and seized studs with the new VersaDrive® impact rated bolt extractor. A vast improvement to using traditional hand operated eazy-outs.

ImpactaBite uses the impact feature to break the grip caused by corroded or damaged threads.

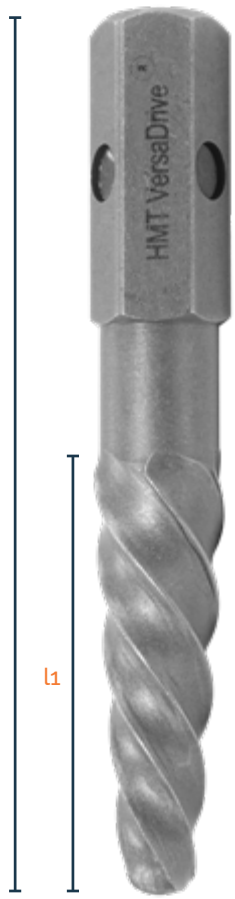
Use once the pilot holes have been created with ImpactaBite Left Hand Drill Bits.

- *Extract seized or sheared bolts and studs*
- *Impact Rated for high speed operation*
- *Solid one piece steel design for heavy duty applications*
- *Heavy-duty hex shank design for secure non-slip operation*
- *VersaDrive patented shank & adapters provide multiple modular solutions*
- *Use on impact to prevent dangerous kickback caused by handheld rotary tools*

Part No.	Bolt Extractor No.	Use with bolt sizes	Use with bolt sizes	l1 (mm)	L (mm)
403010-030	3	M5 - M6	7/32 - 9/32"	25	65
403010-040	4	M8 - M10	9/32 - 3/8"	35	74
403010-050	5	M12 - M14	3/8 - 5/8"	39	77
403010-060	6	M16 - M20	5/8 - 7/8"	46	84
403010-070	7	M22 - M26	7/8 - 1-1/8"	49	90

STAKIT® Pilot Drill & Bolt Extractor ETOP2 12pc Set

Part No.	Pcs.	Contents	Suitable for
2040EX-SET2	12 pcs	ImpactaBite Left Hand Pilot Drill Bits #3, #4, #5, #6, #7 ImpactaBite Bolt Extractors #3, #4, #5, #6, #7 VersaDrive® Rapid-Lock 1/2" Impact Wrench Adapter VersaDrive® Rapid-Lock Magnet Drill Adapter VersaDrive® STAKIT® ETOP2 Half Top Case	Extract bolts M5 - M26 & 7/32 - 1-1/8"



FOR TECHNICAL DATA & USER ADVICE SEE P.114

VersaDrive® ImpactaBurr TCT Chamfer Tool

The ImpactaBurr chamfer tool has tungsten carbide inserts designed to chamfer the outside edge of tube and round bar.

This removes dangerous burrs and also prepares the facing edge ready to receive an external thread or fastener.

- *Quick and effective deburring and chamfering*
- *Impact rated to reduce dangerous kickback*
- *Compatible with the VersaDrive® adapter range*
- *60° angle*
- *Impact & Rotary rated*

Part No	For use with	Ø	L
115200-0190	4 - 18mm Bar	29mm	57mm
115200-0360	19 - 36mm Bar	46mm	61mm

VersaDrive® ImpactaDie Kit
M6 - M12 Threads // 1/4 - 1/2" UNC Threads

The ImpactaDie Impact Die threading kit is a complete solution for creating and repairing external threads on metal bar.

Faster, more efficient and less fatiguing than traditional hand threading practices, the ImpactaDie system can be used to quickly and accurately cut new or repair damaged external threads using an Impact Wrench or Magnetic Drill*.

Along with all necessary dies and guides for threading at sizes M6 - M12 (¼ - ½"), the kit contains the unique VersaDrive® ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading. Supplied in a VersaDrive® ***STAKIT®*** compatible ETOP2 half top case.

*(requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-SET	ImpactaDie Holder, Guide Collar, Flush Collar, M6/8/10/12 Guides, M6/8/10/12 Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case
115820-SET	ImpactaDie Holder, Guide Collar, Flush Collar, 1/4, 5/16, 3/8, 1/2" Guides, 1/4, 5/16, 3/8, 1/2" UNC Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case

FOR TECHNICAL DATA & USER ADVICE SEE P.115

VersaDrive® ImpactaDie (Impact Die Threader)
VERSADRIVE PATENT PROTECTED

Create external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- *Guide collar ensures straight & true threading*
- *Create external threads from M6 - M12*
- *Create external threads up to 50mm long*
- *Impact chipbreaker action for effective swarf evacuation*
- *Use with Impact Wrenches (prevents dangerous kickback)*
- *Clean out existing external threads*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *VersaDrive® patented shank & modular adapters provide unbeatable jobsite flexibility*

VersaDrive® ImpactaDie Holder (body only)	
Part No	Suitable for
115100-01	M6 - M12 Threads 1/4-20 - 1/2-13 UNC

VersaDrive® ImpactaDie Collars	
Part No	Product
115100-02	Guide Collar for creating M6 - M12 & 1/4-20 - 1/2-13 UNC Threads
115100-03	Flush Collar for repairing M6 - M12 & 1/4-20 - 1/2-13 UNC Threads

ImpactaDie Hex 24mm Die Nut	
Part No	To create or repair threads sized
302810-0060	M6 x 1.0
302810-0080	M8 x 1.25
302810-0100	M10 x 1.5
302810-0120	M12 x 1.75
302820-0010	1/4-20 UNC
302820-0020	5/16-18 UNC
302820-0030	3/8-16 UNC
302820-0040	1/2-13 UNC

ImpactaDie Guides	
Part No	For thread sizes
115110-0060	M6
115110-0080	M8
115110-0100	M10
115110-0120	M12
115120-0010	1/4"
115120-0020	5/16"
115120-0030	3/8"
115120-0040	1/2"

Total assembled length of holder + guide collar + guide = 121mm

FOR TECHNICAL DATA & USER ADVICE SEE P.115

VersaDrive® ImpactaDie XL Kits
M16 - M24 Threads // M16-M25 Metric Fine Threads

Create or repair large diameter external threads on metal bar or conduit with VersaDrive® ImpactaDie XL kits.

Offering fast, easy impact-thread cutting in a variety of sizes from M16 - M25 & 5/8" - 1", the ImpactaDie XL system speeds up the challenging and traditionally time-consuming process of creating large external threads.

Kits include the VersaDrive® ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a VersaDrive® ***STAKIT***® compatible ETOP2 half top case.

*(requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-XL-SET1 (Metric Coarse)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24 Guides, M16/20/24 Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case
115810-XL-SET2 (Metric fine for electrical conduit)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/25 Guides, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case
115820-XL-SET (UNC)	ImpactaDie Holder, Guide Collar, Flush Collar, 5/8, 3/4, 7/8, 1" Guides, 5/8, 3/4, 7/8, 1" UNC Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case

VersaDrive® ImpactaDie XL Complete Kit
M16-M24 Metric Coarse & M16-M25 Metric Fine Threads

The VersaDrive® ImpactaDie XL complete kit is the ultimate solution for creating and repairing large diameter external threads in both Metric Coarse and Metric Fine sizes.

Comprising dies and guides in both Metric Coarse M16 - M24 and Metric Fine M16 - M25, this kit offers fast, easy thread cutting for fixings on standard metal bar as well as electrical conduit.

Whatever the job and whatever the challenges, the ImpactaDie XL complete kit will ensure you have the tools needed to quickly and easily tackle the issue whether it be unexpected last minute modifications, every-day workshop use or emergency on-site repairs.

The VersaDrive® ImpactaDie XL system can be used with high-torque impact wrenches and high-power magnetic drills*.

The complete kit also includes the unique VersaDrive® ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading and comes supplied in a VersaDrive® ***STAKIT***® compatible ETOP2 half top case.

*(requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-XL-SET3	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24/25 Guides, M16/20/24 Metric Coarse Hex Die Nuts, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case

FOR TECHNICAL DATA & USER ADVICE SEE P.115

VersaDrive® ImpactaDie XL (Impact Die Threader)

Create XL external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- *Guide collar ensures straight & true threading*
- *Create external threads from M16 - M25*
- *Create external threads up to 75mm long*
- *Impact chipbreaker action for effective swarf evacuation*
- *Use with Impact Wrenches (prevents dangerous kickback)*
- *Clean out existing external threads*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *VersaDrive® patented shank & modular adapters provide unbeatable jobsite flexibility*

ImpactaDie XL Holder

59.5mm

Flush Collar
(for repairing threads)

Guide Collar
(for creating threads)

ImpactaDie XL Hex Die Nut

ImpactaDie XL Guide

VersaDrive® ImpactaDie XL Holder (body only)

Part No	Suitable for
115300-01	M16 - M25 Threads 5/8" - 1" UNC

VersaDrive® ImpactaDie XL Collars

Part No	Product
115300-02	Guide Collar for creating M16 - M25 & 5/8" - 1" UNC Threads
115300-03	Flush Collar for repairing M16 - M25 & 5/8" - 1" UNC Threads

ImpactaDie XL Hex 36mm Die Nut

Part No	To create or repair threads sized
303810-0160	M16 x 2.0
303810-0200	M20 x 2.5
303810-0240	M24 x 3.0
303815-0160	M16 x 1.5 Metric Fine
303815-0200	M20 x 1.5 Metric Fine
303815-0250	M25 x 1.5 Metric Fine
302830-0050	5/8" UNC
302830-0060	3/4" UNC
302830-0070	7/8" UNC
302830-0080	1" UNC

ImpactaDie XL Guides

Part No	For thread sizes
115310-0160	M16
115310-0200	M20
115310-0240	M24
115310-0250	M25
115320-0050	5/8"
115320-0060	3/4"
115320-0070	7/8"
115320-0080	1"

Also available with VersaDrive® MAX shank on request (115400-01)

Total assembled length of XL holder + XL guide collar + XL guide = 146.5mm

FOR TECHNICAL DATA & USER ADVICE SEE P.115

VersaDrive® TurboTip 4pc Sets

Part No	Set contents
209015-SET1	6, 8, 10, 12mm
209016-SET1	3/16, 1/4, 5/16, 1/2"
209016-SET2	#7, #F, 5/16, 27/64"

VersaDrive® TurboTip 7pc Sets

Part No	Set contents
209015-SET2	6, 7, 8, 9, 10, 11, 12mm
209015-SET3	6.8, 8, 8.5, 10, 10.5, 12, 14mm
209015-SET4	6, 8, 10, 12, 14, 18, 22mm
209015-SET7	11, 12, 13, 14, 16, 18, 20mm

VersaDrive® TurboTip 8pc Set

Part No	Set contents
209015-SET6	6, 6.8, 7, 8, 8.5, 9, 10, 10.5mm

VersaDrive® TurboTip 3" Flute 6pc Set

Part No	Set contents
209016-SET3	17/32, 9/16, 5/8, 11/16, 3/4, 13/16"

VersaDrive® TurboTip 12pc Set - Inch

Part No	Set contents
209016-SET12	3/16, #7, 7/32, 1/4, #F, 9/32, 5/16, 11/32, 3/8, 27/64, 7/16, 1/2"

VersaDrive® TurboTip 16pc Set - Metric

Part No	Set contents
209015-SET16	6, 6.8, 7, 8, 8.5, 9, 10, 10.5, 11, 12, 13, 14, 16, 18, 20, 22mm

FOR TECHNICAL DATA & USER ADVICE SEE P.116

VersaDrive® TurboTip Drill Bits

VersaDrive® TurboTip Impact drill bits are stepped tip bits that drill at twice the speed of standard bits without the need for pilot drilling while cutting a perfectly round hole.

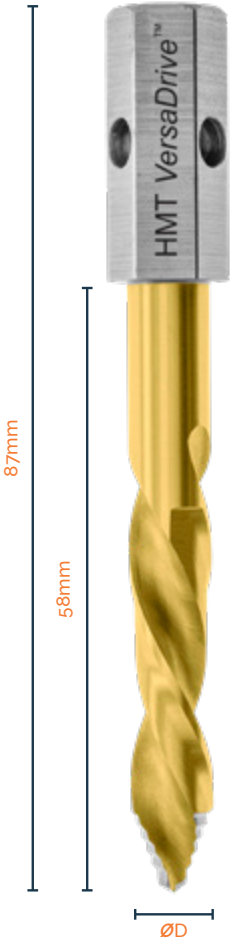
Turbocharge your drilling performance by using this revolutionary tool with an Impact Wrench or Impact Driver. Double hardened and titanium coated for faster drilling & reduced wear.

- *No pilot drilling needed due to patented stepped-tip drill point*
- *Faster drilling with 1/3 less feed pressure required*
- *Reduces fatigue for the operator*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

	Metric	ØD (mm)
	209015-0060	6
	209015-0068	6.8
	209015-0070	7
	209015-0080	8
	209015-0085	8.5
	209015-0090	9
	209015-0100	10
NEW Size	209015-0102	10.2
	209015-0105	10.5
	209015-0110	11
	209015-0120	12
	209015-0130	13
	209015-0140	14
	209015-0160	16
NEW Size	209015-0175	17.5
	209015-0180	18
	209015-0200	20
NEW Size	209015-0210	21
	209015-0220	22

Inch	ØD (")
209016-0010	3/16
209016-0020	#7
209016-0030	7/32
209016-0040	1/4
209016-0050	#F
209016-0060	9/32
209016-0070	5/16
209016-0080	11/32
209016-0090	3/8
209016-0100	27/64
209016-0120	7/16
209016-0130	1/2
209016-0140	17/32**
209016-0150	9/16**
209016-0160	5/8**
209016-0170	11/16**
209016-0180	3/4**
209016-0190	13/16**

**3" flute length



FOR TECHNICAL DATA & USER ADVICE SEE P.116

VersaDrive® Cobalt Drill Bit 4pc Sets

Part No	Set contents
209010-SET1	6, 8, 10, 12mm
209010-SET2	5, 6.8, 8.5, 10.2mm
209013-SET1	1/4, 5/16, 3/8, 1/2"
209013-SET2	#7, #F, 5/16, 3/8"

VersaDrive® Cobalt Drill Bit 7pc Set (5-10.2mm)

Part No	Set contents
209010-SET3	5, 6, 6.8, 8, 8.5, 10, 10.2mm

VersaDrive® Cobalt Drill Bit 7pc Sets (Blacksmith Sizes)

Part No	Set contents
209010-SET4	12, 13, 14, 16, 18, 20, 22mm
209010-SET7	10.2, 11.5, 12, 13, 14, 16, 18mm

VersaDrive® Cobalt Drill Bit 7pc Set (Inch Blacksmith Sizes)

Part No	Set contents
209013-SET3	#7, 1/4, #F, 5/16, 3/8, 27/64, 1/2"

VersaDrive® Cobalt Drill Bit 8pc Set (5-10mm)

Part No	Set contents
209010-SET6	5, 6, 6.8, 7, 7.5, 8, 9, 10mm

VersaDrive® Cobalt Drill Bit 8pc Set (3/16 - 9/16")

Part No	Set contents
209013-SET4	3/16, 1/4, 5/16, 3/8, 27/64, 7/16, 1/2, 9/16"

FOR TECHNICAL DATA & USER ADVICE SEE P.117

VersaDrive® Cobalt Drill Bits

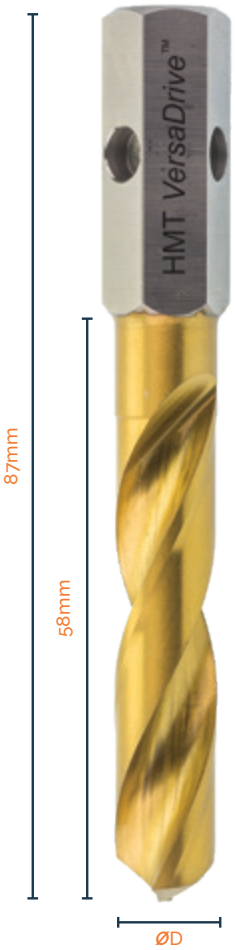
VersaDrive® Cobalt Drills are a premium grade 8% Cobalt drill bit with fully ground flutes, 135˚ Split point and Titanium coating for faster drilling & reduced wear.

Suitable for heavy fabrication use, this Cobalt drill bit can also be used to drill stainless steel, mild steel, cast iron and a wide range of other structural materials.

- *Precision ground flute design provide easy chip clearance*
- *8% Cobalt tool steel for long life & endurance with 135° split point for easy starting & high accuracy*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)
209010-0042	4.2
209010-0050	5
209010-0055	5.5
209010-0060	6
209010-0065	6.5
209010-0068	6.8
209010-0070	7
209010-0075	7.5
209010-0080	8
209010-0085	8.5
209010-0090	9
209010-0095	9.5
209010-0100	10
209010-0102	10.2
209010-0105	10.5
209010-0115	11.5
209010-0120	12
209010-0125	12.5
209010-0130	13
209010-0140	14
209010-0155	15.5
209010-0160	16
209010-0175	17.5
209010-0180	18
209010-0200	20
209010-0210	21
209010-0220	22

Inch	ØD (")
209013-0010	3/16
209013-0020	#7
209013-0030	7/32
209013-0040	1/4
209013-0050	#F
209013-0060	9/32
209013-0070	5/16
209013-0080	11/32
209013-0090	3/8
209013-0100	27/64
209013-0120	7/16
209013-0130	1/2
209013-0140	9/16



FOR TECHNICAL DATA & USER ADVICE SEE P.117

VersaDrive® Impact Step Drills

VERSADRIVE PATENT PROTECTED

The first step drill optimised for use with Impact Wrenches & Impact Drivers allowing the user to create holes in seconds.

Featuring a spiral flute design with self-starting drill tip, for fast, smooth drilling with a rotary drill or Impact Wrench and market leading 5mm thick drilling capacity.

- *Market leading 5mm step thickness*
- *118° split point angle for easy hole start & pilot accuracy*
- *Spiral flute design and size markings at each step*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)	l1 (mm)	L (mm)	Step Diameters (mm)
505020-0120	12	47	75	4, 6, 8, 10, 12
505020-0220	22	58	86	4, 6, 8, 10, 12, 14, 16, 18, 20, 22
505020-0300	30	77	105	4, 6, 8, 10, 12, 14, 16, 18, 20, 22, 24, 26, 28, 30
505020-0400	40	72	101	6, 8, 10, 12,16, 18, 20, 25,29, 32, 36, 40
Electrician's Step Drill 4 - 32.5mm				
505040-0320	32.5	70	99	4, 6, 8.5, 10.5, 12.5, 14.5, 16, 18.5, 20.5, 23.5, 25, 30.5, 32.5
Inch	**ØD (")**	**l1 (")**	**L (")**	**Step Diameters (")**
505030-0010	1/2	1-1/2	2-43/64	3/16, 1/4, 5/16, 3/8, 7/16, 1/2
505030-0020	7/8	2-9/32	3-15/32	3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8
505030-0030	1-3/8	1-31/32	3 5/32	1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1-1/8, 1-1/4, 1-3/8

InsertFoam Sets	
505020-SET1	12, 22, 30mm
505020-SET2	12, 22, 30, 40mm
505030-SET1	1/2, 7/8, 1-3/8"

**Metric step depth = 5mm - Except 505020-0400 which has 6mm Step Depth*
Inch Step Depth = 3/16"
***Rated for material thickness no greater than the depth of each step*

FOR TECHNICAL DATA & USER ADVICE SEE P.118

VersaDrive® ImpactaStep Cutters

VERSADRIVE PATENT PROTECTED

The ImpactaStep Cutter offers combined drilling and reaming on materials up to 12mm thick.

Featuring 5 individual cutting diameters and a straight flute design for strength and easy resharpening, the ImpactaStep Cutter is optimised for use with Impact Wrenches as well as the latest range of VersaDrive® Premium Magnet Drills.

- *5 heavy duty drill bits in one tool*
- *Drill new & enlarge existing holes in metal up to 12mm thick*
- *Safety collar prevents injury & damage when using the largest step*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)	Ød1 (mm)	l1 (mm)	L (mm)	Step Diameters (mm)
506010-0160	16	8	77	105	8, 10, 12 14, 16
506010-0220	22	14	82	110	14, 16, 18, 20, 22
506010-0260	26	18	83	111	18, 20, 22, 24, 26
506010-0320	32	24	87	115	24, 26, 28, 30, 32
Inch	**ØD (")**	**Ød1 (")**	**l1 (")**	**L (")**	**Step Diameters (")**
506030-0010	9/16	5/16	3	4-3/16	5/16, 3/8, 7/16, 1/2, 9/16
506030-0020	13/16	9/16	3-1/8	4-5/16	9/16, 5/8, 11/16, 3/4, 13/16
506030-0030	1- 1/16	13/16	3-1/4	4-7/16	13/16, 7/8, 15/16, 1, 1-1/16

InsertFoam Sets	
506010-SET1	16, 22, 26mm
506010-SET2	16, 22, 26, 32mm
506030-SET1	9/16, 13/16, 1-1/16"

Metric step depth = 12mm
Inch Step Depth = 1/2"

FOR TECHNICAL DATA & USER ADVICE SEE P.119

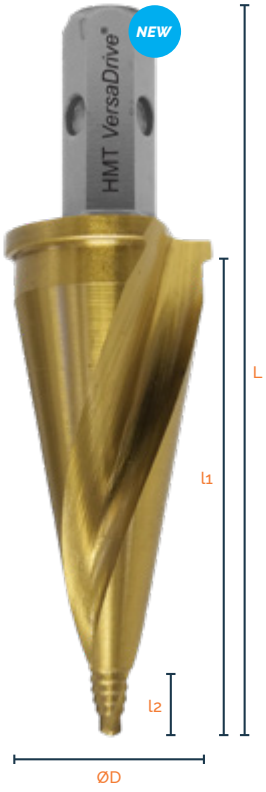
VersaDrive® TurboTip Impact ConeCutters

VERSADRIVE PATENT PROTECTED

The new Impact-rated TurboTip ConeCutter is designed for thin materials such as electrical boxes or sheet metalwork.

Ideal to enlarge an undersized hole to fit an electrical gland. The TurboTip stepped tip allows for fast hole starting with no pilot drill needed The short drill length allows use in tight spaces.

- *Safety collar prevents injury & damage*
- *Spiral flute design*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *VersaDrive® patented shank and modular adapters provide unbeatable jobsite flexibility*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*



Metric	ØD (mm)	ØD (")	l1 (mm)	l2 (mm)	L (mm)	Diameter range (mm)
505050-0200	20	13/16"	52	9.5	81	8 - 20
505050-0250	25	1"	67	9.5	95.5	8 - 25
505050-0320	32	1-1/4"	68	14.5	97	16 -32

InsertFoam Sets	
505050-SET1	20, 25, 32mm

Note: VersaDrive® Cone Cutters are designed for use in sheet metal and should not be used in material exceeding 2-3mm in thickness

FOR TECHNICAL DATA & USER ADVICE SEE P.118

VersaDrive® TurboTip ImpactaStep Cutters

VERSADRIVE PATENT PROTECTED

The new Impact-rated TurboTip ImpactaStep cutters are a unique combination drill bit. The innovative TurboTip stepped design now allows for fast pilot drilling with low feed pressure with superb accuracy and hole finish.

Each ImpactaStep cutter features 5 stepped hole sizes with each size clearly marked inside the flute, and offers combined drilling and reaming on materials up to 12mm thick.

