



Metric **Impact Torque Nm**

Step Drill Diameter	Impact Torque
Diameter Ø	Nm Torque
3-12 mm	200-280
14-22 mm	330-400
24-30 mm	400-485
32-40 mm	610-750

Revolutions per minute (Rotary)

Step Drill Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
3-12 mm	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
14-22 mm	597-430	390-270	200-145	600-440	245-180	380-275
24-30 mm	420-330	260-215	140-110	420-330	175-135	275-180
32-40 mm	260-230	160-145	85-75	260-230	95-85	150-140

Inch **Impact Torque Ft Lbs**

Step Drill Diameter	Impact Torque
Diameter Ø	Ft Lbs Torque
3/16-1/2"	270-380
3/16-7/8"	440-540
1/4-1-3/8"	540-660

Revolutions per minute (Rotary)

Step Drill Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
3/16-1/2"	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
3/16-7/8"	597-430	390-270	200-145	600-440	245-180	380-275
1/4-1-3/8"	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

<p>1</p> <p>Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage</p>	<p>4</p> <p>Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.</p>
<p>2</p> <p>Apply firm, steady feed pressure throughout the cut</p>	<p>5</p> <p>Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant</p>
<p>3</p> <p>Avoid lateral movement or tilting which can cause damage to the tool</p>	<p>6</p> <p>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.</p>

Quick Guide

1	<i>For fastest performance use on impact wrenches & impact drivers</i>
2	<i>Excellent life and performance when used with rotary pistol drills or drill presses</i>
3	<i>Suitable for stainless and harder materials if used at low RPM</i>
4	<i>Use appropriate lubrication and correct RPM to achieve long tool life</i>