HOLEMAKER TECHNOLOGY

HMT

Edition 17: 2026

UNPRICED

FASTER - SAFER - MODULAR

Portable Drilling Systems to Speed Up Metalworking

STEELBOR®

VERSADRIVE®
PATENT PROTECTED

STAKIT®

The HMT story

Holemaker Technology was founded in 2014 by brothers Piers & Hugh Crane, building on a family heritage in welding and industrial supplies.

That background gave us a practical understanding of the challenges faced every day in the metalworking industry.

From those real-world experiences came a simple idea: to create tooling solutions that didn't yet exist — but that professionals were clearly asking for.

Since then, we've made it our mission to bring fresh innovation to cutting-tool design, developing systems that make metalworking faster, safer, and more efficient.

Ever since those early days, we've focused entirely on one thing — delivering better ways to create holes in metal.

That single-minded approach has made us specialists in our field and driven constant innovation across our product range.

From a small start-up with only an idea and a clear goal, Holemaker Technology has redefined what's possible in portable drilling.

Over these 12 years, we've evolved into the market-leading brand for metalworkers, now trusted and sold in over 50 countries.

Mission

To speed up metalworking through cutting tool innovation

Vision

To become the leading brand of portable drilling systems for metalworkers

Values

INNOVATE	Constantly adding improvements in all areas
SPECIALISE	Laser-focus on developing holemaking systems
OPTIMISE	Refining every component and process
BE AGILE	Always ready to respond to new challenges
BE NICE	Being a great team to work with

Problems we solve

HMT solves one of the most overlooked but critical challenges in metalworking: the difficulty of creating and modifying connection holes in metal components—especially during fabrication, installation, or maintenance when working in-situ.

For many years, portable drilling applications had relied on traditional methods that are slow, unsafe & expensive. Now, that has all changed.

Points of Difference

FASTER	15X Faster than traditional methods
SAFER	Eliminate drilling hazards
MODULAR	More Solutions from less tools

VERSADRIVE

Versadrive is HMT's unique modular cutting tool system, built with our patented hex-shank quick-change design.

STEELBOR

Steelbor is HMT's range of magnet drills and tooling, built around the universal weldon shank.

STAKIT

HMT's heavy-duty modular storage and custom kitting solution. Protect, organise and transport with ease.

ACCESSORIES

The essential companion range for Versadrive & Steelbor

Adaptable

Versadrive is an interchangeable system—with over 20 different quick-change modular adapters and extensions, it works with every type of drilling machine, giving you more solutions with fewer tools.

Impact Rated

Versadrive is the world's first cutting tool range specifically designed for use with impact wrenches—delivering up to 15X faster holemaking, while eliminating dangerous kickback for a safer, more controlled operation.

Accurate

The Versadrive hex shank features three concentric lock-points that align the tool perfectly in the adapter, ensuring maximum grip and reduced runout. This delivers cleaner, more accurate holes, even under high torque and impact conditions.

Maximum Power, Minimum Weight

All Steelbor Magnetic Drilling machines deliver an unmatched power-to-weight ratio—making it easier to work in tight or awkward spaces without compromising on performance.

The Complete Line-Up

From the compact cordless units to the mighty MAX200T, the scale and versatility of the Steelbor range is unmatched—covering everything from everyday site work to the most demanding holemaking tasks.

Multiple Options. One System

The Steelbor tiered tooling range includes ULTRA coated tooling for extreme applications, premium TCT for tough materials, and entry-level Silvermax HSS for everyday applications.

All Steelbor tooling features the universal Weldon shank—ensuring compatibility with a wide range of machines, wherever the job takes you.

Custom Kitting

Mix and match modular cases and insertfoams

Pre-Built Kits

Professionally assembled with proven, widely specified tooling

Full Sitekits

Comprehensively stocked site carts, configured for rapid roll-out

Lubricant Range

Formulated to optimise tool life and cutting performance

18v Drilling Machines

Powerful impact wrench and pistol drill for handheld applications

Burrs, Drill Bits, Countersinks

Engineered for compatibility with industry-standard equipment

Technical Advice

As the experts in portable drilling – HMT is your specialist resource for selecting and optimising the best solution for every task.