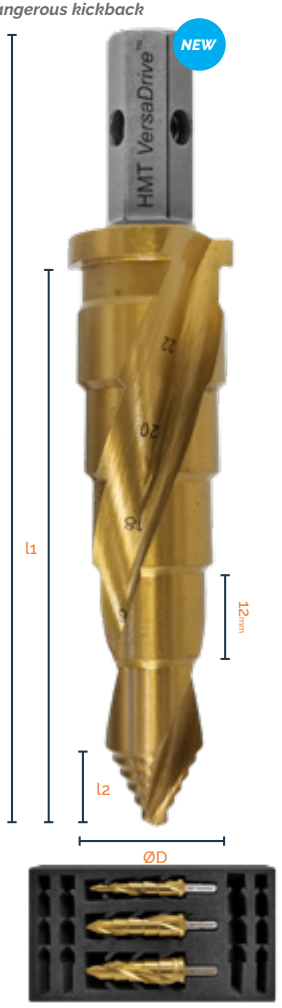
- *5 heavy duty drill bits in one tool*
- *Drill new & enlarge existing holes in metal up to 12mm thick*
- *Safety collar prevents injury & damage when using the largest step*
- *Upgraded spiral-flute design for increased performance and swarf clearance*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *Use on Impact to prevent dangerous kickback*

Metric	ØD (mm)	l1 (mm)	l2 (mm)	L (mm)	Step Diameters (mm)
506040-0160	16	82	10	112	8, 10, 12 14, 16
506040-0220	22	85.5	12.5	115	14, 16, 18, 20, 22
506040-0260	26	89.5	16	118	18, 20, 22, 24, 26
506040-0320	32	94	20.5	123	24, 26, 28, 30, 32

Inch	ØD (")	l1 (")	l2 (")	L (")	Step Diameters (")
506050-0010	9/16"	3-5/16"	3/8"	4-27/64"	5/16", 3/8", 7/16", 1/2", 9/16"
506050-0020	13/16"	3-17/32"	27/64"	4-5/8"	9/16", 5/8", 11/16", 3/4", 13/16"
506050-0030	1-1/16"	3-3/4"	13/16"	4-55/64"	13/16", 7/8", 15/16", 1", 1-1/16"

InsertFoam Sets	
506040-SET1	16, 22, 26mm
506040-SET2	16, 22, 26, 32mm
506050-SET1	9/16, 13/16, 1-1/16"

Metric step depth = 12mm
Inch Step Depth = 1/2"



FOR TECHNICAL DATA & USER ADVICE SEE P.119

VersaDrive® Reamer 3pc Sets

Part No	Set contents
501030-3SET	14, 18, 22mm
501040-3SET	1/2, 5/8, 3/4"

VersaDrive® Reamer 5pc Sets

Part No	Set contents
501030-SET	12, 14, 18, 22, 26mm
501040-5SET	1/2, 5/8, 3/4, 7/8, 1-1/16"
501040-SET7	9/16, 11/16, 13/16, 15/16, 1-1/16"

VersaDrive® Reamer 6pc Set

Part No	Set contents
501030-SET3	8, 10, 12, 14, 16, 18mm

VersaDrive® Reamer 6pc Set

Part No	Set contents
501030-SET4	18, 20, 21, 22, 24, 26mm

VersaDrive® Reamer 10pc ETOP4 Set - Inch Sizes

Part No	Set contents
501040-SET10	1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8, 15/16, 1, 1-1/16"

VersaDrive® Reamer 11pc ETOP4 Set - Metric Sizes

Part No	Set contents
501030-SET11	8, 10, 12, 14, 16, 18, 20, 21, 22, 24, 26mm

FOR TECHNICAL DATA & USER ADVICE SEE P.120

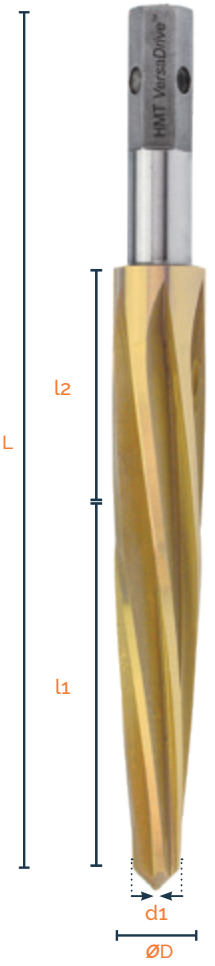
VersaDrive® Impact Reamers
VERSADRIVE PATENT PROTECTED

VersaDrive® reamers are the perfect hole alignment and enlarging tool for metalworkers & steel erectors for keeping the job moving when a hole is misaligned or the incorrect size for the fixing.

Featuring a specially designed 6 flute cutting geometry and Titanium coating, VersaDrive® Reamers are fully Impact rated and perform fastest when used with an Impact Wrench.

- *Precision 6-flute design for smooth cutting*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Edge cutting design for hole enlargement, giving much better results that a drill bit*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)	Ød1 (mm)	l1 (mm)	l2 (mm)	L (mm)
501030-0080	8	4.5	34	34	106
501030-0100	10	6.3	34	36	108
501030-0120	12	7.5	47	56.5	142
501030-0140	14	8.5	63	43.5	144
501030-0160	16	8.5	58	56.5	152.5
501030-0180	18	10	58	63.5	171
501030-0200	20	11.6	61	75	185.5
501030-0210	21	12	61	66	178.5
501030-0220	22	13	66	70	185
501030-0240	24	15	66	71	185
501030-0260	26	16	64	71	185
Inch	**ØD (")**	**Ød1 (")**	**l1 (")**	**l2 (")**	**L (")**
501040-0040	1/2 (12.7mm)	19/64	1-15/16	2-1/16	5 1/2
501040-0050	9/16 (14.3mm)	9/32	2-1/16	1-15/16	5 1/2
501040-0060	5/8 (15.9mm)	5/16	2-11/64	2-21/64	6
501040-0070	11/16 (17.5mm)	3/8	2-1/4	2-1/4	6
501040-0080	3/4 (19.05mm)	13/32	2-31/64	2-33/64	7
501040-0085	13/16 (20.63mm)	15/32	2-33/64	2-31/64	7
501040-0090	7/8 (22.2mm)	17/32	2-19/32	2-13/32	7
501040-0100	15/16 (23.8mm)	19/32	2-43/64	2-21/64	7
501040-0110	1 (25.4mm)	5/8	2-43/64	2-21/64	7
501040-0120	1-1/16 (27mm)	45/64	2-9/16	2-7/16	7



FOR TECHNICAL DATA & USER ADVICE SEE P.120

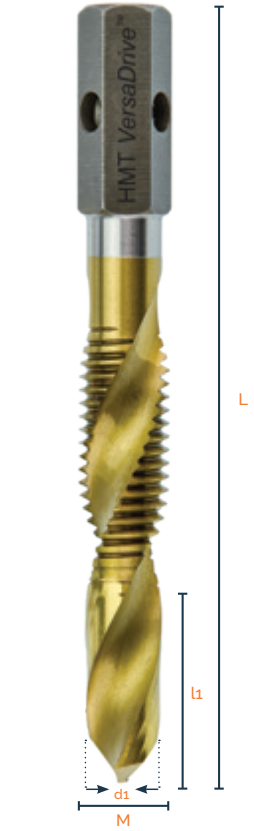
VersaDrive® Impact Drill Taps

VERSADRIVE PATENT PROTECTED

VersaDrive® Drill Taps are a time saving solution for pilot drilling & tapping in one easy operation. The Titanium coating provides wear resistance and faster cutting performance.

Recommended for use with Impact Drivers for high drilling and tapping productivity.

- *Drill pilot holes and then tap in one fast easy operation*
- *Dual hardened for impact use*
- *Ground flute twist drill creates the correct pilot hole size*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Up to 15X faster speed than traditional methods*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Impact Chipbreaker action for effective swarf evacuation*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*



Metric	M Thread Size & Pitch	Max Material Thickness**	Ød1 (mm)	L (mm)	l1 (mm)
301125-0030	M3 x 0.50	3mm	2.5	54	4.8
301125-0040	M4 x 0.70	4mm	3.3	68.5	7
301125-0050	M5 x 0.80	5mm	4.2	70	11
301125-0060	M6 x 1.00	6mm	5.0	73.5	13
301125-0080	M8 x 1.25	8mm	6.8	80.5	15
301125-0100	M10 x 1.50	10mm	8.5	89	18
301125-0120	M12 x 1.75	12mm	10.2	102.5	25

Inch	M Thread Size & Pitch	Max Material Thickness	Ød1 (")	L (")	l1 (")
301126-0010	4-40 UNC	3/32	3/32	2-11/64	15/64
301126-0020	6-32 UNC	1/8	7/64	2-23/64	23/64
301126-0030	8-32 UNC	5/32	9/64	2-23/64	23/64
301126-0040	10-24 UNC	13/64	5/32	2-51/64	33/64
301126-0045	12-24 UNC	13/64	5/32	2-51/64	33/64
301126-0050	1/4-20 UNC	1/4	13/64	2-61/64	19/32
301126-0060	5/16-18 UNC	5/16	1/4	3-15/64	45/64
301126-0070	3/8-16 UNC	3/8	5/16	3-5/8	55/64
301126-0080	1/2-13 UNC	1/2	27/64	4/16	1-7/64

InsertFoam Sets	
301125-SET1	M5, M6, M8, M10, M12
301126-SET1	1/4, 5/16, 3/8, 1/2" UNC

***Rated for material thickness no greater than the diameter of the drill-tap*

FOR TECHNICAL DATA & USER ADVICE SEE P.122

VersaDrive® Heavy Duty DrillTaps

VERSADRIVE PATENT PROTECTED

VersaDrive® Heavy Duty Drill Taps are an industrial metalwork or fabrication tool for drilling and tapping heavy steel in one easy operation.

Primarily designed to be used with a reversible Magnet Drill, they can be adapted for use with an Impact Wrench to enlarge and tap existing holes.

Not recommended for use in a Pistol Drill. If being used with an Impact Wrench to enlarge & tap holes pilot drilling is recommended.

- *Impact Chipbreaker action for effective swarf evacuation*
- *Ground flute twist drill creates the correct pilot hole size*
- *Rated for heavy duty plate thicknesses*
- *Heavy duty straight flute design creates a strong and durable tool*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*

Metric	M Thread Size & Pitch	Ød1 (mm)	L (mm)	l1 (mm)	MTD** (mm)
301130-0080	M8 x 1.25	6.8	117	28.5	20
301130-0100	M10 x 1.50	8.5	118	27	20
301130-0120	M12 x 1.75	10.2	117	27	25
301130-0160	M16 x 2.00	14	117	25	25
301130-0200	M20 x 2.50	17.5	135	27.5	35
301130-0240	M24 x 3.00	21	150	32	40

Inch	M Thread Size & Pitch	Ød1 (")	L (")	l1 (")	MTD** (")
301140-0001	1/2-13 UNC	27/64	4 -23/32	1-3/8	1
301140-0002	5/8-11 UNC	17/32	5-1/8	1-29/64	1
301140-0003	3/4-10 UNC	21/32	5-33/64	1-37/64	1-3/8
301140-0005	1-8 UNC	7/8	6-19/64	1-49/64	1-37/64

InsertFoam Sets	
301130-SET1	M12, M16, M20, M24
301130-SET2	M8, M10, M12, M16, M20, M24
301140-SET1	1/2, 5/8, 3/4, 1"

***Max Tapping Depth*

FOR TECHNICAL DATA & USER ADVICE SEE P.123

VersaDrive® ImpactaTap Sets - Metric

Part No	Set contents
308010-SET1	M6, M8, M10, M12, M16
308010-SET2	M12, M16, M20, M24

VersaDrive® ImpactaTap Set - Metric

Part No	Set contents
308010-SET3	M6, M8, M10, M12, M16, M20, M24

VersaDrive® ImpactaTap Set - Inch

Part No	Set contents
308050-SET1	1/4, 5/16, 3/8, 1/2, 5/8" UNC

VersaDrive® ImpactaTap Sets - Inch

Part No	Set contents
308050-SET2	1/2, 5/8, 3/4, 1" UNC

VersaDrive® TurboTip & ImpactaTap Combi Set

Part No	Set contents
328015-SET1	6.8, 8.5, 10.5, 14mm TurboTips + M8, M10, M12, M16 ImpactaTaps

VersaDrive® TurboTip & ImpactaTap Combi Set

Part No	Set contents
328016-SET2	#7, #F, 5/16, 27/64" TurboTips + 1/4, 5/16, 3/8, 1/2" ImpactaTaps

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® ImpactaTaps

VersaDrive® ImpactaTaps are the first range of taps that are suitable to be driven by Impact Wrenches and Impact Drivers, providing at least 15x faster performance than tapping by hand.

With a specially designed twin-lead, cutting geometry, specialist Titanium coating and dual hardened body, ImpactaTaps provide a fantastic solution for quickly & easily tapping holes in steel.

- *Impact Chipbreaker action for effective swarf evacuation*
- *Unique twin-point cutting geometry with ground flutes*
- *Create internal threaded holes with speed and precision*
- *Quickly clean out & repair damaged or fouled internal threads*
- *Impact-rated due to dual hardening process*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Allows up to 15X faster speed than traditional methods*

Metric Coarse	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308010-0050	M5 x 0.80	56	18	4.2
308010-0060	M6 x 1.00	58	20	5
308010-0080	M8 x 1.25	60	22	6.8
308010-0100	M10 x 1.50	70	24	8.5
308010-0120	M12 x 1.75	80	29	10.2
308010-0140	M14 x 2.00	90	32	12
308010-0160	M16 x 2.00	90	32	14
308010-0180	M18 x 2.50	100	37	15.5
308010-0200	M20 x 2.50	100	37	17.5
308010-0240	M24 x 3.00	110	45	21
308010-0270	M27 x 3.00	130	47	24
308010-0300	M30 x 3.50	130	48	26.5
UNC	**M Thread Size & Pitch**	**L (")**	**l1 (")**	**Tap Hole Size**
308050-0010	1/4 x 20 UNC	58	20	#7 (5.1mm)
308050-0020	5/16 x 18 UNC	60	22	#F (6.6mm)
308050-0030	3/8 x 16 UNC	70	24	5/16" (8mm)
308050-0040	1/2 x 13 UNC	80	29	27/64" (10.8mm)
308050-0050	5/8 x 11 UNC	90	32	17/32" (13.5mm)
308050-0060	3/4 x 10 UNC	100	37	21/32" (16.5mm)
308050-0065	7/8 x 9 UNC	105	40	49/64" (19.5mm)
308050-0070	1 x 8 UNC	110	45	7/8" (22.25mm)

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® Spiral Flute Tap Sets - Metric

Part No	Set contents
309010-SET1	M6, M8, M10, M12, M16
309010-SET2	M12, M16, M20, M24

VersaDrive® Spiral Flute Tap Sets - Inch

Part No	Set contents
309020-SET1	1/4, 5/16, 3/8, 1/2, 5/8" UNC
309020-SET2	1/2, 3/4, 1" UNC

VersaDrive® Impact Wrench Clutched Adapter Set - Metric Coarse

Part No	Set contents
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) + 1/2" Impact Wrench Clutched Adapter (M12 - M16) + 3/4" Impact Wrench Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps

VersaDrive® Impact Wrench Clutched Adapter Set - Inch UNC

Part No	Set contents
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) + 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) + 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps

VersaDrive® Morse Taper Clutched Adapter Set - Metric Coarse

Part No	Set contents
132000-SET1	MT2 Clutched Adapter (M8 - M12) + MT2 Clutched Adapter (M12 - M16) + MT3 Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps

VersaDrive® Morse Taper Clutched Adapter Set - Inch UNC

Part No	Set contents
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) + MT2 Clutched Adapter (1/2" - 5/8" UNC) + MT3 Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® Spiral Flute Taps

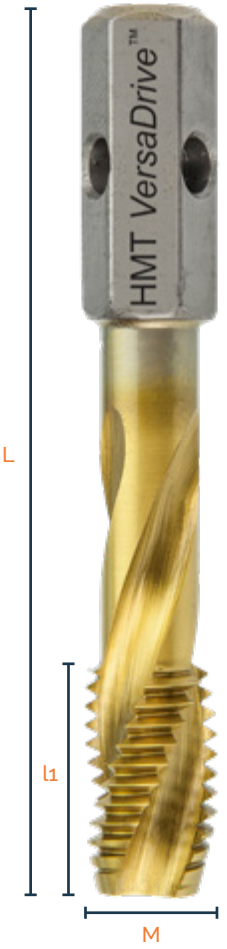
VersaDrive® Spiral Flute Taps are designed for tapping blind holes.

They can be adapted for use in a reversible Magnet Drill, Impact Wrench, cordless pistol drill or even used with any standard Hand Tap wrench.

Recommended for use with the NEW VersaDrive® Clutched Adapters on p.22 & p.23.

- *Ground flutes create the perfect tapped hole*
- *Safer tapping with minimal kickback*
- *Create internal threaded holes with speed and precision*
- *Quickly clean out & repair damaged or fouled internal threads*
- *Impact-rated due to dual hardening process*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Allows up to 15X faster speed than traditional methods*

Metric Coarse	M Thread Size & Pitch	L (mm)	l1 (mm)	THS**	THS***
309010-0060	M6 x 1.00	58	20	5.0	-
309010-0080	M8 x 1.25	60	22	6.8	-
309010-0100	M10 x 1.50	70	24	8.5	-
309010-0120	M12 x 1.75	80	29	10.2	-
309010-0160	M16 x 2.00	90	32	14.0	-
309010-0200	M20 x 2.50	100	37	17.5	-
309010-0240	M24 x 3.00	110	45	21.0	-
309010-0300	M30 x 3.50	130	48	26.5	-
Inch	**M Thread Size & Pitch**	**L (*)**	**l1 (*)**	**THS****	**THS*****
309020-0010	1/4 x 20 UNC	2-3/8	63/64	5.1	#7
309020-0020	5/16 x 18 UNC	2-3/8	63/64	6.6	#F
309020-0030	3/8 x 16 UNC	2-3/4	1	8	5/16
309020-0040	1/2 x 13 UNC	3-1/8	1-3/64	10.8	27/64
309020-0050	5/8 x 11 UNC	3-1/2	1-5/64	13.5	17/32
309020-0060	3/4 x 10 UNC	3-31/32	1-9/64	16.5	21/32
309020-0065	7/8 x 9 UNC	4-1/8	1-13/16	19.5	49/64
309020-0070	1 x 8 UNC	4-3/8	2	22.25	7/8
309020-0110	1-1/4 x 7 UNC	5	2	28	1-7/64



** *Tap Hole Size (mm)* *** *Tap Hole Size (")*

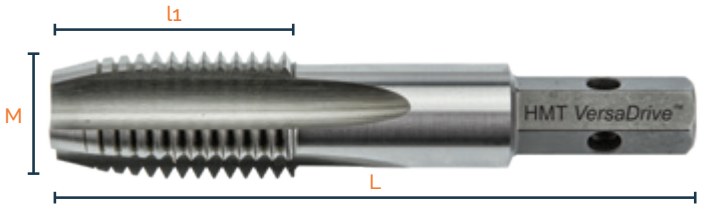
FOR TECHNICAL DATA & USER ADVICE SEE P.124

ImpactaTaps Long Series - Metric Coarse

Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	l2 (mm)	Tap Hole Size (mm)
308015-0080	M8 x 1.25	140	45	112	6.8
308015-0100	M10 x 1.50	155	50	127	8.5
308015-0120	M12 x 1.75	180	55	152	10.2
308015-0160	M16 x 2.0	200	65	172	14
308015-0200	M20 x 2.5	230	70	202	17.5
308015-0240	M24 x 3.0	260	75	232	21

Spiral Point Taps for fast chip ejection in through holes.

ImpactaTaps - Metric Coarse Oversized - For use with Galvanised Fixings

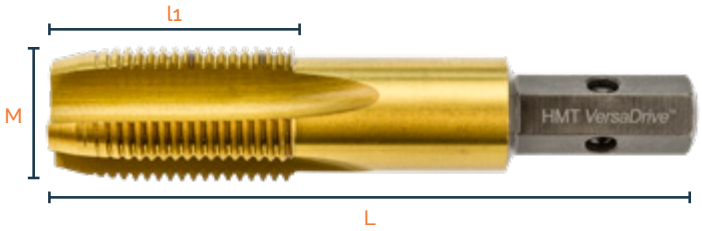


Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (Metric Coarse thread - mm)
308020-0050	M5.4 x 0.80	55	18	4.2
308020-0060	M6.4 x 1.00	55	20	5.0
308020-0080	M8.4 x 1.25	60	22	6.8
308020-0100	M10.4 x 1.50	70	24	8.5
308020-0120	M12.4 x 1.75	80	29	10.2
308020-0160	M16.4 x 2.00	90	32	14.0
308020-0200	M20.4 x 2.50	100	37	17.5
308020-0240	M24.4 x 3.00	110	45	21.0
308020-0300	M30.4 x 3.50	130	48	26.5
InsertFoam Set				
308020-SET1	6 Pc Set: M5.4, M6.4, M8.4, M10.4, M12.4, M16.4			

FOR TECHNICAL DATA & USER ADVICE SEE P.124

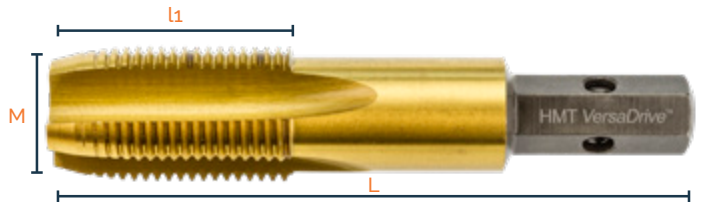
VersaDrive® ImpactaTaps
VERSADRIVE PATENT PROTECTED

ImpactaTaps - Metric Fine Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308030-0060	M6 x 0.75 MF	60	19	5.2
308030-0800	M8 x 1.00 MF	70	22	7.0
308030-0100	M10 x 1.25 MF	70	24	8.8
308030-0120	M12 x 1.50 MF	80	29	10.5
308030-0160	M16 x 1.50 MF	90	32	14.5
308030-0180	M18 x 1.50 MF	100	37	16.5
308030-0200	M20 x 1.50 MF	100	37	18.5
308030-0240	M24 x 1.50 MF	120	92	22.5

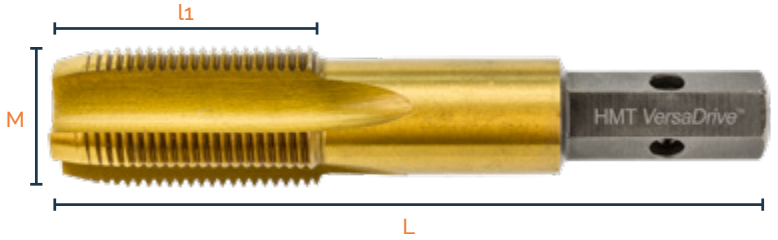
ImpactaTaps - UNF Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size
308051-0010	1/4 x 28 UNF	58	20	#3
308051-0020	5/16 x 24 UNF	60	22	#I
308051-0030	3/8 x 20 UNF	70	24	#Q
308051-0040	1/2 x 20 UNF	80	29	29/64"
308051-0050	5/8 x 18 UNF	90	32	37/64"
308051-0060	3/4 x 16 UNF	100	37	11/16"
308051-0065	7/8 x 14 UNF	105	40	13/16"
308051-0070	1 x 12 UNF	110	45	59/64"

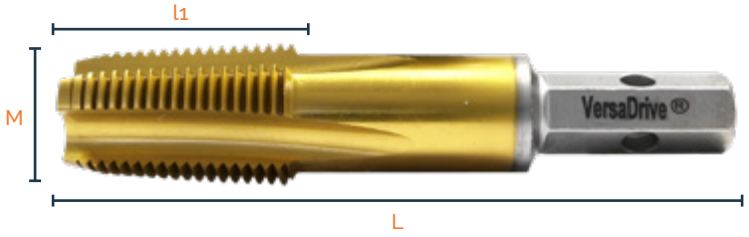
FOR TECHNICAL DATA & USER ADVICE SEE P.124

