KENNEDY
QUALITY INDUSTRIAL TOOLING

Recommended Cutting Speeds (RPM) for HSS Hole Saws





Uses: Steels, Cast Iron, Tool Steel, Stainless steel, Brass, Aluminium, Wood etc.

Note:

- Always use coolant when cutting metals except for cast iron which is cut dry.
- Only apply sufficient pressure to ensure that the hole saw cuts freely, too much pressure will create heat and dull the teeth.
- If cutting wood or laminates, finish the cut from the reverse side once the pilot drill shows through to avoid splintering.

(mm)	(inch)	Mild Steel	Cast Iron	Tool Steel Stainless	Brass	Aluminium	Wood
14	9/16"	580	400	300	790	900	800
16	5/8"	550	365	275	730	825	760
19	3/4"	460	300	230	600	690	680
20	-	440	290	220	580	660	640
21	13/16"	425	280	210	560	635	600
22	7/8"	390	260	195	520	585	560
25	1"	350	235	175	470	525	500
29	1 1/8"	300	200	150	400	450	450
30	"	285	190	145	380	425	430
32	1 1/4"	275	180	140	380	410	410
35	1 3/8"	250	165	125	330	375	370
38	1 1/2"	230	150	115	300	345	330
40	"	220	145	110	290	330	310
41	1 5/8"	210	140	105	280	315	290
44	1 3/4"	195	130	95	260	295	250
48	1 7/8"	180	120	90	240	270	210
51	2"	170	115	85	230	255	200
57	2 1/4"	150	100	75	200	225	185
60	2 3/8"	140	95	70	190	220	180
64	2 1/2"	135	90	65	180	205	180
70	2 3/4"	125	80	60	160	185	160
76	3"	115	75	55	150	170	150
83	3 1/4"	105	70	50	140	155	140
89	3 1/2"	95	65	45	130	145	130
102	4"	85	55	40	110	130	100
127	5"	65	45	30	90	90	85
152	6"	55	35	25	75	75	75

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General Health & Safety Advice

When using Kennedy Holesaws, always be aware and take care of your own personal protection.

1) Make sure you tie back long hair to avoid it coming into contact with the saw and causing serious injury. Wear close fitting overalls to prevent loose clothing getting caught in the saw.

2) Wear suitable Eye protection to prevent dust, splinters or shards of waste material entering the eyes.

3) Wear protective gloves, again to stop any splinters and shards of waste materials penetrating the skin. Also to protect against contamination from any cutting lubricant you may use if cutting metals.

4) Wear suitable ear protection, especially if using continuously

5) Wear a dust mask when cutting materials likely to create fine particles when cutting. If necessary wear breathing apparatus when working in dust continuously.