MATLAS

Our unique methodology and checklist for getting the right tools and the right outcome every time.

Field Demonstration Team

Set up to visit your site and assist with tool selection, training, and live demonstrations.

Digital Training Library

Giving you instant access to expert online video training to get the right results from your tooling.

Stock Availability

HMT's 95% stock availability reflects our commitment to stock investment.

HMT Hub

Our Online Dealer portal give 24/7 access to product data, stock levels, order tracking and more, at your convenience.

Fast Shipping

HMT's digital warehouse systems can dispatch your orders the same day, helps prevent downtime and keeps the job moving.

Warranty System

Our unique warranty and advisory system, providing fast support and replacements when needed.

RAPID-LOCK ADAPTERS



EXTENSION & MORSE TAPER ADAPTERS



HEAVY DUTY ADAPTERS



HEAVY DUTY & CLUTCHED TAPPING ADAPTERS


NEW Size

CREATE A NEW HOLE



ENLARGE AN EXISTING HOLE



THREADING



COUNTERSINKING



CORDLESS RANGE

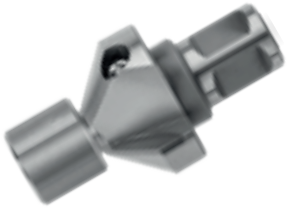
COMPACT & CORDED MAGNET DRILLS

TAPPING & LARGE CAPACITY MAGNET DRILLS

SPECIALIST SOLUTIONS

ANNULAR BROACH CUTTERS

COUNTERSINKING



VERSADRIVE ADAPTERS

Versadrive Adapter Foam - P113

Versadrive Rapid-Lock Adapter Set - P112

Versadrive Heavy Duty Adapter Set - P112

VERSADRIVE COMPATIBLE FOAMS FOR TOOLING UP TO 115MM LENGTH

Versadrive 8 space InsertFoam - P113

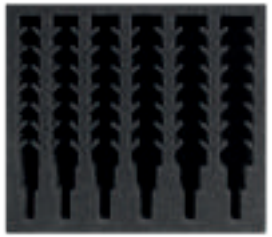
Versadrive 7 space InsertFoam - P113

Versadrive InsertFoam Sets - From P32

VERSADRIVE & STEELBOR COMPATIBLE FOAMS FOR TOOLING UP TO 195MM LENGTH

Versadrive XL Length InsertFoam - P113

Versadrive XL Length InsertFoam - P113



Versadrive XL Length Sets - From P32

STEELBOR COMPATIBLE FOAMS FOR TOOLING UP TO 103MM LENGTH

SteelBor 5 Space InsertFoam - P113

SteelBor InsertFoam Sets - From P72

ULTRA InsertFoam Sets - From P84

ETOP 2 CASES & KITS

Empty ETOP2 Case - P112

ETOP2 Turbo Impact Set - P114

ETOP2 Turbo Drilling Set - P114

ETOP 4 CASES & KITS

Empty ETOP4 Case - P112

ETOP4 Impact Set - P115

ETOP4 Combination Sets - P119

EMID KITS

Versadrive Site Installation Kit - P117

Versadrive MAX Reamer Kit - P68

Broach, Tap & Ream Kit - P70

SITECARTS & SITEKITS

STAKIT Wheeled SiteCart - P116

STAKIT Wheeled SiteCart - P116

STAKIT SiteKits

POWER TOOLS

V18-900 ½" Cordless Impact Wrench - P26

V18-120 Cordless Combi Drill - P27

OverReach System - P98

MORSE TAPER ACCESSORIES

Morse Taper Arbor - P102

Morse Taper Extension - P111

Morse Taper Sleeve Reducers - P111

MAGNET DRILL ACCESSORIES

31.75 to 19.05mm Shank Adapter - P102

Magnet Drill Chuck Adapter - P102

Morse Taper Drifts - P111

LUBRICANTS

500ml BioCut Blue Cutting Fluid - P107

5L BioCut Blue Cutting Fluid - P107

Cordless Coolant Pump - P106

TURBOTIP COBALT JOBBER DRILL BITS

TurboTip Jobber Drill Bits - P108

TurboTip Jobber Drill Bit Sets - P108

TurboTip Jobber Drill Bit Sets - P108

MORSE TAPER DRILL BITS & COUNTERSINKS

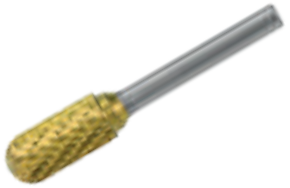
Morse Taper Drill Bits - P110

Morse Taper Countersinks - P111