ImpactaTaps - BSP Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308070-0010	1/8 x 28 BSP	70	24	8.8
308070-0020	1/4 x 19 BSP	90	32	11.8
308070-0030	3/8 x 19 BSP	90	32	15.25
308070-0040	1/2 x 14 BSP	100	37	19
308070-0050	5/8 x 14 BSP	100	37	21
308070-0060	3/4 x 14 BSP	100	37	24.5
308070-0070	1 x 11 BSP	110	45	30.75

ImpactaTaps - NPT Thread

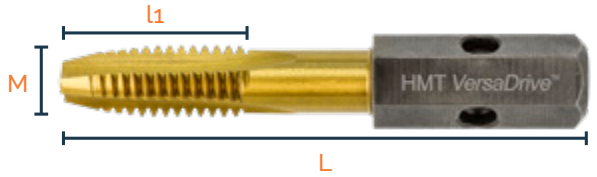


Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size
308075-0010	1/8 x 27 NPT	70	19	#R
308075-0020	1/4 x 18 NPT	90	27	7/16"
308075-0030	3/8 x 18 NPT	90	27	37/64"
308075-0040	1/2 x 14 NPT	100	35	23/32"
308075-0050	3/4 x 14 NPT	100	35	59/64"
308075-0060	1 x 11.5 NPT	110	44	1-5/32"

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® ImpactaTaps
VERSADRIVE PATENT PROTECTED

ImpactaTaps - BSW Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308060-0010	1/4 x 20 BSW	58	20	5.1
308060-0015	5/16 x 18 BSW	60	22	6.5
308060-0020	3/8 x 16 BSW	70	24	7.9
308060-0030	1/2 x 12 BSW	80	29	10.5
308060-0040	5/8 x 11 BSW	90	32	13.5
308060-0050	3/4 x 10 BSW	100	37	16.25
308060-0060	1 x 8 BSW	110	45	22

ImpactaTaps - Thread Chaser Taps

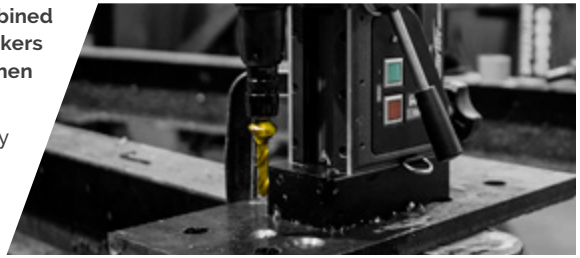
Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
309210-0060	M6 x 1.0	61	25	5.2
309210-0080	M8 x 1.25	60	23.5	7
309210-0100	M10 x 1.5	70	25.5	8.8
309210-0120	M12 x 1.75	80	32	10.2
309210-0160	M16 x 2.0	90	32.5	14.5
309210-0200	M20 x 2.5	100	38	18.5
309210-0240	M24 x 3.0	110.5	46	22.5
InsertFoam Sets	Contents			
309210-SET1	5Pc Set: M6, M8, M10, M12, M16			
309210-SET2	4Pc Set: M12, M16, M20, M24			
309210-SET	7Pc Set: M6, M8, M10, M12, M16, M20, M24			

FOR TECHNICAL DATA & USER ADVICE SEE P.124

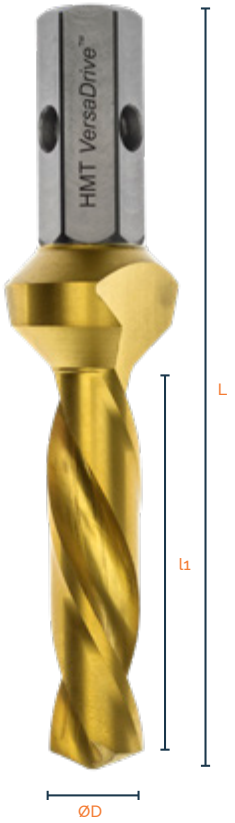
VersaDrive® DrillSinks

The VersaDrive® DrillSink is an innovative combined drilling & countersinking tool to save metalworkers time & increase hole accuracy by drilling & then countersinking fixing holes in one operation.

This provides perfect countersinking accuracy every time by locating the drilled hole in perfect alignment to the countersink. This helps prevent tool chatter and blunting commonly found with standard countersinks.



- *Drill & countersink in one easy operation*
- *Ground flutes for high accuracy & long life*
- *Perfect concentricity for accurate countersinking*
- *Integrated pilot drill prevents the chattering of standard countersinks*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*



Clearance Hole	Ø D (mm)	Countersink Size (mm)	l1 (mm)	L (mm)	Countersunk Screw	CSK Angle
603070-08124	8	12.4	45	91.2	M6	90°
603070-10165	10	16.5	44.5	84	M8	90°
603070-11205	11	20.5	44	89	M10	90°
603070-12205	12	20.5	44.5	88.5	M10	90°
603070-13250	13	25	44	92	M12	90°
603070-14250	14	25	42	91.7	M12	90°
Tapped Hole	**Ø D (mm)**	**Countersink Size (mm)**	**l1 (mm)**	**L (mm)**	**Countersunk Screw**	**CSK Angle**
603070-68165	6.8	16.5	47	85	M8 (Tap)	90°
603070-85205	8.5	20.5	47	89	M10 (Tap)	90°
603070-102250	10.2	25	47	93	M12 (Tap)	90°

InsertFoam Set

603070-SET4	8/12.4, 10/16.5, 12/20.5, 14/25mm

FOR TECHNICAL DATA & USER ADVICE SEE P.126

VersaDrive® Countersinks

The VersaDrive® Countersink is a premium quality countersink with fully ground flutes and GoldMax Titanium coating to help reduce wear and blunting.

Utilise the convenience and power of an Impact Wrench to quickly debur and countersink holes up to 16.5mm with minimal torque kick-back against the operator.

- *The first impact rated countersink on the market*
- *Perfect concentricity for accurate countersinking*
- *VersaDrive patented shank and modular adapters provide unbeatable jobsite flexibility*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Ground flutes for high accuracy & long life*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*

Metric - 90°	ØD (mm)	Ød1 (mm)	l1 (mm)	L (mm)	Countersunk Screw	CSK Angle
603060-0063	6.3	1.5	5.5	45	M3	90°
603060-0083	8.3	2.0	6	50	M4	90°
603060-0104	10.4	2.5	8	50	M5	90°
603060-0124	12.4	2.8	8	56	M6	90°
603060-0165	16.5	3.2	11.5	60	M8	90°
603060-0205	20.5	3.5	12	63	M10	90°
603060-0250	25	3.8	15	67.5	M12	90°
603060-0310	31	4.2	18	69	M16	90°
Inch - 82°	**ØD (")**	**Ød1 (")**	**l1 (")**	**L (")**	**Countersunk Screw**	**CSK Angle**
603065-0100	1/4	1/16	7/64	1-27/32	-	82°
603065-0200	3/8	7/64	5/32	2-3/64	-	82°
603065-0300	1/2	7/64	7/32	2-9/32	-	82°
603065-0400	5/8	1/8	9/32	2-7/16	-	82°
603065-0500	3/4	1/8	11/32	2-9/16	-	82°
603065-0600	1	11/64	31/64	2-23/32	-	82°

InsertFoam Sets

603060-5SET	12.4, 16.5, 20.5, 25, 31mm - 90°
603065-5SET	3/8, 1/2, 5/8, 3/4, 1" - 82°

FOR TECHNICAL DATA & USER ADVICE SEE P.127

VersaDrive® TCT HoleCutter Sets - Metric

Part No	Set contents
101030-SET1	14, 18 & 22mm
101030-SET2	14, 17, 18, 21 & 22mm

VersaDrive® TCT HoleCutter Sets - Inch

Part No	Set contents
101030-INSET1	9/16, 11/16, 13/16"
101030-INSET2	9/16, 11/16, 13/16, 15/16, 1-1/16"

VersaDrive® TCT HoleCutter Upgrade Kit

HoleCutter Upgrade Kit	
101030P-0004	VersaDrive® TCT HoleCutter Upgrade Kit 1 x TurboTip 1/4" / 6.35mm & 1 x Pilot Pin *Suitable for cutters 14mm and larger

VersaDrive® TCT HoleCutter Pilot Drill Bits & Pins

101030 Pilot Drills & Pins	
101030P-0130	Pilot Drill for 12 & 13mm HoleCutters (2pk) (Supplied WITHOUT ejection spring)
101030P-0001	Pilot Drill for 14-80mm HoleCutters (2pk) (Supplied WITH ejection spring)
101030P-0003	VersaDrive® HoleCutter Magnet Broaching / MultiSink Pilot Pin, (2pk)

101035 Pilot Drills & Pins	
101035P-01	Extra Long TCT HoleCutter Pilot Drills 6.35x165mm, (2pk)
101035P-02	Extra Long HoleCutter Guide Pin 6.35x205mm, (2pk)

VersaDrive® Extra Long TCT HoleCutters

Part No	ØD (mm)	ØD (")	Set Screw
101035-0140	14	9/16"	M5
101035-0170	17	11/16"	M6
101035-0180	18		
101035-0200	20		
101035-0210	21	13/16"	M8
101035-0220	22	7/8"	
101035-0240	24	15/16"	
101035-0260	26		

VersaDrive® Extra Long TCT HoleCutter Sets

Part No	Set contents
101035-SET1	14, 18, 20, 22, 24 & 26mm
101035-SET2	9/16, 11/16, 7/8, 15/16"

FOR TECHNICAL DATA & USER ADVICE SEE P.112

VersaDrive® TCT HoleCutters
VERSADRIVE PATENT PROTECTED

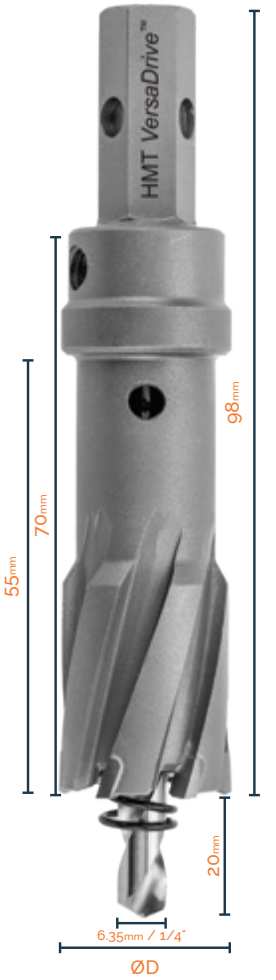
VersaDrive® TCT HoleCutters are a high performance solution for cutting larger diameter holes quickly and effectively. Premium grade Tungsten Carbide teeth provide ultimate cutting performance in a wide range of metals including Stainless Steel and Cast Iron.

The go-to solution for fabricators and steel erectors needing to drill through heavy steel.

- *Massive 70mm reach with 55mm depth of cut*
- *Perfect for drilling heavy steel in remote locations*
- *Premium quality Tungsten Carbide teeth*
- *Combine with MultiSink to broach & countersink in 1 pass*
- *Use with Magnet Drill adapter*
- *Use in standard 1/2" drill chuck*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Rotary Rated - not recommended for Impact use*

Part No	ØD (mm)	ØD (")	Set Screw
101030-0120	12		M5
101030-0130	13		
101030-0140	14	9/16"	
101030-0150	15		
101030-0160	16	5/8"	
101030-0170	17	11/16"	M6
101030-0175	17.5		
101030-0180	18		
101030-0190	19	3/4"	
101030-0200	20		
101030-0210	21	13/16"	M8
101030-0220	22	7/8"	
101030-0230	23		
101030-0240	24	15/16"	
101030-0250	25	1"	
101030-0260	26		
101030-0270	27	1-1/16"	
101030-0280	28		
101030-0290	29	1-1/8"	
101030-0300	30	1-3/16"	
101030-0310	31		
101030-0320	32	1-1/4"	
101030-0330	33	1-5/16"	
101030-0340	34		

Part No	ØD (mm)	ØD (")	Set Screw
101030-0350	35	1/3-8"	M8
101030-0360	36		
101030-0370	37	1-7/16"	
101030-0380	38	1-1/2"	
101030-0390	39	1-9/16"	
101030-0400	40		
101030-0410	41	1-5/8"	
101030-0420	42		
101030-0430	43	1-11/16"	
101030-0440	44	1-3/4"	
101030-0450	45		
101030-0460	46	1-13/16"	
101030-0470	47		
101030-0480	48	1-7/8"	
101030-0490	49		
101030-0500	50		
101030-0510	51	2"	
101030-0520	52	2-1/16"	
101030-0550	55	2-5/32"	
101030-0600	60	2-3/8"	
101030-0650	65	2-9/16"	
101030-0700	70	2-3/4"	
101030-0750	75		
101030-0800	80	3-5/32"	



FOR TECHNICAL DATA & USER ADVICE SEE P.112

VERSADRIVE® MAX

The VersaDrive® MAX new product range develops the patented VersaDrive® shank into new territory for the most demanding industrial applications.

The standard VersaDrive® Shank measures 11mm Hex

The new heavy-duty VersaDrive® MAX shank is 20mm Hex meaning it can be used in thicker materials with higher torque application.

HEAVY DUTY SHANK

This increased shank strength means that VersaDrive® MAX can be used to power larger diameter cutting tools, for example 41mm diameter reamers and M42 Taps.

PERFECT FOR USE IN:

- **Heavy gauge structural steel**
- **Bridge refurbishment**

VERSADRIVE® PATENT PROTECTED

(Images below are to scale)

11mm SHANK

VERSADRIVE® MAX

TECHNICAL DATA & USER ADVICE - P.120

20mm SHANK

Tested on 50mm thick structural steel with 1" Milwaukee Impact Wrench & MT5 magnetic drilling machines

Impact Wrenches

Magnet Drills

VersaDrive® MAX Adapters

VERSADRIVE® PATENT PROTECTED

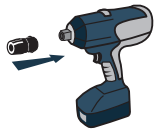
VersaDrive® MAX adapters have been designed to accommodate the larger 20mm VersaDrive® MAX shank & can withstand the highest levels of torque.

Adapters are available to fit VersaDrive® MAX tooling to both Impact Wrenches & high power Magnet Drills.

- *Use with the highest torque drive tools*
- *Impact adapters are made to a trusted heavy-duty design with pull forward locking collar*
- *Impact adapters supplied with retention ring & pin*

VersaDrive® MAX HD Impact Wrench Adapter ½" Drive

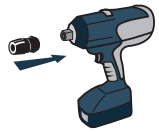
Heavy Duty adapter to convert high-power ½" Impact Wrenches for use with VersaDrive® MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-012A	35	30	65

VersaDrive® MAX HD Impact Wrench Adapter ¾" Drive

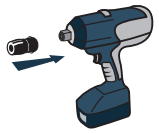
Heavy Duty adapter to convert high-power ¾" Impact Wrenches for use with VersaDrive® MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-034A	35	38	75

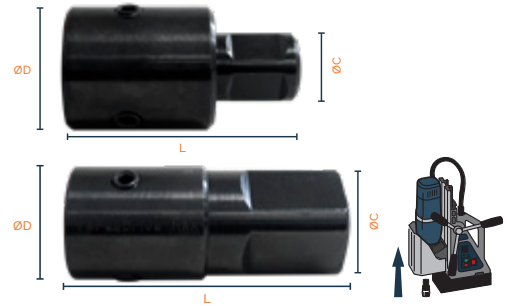
VersaDrive® MAX HD Impact Wrench Adapter 1" Drive

Heavy Duty adapter to convert high-power 1" Impact Wrenches for use with VersaDrive® MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-100A	35	54	80

VersaDrive® MAX HD Magnet Drill Adapters



Part No	ØC (Weldon Shank mm)	ØD (mm)	L (mm)
111031-01	19.05 (¾")	34	63
111031-02	31.75 (1-¼")	34	80

VersaDrive® MAX Reamer ETOP2 Kits - Metric

Part No	Reamers	Set contents
501050-3SET	3pcs	18, 22, 26mm + 3/4" Impact Adapter
501050-4SET	4pcs	18, 22, 24, 26mm + 3/4" Impact Adapter

VersaDrive® MAX Reamer ETOP2 Kits - Inch

Part No	Reamers	Set contents
501051-SET1	3pcs	11/16, 13/16, 15/16" + 3/4" Impact Adapter
501051-SET2	4pcs	11/16, 13/16, 15/16, 1-1/16" + 3/4" Impact Adapter

VersaDrive® MAX Impact Reamer STAKIT® Kit - 5pc

Part No	Set contents
STC-EMID-MAX02	22, 26, 30, 32, 36mm VersaDrive® MAX Reamers, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter
STC-EMID-INMAX02	15/16, 1-1/16, 1-3/16, 1-5/16, 1-3/8" VersaDrive® MAX Impact Reamers, ¾" VersaDrive® MAX Impact Wrench Adapter, ¾" Weldon Shank Magnet Drill Adapter

VersaDrive® MAX Impact Reamer STAKIT® Kit - 10pc

Part No	Set contents
STC-EMID-MAX01	14, 18, 20, 22, 24, 26, 30, 32, 36, 39mm VersaDrive® MAX Reamers, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter
STC-EMID-INMAX01	11/16, 13/16, 15/16, 1-1/16, 1-3/16, 1-5/16, 1-3/8, 1-7/16, 1-1/2, 1-5/16" VersaDrive® MAX Reamers, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Metric

Part No	Set contents
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm VersaDrive® MAX Reamers, M24, M27, M30, M33, M36 VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Inch

Part No	Set contents
STC-EMID-INMAX04	1, 1-1/16, 1-5/16, 1-3/8, 1-5/8" CarbideMax 55 TCT Broach Cutters, 15/16, 1-1/16, 1-3/16, 1-5/16, 1-7/16" VersaDrive® MAX Reamers, 1-1/16, 1-1/4, 1-3/8, 1-1/2, 1-3/4" VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

FOR TECHNICAL DATA & USER ADVICE SEE P.120

VersaDrive® MAX Reamers
VERSADRIVE PATENT PROTECTED

VersaDrive® MAX reamers offer a heavy duty solution for enlarging and aligning holes in thick metal plate (e.g. 20mm and above) or at large diameters.

Specially designed cutting geometry and a unique 20mm shank mean they can be used with high torque Impact Wrenches and the most powerful Magnet Drills for superior performance and portability, allowing the job to be completed on-site and not removed for reworking.

- *Ideal for steel erection & bridge work*
- *Ideal for modifying & enlarging holes*
- *Prepare holes for TCB & friction grip bolt*
- *Use with 1/2", 3/4" & 1" high torque Impact Wrenches*
- *Use with high torque, low speed Magnetic Drills*
- *6 flute design for a faster, smoother cut*

	Metric	ØD (mm)	Ød1 (mm)	l1 (mm)	l2 (mm)	L (mm)
NEW Size	501050-0140	14	8.8	52	56	158
	501050-0180	18	12.2	58	73	181
NEW Size	501050-0200	20	13.4	66	85	201
	501050-0220	22	15.4	66	85	201
	501050-0230	23	16.4	66	85	201
	501050-0240	24	16.8	72	94	216
	501050-0260	26	18.8	72	94	216
	501050-0280	28	20.2	78	103	231
	501050-0300	30	22.2	78	103	231
	501050-0320	32	23.6	84	112	246
	501050-0330	33	23.6	84	112	246
	501050-0350	35	24	92	124	266
	501050-0360	36	25	92	124	266
	501050-0370	37	26	92	124	266
	501050-0380	38	27	92	124	266
	501050-0390	39	27	92	124	266
	501050-0400	40	28	92	124	266
	501050-0410	41	29	92	144	286
	Inch	**ØD (")**	**Ød1 (")**	**l1 (")**	**l2 (")**	**L (")**
	501051-0010	11/16	15/32	2-9/32	2-7/8	7-1/8
	501051-0020	13/16	39/64	2-19/32	3-11/32	7-29/32
	501051-0030	15/16	21/32	2-27/32	3-45/64	8-1/2
	501051-0040	1-1/16	47/64	3-5/64	3-45/64	9-3/32
	501051-0050	1-3/16	7/8	3-5/64	4-1/16	9-3/32
	501051-0060	1-5/16	63/64	3-5/16	4-13/32	9-11/16
	501051-0070	1-3/8	29/32	3-5/8	4-7/8	10-15/32
	501051-0080	1-7/16	31/32	3-5/8"	4-7/8	10-15/32
	501051-0090	1-1/2	1-1/32	3-5/8	4-7/8	10-15/32
	501051-0100	1-9/16	1-3/32	3-5/8	4-7/8	10-15/32
	501051-0110	1-5/8	1-5/32	3-5/8	5-43/64	11-1/4

FOR TECHNICAL DATA & USER ADVICE SEE P.120

VersaDrive® MAX Broach & Tap Set - 10pc Metric

Part No	Set contents
STC-EMID-MAX03	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, M24, M27, M30, M33, M36 VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

VersaDrive® MAX Broach & Tap Set - 10pc Inch

Part No	Set contents
STC-EMID-INMAX03	1, 1-1/16, 1-5/16, 1-3/8, 1-5/8" CarbideMax 55 TCT Broach Cutters, 1-1/16, 1-1/4, 1-3/8, 1-1/2, 1-3/4" VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Metric

Part No	Set contents
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm VersaDrive® MAX Reamers, M24, M27, M30, M33, M36 VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Inch

Part No	Set contents
STC-EMID-INMAX04	1, 1-1/16, 1-5/16, 1-3/8, 1-5/8" CarbideMax 55 TCT Broach Cutters, 15/16, 1-1/16, 1-3/16, 1-3/8, 1-7/16" VersaDrive® MAX Reamers, 1-1/16, 1-1/4, 1-3/8, 1-1/2, 1-3/4" VersaDrive® MAX ImpactaTaps, ¾" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter

FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® MAX ImpactaTaps
VERSADRIVE PATENT PROTECTED

VersaDrive® MAX taps are heavy duty, impact rated taps for use in challenging industrial applications.

Based on the bestselling ImpactaTaps, they are double hardened with a unique cutting geometry that makes them suitable for use with impact wrenches.

- *Thread new holes effectively with high-torque impact wrenches*
- *Ideal for cleaning and rethreading pre-threaded holes*
- *Used in commercial vehicle and transportation repair applications*
- *Can also be used with heavy duty, reversible magnetic drills*
- *Swarf chipbreaker action for effective use on through holes*
- *6 flute design for a faster, smoother cut*

	Metric	M Thread Size & Pitch	L (mm)	l1 (mm)
NEW Size	308610-0240	M24 x 3.0	135	45
	308610-0270	M27 x 3.0	136	48
	308610-0300	M30 x 3.5	138	48
	308610-0330	M33 x 3.5	151	51
	308610-0360	M36 x 4.0	162	57
	308610-0390	M39 x 4.0	170	60
	308610-0420	M42 x 4.5	170	60
	Inch	**M Thread Size & Pitch**	**L (")**	**l1 (")**
	308650-0105	1-1/8 x 7 UNC	4-9/16	1-7/8
	308650-0110	1-1/4 x 7 UNC	5	2
	308650-0120	1-3/8 x 6 UNC	5-3/8	2-1/4
	308650-0130	1-1/2 x 6 UNC	5-5/8	2-3/8
	308650-0140	1-3/4 x 5 UNC	6-1/4	2-5/8

FURTHER SIZES AVAILABLE ON REQUEST

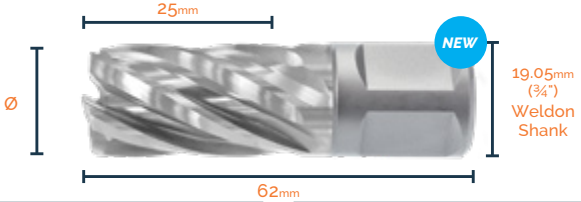
FOR TECHNICAL DATA & USER ADVICE SEE P.124

SilverMax 25 HSS Broach Cutters

STEELBOR

SilverMax HSS annular broach cutters will fit any standard magnetic drill system and are suitable for broaching metal up to 25mm thick.

