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