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KENNEDY®
QUALITY INDUSTRIAL TOOLING

OPERATING SUGGESTIONS

High Speed Steel Bimetal Hole Saws

Cutting tools may shatter when broken, we recommend you use approved eye and hand protection.

Arbors - Always ensure that you use the correct arbor for the size saw you plan to operate (See table below). The K2 and K10 arbors are fitted with quick release lock pins, which enable removal of the saw without removing from the chuck.

Arbors with 6.35mm (1/4") High Speed Pilot Drills

Arbor	Order Code KEN-050	Holesaw Size		Chuck Size	
		mm	In	mm	In
K4	**-1750K**	14-30	9/16 - 13/16	6.35	1/4
K1	**-1600K**	14-30	9/16 - 13/16	9.50	3/8
K10	**-1850K**	32-152	1 1/4 - 8 9/32	13.0	1/2
K1-1	**-1550K**	14-32	9/16 - 1 3/16	SDS - PLUS	
K2-1	**-1560K**	33-152	1 1/4 - 6	SDS - PLUS	

Lubrication - For cleaner cutting action and longer tool life use good quality lubricant when machining metal (excluding cast iron). Always keep the cutting teeth clear to prevent packing and overheating.

CUTTING SPEEDS

Suggested speeds for sawing various materials are shown below.
Because cutting conditions and materials are subject to variation, this data is only for guidance.

mm	Mild Steel	Stain-Steels	Cast Iron	Brass Bronze	Aluminium	Wood	mm	Mild Steel	Stain-Steels	Cast Iron	Brass Bronze	Aluminium	Wood
14	580	300	400	790	900	800	**60**	140	70	95	190	220	180
16	550	275	365	730	825	760	**64**	135	65	90	180	205	180
17	500	250	330	665	750	720	**65**	130	65	85	175	200	175
19	460	230	300	600	690	680	**67**	130	65	85	170	195	170
20	445	220	290	580	660	640	**68**	130	65	85	165	190	165
21	425	210	280	560	630	600	**70**	125	60	80	160	185	160
22	390	195	260	520	585	560	**73**	120	60	80	160	180	155
24	370	185	245	494	555	520	**76**	115	55	75	150	170	150
25	350	175	235	470	525	500	**79**	110	55	70	140	165	150
27	325	160	215	435	480	500	**83**	105	50	70	140	155	140
29	300	150	200	400	450	450	**86**	100	50	65	130	150	135
30	285	145	190	380	425	430	**89**	95	45	65	130	145	130
32	275	140	180	360	410	410	**92**	95	45	60	120	140	125
33	260	135	175	345	390	390	**95**	90	45	60	120	135	120
35	250	125	165	330	375	370	**98**	90	45	60	120	135	115
37	240	120	160	315	360	350	**102**	85	40	55	110	130	100
38	230	115	150	300	345	330	**105**	80	40	55	110	120	100
40	220	110	145	290	330	310	**108**	80	40	55	110	120	95
41	210	105	140	280	315	290	**111**	80	40	50	100	120	90
43	205	110	135	270	305	270	**114**	75	35	50	100	105	90
44	195	95	130	260	295	250	**121**	70	35	45	90	95	85
46	190	95	125	250	285	230	**127**	65	30	40	85	90	85
48	180	90	120	240	270	210	**133**	65	30	40	85	90	80
51	170	85	115	230	255	200	**140**	60	30	35	80	85	80
52	165	80	110	220	245	200	**152**	55	25	35	75	85	75
54	160	80	105	210	240	190							
56	155	75	100	205	230	190							
57	150	75	100	200	225	185							
59	145	75	100	195	225	185							

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37	240	120	160	315	360	350	102	85	40	55	110	130	100
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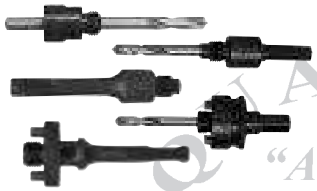
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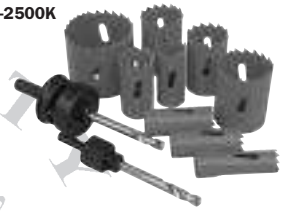
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HOLE SAW KITS & ACCESSORIES

Holesaws Arbors
Precision machined and threaded, made from alloy steel. Designed to ensure a quick change of holesaw or HSS pilot drill.



Tradesmen's Kit
Comprises of 11 variable pitch bi-metal high speed steel holesaws with hardened cutting edges and arbors. Complete with handy plastic storage tube.
KEN-050-2500K



Electrician's Kit
Comprises of 6 variable pitch bi-metal high speed steel holesaws with hardened cutting edges. With 2 arbors in a robust plastic carry case.
KEN-050-2300K



Service engineers Kit
Comprises of 6 variable pitch bi-metal high speed steel holesaws with hardened cutting edge. With 2 arbors in a robust plastic carry case.
KEN-050-2400K



Plumber's Kit
Comprises of 4 variable pitch bi-metal high speed steel holesaws with hardened with cutting edges. With 2 arbors in a robust plastic carry case.
KEN-050-2200K



Constant Pitch Holesaws Service Engineers Kit
Comprises of 6 constant pitch bi-metal high speed steel holesaws with hardened cutting edges. With 2 arbors supplied in a robust plastic carry case.
KEN-050-2000K



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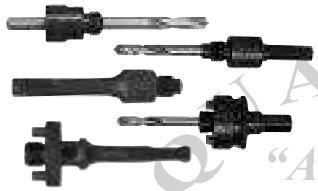
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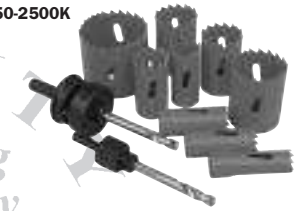
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