- *Precision ground from a solid billet of high grade M2 HSS Tool steel*
- *Economically produced on fully-automatic CNC grinding machines*
- *Advanced tooth geometry for superior cutting performance*
- *Broach holes in metals up to 25mm thick*
- *Weldon 19.05mm (3/4") shank*

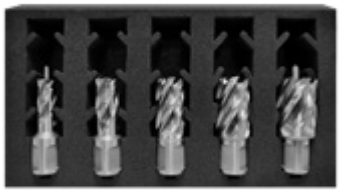


Part No	D Ø (mm)
107020-0120	12mm
107020-0130	13mm
107020-0140	14mm
107020-0150	15mm
107020-0160	16mm
107020-0170	17mm
107020-0180	18mm
107020-0190	19mm
107020-0200	20mm
107020-0210	21mm
107020-0220	22mm
107020-0230	23mm
107020-0240	24mm
107020-0250	25mm
107020-0260	26mm
107020-0270	27mm
107020-0280	28mm
107020-0290	29mm
107020-0300	30mm
107020-0310	31mm

Part No	D Ø (mm)
107020-0320	32mm
107020-0330	33mm
107020-0340	34mm
107020-0350	35mm
107020-0360	36mm
107020-0370	37mm
107020-0380	38mm
107020-0390	39mm
107020-0400	40mm
107020-0410	41mm
107020-0420	42mm
107020-0430	43mm
107020-0440	44mm
107020-0450	45mm
107020-0460	46mm
107020-0470	47mm
107020-0480	48mm
107020-0490	49mm
107020-0500	50mm

Pilot Pins

For 12-50mm cutters	ØD	Length	Unit of sale
107020P-0500	6.35mm	77mm	Pack 2
107020P-0500-P10	6.35mm	77mm	Pack 10



InsertFoam Sets

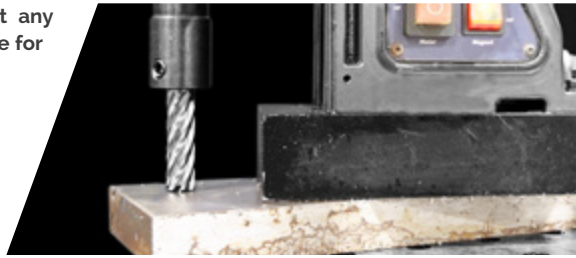
107020-SET	14, 18, 22mm + Pilot Pin
107020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

FOR TECHNICAL DATA & USER ADVICE SEE P.111

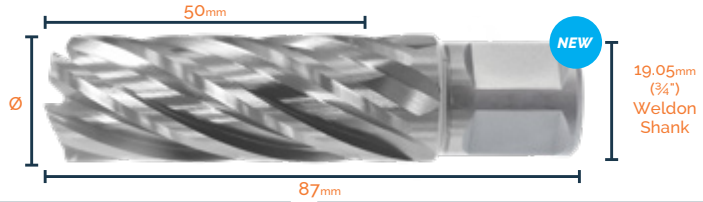
SilverMax 50 HSS Broach Cutters

STEELBOR

SilverMax HSS annular broach cutters will fit any standard magnetic drill system and are suitable for broaching metal up to 50mm thick.



- *Precision ground from a solid billet of high grade M2 HSS Tool steel*
- *Economically produced on fully-automatic CNC grinding machines*
- *Advanced tooth geometry for superior cutting performance*
- *Broach holes in metals up to 50mm thick*
- *Weldon 19.05mm (3/4") shank*

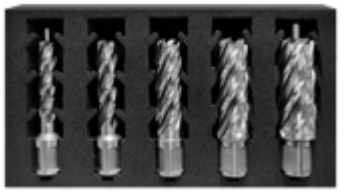


Part No	D Ø (mm)
107010-0120	12mm
107010-0130	13mm
107010-0140	14mm
107010-0150	15mm
107010-0160	16mm
107010-0170	17mm
107010-0180	18mm
107010-0190	19mm
107010-0200	20mm
107010-0210	21mm
107010-0220	22mm
107010-0230	23mm
107010-0240	24mm
107010-0250	25mm
107010-0260	26mm
107010-0270	27mm
107010-0280	28mm
107010-0290	29mm
107010-0300	30mm
107010-0310	31mm

Part No	D Ø (mm)
107010-0320	32mm
107010-0330	33mm
107010-0340	34mm
107010-0350	35mm
107010-0360	36mm
107010-0370	37mm
107010-0380	38mm
107010-0390	39mm
107010-0400	40mm
107010-0410	41mm
107010-0420	42mm
107010-0430	43mm
107010-0440	44mm
107010-0450	45mm
107010-0460	46mm
107010-0470	47mm
107010-0480	48mm
107010-0490	49mm
107010-0500	50mm

Pilot Pins

For 12-50mm cutters	ØD	Length	Unit of sale
107010P-0500	6.35mm	103mm	Pack 2
107010P-0500-P10	6.35mm	103mm	Pack 10



InsertFoam Sets

107010-SET	14, 18, 22mm + Pilot Pin
107010-5SET	12, 14, 18, 22, 26mm + 2 Pilots

FOR TECHNICAL DATA & USER ADVICE SEE P.111

CarbideMax® 40 Broach Cutter

STEELBOR

The CarbideMax® 40 Series will broach up to 35mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS cutters*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter free performance*

Part No	D Ø (mm)
108030-0120	12
108030-0130	13
108030-0140	14
108030-0150	15
108030-0160	16
108030-0170	17
108030-0180	18
108030-0190	19
108030-0200	20
108030-0210	21
108030-0220	22
108030-0230	23
108030-0240	24
108030-0250	25
108030-0260	26
108030-0270	27
108030-0280	28
108030-0290	29
108030-0300	30
108030-0310	31
108030-0320	32
108030-0330	33
108030-0340	34

Part No	D Ø (mm)
108030-0350	35
108030-0360	36
108030-0370	37
108030-0380	38
108030-0390	39
108030-0400	40
108030-0410	41
108030-0420	42
108030-0430	43
108030-0440	44
108030-0450	45
108030-0460	46
108030-0470	47
108030-0480	48
108030-0490	49
108030-0500	50
108030-0550	55
108030-0600	60
108030-0650	65
108030-0700	70
108030-0750	75
108030-0800	80

Pilot Pins

For 12-17mm cutters	ØD	Length	Unit of sale
108030P-0170	6.34mm	90mm	Pack 2
108030P-0170-P10	6.34mm	90mm	Pack 10
For 18-80mm cutters			
108030P-0600	7.98mm	90mm	Pack 2
108030P-0600-P10	7.98mm	90mm	Pack 10

InsertFoam Sets

108030-SET	14, 18, 22mm + 2 Pilot Pins
108030-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

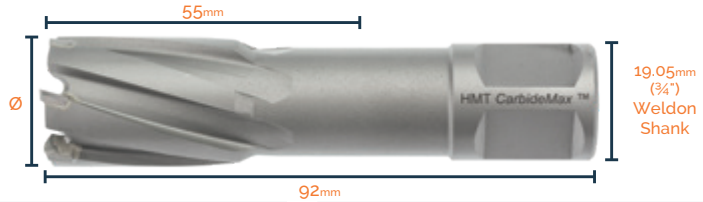
FOR TECHNICAL DATA & USER ADVICE SEE P.113

CarbideMax® 55 Broach Cutter

STEELBOR

The CarbideMax® 55 Series will broach up to 50mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS cutters*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter free performance*



Part No	D Ø (mm)
108020-0120	12
108020-0130	13
108020-0140	14
108020-0150	15
108020-0160	16
108020-0170	17
108020-0175	17.5
108020-0180	18
108020-0190	19
108020-0200	20
108020-0210	21
108020-0220	22
108020-0230	23
108020-0240	24
108020-0250	25
108020-0260	26
108020-0265	26.5
108020-0270	27
108020-0280	28
108020-0290	29
108020-0300	30
108020-0310	31
108020-0320	32
108020-0330	33
108020-0340	34

Part No	D Ø (mm)
108020-0350	35
108020-0360	36
108020-0370	37
108020-0380	38
108020-0390	39
108020-0400	40
108020-0410	41
108020-0420	42
108020-0430	43
108020-0440	44
108020-0450	45
108020-0460	46
108020-0470	47
108020-0480	48
108020-0490	49
108020-0500	50
108020-0510	51
108020-0520	52
108020-0530	53
108020-0540	54
108020-0550	55
108020-0560	56
108020-0570	57
108020-0580	58
108020-0590	59
108020-0600	60

Pilot Pins

For 12-17mm cutters	ØD	Length	Unit of sale
108020P-0170	6.34mm	106mm	Pack 2
108020P-0170-P10	6.34mm	106mm	Pack 10
For 17.5-60mm cutters			
108020P-0600	7.98mm	106mm	Pack 2
108020P-0600-P10	7.98mm	106mm	Pack 10

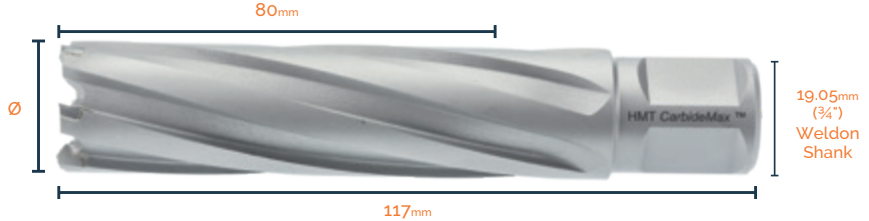
InsertFoam Sets

108020-SET	14, 18, 22mm + 2 Pilot Pins
108020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

FOR TECHNICAL DATA & USER ADVICE SEE P.113

The CarbideMax® 80 Series will broach up to 75mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS cutters*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter free performance*



Part No	D Ø (mm)
108010-0120	12
108010-0140	14
108010-0160	16
108010-0180	18
108010-0200	20
108010-0220	22
108010-0240	24
108010-0260	26
108010-0280	28
108010-0300	30
108010-0320	32

Part No	D Ø (mm)
108010-0330	33
108010-0340	34
108010-0350	35
108010-0360	36
108010-0380	38
108010-0390	39
108010-0400	40
108010-0420	42
108010-0450	45
108010-0500	50

Pilot Pins

For 12-17mm cutters	ØD	Length	Unit of sale
108010P-0170	6.34mm	130mm	Pack 2
For 18-60mm cutters			
108010P-0600	7.98mm	130mm	Pack 2

InsertFoam Sets

108010-SET	18, 22, 24, 26, 28, 30mm + 2 Pilots

FOR TECHNICAL DATA & USER ADVICE SEE P.113

The CarbideMax® 110 Series will broach up to 105mm thickness of metal. Individually brazed cutting teeth are made from Tungsten Carbide capable of drilling through the toughest steels.

- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS cutters*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter free performance*

Part No	D Ø (mm)
108040-0140	14
108040-0160	16
108040-0180	18
108040-0190	19
108040-0200	20
108040-0210	21
108040-0220	22
108040-0230	23
108040-0240	24
108040-0250	25
108040-0260	26
108040-0270	27
108040-0280	28
108040-0290	29
108040-0300	30
108040-0320	32
108040-0330	33
108040-0340	34
108040-0350	35
108040-0360	36
108040-0380	38

Part No	D Ø (mm)
108040-0390	39
108040-0400	40
108040-0410	41
108040-0420	42
108040-0430	43
108040-0440	44
108040-0450	45
108040-0460	46
108040-0470	47
108040-0480	48
108040-0490	49
108040-0500	50
108040-0510	51
108040-0520	52
108040-0540	54
108040-0550	55
108040-0560	56
108040-0570	57
108040-0580	58
108040-0590	59
108040-0600	60

Pilot Pins

For 14-17mm cutters	ØD	Length	Unit of sale
108040P-0171	6.34mm	155mm	Pack 2
For 18-60mm cutters			
108040P-0600	7.98mm	155mm	Pack 2

InsertFoam Sets

108040-SET	14, 18, 22, 24, 26mm + 2 Pilots

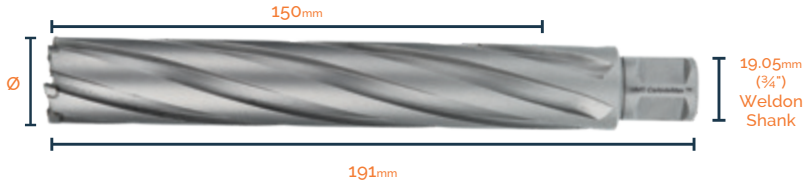
FOR TECHNICAL DATA & USER ADVICE SEE P.113

Extreme drilling depth with CarbideMax ® Extra Long.

For the most extreme drilling depths the CarbideMax ® range offers 150mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any Magnet Drill with sufficient stroke.

Drill matching holes through box or H section in a single pass



Part No.	D Ø (mm)
108045-0180	18
108045-0200	20
108045-0220	22
108045-0240	24
108045-0260	26
108045-0280	28
108045-0300	30
108045-0320	32
108045-0330	33
108045-0360	36
108045-0390	39
108045-0500	50

Pilot Pins

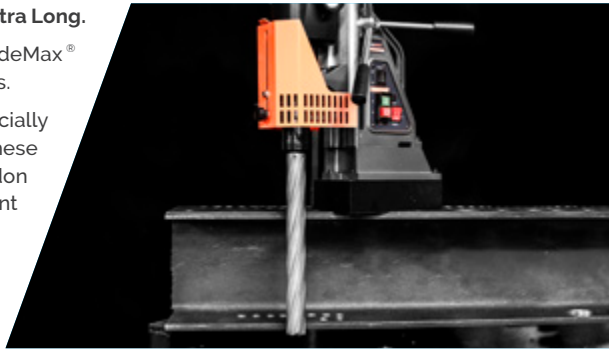
Part No.	D Ø	Length	Unit of sale
108045P-0600	7.98mm	205mm	Pack 2

FOR TECHNICAL DATA & USER ADVICE SEE P.113

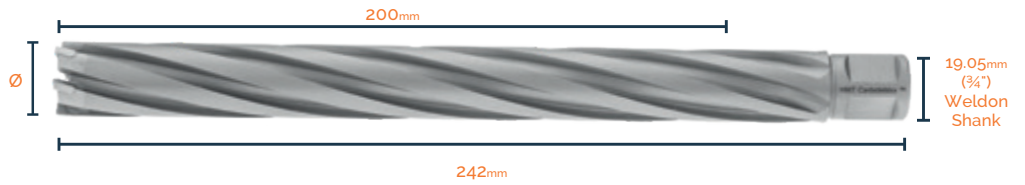
Extreme drilling depth with CarbideMax ® Extra Long.

For the most extreme drilling depths the CarbideMax ® range offers 200mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any Magnet Drill with sufficient stroke.



Drill matching holes through box or H section in a single pass



Part No.	D Ø (mm)
108050-0180	18
108050-0200	20
108050-0220	22
108050-0240	24
108050-0260	26
108050-0300	30
108050-0320	32
108050-0330	33
108050-0360	36
108050-0390	39
108050-0420	42
108050-0450	45
108050-0500	50

Pilot Pins

Part No.	D Ø	Length	Unit of sale
108050P-0600-2P	7.98mm	255mm	Pack 2

When using the 2 part pilot pin and drilling material greater than 50mm thick, when the pilot pin reaches the extent to which it can retract inside the Magnet Drill arbor, the bottom section of the pilot can be removed to allow the hole to be completed without removing the pilot pin from the cutter.

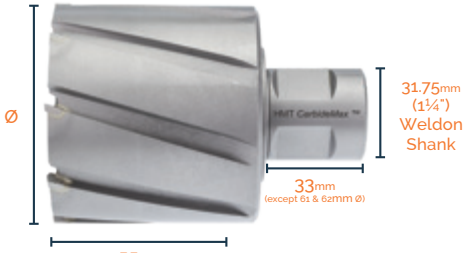
FOR TECHNICAL DATA & USER ADVICE SEE P.113

Ultra large diameter drilling with CarbideMax® XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL® range offers cutters from 61mm up to 150mm diameter with a 55mm cutting depth.

These high quality TCT cutters have a reinforced 31.75mm diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 31.75mm shank for use with standard 19.05mm weldon shank Magnet Drills.



Part No.	D Ø (mm)
108020-0610	61
108020-0620	62
108020-0630	63
108020-0640	64
108020-0650	65
108020-0660	66
108020-0670	67
108020-0680	68
108020-0690	69
108020-0700	70
108020-0750	75
108020-0800	80
108020-0850	85
108020-0900	90

Part No.	D Ø (mm)
108020-0950	95
108020-1000	100
108020-1050	105
108020-1100	110
108020-1150	115
108020-1200	120
108020-1250	125
108020-1270	127
108020-1300	130
108020-1350	135
108020-1400	140
108020-1450	145
108020-1500	150

31.75mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 31.75mm shank cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-55	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 55mm cutters

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"
108020P-1500	CarbideMax55 Pilot Pin, 61-150mm, Pk 2	

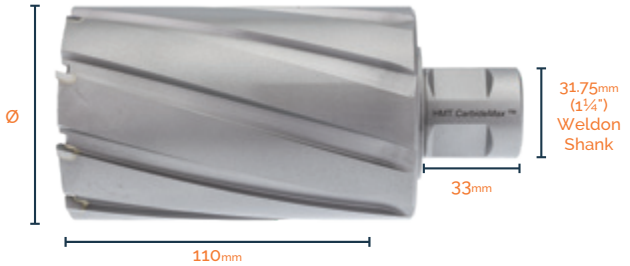
FOR TECHNICAL DATA & USER ADVICE SEE P.113

Ultra large diameter drilling with CarbideMax® XL.

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL® range offers cutters from 61mm up to 200mm diameter with a 110mm cutting depth.

These high quality TCT cutters have a reinforced 31.75mm diameter shank to withstand the high levels of torque generated.

Adapters are available to convert the 31.75mm shank for use with standard 19.05mm weldon shank Magnet Drills.



Part No.	ØD (mm)
108040-0610	61
108040-0620	62
108040-0630	63
108040-0640	64
108040-0650	65
108040-0660	66
108040-0670	67
108040-0680	68
108040-0690	69
108040-0700	70
108040-0730	73
108040-0750	75
108040-0800	80
108040-0850	85
108040-0900	90
108040-0950	95

Part No.	ØD (mm)
108040-1000	100
108040-1050	105
108040-1100	110
108040-1150	115
108040-1200	120
108040-1250	125
108040-1300	130
108040-1350	135
108040-1400	140
108040-1500	150
108040-1600	160
108040-1700	170
108040-1800	180
108040-1900	190
108040-2000	200

31.75mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 31.75mm shank cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-110	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 110mm cutters

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"
108040P-1500-2P	CarbideMax110 2 Piece Pilot Pin 61-200mm, Pk2	

FOR TECHNICAL DATA & USER ADVICE SEE P.113

Weldon Shank Twist Drill 4pc Set

Part No	Set contents
201070-SET	6, 8, 10, 12mm

Weldon Shank Tapping Size Twist Drill 4pc Set

Part No	Set contents
201070-TSET	5, 6.8, 8.5, 10.2mm

Weldon Shank Twist Drill 5pc Set - Inch Sizes

Part No	Set contents
201075-SET1	1/4, 5/16, 3/8, 7/16, 1/2"

Broaching Starter Set HSS Short Series 6 - 26mm

Part No	Set contents
107020-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm SilverMax 25 HSS Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

Broaching Starter Set HSS Long Series 6 - 26mm

Part No	Set contents
107010-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm SilverMax 50 HSS Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

Broaching Starter Set TCT 6 - 26mm

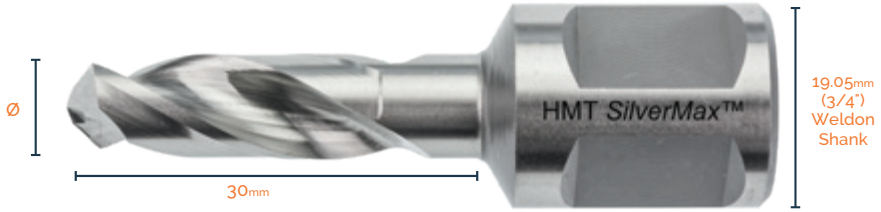
Part No	Set contents
108030-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm CarbideMax 40 TCT Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

SilverMax Weldon Shank Twist Drill Bits STEELBOR

HSS-XE twist drill bits with integrated Weldon shank for simple and accurate drilling in steel and fast tool changing. Removes the need for using a separate drill chuck in a Magnet Drill.

Where drilling smaller holes in thick steel has been a long and time consuming job in the past, fitting the SilverMax Weldon Shank Twist Drills into a Magnet Drill can suddenly make the job far quicker and safer than struggling with a Pistol Drill and jobber bits.

- *Integrated weldon shank*
- *Simple & accurate drilling in steel*
- *No need for a tool chuck when using a Magnet Drill*
- *Fast tool changing*
- *Quicker and safer than struggling with a Pistol Drill*
- *Fits 19.05mm arbors - use with any standard mag drill*



Metric	D Ø (mm)	Tap Size
20170-0050	5	M6
20170-0060	6	-
20170-0068	6.8	M8
20170-0070	7	-
20170-0080	8	-
20170-0085	8.5	M10
20170-0090	9	-
20170-0100	10	-
20170-0102	10.2	M12
20170-0110	11	-
20170-0120	12	-
Inch	**D Ø (")**	**Tap Size**
201075-0030	1/4	-
201075-0050	5/16	3/8"
201075-0060	3/8	-
201075-0070	7/16	-
201075-0080	1/2	-

CarbideMax® ULTRA 55

CarbideMax® Ultra cutters are specifically designed for long-life performance in the toughest broaching jobs on the planet.

- *Individually brazed, highest quality carbide cutting teeth*
- *ULTRA coated for optimum performance & lifespan*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter free performance when used correctly*

Part No.	ØD (mm)
108070-0160	16
108070-0170	17
108070-0175	17.5
108070-0180	18
108070-0190	19
108070-0200	20
108070-0210	21
108070-0220	22
108070-0230	23
108070-0240	24
108070-0250	25
108070-0260	26
108070-0265	26.5
108070-0270	27
108070-0280	28
108070-0290	29
108070-0300	30
108070-0310	31
108070-0320	32
108070-0330	33
108070-0340	34
108070-0350	35
108070-0360	36
108070-0370	37

Part No.	ØD (mm)
108070-0380	38
108070-0390	39
108070-0400	40
108070-0410	41
108070-0420	42
108070-0430	43
108070-0440	44
108070-0450	45
108070-0460	46
108070-0470	47
108070-0480	48
108070-0490	49
108070-0500	50
108070-0510	51
108070-0520	52
108070-0530	53
108070-0540	54
108070-0550	55
108070-0560	56
108070-0570	57
108070-0580	58
108070-0590	59
108070-0600	60

Pilot Pins			
For 12-17mm cutters	ØD	Length	Unit of sale
108020P-0170	6.34mm	103mm	Pack 2
For 18-60mm cutters			
108020P-0600	7.98mm	103mm	Pack 2

InsertFoam Sets	
108070-SET2	18, 20, 22, 24, 26mm + 2 Pilots

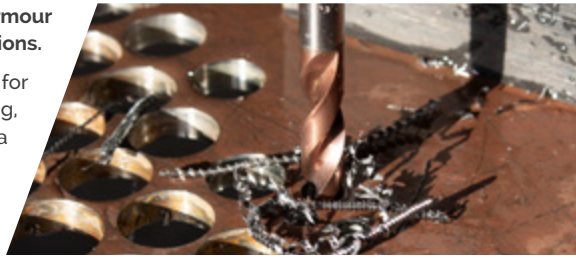
FOR TECHNICAL DATA & USER ADVICE SEE P.128

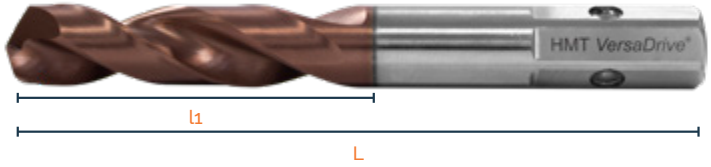
ULTRA Coated Twist Drill Bits

VersaDrive® Ultra Drill Bits - for Wear Plate, Armour Plate and RailTrack signalling/bonding applications.

