Impact Reamers - Data Sheet

Impact Torque Nm

Reamer Diameter	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel	Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel
Diameter Ø	Nm Torque		Ft Lb Torque	
8MM	200	380	160	290
10MM	220	400	175	300
12MM	280	420	185	305
1/2"	300	445	205	310
14MM	320	480	220	330
9/16"	330	490	235	355
5/8"	335	505	250	375
16MM	340	510	260	390
11/16"	350	525	265	400
18MM	360	540	270	410
3/4"	370	550	280	420
20MM	380	570	285	425
21MM	390	580	290	430
22MM	400	600	300	435
7/8"	425	630	310	440
15/16"	460	695	380	575
24MM	520	780	385	600
1"	530	805	390	620
26MM	545	840	405	640
1-1/16"	575	875	440	660
28MM	600	900	480	750
30MM	650	975	520	785
32MM	680	1020	545	820
33MM	695	1035	560	840
36MM	740	1090	600	870
39MM	900	1150	720	920

Revolutions per minute (Rotary)

Reamer Diameter	Structural Steel <500Nm 32m/Min	Structural Steel <1000Nm 18m/Min	Stainless Steel INOX 12m/Min	Brass 32m/Min	Cast Iron (Grey) 16m/Min	Aluminium 45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2"	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16"	690	360	305	450	450	1025
5/8"	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16"	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4"	490	230	195	250	280	745
20MM	490	230	195	510	250	745
21MM	480	225	190	500	240	710
22MM	460	210	180	470	235	690
7/8"	460	210	180	235	235	675
15/16"	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1"	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16"	295	130	125	190	385	380
28MM	295	130	125	340	190	360
30MM	275	120	110	290	180	330
32MM	250	110	100	275	170	305
33MM	240	105	95	270	165	295
36MM	215	95	80	255	150	255
39MM	195	80	65	240	135	220

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	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.	5	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
2	To maximise tool life do not attempt to increase the existing hole diameter beyond 2-3mm. If a larger, finished hole size is required, then the next size reamer should be used to 'step up' until the finished hole diameter is reached.	6	Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive reamer.
3	Avoid lateral movement or tilting which can cause damage to the tool	7	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	8	Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Reamer should be rotating before starting the cut*
4	*Use steady feed pressure throughout the cut*