The new VersaDrive® Ultra Drill bits are designed for the toughest applications in the mining, quarrying, and military engineering market. VersaDrive Ultra Drill bits are also suitable for use drilling holes for bonding wires in track circuit signalling / bonding and wheel detector applications.

High grade tool steel combined with the specialist high-performance Ultra coating provides the ability to drill the toughest materials.





Metric	ØD (mm)	l1 (mm)	L (mm)
209020-0040	4	22	55
209020-0050	5	26	62
209020-0060	6	28	66
209020-0070	7	34	74
209020-0080	8	37	79
209020-0090	9	40	84
209020-0100	10	43	89
209020-0110	11	47	95
209020-0120	12	51	102
209020-0130	13	51	102
209020-0140	14	54	107
Inch	**ØD (")**	**l1 (")**	**L (")**
209021-0010	1/4	1-3/8	2-1/2
209020-0070	9/32	1-11/32	2-15/16
209021-0020	5/16	1-5/8	2-13/16
209021-0030	3/8	1-13/16	3-1/8
209021-0040	1/2	2-1/4	3-3/4
209021-0050	9/16	2-43/64	4-11/16

InsertFoam Sets	
209020-SET1	6, 8, 10, 12, 14mm
209020-SET2	4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14mm
209021-SET1	1/4, 5/16, 3/8, 1/2, 9/16"

FOR TECHNICAL DATA & USER ADVICE SEE P.128

STAKIT® V18-900 Install SiteKit

The V18-900 Install SiteKit is a portable powerhouse of compact, lightweight and easily transportable drilling and fastening solutions.

The new cordless 18v V18-900 Impact Wrench has a 1/2" drive, 900Nm of torque and is rated for metal drilling, threading and reaming as well as for performing standard bolt fastening and unfastening operations.

Working seamlessly with the V18-900, the accompanying VersaDrive® installation kit gives a bestselling selection of cutting tools to overcome the most frequently encountered drilling and hole modification challenges. Drill new holes with VersaDrive® TurboTips and TCT HoleCutters, enlarge existing holes with the unique ImpactaStep Cutter and align connection holes with VersaDrive® Impact Reamers before threading quickly and easily with VersaDrive® ImpactaTaps.

The wheeled sitecart gives additional storage and helps transport everything around site.

Contents:

1 x VersaDrive® V18-900 1/2" Impact Wrench (p.75)
(Supplied in ***STAKIT***® Mid case, with 2 x 4.0Ah batteries + compact charger & VersaDrive® Rapid-Lock Impact Wrench Adapter)

1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)

1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-V189INS-2B	***STAKIT***® V18-900 Install SiteKit

VersaDrive® V18-900 Impact Wrench

The VersaDrive® V18-900 is a powerful and compact brushless impact wrench, rated for metal drilling, threading, and hole enlargement work alongside standard bolt tightening & loosening.

Quickly and safely create and modify connection holes in heavy metal components. Optimised for use with the VersaDrive® range of cutting tools.

- *Compatible with the Makita LXT 18V battery platform*
- *Supplied with VersaDrive® Rapid-Lock adapter*
- *3 Impact settings plus Nutbuster mode*
- *Powerful & efficient brushless motor*
- *Rapid airflow cooling system*
- *Twin LED spotlights for bright, shadow-free illumination*

TECHNICAL SPECIFICATIONS

ANVIL/DRIVE SIZE	½"
NO LOAD SPEED (RPM)	1500 / 2000 / 2500
IMPACT MODES	3
IMPACT TORQUE	400 / 630 / 900Nm
IMPACT RATE (BPM)	1600 / 2200/ 2700
DRILLING/FASTENING TORQUE	900 Nm
NUT BUSTING MODES	1
NUT BUSTING TORQUE	1180 Nm
WEIGHT (w/o battery)	1.9kg
WEIGHT (with 4Ah battery)	2.5kg
WIDTH	170mm
HEIGHT (w/o battery)	225mm
HEIGHT (with battery)	272mm
VOLTAGE	18v
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & MAKITA LXT

Part No	Contents
808010-010	VersaDrive® 1/2" Impact Wrench Body only Inc. VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter
808010-025	VersaDrive® 1/2" Impact Wrench 4.0Ah Kit Inc. Body + 2 x 4.0Ah Batteries + Compact Charger + VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter
808010-020	VersaDrive® 1/2" Impact Wrench 9.0Ah Kit Inc. Body + 2 x 9.0Ah Batteries + Compact Charger + VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter
809010-040	18v 4.0Ah Battery
809010-090	18v 9.0Ah Battery
809020-020	18v Compact Battery Charger (170 x 130 x 86mm)

All versions supplied with VersaDrive® Rapid-Lock adapter
Kits also supplied with STAKIT® EMID-100 case, 2 batteries and charger

The RTV36 Install SiteKit offers compact, lightweight, and easily transportable drilling solutions, perfect for sites without power or with tight access.

The new RTV36 runs on an 18V, Makita LXT compatible battery platform that provides variable speed broaching up to 36mm, drilling up to 13mm and countersinking up to 32mm.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

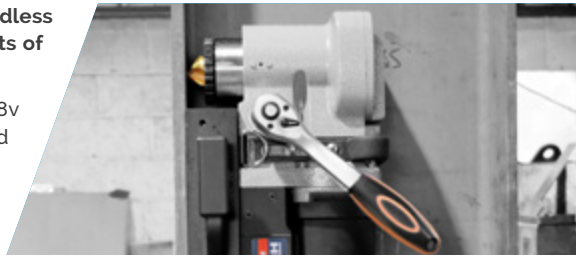
Contents:

1 x HMT RTV36 Cordless Low Profile Mag Drill (p.77)
(Supplied in ***STAKIT***® Base 200 case, with 2 x 9.0Ah batteries + compact charger)
1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)
1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-RTV36INS-2B	***STAKIT***® RTV36 Install Sitekit

The HMT RTV36 offers the flexibility of a cordless machine coupled with the accessibility benefits of a low profile machine.

Fitting into any gap greater than 178mm, the 18v battery powered RTV36 gives high-powered broaching and drilling solutions for jobsites with restricted access requirements or without generators or electrical connections.

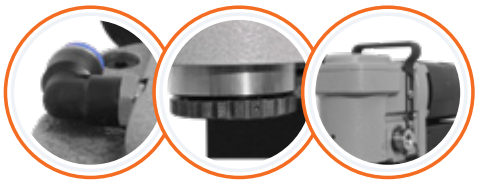


- *Compatible with Makita LXT batteries*
- *Quick release weldon arbor for keyless use*
- *Up to 49 x 18mm holes per 9.0Ah battery (10mm plate)*
- *Ratchet handle can be used on both sides of machine*
- *36mm diameter TCT broaching capacity*
- *Fits into spaces 178mm or greater*
- *Max 40mm cutting depth*

TECHNICAL SPECIFICATIONS

CUTTER SIZE RANGE	12 -36mm
MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	32mm
LENGTH (Inc 4Ah battery)	385mm
WIDTH	140mm
HEIGHT	177mm
WEIGHT	11.3 kg
STROKE	40mm
MAGNETIC FORCE	650 kg
MOTOR POWER	1000 W
TOTAL POWER	1000 W
SPEED RPM (No Load)	270 - 430
SPINDLE WELDON	19.05mm (¾")
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY CAPACITY	18V 4Ah / 9Ah Li-ion

Part No	Contents
805046-010	RTV36 Magnet Drill - Bare Machine
805046-025	RTV36 Magnet Drill Kit Inc. 2 x 4Ah Batteries + Charger
805046-020	RTV36 Magnet Drill Kit Inc. 2 x 9Ah Batteries + Charger
809010-040	18v 4.0Ah Battery
809010-090	18v 9.0Ah Battery
809020-020	18v Compact Battery Charger (170 x 130 x 86mm)



Kit supplied in STAKIT® Base 200 case with 2 batteries, charger, hex keys, restraint strap and ratchet.

The V36 18V Install SiteKit is the ultimate lightweight portable drilling package.

The new Cordless V36 18V magdrill install sitekit offers the ultimate jobsite freedom. Operate away from mains power. Compatible with the Makita LXT battery platform. Broaching capacity to 36mm, drilling to 12mm.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

1 x VersaDrive® V36 Cordless Magnet Drill (p.79)
(Supplied in ***STAKIT***® Base 200 case, with 2 x 9.0Ah batteries + charger)

1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)

1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-V36INS-2B	***STAKIT***® V36-18 Install SiteKit - c/w 2x9Ah Batteries & Charger

Increase your jobsite solutions with this unique cordless magdrill, the most compact & lightweight unit in its class. Market-leading 140mm stroke which is ideal for extra-long broach cutters and VersaDrive® cutting tools.

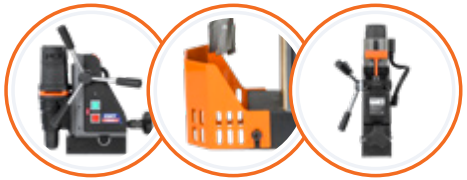
The 18V battery pack is compatible with the entire range of Makita LXT powertools.

Permanent magnet provides safe & powerful hold, even on thin materials.

- *Compatible with Makita LXT batteries*
- *Up to 49 x 18mm holes per charge (10mm plate + 9.0Ah battery)*
- *Weighs just 9.8kg for easy handling*
- *Available with **STAKIT**® kit options or Bare machine*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	10 - 25mm
REAMING	N/A
TAPPING	N/A
LENGTH	325mm
WIDTH (Inc Handles)	184mm
HEIGHT (Min-Max)	275 - 415mm
STROKE	140mm
WEIGHT	9.8 kg
MAGNET (L X W)	157 x 85mm
MAGNETIC FORCE	650 kgs
MOTOR POWER	1000w
TOTAL POWER	1000w
SPEED RPM (No Load)	530
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY CAPACITY	18V 4Ah / 9Ah Li-ion



Part No	Contents
805036-010	V36-18 Magnet Drill - Bare Machine
805036-025	V36-18 Magnet Drill Kit Inc. 2 x 4Ah Batteries + Charger
805036-020	V36-18 Magnet Drill Kit Inc. 2 x 9Ah Batteries + Charger
809010-040	18v 4.0Ah Battery
809010-090	18v 9.0Ah Battery
809020-010	18v Battery Charger (190 x 155 x 70mm)

*Kit supplied in **STAKIT**® Base 200 case, with Rapid-Lock VersaDrive® adapter, 2 batteries & battery charger*

The V35 Install SiteKit is a lightweight package of portable drilling solutions.

The mains powered V35 magdrill provides single speed, lightweight site drilling. Broach up to 35mm diameter, Drilling to 12mm, Countersinking to 25mm.

The VersaDrive® installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

1 x VersaDrive® V35 Magnet Drill (p.81)
(Supplied in ***STAKIT***® Base 200 case)
1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)
1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-V35INS-110	***STAKIT***® V35 Install SiteKit - 110v
STC-KIT-V35INS-230	***STAKIT***® V35 Install SiteKit - 230v

The HMT V35 is the first UK Built portable drilling machine designed for high-performance, low-maintenance, industrial quality drilling up to 35mm diameter.

With a 140mm stroke, maximum cutter length of 110mm and seamless integration with the VersaDrive® modular cutting system, it offers the most flexibility of any compact Magnet Drill on the market.

- *140mm Stroke*
- *110mm Cutting Depth*
- *Only 9.5kg*
- *Countersinking to 25mm*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	35mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	12mm
COUNTERSINKING	25mm
REAMING	N/A
TAPPING	N/A
LENGTH	220mm
WIDTH (Inc Handles)	173mm
HEIGHT (Min-Max)	305 - 445mm
STROKE	140mm
WEIGHT	9.5 kg
MAGNET (L X W)	160 x 80mm
MAGNETIC FORCE	1000 kgs
MOTOR POWER	850w
TOTAL POWER	900w
SPEED RPM (No Load)	750
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850035-110	V35 Magnetic Drill Kit 110V
850035-230	V35 Magnetic Drill Kit 230V

*Supplied in **STAKIT**® Base 200 case, with Rapid-Lock VersaDrive® adapter*

The V50 Install SiteKit provides lightweight portable drilling solutions to get the job done onsite or in the workshop.

The new V50 magdrill offers high power operation from a lightweight body with two speed settings for rapid drilling, cutting and reaming alongside controlled, accurate countersinking.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

1 x VersaDrive® V50 Magnet Drill (p.83)
(Supplied in ***STAKIT***® Base 200 case)
1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)
1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-V50INS-110	***STAKIT***® V50 Install SiteKit - 110v
STC-KIT-V50INS-230	***STAKIT***® V50 Install SiteKit - 230v

Market leading power-to-weight ratio. This powerful 1200w, 2 speed magnetic drill is designed for all day drilling duties

The market-leading 160mm stroke length is ideal for extra-long broach cutters and VersaDrive® cutting tools.

Supplied with ***STAKIT***® sitecase, accessory pack & VersaDrive® weldon adapter as standard.

- *High power to weight 2 speed machine*
- *Perfect cutting up to 55mm diameter (TCT)*
- *160mm stroke for long cutters and reamers*
- *Countersinking to 32mm*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	55mm
MAX HSS CUTTER CAPACITY	50mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	1 - 18mm
COUNTERSINKING	32mm
REAMING	18mm
TAPPING	N/A
LENGTH	270mm
WIDTH (Inc Handles)	165mm
HEIGHT (Min-Max)	400 - 560mm
STROKE	160mm
WEIGHT	12.7 kg
MAGNET (L X W)	167 x 80 x 50mm
MAGNETIC FORCE	1250 kgs
MOTOR POWER	1200w
SPEED RPM (No Load)	400 / 720
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Yrs (When registered)

Part No	Contents
850050-110	V50 Magnetic Drill Kit 110V
850050-230	V50 Magnetic Drill Kit 230V

*Supplied in **STAKIT**® Base 200 case, with Rapid-Lock VersaDrive® adapter*

The V60T Install SiteKit is the top-of-the-range SiteKit, offering portable machining capacity that is unrivalled in the market.

The mains powered V60T reversible magdrill has 2 speeds plus dial adjustable torque and speed. This gives tapping capacity to M20, broaching to 60mm diameter (TCT), drilling & reaming to 20mm & countesinking to 40mm.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

1 x VersaDrive® V60T Magnet Drill (p.85)
(Supplied in ***STAKIT***® Base 200 case)
1 x ***STAKIT***® Site Installation Kit (p.107)
(supplied in ***STAKIT***® Mid Case)
1 x ***STAKIT***® SiteCart Compact (p.106)

Part No	Product
STC-KIT-V60INS-110	***STAKIT***® V60T Install SiteKit - 110v
STC-KIT-V60INS-230	***STAKIT***® V60T Install SiteKit - 230v

The HMT V60T is designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit.

The powerful forward/reverse, variable speed, Eibenstock motor will tap holes up to M20 diameter. The V60T is also fully rated for reaming & countersinking.

Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability. Supplied with a coolant fed arbor.

- *All-day broaching capability up to 60mm diameter*
- *Forward and reverse*
- *Variable speed motor*
- *220mm Stroke*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	60mm
MAX HSS CUTTER CAPACITY	55mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
STROKE	220mm
LENGTH	315mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	385 - 605mm
WEIGHT	18kg
MAGNET (L X W)	200 x 100mm
MAGNETIC FORCE	1750kg
MOTOR POWER	1150W
TOTAL POWER	1270W
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19.05mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850060-P-110	V60T Magnetic Drill Kit - 110v
850060-P-230	V60T Magnetic Drill Kit - 230v

*Supplied with **STAKIT**® case, VersaDrive® Rapid-Lock adapter, handles, restraint strap and heavy duty metal guard.*

HMT V85T Magnet Drill

STEELBOR

The HMT V85T combines light weight portability with high power, all-day broaching capability up to 85mm diameter.

The powerful forward/reverse, variable speed, Eibenstock motor will tap holes up to M27 diameter. The V85T is also fully rated for reaming and countersinking. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability. Supplied with a coolant fed arbor.

- *All-day broaching capability up to 80mm diameter*
- *Forward and reverse*
- *Variable speed motor*
- *Variable Torque control*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	85mm
MAX HSS CUTTER CAPACITY	75mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	27mm
COUNTERSINKING	55mm
REAMING	24mm
MAX TAP CAPACITY	M27
LENGTH	325mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	425 - 645mm
STROKE	220mm
WEIGHT	20.5 kg
MAGNET (L X W)	200 x 100mm
MAGNETIC FORCE	1750 kgs
MOTOR POWER	1800w
TOTAL POWER	1920w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19.05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850085-P-110	V85T Magnetic Drill Kit - 110v
850085-P-230	V85T Magnetic Drill Kit - 230v

Supplied with case, VersaDrive® Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

HMT V100T Magnet Drill

STEELBOR

The HMT V100T offers high performance, low maintenance industrial drilling with an all-day broaching capacity up to 100mm diameter.

Its powerful forward /reverse, variable speed, geared Eibenstock motor will tap holes up to M30 and can be used with the VersaDrive® blind hole tapping system up to M30. The V100T is also fully rated for reaming and countersinking.

- *All-day broaching capability up to 100mm diameter*
- *Forward and reverse*
- *Variable speed motor*
- *220mm Stroke*
- *Supplied with a coolant fed arbor*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	100mm
MAX HSS CUTTER CAPACITY	90mm
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	55mm
REAMING	26mm
MAX TAP CAPACITY	M30
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	450 - 730mm
STROKE	280mm
WEIGHT	24.5 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC FORCE	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19.05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850100-P-110	V100T Magnetic Drill Kit - 110v
850100-P-230	V100T Magnetic Drill Kit - 230v

Supplied with case, VersaDrive® Rapid-Lock adapter, handles, restraint strap and heavy duty metal guard.

HMT V125T Magnet Drill

STEELBOR

The HMT V125T offers heavy duty, portable drilling up to 125mm diameter.

An all day broaching capacity combines with powerful tapping capability up to M32 for both through & blind holes thanks to a powerful forward/reverse, variable speed, multi-geared Eibenstock motor. Advanced British electromagnets also provide enhanced magnet hold for exceptional safety & stability.

- *All-day broaching capability up to 125mm diameter*
- *Forward and reverse*
- *Variable speed motor*
- *Variable Torque control*
- *Supplied with a coolant fed arbor*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	125mm
MAX HSS CUTTER CAPACITY	110mm
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	60mm
REAMING	32mm
MAX TAP CAPACITY	M32
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	470 - 750mm
STROKE	280mm
WEIGHT	25 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC FORCE	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60-140 / 100-220 / 140-310 / 210-490
SPINDLE	MT3
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850125-P-110	V125T Magnetic Drill Kit - 110v
850125-P-230	V125T Magnetic Drill Kit - 230v

Supplied with case, VersaDrive® Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

HMT RTQ40 Low Profile Magnet Drill

STEELBOR

The HMT RTQ40 is a low profile Magnet Drill for tight access applications.

Designed to fit into any gap greater than 180mm it is suitable for use with any standard broaching cutters but is optimised to work with the high-performance CarbideMax 40 cutters. The ratchet drive can be mounted on either side of the machine and its powerful motor and magnet give excellent stability.

- *Fits into spaces 180mm or greater*
- *Quick release weldon arbor for keyless use*
- *Ratchet handle can be used on both sides of machine*
- *40mm diameter broaching capacity*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	40mm
MAX HSS CUTTER CAPACITY	36mm
TWIST DRILL CAPACITY	13mm
COUNTERSINKING	32mm
LENGTH	310mm
WIDTH	135mm
HEIGHT	180mm
STROKE	40mm
WEIGHT	10.8kg
MAGNET (L x W x H)	160x80x37mm
MAGNETIC FORCE	1200kg
MOTOR POWER	1050W
TOTAL POWER	1100W
SPEED RPM (No Load)	700RPM
SPINDLE	Quick change 19.05mm 3/4" Weldon arbor for all standard broaching cutters
COOLANT SYSTEM	Optional Extra
WARRANTY	1 Year

Part No	Contents
803084-110	RTQ40 Magnetic Drill 110v
803084-230	RTQ40 Magnetic Drill 230v

Supplied in STAKIT® Base 200 case with hex keys, restraint strap and ratchet.

HMT V35 Pipe Magnet Drill

STEELBOR

The V35 Pipe Magnet Drill offers all the advantages of the standard V35 with the added benefit of a pipe compatible magnetic base.

Two switched permanent magnets are secured to swivelling mounting points and can be positioned as needed, allowing use on tubes and piping with a minimum diameter of 76mm. This also allows use on many contoured surfaces and internal use on large pipes.

- *Use on both contoured and flat surfaces*
- *Two switched permanent magnets with individual swivel action*
- *Supplied with coolant fed arbor*
- *Use on pipe/tubing internally and externally as needed (min diameter 76.2mm)*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	35mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	12mm
COUNTERSINKING	25mm
REAMING	N/A
MAX TAP CAPACITY	N/A
STROKE	140mm
LENGTH	275mm
WIDTH (Inc Handles)	185mm
HEIGHT (Min-Max)	330 - 470mm
WEIGHT	10.5kg
MAGNET (L X W X H)	187 x 165 x 83mm
MAGNETIC FORCE	532kg
MOTOR POWER	850W
TOTAL POWER	900W
SPEED RPM (No Load)	750
SPINDLE	3/4" Weldon
ARBOR	Integral 3/4" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850035-T-110	V35 PIPE Twin Magnet Drill Kit 110V
850035-T-230	V35 PIPE Twin Magnet Drill Kit 230V

*Supplied with **STAKIT**® case, VersaDrive® Rapid-Lock adapter, handles, restraint strap & heavy duty metal guard*

HMT V60T Pipe Magnet Drill

STEELBOR

The V60T Pipe Magnet Drill offers all the advantages of the standard V60T with the added benefit of a pipe compatible magnetic base.

Two switched permanent magnets are secured to swivelling mounting points and can be positioned as needed, allowing use on tubes and piping with a minimum diameter of 80mm. This also allows use on many contoured surfaces and internal use on large pipes.

- *Use on both contoured and flat surfaces*
- *Two switched permanent magnets with individual swivel action*
- *Supplied with coolant fed arbor*
- *Use on pipe/tubing internally and externally as needed (min diameter 80mm)*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	60mm
MAX HSS CUTTER CAPACITY	55mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
LENGTH	320mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	415 - 635mm
STROKE	220mm
WEIGHT	19 kg
MAGNET (L X W)	266 x 239 x 82mm
MAGNETIC FORCE	860kg
MOTOR POWER	1150w
TOTAL POWER	1270w
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19.05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2 Year (When registered)

Part No	Contents
850060-T-110	V60T PIPE Twin Magnet Drill Kit 110v
850060-T-230	V60T PIPE Twin Magnet Drill Kit 230v

Supplied with case, VersaDrive® Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap & heavy duty metal guard

The HMT MAX150T offers immense capacity for portable drilling, tapping and countersinking.

Designed for heavy duty, industrial applications, it tackles the most challenging metalworking tasks with its 2400W, high torque, variable speed, reversible motor.

Broach up to 150mm diameter, drill or ream up to 46mm and countersink up to 90mm.

- *4 speed gearbox for low speed, high torque applications*
- *Lifting eyes for safe positioning of the unit*
- *Morse Taper 4 spindle with XL Weldon Arbor supplied in kit*
- *Emergency stop function and safety guard included*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	150mm
MAX HSS CUTTER CAPACITY	125mm
MAX CUTTER LENGTH	200mm
MAX TWIST DRILL	46mm
MAX TAPPING SIZE	M42
COUNTERSINKING	90mm
REAMING	46mm
LENGTH	390mm
WIDTH INC HANDLES	210mm
HEIGHT	630-930mm
STROKE	300mm
WEIGHT	42kg
MAGNET SIZE	270x135x70mm
MAGNETIC FORCE	2100kg
POWER CONSUMPTION	2,400W
SPEED RPM (No Load)	60-80//125-165// 205-275//410-545
SPINDLE	MT4
ARBOR	31.75mm (1-1/4") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1 Year

Part No	Contents
803094-110	HMT MAX150T Magnet Drill 110v
803094-230	HMT MAX150T Magnet Drill 230v

Supplied with a heavy duty site case, morse taper broaching arbor, handles, restraint strap & heavy duty metal guard

The HMT MAX200T offers the world's largest capacity for portable drilling, tapping and countersinking.

Designed for heavy duty, industrial applications, it tackles the most challenging metalworking tasks with its 2850W, high torque, variable speed, reversible motor.

Broach up to 200mm diameter, drill or ream up to 56mm and countersink up to 110mm.

- *4 speed gearbox for low speed, high torque applications*
- *Lifting eyes for safe positioning of the unit*
- *Morse Taper 5 spindle with XL Weldon Arbor supplied in kit*
- *Emergency stop function and safety guard included*

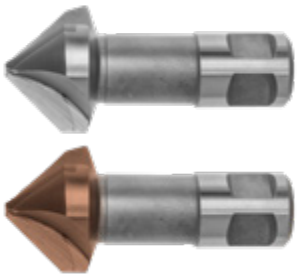
TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	200mm
MAX HSS CUTTER CAPACITY	175mm
MAX CUTTER LENGTH	200mm
MAX TWIST DRILL	56mm
MAX TAPPING SIZE	M52
COUNTERSINKING	110mm
REAMING	56mm
LENGTH	455mm
WIDTH INC HANDLES	280mm
HEIGHT	730-955mm
STROKE	330mm
WEIGHT	52kg
MAGNET SIZE	295x140x70mm
MAGNETIC FORCE	2700kg
POWER CONSUMPTION	2,850W
SPEED RPM (No Load)	40-60//90-130// 170-240//380-545
SPINDLE	MT5
ARBOR	31.75mm (1-1/4") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1 Year

Part No	Contents
803096-110	HMT MAX200T Magnet Drill 110v
803096-230	HMT MAX200T Magnet Drill 230v

Supplied with a heavy duty site case, morse taper broaching arbor, handles, restraint strap & heavy duty metal guard

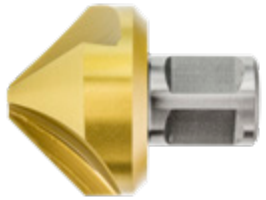
HMT Weldon Shank TCT Countersinks



Premium countersink with 3X heavy duty tungsten carbide inserts for maximum life in challenging materials.
Standard 19.05mm (3/4") Weldon shank for use in all standard Magnet Drills.
Use with a 103013 Morse taper arbor to use in a Pillar or Radial Drill.
ULTRA version for use on wear plate like Hardox & Raex

TCT Countersink	Size	Point Angle	Length
601035-0320	32mm	90°	72mm
601037-0010	1-1/4"	82°	2-7/8"
ULTRA Countersink	**Size**	**Point Angle**	**Length**
601036-0320	32mm	90°	72mm
601038-0010	1-1/4"	82°	2-7/8"

GoldMax HSS Weldon Countersink



Specially coated for increased tool life.

Standard 19.05mm (3/4") Weldon shank for use in all standard Magnet Drills.

Part No	Size	Point Angle
601025-0300	30mm	90°
601025-0400	40mm	90°
601025-0550	55mm	90°
601026-0020	1-1/2"	82°
601026-0030	2"	82°

HMT Magnet Drill Countersink - 50mm, 60°

High Speed Steel with precision ground flutes.

Standard 19.05mm Weldon shank for use in all standard Magnet Drills.

Part No	Size
601040-0500	50mm

HMT 90° Carbide Indexable Countersink 76mm

76mm heavy-duty large countersink with Morse Taper shank.

Each countersink is supplied with Premium replaceable carbide inserts for cost effective performance in structural metals.

Supplied with set of 3 tips which are double sided for extended use.

Part No	Product
602040-0760	MT3 Carbide Indexable Countersink
602040-0760R	Single Tungsten Carbide Tip - 2 sided

FOR TECHNICAL DATA & USER ADVICE SEE P.121 & P.128

The MultiSink is a worldwide unique Combination Countersink Tool designed and developed by HMT for use with Magnetic Drills.

The tool is designed to combine with the VersaDrive® product range to Broach & Countersink, Drill & Countersink, Tap & Countersink or even Drill, Tap & Countersink in one operation - providing huge time-saving benefits.

- *Innovative combination countersinking tool*
- *Save time completing countersunk holes*
- *Broach/Drill & countersink in one operation*
- *Suitable for holes 16mm and above*
- *Pilot feature gives a precise, concentric fit for excellent performance*
- *Tap & countersink in one operation*

TCT MultiSink

Part No	D Ø	D2	L	Shank	Point Angle
601055-0400	40mm	14mm	100mm	19.05mm / 3/4"	90°
601055-0550	55mm	14mm	109mm	19.05mm / 3/4"	90°
601057-0010	1-1/2"	9/16"	3-15/16"	3/4" / 19.05mm	82°
601057-0020	2-1/4"	9/16"	4-5/16"	3/4" / 19.05mm	82°

ULTRA MultiSink - *Increased wear resistance & long life performance - for use on wear plate*

Part No	D Ø	D2	L	Shank	Point Angle
601056-0400	40mm	14mm	100mm	19.05mm / 3/4"	90°
601056-0550	55mm	14mm	109mm	19.05mm / 3/4"	90°
601058-0010	1-1/2"	9/16"	3-15/16"	3/4" / 19.05mm	82°
601058-0020	2-1/4"	9/16"	4-5/16"	3/4" / 19.05mm	82°

MultiSink Pilots

Part No	D Ø	L	Shank
601050-0160	16mm	52mm	11mm
601050-0180	18mm		
601050-0200	20mm		
601050-0220	22mm		
601050-0240	24mm		
601050-0260	26mm		
601051-0010	9/16"	2-3/64"	7/16"
601051-0015	5/8"		
601051-0020	11/16"		
601051-0025	3/4"		
601051-0030	13/16"		
601051-0035	7/8"		
601051-0040	15/16"		

Use MultiSink pilot when countersinking bolt holes from 16 - 26mm diameter.
Use MultiSink with variable speed Magnet Drill.
The speed must be reduced when countersinking.

FOR TECHNICAL DATA & USER ADVICE SEE P.121 & P.128

Weldon Shank - Morse Taper Arbor 19.05mm

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0192	MT2	19.05mm / 3/4"
103013-0193	MT3	19.05mm / 3/4"
103013-0194	MT4	19.05mm / 3/4"
103014-0192	MT2 Internal Cooling Arbor 19.05mm	
103014-0193	MT3 Internal Cooling Arbor 19.05mm	

Spring Loaded Extension Arbor

Spring Loaded extension arbor for very deep drilling using multiple extension arbors in series. The spring loaded design means only the bottom extension needs to be piloted, with standard cutter pilot pin. Will pass through hole diameters greater than 35mm.

Part No	Extension Length	Shank Size
103095-1000	100mm	19.05mm / 3/4"

31.75mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 31.75mm Shank XL cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-55	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 55mm cutters
103091-1932-110	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 110mm cutters

Standard Weldon Shank Extension Arbor

Will pass through hole diameters greater than 35mm

Part No	Extension Length	Shank Size
103090-0500	50mm	19.05mm / 3/4"
103090-0750	75mm	19.05mm / 3/4"
103090-1000	100mm	19.05mm / 3/4"

Replacement Set Screws

Part No	Thread Size	Hex Key Size	Unit of sale
103060-0606	M6 x 6	3mm	Pack 10
103060-0808	M8 x 8	4mm	Pack 10
103060-1010	M10 x 10	5mm	Pack 10
103060-1212	M12 x 12	6mm	Pack 10

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"

Morse Taper Sleeve

Morse Taper sleeve reducers have a smaller internal taper size than the machine (drive) end, to allow a smaller morse taper to be fitted. Hardened and ground high precision specification.

Part No	Size
103615-R21	MT2 outside, MT1 Inside
103615-R32	MT3 outside, MT2 Inside
103615-R43	MT4 outside, MT3 Inside
103615-R53	MT5 outside, MT3 Inside
103615-R54	MT5 outside, MT4 Inside

Morse Taper Drifts

Tapered steel drifts for simple removal of Morse Taper arbors, drill bits and tooling from MT2, MT3 or MT4 machine spindles

Part No	Suits
103012-0002	MT1 & MT2
103012-0003	MT3
103012-0004	MT4

Swarf Magnet

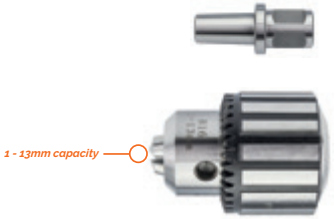
Part No	Total Length	Magnet Length
103011-01	400mm	180mm
103011-01-P12	12 Pack	

Morse Taper Extension

Morse Taper Extensions have an Internal and an External Morse Taper and are used to extend the reach of Magnet Drill Arbors and enable the use of tooling with different size shanks. Hardened and ground high precision specification.

Part No	Size
103616-E32	MT3 outside, MT2 inside
103616-E33	MT3 outside, MT3 inside
103616-E34	MT3 outside, MT4 inside
103616E-E43	MT4 outside, MT3 inside
103616-E44	MT4 outside, MT4 inside

Heavy Duty Magnet Drill Chuck & Adapter



Part No	Description	Fitting Type
103017	Chuck Adapter	19.05mm / 3/4"
103070	Keyed Chuck	1/2" Chuck - B16 taper

Weldon Quick Change Morse Taper Magnet Drill Arbor

Weldon Morse Taper Arbor with a smooth action, rotating collar and push-release action to allow rapid tool or adapter loading and unloading without the need for fiddly, time consuming grub screws or Allen keys. Takes 19.05mm (3/4") Magnet Drill Weldon fitting.

Part No	Description
103016-0192	MT2 Quick change arbor
103016-0193	MT3 Quick change arbor

GoldMax TCT Flame Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402050-0060	6 x 16mm	60mm
402050-0120	12 x 31mm	76mm

GoldMax TCT Cylinder End Cut Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402040-0060	6 x 16mm	60mm
402040-0120	12 x 25mm	69mm

GoldMax TCT Ball Nose Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402020-0060	6 x 16mm	60mm
402020-0120	12 x 25mm	69mm

TCT Flame Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402150-0060	6 x 16mm	60mm
402150-0120	12 x 31mm	76mm

TCT Cylinder End Cut Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402140-0060	6 x 16mm	60mm
402140-0120	12 x 25mm	69mm

TCT Ball Nose Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402120-0060	6 x 16mm	60mm
402120-0120	12 x 25mm	69mm

AliCut TCT Flame Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402250-0060	6 x 16mm	60mm
402250-0120	12 x 31mm	76mm

AliCut TCT Cylinder End Cut Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402240-0060	6 x 20mm	50mm
402240-0120	12 x 25mm	70mm

AliCut TCT Ball Nose Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402220-0060	6 x 16mm	60mm
402220-0120	12 x 25mm	70mm

GoldMax TCT Ball Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402010-0060	6 x 16mm	50mm
402010-0120	12 x 10mm	55mm

GoldMax TCT Tree Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402060-0060	6 x 16mm	60mm
402060-0120	12 x 25mm	69mm

GoldMax 4 Piece TCT Burr Set

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension
4020-SET2	6mm
4020-SET1	12mm

TCT Ball Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402110-0060	6 x 16mm	50mm
402110-0120	12 x 10mm	55mm

TCT Tree Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402160-0060	6 x 16mm	60mm
402160-0120	12 x 25mm	69mm

4 Piece TCT Burr Set

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension
4021-SET2	6mm
4021-SET1	12mm

AliCut TCT Ball Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402210-0060	6 x 16mm	50mm
402210-0120	12 x 10mm	55mm

AliCut TCT Tree Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402260-0060	6 x 16mm	60mm
402260-0120	12 x 25mm	69mm

AliCut 4 Piece TCT Burr Set

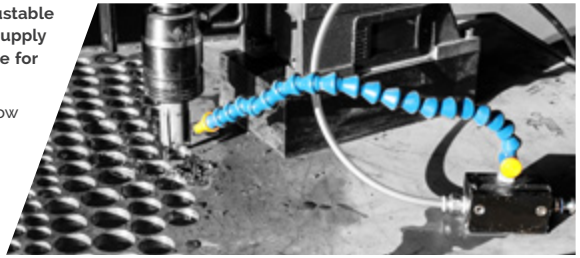
Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension
4022-SET2	6mm
4022-SET1	12mm

4 Litre, rechargeable cordless coolant pump with adjustable dispensing arm, magnetic foot and additional coolant supply outlet that can be connected to a magnet drill arbor. Use for both external flooding and through arbor cooling.

Dispensing arm provides hands-free, adjustable flow lubrication and cooling for otherwise difficult operations.

The magnetic foot can be secured to any magnetic surface for maximum flexibility of use when working at height, in tight, awkward locations or just where two hands are needed for the job and lubrication wouldn't otherwise be possible.



- *4 Litre capacity*
- *Cordless, with integrated rechargeable battery*
- *Magnetic foot for continuous hands free lubrication*
- *Can also be used to for through-arbor coolant on magnetic drills.*

TECHNICAL SPECIFICATIONS

LENGTH	320mm (Exc. dispensing arm)
WIDTH	155mm
HEIGHT	260mm
WEIGHT	950g (Empty)
BATTERY	2Ah
BATTERY LIFE	Up to 3hrs
CAPACITY	4 Litres

Part No	Contents
103010-KIT	4L Cordless Coolant Pump Kit

For best results use with BioCut Blue lubricant & room temperature tap water. Suggested mix: 0.5L of BioCut Blue to 3.5L water

SpeedLube™ Lubricant Spray

SpeedLube™ is a high performance foaming lubricant suitable for a wide variety of metal drilling applications across a range of materials including stainless steel.
Aerosol propellant ensures the lubricant foams on contact to ensure maximum tool coverage and heat dissipation. Easy one-handed application provides fast, efficient lubricant coverage and minimises the amount of applications needed during the drilling process. Unique 360° valve which enables SpeedLube to be sprayed from all angles.

Part No	Aerosol Size	Unit of Sale
701010-0002	500ml	Each
701010-0002-P12	500ml	Pack of 12
701010-0002-144	500ml	12 Packs of 12
701010-0002-432	500ml	36 Packs of 12

AeroPaste™ Lubricant Spray

AeroPaste™ is an aerosol applied paste-type, metalworking lubricant for hole broaching, tapping, reaming & drilling applications. Ideal for overhead or positional application, the high viscosity of AeroPaste allows it to cling directly to the cutting tool or steel it is applied to, without fluid run-off.
Ideal for use in environmentally sensitive areas such as above water. Using AeroPaste minimises repainting or galvanising issues caused by conventional soluble lubricants and reduces mess and slipping hazards.

Part No	Aerosol Size	Unit of Sale
701010-0001	500ml	Each
701010-0001-P12	500ml	Pack of 12

BioCut Blue Neat Broaching Oil

BioCut Blue is a ultra high-performance cutting fluid designed for metal fabrication broaching, cutting, and drilling tasks.

- Water-soluble fluid supplied ready-for-use.
- Inherently bio-degradable, can be 100% removed with water.
- Synthetic based, chlorine free, with zero mineral oils.
- No adverse affects for welding and galvanising.
- Excellent performance on Stainless Steel & Hardox type materials

Part No	Bottle Size	Unit of Sale
704010-0001	5 Litres	Each
704010-0001-P4	5 Litres	Box of 4
704010-0002	500ml Bottle	Each
704010-0002-P20	500ml Bottle	Box of 20

BioCut Paste - Drilling & Tapping Paste

BioCut Drilling & Cutting paste is specifically formulated for superb performance when used with HMT Impact Wrench cutting tools. Extreme pressure concentration provides accurate hole lubrication. Excellent general purpose paste lubricant when drilling, tapping, countersinking, reaming and broaching. Chlorine Free for safer use. Suitable for use with all grades of steel including Stainless Steel & Aluminium.

Part No	Aerosol Size	Unit of Sale
704030-0001	250g	Each
704030-0001-P16	250g	Pack of 16

Empty ETOP2 Half Top Case

Build your own personalised toolkit with the ETOP2 Half case. The ultimate in portability & lightweight, easy to transport tooling protection, the ETOP2 fits
2 x Small InsertFoams or
1 x Large InsertFoam

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
MKC-ETOP2	Empty STAKIT® ETOP2 Half Top Case

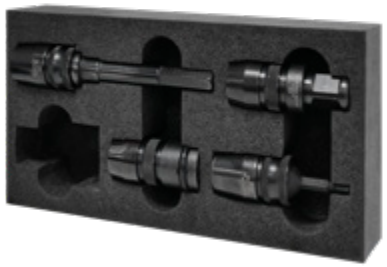
Empty ETOP4 Full Top Case

The ETOP4 Top case gives complete freedom when creating your own unique toolkit. Choose between:
4 x Small InsertFoams or
2 x Large InsertFoams or
2 x Small InsertFoams + 1 x Large InsertFoam

L x W x H (mm) - 540 x 390 x 95

Part No	Set contents
MKC-ETOP4	Empty STAKIT® ETOP4 Full Top Case

VersaDrive® Rapid-Lock Adapter Set

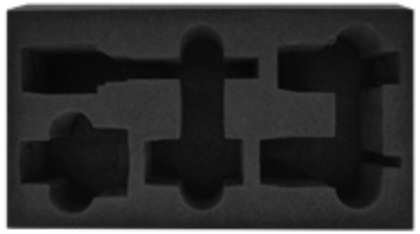


Part No	Product
111005-SET1	VersaDrive® Rapid-Lock Adapter InsertFoam Set 4pc

VersaDrive® Heavy-Duty Adapter Set

Part No	Product
111005-SET2	VersaDrive® HD Adapter InsertFoam Set 4pc

VersaDrive® InsertFoam for adapters - 5 spaces

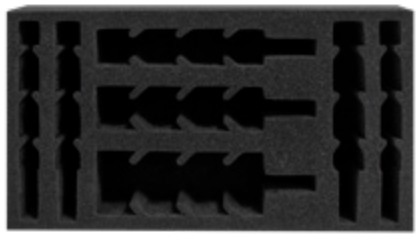


Part No	Product
SETFM-ADP-05	VersaDrive® Adapter Small InsertFoam

VersaDrive® InsertFoam for long series tools - 3 spaces

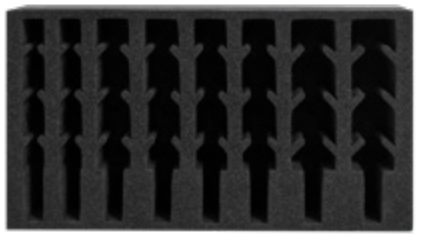
Part No	Product
SETFM-LS-03	VersaDrive® Long Series Tools InsertFoam

VersaDrive® STAKIT® Small InsertFoam - 7 spaces



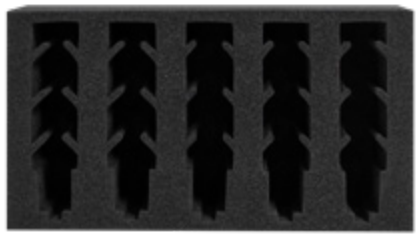
Part No	Product
SETFM-VSD-07	VersaDrive® InsertFoam Small - 7 Spaces

VersaDrive® STAKIT® Small InsertFoam - 8 spaces



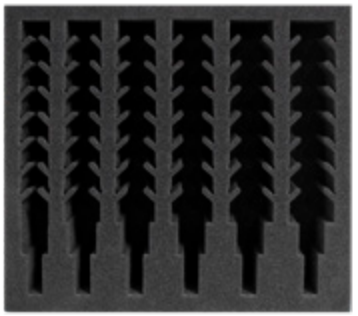
Part No	Product
SETFM-VSD-08	VersaDrive® InsertFoam Small - 8 Spaces

CarbideMax® STAKIT® Small InsertFoam - 5 spaces



Part No	Product
SETFM-WLD-05	CarbideMax InsertFoam Small - 5 Spaces

VersaDrive® STAKIT® Large InsertFoam - 6 spaces



Part No	Product
SETFM-LS-06	VersaDrive® Long Series Tools InsertFoam 6 Spaces

STAKIT® ETOP2 Starter Kit

Compact but fully stocked, the ETOP2 Starter Kit provides all the most commonly needed sizes of drilling, tapping and enlarging tools for hole creation and modification in the field.

Connects to ***STAKIT***® ETOP2 and ETOP4 cases

Metric Kit Contents:

4 x TurboTips	6.8, 8.5, 10.5, 14mm
4 x ImpactaTaps	M8, M10, M12, M16
3 x ImpactaStep Cutters	8-16, 14-22, 18-26mm

Inch Kit Contents:

4 x TurboTips	#7, #F, 5/16, 27/64"
4 x ImpactaTaps	1/4, 5/16, 3/8, 1/2"
3 x ImpactaStep Cutters	9/16, 13/16, 1-1/16"

1 x VersaDrive® ½" Rapid-Lock Impact Wrench Adapter
1 x VersaDrive® 130mm / 5" Extension Arbor
1 x ***STAKIT***® ETOP2 Half Top Case

L x W x H (mm) - 270 x 370 x 95

Part No	Product
STC-ETOP2-IMPACT	ETOP2 Starter Kit - Metric Sizes
STC-ETOP2-IK01	ETOP2 Starter Kit - Inch Sizes

FOR TECHNICAL DATA & USER ADVICE SEE P.116 ONWARDS

STAKIT® ETOP4 Starter Kit

Create, enlarge and tap holes using Impact Wrenches with the NEW ***STAKIT***® ETOP4 Impact Kit. The perfect kit for steel erectors, snaggers and site crews looking to keep the job moving.

Connects to ***STAKIT***® ETOP2, ETOP4 and EMID cases

Metric Kit Contents:

7 x TurboTips	6.8, 8, 8.5, 10, 10.5, 12, 14mm
5 x ImpactaTaps	M6, M8, M10, M12, M16
3 x Impact Reamers	14, 18, 22mm
2 x ImpactaStep Cutters	8-16, 18-26mm

Inch Kit Contents:

4 x TurboTips	#7, #F, 5/16, 27/64"
5 x ImpactaTaps	1/4, 5/16, 3/8, 1/2, 5/8"
3 x Impact Reamers	9/16, 11/16, 13/16"
2 x ImpactaStep Cutters	9/16, 13/16"

1 x VersaDrive® ½" Rapid-Lock Impact Wrench Adapter
1 x VersaDrive® 130mm / 5" Extension Arbor
1 x ***STAKIT***® ETOP4 Full Top Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
STC-ETOP4-IMPACT	ETOP4 Impact Kit - Metric Sizes
STC-ETOP4-IK02	ETOP4 Impact Kit - Inch Sizes

FOR TECHNICAL DATA & USER ADVICE SEE P.116 ONWARDS

VersaDrive® STAKIT® SiteCart Compact

The ***STAKIT***® SiteCart Compact is a wheeled base unit with retractable handle and robust, water and dust proof construction.

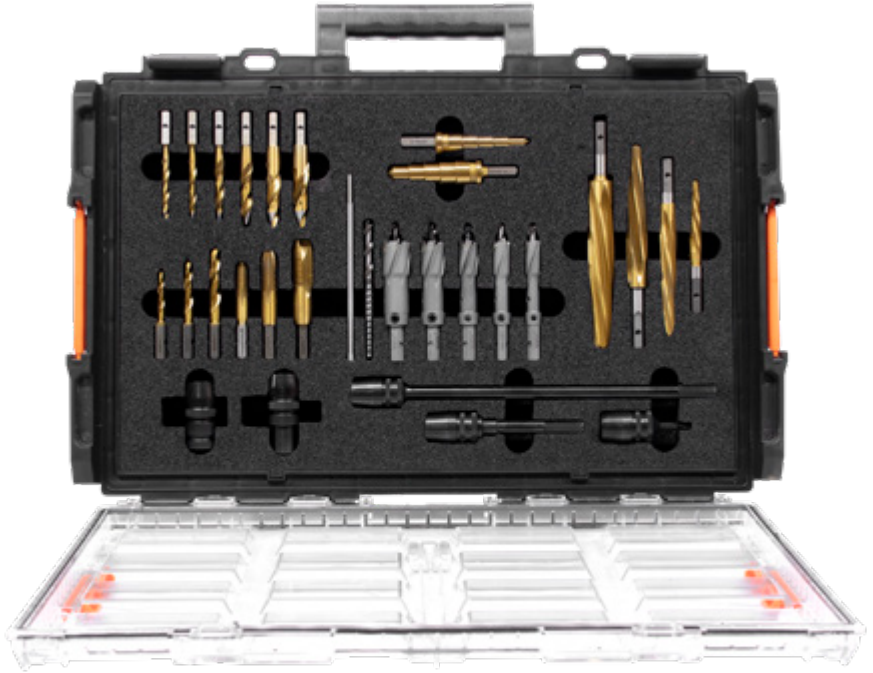
The case can be used on its own for large equipment storage or combined with the rest of the ***STAKIT***® system to transport tooling and cases to and around the job site or workshop.

The case is designed to be tilted and pulled, has a handy narrow size and is easy to manoeuvre. Supplied empty.

L x W x H (mm) - 605 x 405 x 345mm

Part No	Product
STC-SITECART2	VersaDrive® ***STAKIT***® Wheeled SiteCart Compact

STAKIT® Site Installation Kit



The ***STAKIT***® Site Installation Kit combines an essential set of best-selling VersaDrive® products to overcome all common site installation and steel erection holemaking challenges.

Keeps the job moving when you find an unexpected challenge.

Presented in an interlocking, stackable, and protective ***STAKIT***® EMID Case.

Connects to ***STAKIT***® ETOP4, EMID and Base cases

Metric Kit Contents:		***Inch Kit Contents:***	
6 x TurboTips	6, 6.35, 8, 10.5, 12, 14mm	6 x TurboTips	1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
5 x HoleCutters	14, 17, 18, 20, 22mm	5 x HoleCutters	9/16, 5/8, 3/4, 7/8, 1"
4 x Impact Reamers	12, 14, 18, 22mm	4 x Impact Reamers	1/2, 9/16, 11/16, 13/16"
3 x Impact DrillTaps	M6, M8, M10	3 x Impact DrillTaps	5/16, 3/8, 1/2"
3 x ImpactaTaps	M12, M16, M20	3 x ImpactaTaps	1/2, 5/8, 3/4"
2 x ImpactaStep Cutters	8-16, 14-22mm	2 x ImpactaStep Cutters	9/16, 13/16"

+ 5x Rapid lock VersaDrive® adapters

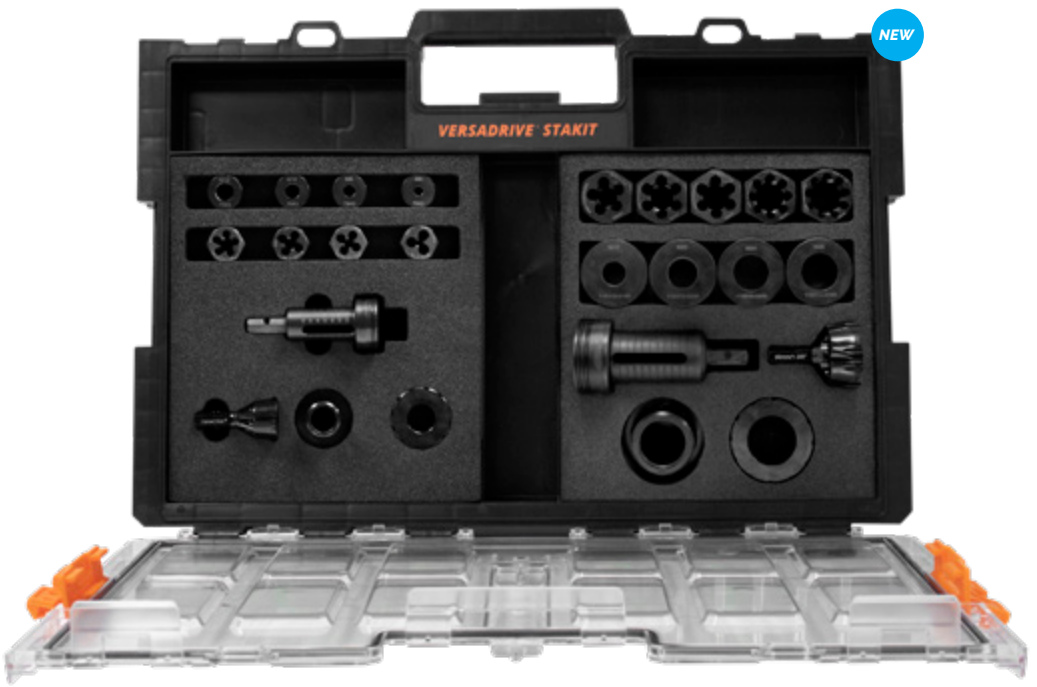
¼" Impact Driver Adapter, ½" Impact Wrench Adapter,
Magnet Drill Adapter, 130mm Extension, 300mm Extension

L x W x H (mm) - 582 x 387 x 131

Part No	Product
STC-EMID-MEIK	VersaDrive® ***STAKIT***® Installation Kit - Metric Sizes
STC-EMID-INIK	VersaDrive® ***STAKIT***® Installation Kit - Inch Sizes

FOR TECHNICAL DATA & USER ADVICE SEE P.112 ONWARDS

VersaDrive® ImpactaDie Complete Kit



Create or repair large diameter external threads on metal bar or conduit with the VersaDrive® ImpactaDie system.

Offering fast, easy impact-thread cutting in a variety of sizes from M6 - M25, the ImpactaDie complete kit speeds up the challenging and traditionally time-consuming process of creating both small and large external threads.

Utilize the speed and power of high-torque impact wrenches* or the power and precision of magnetic drills* to reduce labour and fatigue, improve productivity and complete jobs in less time.

The kit includes the VersaDrive® ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a VersaDrive® ***STAKIT***® compatible ETOP4 top case.

*(requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter).

Kit Contents:

ImpactaDie Holder for M6 - M12 threads
ImpactaDie Holder for M16 - M25 threads
Guide Collar for M6 - M12 threads
Guide Collar for M16 - M25 threads
Flush Collar for M6 - M12 threads
Flush Collar for M16 - M25 threads
M6/8/10/12/16/20/24/25 Guides
M6/8/10/12/16/20/24 Metric Coarse Hex Die Nuts
M16/20/25 Metric Fine Hex Die Nuts
ImpactaBurr 19mm Chamfer Tool
ImpactaBurr 36mm Chamfer Tool
STAKIT® ETOP4 Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
115810-CSET	VersaDrive® ImpactaDie Complete Kit (M6 - M25)

FOR TECHNICAL DATA & USER ADVICE SEE P.115 ONWARDS

STAKIT® ULTRA Kit

The NEW VersaDrive® *STAKIT*® ULTRA Kit has been developed to offer a comprehensive solution to drilling & countersinking the most challenging materials.

With cutting tools from 6 - 26mm diameter and countersinking options up to 40mm, this kit is a must have for operatives in the quarrying/mining, heavy machinery/plant repair and defence sectors.

Kit Contents:	***Metric Kit:***	***Inch Kit:***
ULTRA 55 TCT Broach Cutters	18, 20, 22, 24, 26mm	11/16, 3/4, 13/16, 15/16"
VersaDrive® ULTRA Drill Bits	6, 8, 10, 12, 14mm	1/4, 5/16, 3/8, 1/2, 9/16"
Weldon Shank ULTRA TCT Countersink	32mm, 90°	1-1/4", 82°
ULTRA coated Tungsten Carbide MultiSink	40mm, 90°	1-1/2", 82°
MultiSink Pilots	18, 20, 22, 24, 26mm	11/16, 3/4, 13/16, 15/16"

1 x VersaDrive® Heavy Duty Magnet Drill Adapter
1 x VersaDrive® ***STAKIT***® ETOP4 Full Top Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
STC-ULTRA-KIT	***STAKIT***® Ultra Kit - Metric Sizes
STC-ULTRA-KIT-01	***STAKIT***® Ultra Kit - Inch Sizes

FOR TECHNICAL DATA & USER ADVICE SEE P.128

Metric to Inch

mm	Fractional Inch	Decimal Inch
0.8	1/32	0.031
1.6	1/16	0.063
2.4	3/32	0.094
3.2	1/8	0.125
4.0	5/32	0.156
4.8	3/16	0.188
6.4	1/4	0.250
7.1	9/32	0.281
7.9	5/16	0.313
8.7	11/32	0.344
9.5	3/8	0.375
10.3	13/32	0.406
11.1	7/16	0.438
11.9	15/32	0.469
12.7	1/2	0.500
13.5	17/32	0.531
14.3	9/16	0.563
15.1	19/32	0.594
15.9	5/8	0.625
16.7	21/32	0.656
17.5	11/16	0.688
18.3	23/32	0.719
19.1	3/4	0.750
19.8	25/32	0.781
20.6	13/16	0.813
21.4	27/32	0.844
22.2	7/8	0.875
23.0	29/32	0.906
23.8	15/16	0.938
24.6	31/32	0.969
25.4	1	1.000

Metric Coarse Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M5	0.8mm	4.2mm
M6	1.0mm	5.0mm
M8	1.25mm	6.8mm
M10	1.5mm	8.5mm
M12	1.75mm	10.2mm
M14	2.0mm	12mm
M16	2.0mm	14mm
M18	2.5mm	15.5mm
M20	2.5mm	17.5mm
M24	3.0mm	21mm
M27	3.0mm	24mm
M30	3.5mm	26.5mm
M30	3.5mm	26.5mm
M33	3.5mm	29.5mm
M36	4.0mm	32mm
M39	4.0mm	35mm
M42	4.5mm	37.5mm

UNC Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	20	5.1mm
5/16"	18	6.6mm
3/8"	16	8.0mm
1/2"	13	10.8mm
5/8"	11	13.5mm
3/4"	10	16.5mm
7/8"	9	19.5mm
1"	8	22.2mm
1-1/8"	7	25.0mm
1-1/4"	7	28.0mm
1-3/8"	6	31.0mm
1-1/2"	6	34.0mm
1-3/4"	5	39.5mm

Metric Coarse Galvanised Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M5.4	0.8mm	4.2mm
M6.4	1.0mm	5.0mm
M8.4	1.25mm	6.8mm
M10.4	1.5mm	8.5mm
M12.4	1.75mm	10.2mm
M16.4	2.0mm	14mm
M20.4	2.5mm	17.5mm
M24.4	3.0mm	21mm
M30.4	3.5mm	26.5mm

Metric Fine Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M6	0.75mm	4.5mm
M8	1.0mm	7.0mm
M10	1.25mm	8.8mm
M12	1.5mm	10.5mm
M16	1.5mm	14.5mm
M18	1.5mm	16.5mm
M20	1.5mm	18.5mm
M24	1.5mm	22.0mm

NPT Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/8"	27	8.5mm
1/4"	18	11.0mm
3/8"	18	14.5mm
1/2"	14	18.0mm
3/4"	14	23.0mm
1"	11.5	29.0mm

BSW Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	20	5.1mm
5/16"	18	6.5mm
3/8"	16	7.9mm
1/2"	12	10.5mm
5/8"	11	13.5mm
3/4"	10	16.25mm
1"	8	22.0mm

BSP Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/8"	28	8.8mm
1/4"	19	11.8mm
3/8"	19	15.25mm
1/2"	14	19mm
5/8"	14	21mm
3/4"	14	24.5mm
1"	11	30.75mm

UNF Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	28	5.5mm
3/8"	20	8.5mm
1/2"	20	11.5mm
5/8"	18	14.5mm
3/4"	16	17.5mm
7/8"	14	20.5mm
1"	12	23.5mm

Diameter	Structural Steel <500 Mpa (S275, S355) Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Cast Iron-Grey	Aluminium
	RPM Range				
12-18mm	665-500	325-255	320-230	480-360	980-690
19-23mm	480-375	250-180	230-180	360-275	690-505
24-28mm	350-285	180-165	180-150	265-220	500-405
29-33mm	260-225	165-125	150-130	215-180	400-345
34-41mm	225-200	120-115	125-100	175-150	340-300
42-45mm	200-180	115-105	100-85	145-125	295-280
46-48mm	180-170	105-95	85-75	125-110	280-270
49-50mm	170-150	90-80	75-70	120-110	270-255

BEST PRACTICE ADVICE

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

1. Centre punch or pilot drill the surface for accurate hole start
2. Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage
3. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
4. Avoid lateral movement or tilting which can cause damage to the cutter
5. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
6. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
7. Regularly check that magnet drill slides, handles, arbors and movable parts have not vibrated loose over time
8. Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling
9. For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
10. Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task

QUICK GUIDE

- Adjust RPM to match the material
- Slowly and cautiously begin cutting before increasing pressure
- For best results & swarf clearance always select a cutter longer than the material thickness
- For hard or challenging materials (eg Stainless steels, Hardox etc) use Carbidemax & Ultra coated cutters

MORE INFO

TCT HoleCutters - Data Sheet

VERSADRIVE PATENT PROTECTED

Diameter	Structural Steel <500 Mpa Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Aluminium	Cast Iron (Grey)	Fibreglass	Composite	Plastics	Wood
	RPM Range								
13-17mm	1350-850	840-585	500-360	2210-1575	900-625	780-705	1350-850	900-640	1495-1010
18-25mm	850-625	580-420	350-250	1575-1125	600-455	700-520	850-625	620-450	990-895
26-31mm	620-500	415-325	240-195	1080-885	435-345	500-405	620-500	440-345	895-850
32-39mm	480-410	320-275	195-160	875-740	330-285	400-330	480-410	345-280	850-740
40-46mm	390-340	270-220	160-145	730-620	285-240	315-275	390-340	175-235	740-610
47-53mm	335-300	220-180	140-120	615-545	235-215	275-245	335-300	235-215	600-505
54-60mm	295-260	180-165	115-100	525-485	210-180	240-215	295-260	210-185	500-460
61-70mm	260-225	165-155	100-90	475-415	180-160	205-185	260-225	180-160	455-400
71-80mm	220-195	155-140	90-75	410-365	155-140	180-160	220-195	155-140	395-360

BEST PRACTICE ADVICE

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

1. Centre punch or pilot drill the surface for accurate hole start
2. Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage
3. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
4. Avoid lateral movement or tilting which can cause damage to the tool
5. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
6. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
7. When using a Magnet Drill regularly check that slides, handles, arbors and movable parts have not vibrated loose over time
8. Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling
9. For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
10. For thicker materials, predrill 6.35mm pilot hole first and use then sprung pilot drill or pilot pin as a guide

QUICK GUIDE

- Optimum life & performance when used with Rotary Pistol Drills
- Good results from SDS Drills when used in Rotary-Only mode
- For best results pre-drill the pilot hole
- Use appropriate lubrication and correct RPM to achieve long tool life

MORE INFO

TCT Broach Cutters - Data Sheet

HOLEMAKER TECHNOLOGY HMT

Diameter	Structural Steel <500 Mpa (S275, S355) Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Cast Iron-Grey	Aluminium
	RPM Range				
12-19mm	1265-850	850-580	530-350	925-615	2200-1560
20-25mm	840-650	550-410	345-255	610-440	1480-1140
26-32mm	545-460	410-315	250-200	430-335	1125-890
33-39mm	460-395	315-265	195-170	330-280	885-730
40-46mm	405-340	265-250	165-140	280-235	720-620
47-53mm	335-300	250-195	135-120	235-205	615-545
54-60mm	295-265	195-180	120-105	200-180	540-475
61-70mm	260-230	180-140	105-90	180-160	475-415
71-80mm	230-200	140-130	90-70	160-145	410-365
81-90mm	195-180	130-115	70-65	140-125	350-325
91-100mm	180-160	115-100	60-55	125-110	320-280
101-112mm	160-140	100-90	55-50	110-100	280-250
113-124mm	140-120	90-85	50-48	100-90	250-235
125-136mm	120-110	85-75	48-45	90-80	230-205
137-150mm	110-100	70-65	45-40	80-75	205-190
151 - 174mm	70 - 80	50 - 60	45 - 40	55 - 65	145 - 155
175 - 200mm	60 - 70	40 - 50	25 - 30	45 - 55	120 - 140

BEST PRACTICE ADVICE

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

1. Centre punch or pilot drill the surface for accurate hole start
2. Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage
3. Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut
4. Avoid lateral movement or tilting which can cause damage to the cutter
5. Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
6. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
7. Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time
8. Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling
9. For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf
10. Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task

QUICK GUIDE

- Adjust RPM to match the material
- Slowly and cautiously begin cutting before increasing pressure
- For best results & swarf clearance always select a cutter longer than the material thickness
- For hard materials & wear plates like Hardox use Ultra coated cutters. See page 68-73

MORE INFO

Bolt Extractor System - Data Sheet

VERSADRIVE PATENT PROTECTED

Left Handed Pilot Drill Bits		Impact Torque Grade 8.8 bolts Nm Torque	Impact Torque Grade 8.8 bolts Ft Lb Torque
Drill Bit No.	#3	160	178
	#4	280	207
	#5	300	222
	#6	580	430
	#7	Rotary Only	Rotary Only

Bolt Extractor		Impact Torque Grade 8.8 bolts Nm Torque	Impact Torque Grade 8.8 bolts Ft Lb Torque
Extractor No.	#3	140	130
	#4	200	145
	#5	220	160
	#6	430	320
	#7	500	380

LEFT HANDED DRILL BITS BEST PRACTICE ADVICE

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

1. Designed for use in left hand direction (Reverse) only.
2. For best results drilling through hardened bolts and materials, it is recommended to start with a small diameter drill bit and step up to the finished diameter with increasingly larger drill bits
3. Ensure ample application of lubricant (SpeedLube/BioCut Blue) during the drilling process to prevent overheating & work hardening of the fastener.
4. Wherever possible use a scribed or drawn mark to find the exact center of the fastener to be drilled.
5. For best results drill all the way through the bolt/stud before inserting the Screw Extractor
6. Where the application allows, using the Left Hand drills in a reversible Magnet Drill will make the drilling process faster and more stable.
7. For larger diameter drill bit sizes (#6/#7) or when drilling particularly hard materials, using a rotary or magnetic drill may provide better results than an Impact wrench.

BOLT EXTRACTOR BEST PRACTICE ADVICE

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

1. Ensure the correct sized pilot hole is drilled into seized bolt using VersaDrive® Left Hand bits
2. Use a soft-faced hammer to securely tap the extractor into pilot hole
3. Attach VersaDrive® Impact Adapter and use on left hand rotation (Reverse Mode)
4. Where possible ensure ample lubricant is applied to the drilled hole and time allowed for the fastener to cool after drilling and to allow the lubricant to penetrate into the drilled hole and threads.
5. To assist with successful extraction it is important that the pilot hole is drilled square to the centre of the fastener to avoid the extractor running off plane when reversing out, and potentially breaking or coming loose.
6. Whilst the VersaDrive extractors are superior to standard stud extractors readily available, it is recognised that stud/fastener extraction is a very challenging task and a complete success cannot be guaranteed in all circumstances. Using heating methods and/or releasing fluids can often assist with the removal process.

QUICK GUIDE

- Drill correct sized pilot hole in seized bolt using VersaDrive® Left Hand bits
- Use a hammer to securely tap the extractor into pilot hole
- Attach VersaDrive® Impact Adapter and use on left hand rotation

MORE INFO

ImpactaDie & ImpactaDie XL - Data Sheet

VERSADRIVE PATENT PROTECTED

	Die Nut Size	Thread Cutting Impact Torque Nm	Thread Repair / Cleaning Impact Torque Nm	Thread Cutting Ft Lb	Thread Repair / Cleaning Ft Lb
Metric	M6 x 1.0	130	90	95	65
	M8 x 1.25	240	160	180	115
	M10 x 1.5	360	240	270	180
	M12 x 1.75	400	270	295	195
	M16 x 2.0	610	410	455	300
	M20 x 2.5	820	550	605	400
	M24 x 3.0	1190	790	880	585
Inch	1/4" UNC	140	95	105	70
	5/16" UNC	245	165	180	120
	3/8" UNC	355	235	260	175
	1/2" UNC	450	300	330	220
	5/8" UNC	605	405	450	300
	3/4" UNC	810	540	590	400
	7/8" UNC	1060	710	785	520
	1" UNC	1205	805	890	695
		Conduit Thread Cutting Impact Torque Nm	Conduit Thread Repair / Cleaning Impact Torque Nm	Conduit Thread Cutting Ft Lb	Conduit Thread Repair / Cleaning Ft Lb
	M16 x 1.5	330	220	245	165
	M20 x 1.5	410	275	305	200
	M25 x 1.5	520	340	385	245

BEST PRACTICE ADVICE

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

1. Before cutting the thread, the ImpactaBurr chamfer tool must be used to ensure that the fastener/workpiece has a consistent 60 degree bevel/chamfer.
2. To ensure best results for the life of the Die and avoid the thread cutting unevenly on the fastener/workpiece, ensure the tool is held squarely in alignment with the fastener/workpiece.
3. When cutting a new thread use the Guide collar and Guide to help keep the Die in alignment with the fastener/workpiece.
4. For cleaning/repairing or rethreading applications, the flush collar is intended to allow the die to cut a full length thread.
5. Firm forward pressure is recommended both for starting/cutting the thread and when reversing the tool to remove the Die Threader from the fastener.
6. Ensure regular application of SpeedLube cutting fluid prior to and during the cutting process to minimise heat build up.
7. Take care when handling ImpactaDie and workpiece as threaded components may get very hot.
8. Avoid lateral movement or tilting which can cause damage to the tool.
9. Periodically check Die and ImpactaDie Holder/Collar and remove Swarf as required.
10. When cutting a full thread with the ImpactaDie system it is recommended to use an Impact wrench rather than a rotary drill to avoid potential hand/wrist injury from reaction torque.
11. Ensure the use of appropriate PPE at all times when using cutting tools (Safety Glasses, Gloves etc).
12. Impact wrenches of 3/8, 1/2 or 3/4"" square drive are recommended (rather than 1/4" impact drivers).

QUICK GUIDE

- For fastest & safest performance use on Impact Wrenches
- For best results & to avoid kickback, use the ImpactaDie system with an impact wrench rather than a rotary only drill.
- Hardened grades of material may require increased torque
- Use appropriate lubrication and correct torque to achieve long tool life.

MORE INFO

TurboTips - Data Sheet

VERSADRIVE PATENT PROTECTED

Diameter	Impact Torque 6mm Thick Steel	Impact Torque 12mm Thick Steel	Impact Torque 25mm Thick Steel	Impact Torque 1/4" Thick Steel	Impact Torque 1/2" Thick Steel	Impact Torque 1" Thick Steel	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Plastics	Aluminium
	Nm Torque			Ft Lb Torque			32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	30m/Min	45m/Min
							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
17/32"	370	445	675	274	330	500	720	390	260	730	385	745	1160
9/16"	375	455	690	278	337	511	660	350	225	665	340	620	950
5/8"	455	580	880	337	430	652	535	290	200	610	310	510	875
11/16"	580	720	1120	430	533	830	490	245	190	580	275	440	800
3/4"	685	845	1245	507	626	922	450	220	175	550	240	350	730
13/16"	720	900	1360	533	667	1007	340	180	160	510	210	330	645

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 Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & 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. *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*
- *To achieve the best lifespan in Stainless Steel, use with Rotary tools at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO

Cobalt Drill Bits - Data Sheet

VERSADRIVE PATENT PROTECTED

Metric Diameter	Structural Steel 500Nm	Structural Steel 1000Nm (High Tensile)	Stainless Steel	Special Alloys (Eg Duplex)	Cast Iron	Aluminium Brass Plastic
	RPM Range					
4.2mm	2654	1365	1213	682	1820	4625
5mm	2229	1146	1019	573	1529	3885
5.5mm	2027	1042	926	521	1390	3532
6mm	1858	955	849	478	1274	3238
6.5mm	1715	882	784	441	1176	2989
6.8mm	1639	843	749	422	1124	2857
7mm	1592	819	728	409	1092	2775
7.5mm	1486	764	679	382	1019	2590
8mm	1393	717	637	358	955	2428
8.5mm	1311	674	599	337	899	2286
9mm	1238	637	566	318	849	2159
9.5mm	1173	603	536	302	805	2045
10mm	1115	573	510	287	764	1943
10.2mm	1093	562	500	281	749	1905
10.5mm	1062	546	485	273	728	1850
11.5mm	969	498	443	249	665	1689
12mm	929	478	425	239	637	1619
12.5mm	892	459	408	229	611	1554
13mm	857	441	392	220	588	1494
14mm	796	409	364	205	546	1388
16mm	697	358	318	179	478	1214
17.5mm	637	328	291	164	437	1110
18mm	619	318	283	159	425	1079
20mm	557	287	255	143	382	971
21mm	531	273	243	136	364	925
22mm	507	261	232	130	347	883

Inch Diameter	Structural Steel 500Nm	Structural Steel 1000Nm (High Tensile)	Stainless Steel	Special Alloys (Eg Duplex)	Cast Iron	Aluminium Brass Plastic
	RPM Range					
3/16	2654	1365	1213	682	1820	4625
#7	2229	1146	1019	573	1529	3885
7/32	2027	1042	926	521	1390	3532
1/4	1715	882	784	441	1176	2989
#F	1639	843	749	422	1124	2857
9/32	1592	819	728	409	1092	2775
5/16	1393	717	637	358	955	2428
11/32	1238	637	566	318	849	2159
3/8	1238	637	566	318	849	2159
27/64	1093	562	500	281	749	1905
7/16	969	498	443	249	665	1689
1/2	892	459	408	229	611	1554
9/16	796	409	364	205	546	1388

BEST PRACTICE ADVICE

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

1. *Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & 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. *VersaDrive® Drill Bits up to 10mm diameter can be driven by an Impact Wrench*

QUICK GUIDE

- *Optimum life and performance when used with Rotary Pistol Drills*
- *Up to 10mm 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

Step Drill & TurboTip Cone Cutter - Data Sheet

VERSADRIVE PATENT PROTECTED

	Diameter	Impact Torque		Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
		Nm Torque	Ft Lbs Torque	RPM Range					
Metric	3-12mm	280	185	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
Metric	14-22mm	400	270	597-430	390-270	200-145	600-440	245-180	380-275
Metric	24-30mm	485	350	420-330	260-215	140-110	420-330	175-135	275-180
Metric	32-40mm	750	590	260-230	160-145	85-75	260-230	95-85	150-140
Inch	3/16-1/2"	280	185	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
Inch	3/16-7/8"	400	270	597-430	390-270	200-145	600-440	245-180	380-275
Inch	1/4-1-3/8"	540	405	420-330	260-215	140-110	420-330	175-135	275-180

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 Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & 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. *When drilling into box section ensure the tip of the Step-Drill 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. *VersaDrive® Cone Cutters are designed for use in sheet metal & should not be used in material exceeding 2-3mm thickness*

QUICK GUIDE

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Excellent life and performance when used with Rotary Pistol Drills or Pillar Drills*
- *Suitable for stainless and harder materials if used at low RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO

ImpactaStep & TurboTip ImpactaStep Cutter - Data Sheet

VERSADRIVE PATENT PROTECTED

	Diameter	Impact Torque <12mm Thick Steel	Impact Torque <1/2" Thick Steel	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
		Nm Torque	Ft Lb Torque	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	45m/Min
				RPM Range					
Metric	8mm	200	160	940	540	410	1020	550	1365
Metric	10mm	220	175	900	510	380	1005	530	1290
Metric	12mm	280	185	875	490	370	995	520	1200
Metric	14mm	320	220	690	360	305	700	500	1100
Metric	16mm	340	260	640	335	225	660	340	920
Metric	18mm	360	270	535	290	210	550	305	800
Metric	20mm	380	285	490	230	195	510	250	745
Metric	22mm	400	300	460	210	180	470	235	690
Metric	24mm	520	385	360	150	140	430	215	490
Metric	26mm	545	405	310	140	135	375	200	400
Metric	32mm	575	430	290	130	125	340	180	355
Inch	1/2"	300	205	875	490	370	520	510	1185
Inch	9/16"	330	235	690	360	305	450	450	1025
Inch	5/8"	335	250	640	335	225	340	340	975
Inch	11/16"	350	265	535	290	210	305	305	860
Inch	3/4"	370	280	490	230	195	250	280	745
Inch	7/8"	425	310	460	210	180	235	235	675
Inch	15/16"	460	380	360	150	140	215	215	540
Inch	1"	530	390	310	140	135	200	200	410
Inch	1-1/16"	575	440	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 Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & 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. *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 a Reamer.*

QUICK GUIDE

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Excellent life and performance when used with Rotary Pistol Drills or Pillar Drills*
- *Suitable for stainless and harder materials if used at low RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO

Impact Reamers - Data Sheet

VERSADRIVE PATENT PROTECTED

	Diameter	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel	Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
		Nm		Ft Lb		RPM Range					
Metric	8mm	200	380	160	290	940	540	410	1020	550	1365
	10mm	220	400	175	300	900	510	380	1005	530	1290
	12mm	280	420	185	305	875	490	370	995	520	1200
	14mm	320	480	220	330	690	360	305	700	500	1100
	16mm	340	510	260	390	640	335	225	660	340	920
	18mm	360	540	270	410	535	290	210	550	305	800
	20mm	380	570	285	425	490	230	195	510	250	745
	21mm	390	580	290	430	480	225	190	500	240	710
	22mm	400	600	300	435	460	210	180	470	235	690
	24mm	520	780	385	600	360	150	140	430	215	490
	26mm	650	1000	405	640	310	140	135	375	200	400
	28mm	720	1080	480	750	295	130	125	340	190	360
	30mm	780	1365	520	785	275	120	110	290	180	330
	32mm	940	1410	545	820	250	110	100	275	170	305
	33mm	970	1440	560	840	240	105	95	270	165	295
	36mm	1030	1520	600	870	215	95	80	255	150	255
	39mm	1260	1610	720	920	195	80	65	240	135	220
	41mm	1340	1736	750	965	185	75	60	220	125	200
Inch	1/2"	300	445	205	310	875	490	370	520	510	1185
	9/16"	330	490	235	355	690	360	305	450	450	1025
	5/8"	335	505	250	375	640	335	225	340	340	975
	11/16"	350	525	265	400	535	290	210	305	305	860
	3/4"	370	550	280	420	490	230	195	250	280	745
	7/8"	425	630	310	440	460	210	180	235	235	675
	15/16"	460	695	380	575	360	150	140	215	215	540
	1"	530	805	390	620	310	140	135	200	200	410
	1-1/16"	575	875	440	660	295	130	125	190	385	380
	1-3/16"	780	1365	520	785	275	120	110	290	180	330
	1-5/16"	970	1440	560	840	240	105	95	270	165	295
	1-3/8"	1030	1520	600	870	240	105	95	270	165	295
	1-7/16"	1030	1520	600	870	240	105	95	270	165	295
	1-1/2"	1260	1610	720	920	195	80	65	240	135	220
	1-9/16"	1260	1610	720	920	195	80	65	240	135	220
	1-5/8"	1340	1736	750	965	185	75	60	220	125	200

BEST PRACTICE ADVICE

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

1. *Apply firm, steady feed pressure throughout the cut*
2. *Avoid lateral movement or tilting which can cause damage to the tool*
3. *Do not attempt to increase the existing hole diameter beyond 2-3mm. If a larger, finished hole size is required, use the next size reamer to 'step up' until the finished hole diameter is reached.*
4. *Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials*
5. *Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & tool breakage*
6. *Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrenches. In this situation ream with a slow speed Magnet Drill*
7. *Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.*
8. *Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.*

QUICK GUIDE

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Check the minimum torque requirement*
- *Reamer should be rotating before starting the cut*
- *Use steady feed pressure throughout the cut*

MORE INFO

Countersinks - Data Sheet

HOLEMAKER TECHNOLOGY HMT

Metric Countersink Diameter	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
	RPM Range					
30mm	155	105	35	265	105	185
40mm	120	80	30	205	80	140
55mm	95	60	25	145	70	120
63mm	80	55	20	130	55	90
80mm	65	40	20	100	45	75

Inch Countersink Diameter	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
	RPM Range					
1-1/4"	155	105	35	265	105	185
1-1/2"	120	80	30	205	80	140
2"	95	60	25	145	70	120
2-1/4"	90	55	20	140	65	115

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*
9. *Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling*

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

Sheet Metal Drill Taps - Data Sheet

VERSADRIVE PATENT PROTECTED

	Thread Diameter	Max Material Thickness	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa RPM	Structural Steel <1000 Mpa RPM	Stainless Steel INOX RPM	Aluminium RPM	Cast Iron (Grey) RPM
Metric	M3	3mm	105	80	960	810	650	2700	1295
	M4	4mm	120	90	730	610	490	2060	975
	M5	5mm	135	100	585	485	385	1750	780
	M6	6mm	140	105	485	405	325	1455	650
	M8	8mm	150	115	365	310	245	1095	485
	M10	10mm	170	125	295	245	195	870	390
	M12	12mm	320	235	240	200	160	730	330

	Thread Diameter	Max Material Thickness	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa RPM	Structural Steel <1000 Mpa RPM	Stainless Steel INOX RPM	Aluminium RPM	Cast Iron (Grey) RPM
Inch (UNC)	4-40	3/32"	105	75	1050	850	710	2900	1390
	6-32	1/8"	120	90	950	790	650	2700	1295
	8-32	5/32"	135	95	730	610	490	2060	975
	10-24	13/64"	135	100	595	475	395	1700	820
	1/4-20	1/4"	135	105	485	405	325	1455	650
	5/16-18	5/16"	280	110	365	310	245	1095	485
	3/8-16	3/8"	300	120	295	245	195	870	390
	1/2-13	1/2"	320	235	240	200	160	730	330

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. *Impact DrillTaps are recommended for through hole applications only*
2. *Pilot drill the exact tapping size hole for best results*
3. *Select the correct torque for Impact tools using the table above. If exact match is not available select the closest torque setting above the recommendation*
4. *Apply firm, steady feed pressure throughout the cut*
5. *Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage*
6. *Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials*
7. *Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant*
8. *Tap the hole in one pass where possible, applying adequate lubrication before you start.*
9. *Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter*
10. *Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & tool breakage*

QUICK GUIDE

- *For fastest performance use on Impact Wrenches*
- *Check the minimum torque requirement*
- *Up to M10 (3/8") can also be used on cordless drills*

MORE INFO

Heavy Duty DrillTaps - Data Sheet

VERSADRIVE PATENT PROTECTED

	Thread Diameter	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa RPM	Structural Steel <1000 Mpa RPM	Stainless Steel INOX RPM	Aluminium RPM	Cast Iron (Grey) RPM
Metric	M8	280	205	365	310	245	1095	485
	M10	320	220	295	245	195	870	390
	M12	340	235	240	200	160	730	330
	M16	550	425	185	155	125	550	240
	M20	700	475	145	125	100	440	195
	M24	960	630	120	100	85	370	165

	Thread Diameter	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa RPM	Structural Steel <1000 Mpa RPM	Stainless Steel INOX RPM	Aluminium RPM	Cast Iron (Grey) RPM
Inch (UNC)	1/2-13	340	235	240	200	160	730	330
	5/8-11	550	365	185	155	125	550	240
	3/4-10	700	675	145	125	100	440	195
	1-8	960	735	120	100	85	370	165

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. *Impact DrillTaps are recommended for through hole applications only*
2. *Pilot drill the exact tapping size hole for best results*
3. *Select the correct torque for Impact tools using the table above. If exact match is not available select the closest torque setting above the recommendation*
4. *Apply firm, steady feed pressure throughout the cut*
5. *Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage*
6. *Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials*
7. *Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant*
8. *Tap the hole in one pass where possible, applying adequate lubrication before you start.*
9. *When tapping material thicker than 15-20mm, to speed up the process it is advisable to pilot drill the hole first, before drill tapping the hole*
10. *Heavy Duty Drill Taps are designed for use with Magnet Drills/Pillar Drills, or for tapping pre-drilled holes with an Impact Wrench. They are not designed for drill-tapping with hand-held rotary tools*
11. *Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & tool breakage*

QUICK GUIDE

- *Ideal for use in Pillar Drills & Magnet Drills*
- *Correct RPM is critical for good performance on larger sizes*
- *For Impact Wrench use, pilot drilling is recommended*

MORE INFO

	Thread Diameter	Impact Tapping Torque			Impact Tapping Torque			Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
		6mm Steel	12mm Steel	25mm Steel	1/4" Steel	1/2" Steel	1" Steel					
		Nm Torque			Ft Lbs Torque			RPM Range				
Metric Coarse	M3	105	160	N/A	80	120	N/A	960	809	650	2700	1295
	M4	120	180	N/A	90	135	N/A	730	610	490	2060	975
	M5	135	200	N/A	100	150	N/A	585	485	385	1750	780
	M6	140	240	400	105	180	N/A	485	405	325	1455	650
	M8	150	280	430	115	210	330	365	310	245	1095	485
	M10	170	300	480	125	220	360	295	245	195	870	390
	M12	185	320	512	135	235	400	240	200	162	730	330
	M14	190	340	544	140	250	400	210	175	140	625	275
	M16	200	360	576	150	265	425	185	155	125	550	243
	M20	315	400	640	235	300	470	145	125	100	440	194
	M24	N/A	600	960	N/A	440	720	120	100	85	370	165
	M27	N/A	740	1184	N/A	545	875	105	90	75	330	145
	M30	N/A	800	1200	N/A	590	885	95	80	60	310	130
	M33	N/A	N/A	1400	N/A	N/A	1070	84	68	51	265	112
	M36	N/A	N/A	1640	N/A	N/A	1260	72	58	44	228	96
	M39	N/A	N/A	1860	N/A	N/A	1425	54	44	33	171	72
	M42	N/A	N/A	2440	N/A	N/A	1870	40	32	24	126	53
Inch	1/4"	145	255	410	105	180	295	485	405	325	1455	650
	5/16"	145	265	420	110	205	320	365	310	245	1095	485
	3/8"	165	290	440	125	220	355	295	245	195	870	390
	1/2"	190	330	525	135	235	375	240	200	162	730	330
	5/8"	195	355	555	145	365	425	185	155	125	550	243
	3/4"	245	385	615	230	295	470	145	125	100	440	194
	7/8"	N/A	515	775	N/A	370	710	130	115	92	410	180
	1"	N/A	695	1050	N/A	445	735	120	100	85	370	165
	1-1/8"	N/A	N/A	790	N/A	N/A	820	96	78	59	303	128
	1-1/4"	N/A	N/A	1300	N/A	N/A	910	90	75	55	300	120
	1-3/8"	N/A	N/A	1620	N/A	N/A	1245	78	63	48	246	104
	1-1/2"	N/A	N/A	1810	N/A	N/A	1390	50	41	31	158	67
	1-3/4"	N/A	N/A	2670	N/A	N/A	2050	40	32	24	126	53

ImpactaTaps & MAX ImpactaTaps - Data Sheet VERSADRIVE PATENT PROTECTED

BEST PRACTICE ADVICE

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

1. *ImpactaTaps are recommended for through hole applications only*
2. *Spiral Flute ImpactaTaps are primarily recommended for blind hole applications using a clutched adapter to prevent the Tap from breaking when it reaches the bottom of the hole (See pages 22 & 23)*
3. *Pilot drill the exact tapping size hole for best results*
4. *Select the correct torque for Impact tools using the table opposite. If exact match is not available select the closest torque setting above the recommendation*
5. *Select the correct RPM when using rotary drive tools using the table opposite.*
6. *Apply firm, steady feed pressure throughout the cut*
7. *Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage*
8. *Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials*
9. *Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant*
10. *Flame cut/punched/profiled holes will require more torque to tap than drilled holes due to heat build up.*

Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage

11. *Tap the hole in one pass where possible, applying adequate lubrication before you start.*
12. *If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing*
13. *When using cordless tools, torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 4*
14. *When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque*
15. *Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & tool breakage*

N.B. Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

QUICK GUIDE

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Check the minimum torque requirement*
- *Laser cut holes & Stainless Steel require higher torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

MORE INFO

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 117 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

	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

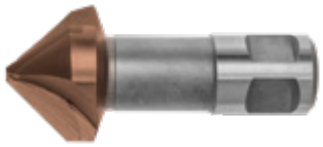
MORE INFO

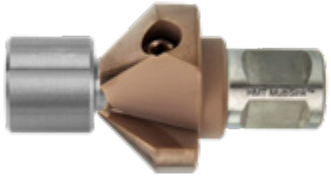
Metric Diameter (mm)	Hard Material c. 450 Brinell RPM (No Load) Based on 8.0 m/min
4	530
5	480
6	424
7	370
8	318
9	286
10	255
11	235
12	212
13	195
14	182

Inch Diameter (")	Hard Material c. 450 Brinell RPM (No Load) Based on 8.0 m/min
1/4	424
9/32	370
5/16	318
3/8	255
1/2	212
9/16	182

Metric Diameter (mm)	Hard Material c. 450 Brinell RPM (No Load) Based on 18.0 m/min
16	358
18	318
20	286
22	260
24	239
26	220
28	205
30	191
32	179
34	169
36	159

Inch Diameter (")	Hard Material c. 450 Brinell RPM (No Load) Based on 18.0 m/min
5/8	358
11/16	318
3/4	286
13/16	260
7/8	260
15/16	239
1	220





Countersink	Diameter		Hard Material c. 450 Brinell RPM (No Load)
Ultra Countersink	32mm	(1-1/4")	80 - 140
Ultra MultiSink	40mm	(1-1/2")	80 - 140
Ultra MultiSink	55mm	(2-1/4")	60 - 100

ULTRA Coated Cutters - Data Sheet
HOLEMAKER TECHNOLOGY HMT

BEST PRACTICE ADVICE

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

ULTRA Cutting Tools are designed for the Machining of Armor and Wear Plates such as HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

1. The extreme hardness and resistance of wear plate makes machining it extremely challenging.
2. Good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, such as the VersaDrive® V125T, and correct lubrication
3. Using an incorrect or poorly maintained Magnet Drill with unstable drilling operation, poor magnet hold, excessive pressure or inadequate lubrication is likely to result in rapid tool failure.
4. Even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It not only requires the correct setup but also experienced operators with the time necessary to proceed with caution.
5. Feed should be applied constantly, do not allow the drill to dwell as the material will work harden (if a rest or repositioning of hands is required, then retract the cutting tool slightly off the material first)
6. When drilling hard materials drill required hole size in one operation - do not attempt to pilot drill & step up through drill sizes
7. When cutting, any rubbing of the cutting tool must be avoided as it will increase the surface hardness, as wear plate material is designed to 'work-harden' to combat wear and abrasion
8. When using a 2-Geared Speed or 4-Geared Speed drilling machine, the lower gear speeds provide the most torque
9. When using the electronic variable speed and torque controls, maximum torque and power is available when both torque and speed are adjusted to their maximum setting
10. Machines fitted with torque control will try to maintain the selected speed and slow slightly, when under load
11. Regular application of lubricant and removal of swarf from the cutting face is essential
12. A hand brush is helpful to keep excess swarf away from the cut
13. Constant coolant application is advisable to carry away any heat generated by cutting, as heat build up can cause work hardening.
14. For best results use the new flood coolant pump with a soluble mix of BioCut Blue lubricant & room temperature tap water.

Suggested mix: 0.5L of BioCut Blue to 3.5L water

15. If a flood cooling system is used, consider there will be excess coolant spillage
16. For best result when countersinking, the countersink should be piloted where possible - see MultiSink pilots on page 95
17. Do not allow the countersink to vibrate over swarf while cutting as this will cause chatter, ultimately causing the cutting edge to chip & blunt

Cordless coolant pump
See page 100

MORE INFO

See the power of VersaDrive® in action

We believe the best way to experience the VersaDrive® advantage is to see it for yourself. That's why we offer multiple ways for you to witness it's the speed and versatility.

ON-SITE DEMOS & TRAINING

We're constantly hosting live demos, training sessions, and industry events. Head over to our events page to find out when we'll be near you, or book a custom demo session.

WATCH IT WORK

Head over to our YouTube channel where we've got live demonstrations, tutorials, and real-world applications showcasing VersaDrive® in action.

Subscribe & see the tools in action

YouTube

NEW HSS Broach Cutters
P.60

NEW Cordless Low Profile Mag Drill
P.77

NEW Cordless 1/2" Impact Wrench
P.75

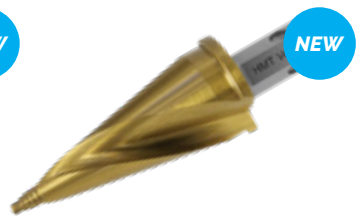
NEW Clutched Tapping Adapters
P.22 & 23

NEW ImpactaDie XL System
P.28 & 29

NEW Thread Chaser ImpactaTaps
P.49

NEW TurboTip Sizes
P.30 & 31

NEW VersaDrive® TurboTip Cone Cutters
P.36



NEW VersaDrive® TurboTip ImpactaSteps
P.36

NEW Clutched Tapping Kits
P.44

NEW VersaDrive® MAX Kits
P.56

NEW UnCoated & AliCut Burrs
P.98 & 99

HOLEMAKER TECHNOLOGY

HMT

Join the Revolution!

Subscribe & access all the latest content

YouTube

Don't miss out on the latest product demos, tutorials & customer success stories.

Stay connected & get the latest updates

@holemakertechnology

/company/holemaker-technology

/holemakertechnology

Find your local dealer at
www.holemaker-technology.com

sales@holemaker-technology.com
03330 110 382

5 061043 634275