Morse Taper Indexable Countersinks - P111

TUNGSTEN CARBIDE BURRS

GoldMax Coated TCT Burrs - P104



Uncoated TCT Burrs - P104

AliCut TCT Burrs - P104

LUBRICANTS & SWARF MAGNET

BioCut Cutting & Drilling Paste - P107

SpeedLube Aerosol Lubricant - P107

Swarf Magnet - P111

V18-900 Cordless Impact Wrench (½" drive)

VERSADRIVE® PATENT PROTECTED

The Versadrive V18-900 is a powerful and compact brushless impact wrench, rated for metal drilling, threading, and hole enlargement work alongside standard bolt tightening & loosening.

Quickly and safely create and modify connection holes in heavy metal components.

Optimised for use with the Versadrive range of cutting tools and compatible with the full range of Makita LXT 18v batteries.

- *Compatible with Makita LXT 18v Batteries*
- *Supplied with Versadrive Rapid-Lock adapter*
- *3 Impact settings plus Nutbuster mode*
- *Powerful & efficient brushless motor*
- *Rapid airflow cooling system*
- *LED lighting for workpiece illumination*

TECHNICAL SPECIFICATIONS

ANVIL/DRIVE SIZE	½"
NO LOAD SPEED (RPM)	1500 / 2000 / 2500
MODES	3 Impact Modes + Nutbuster Mode
IMPACT TORQUE	400 / 630 / 900Nm
IMPACT RATE (BPM)	1600 / 2200/ 2700
DRILLING/FASTENING TORQUE	900 Nm
NUT BUSTING TORQUE	1180 Nm
WEIGHT (with 4Ah battery)	2.5kg
DIMENSIONS (with 4Ah battery)	272 x 74 x 166mm
VOLTAGE	18v
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & Makita LXT 18v

Part No	Contents
808010-010	Versadrive 1/2" Impact Wrench Body only
808010-025	Versadrive 1/2" Impact Wrench 4.0Ah Kit
808010-020	Versadrive 1/2" Impact Wrench 9.0Ah Kit
809010-040	18v 4.0Ah Battery
809010-090	18v 9.0Ah Battery
809020-020	18v Compact Battery Charger

All versions supplied with protective site case & Versadrive Rapid-Lock adapter. Kits also supplied with, 2 batteries and a charger

V18-120 Cordless Combi Drill

VERSADRIVE® PATENT PROTECTED

The V18-120 is a compact, brushless, combi pistol-type drill engineered for precise metal drilling and countersinking in structural and installation work.

Fitted with a metal chuck and all-metal 2-speed gearbox, it delivers smooth torque transfer, long-term durability, and full compatibility with Makita LXT 18V battery systems.

- *Dual speed settings for controlled drilling & countersinking*
- *Compatible with Makita LXT 18v Batteries*
- *Brushless motor for increased efficiency, higher power, long lifespan and reduced maintenance*
- *LED lighting for workpiece illumination*
- *Variable speed trigger with stepless speed adjustment*
- *Triple mode settings for rotary drilling, hammer drilling & clutched screwdriving*

TECHNICAL SPECIFICATIONS

CHUCK SIZE	13mm
RATED VOLTAGE	18v
MOTOR TYPE	Brushless DC
NO LOAD SPEED (RPM)	500 / 2200
MAX OUTPUT TORQUE	120Nm
MAX DRILL CAPACITY (Metal)	13mm
IMPACT PER MINUTE	9500 / 40000
WEIGHT (with 4Ah battery)	2kg
DIMENSIONS (with 4Ah battery)	252 x 75 x 183mm
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & Makita LXT 18v

Part No	Contents
808510-010	Versadrive V18-120 Combi Drill Body only
808510-025	Versadrive V18-120 Combi Drill 4.0Ah Kit Inc. Body + 2 x 4.0Ah Batteries + Compact Charger

See P26 for Batteries and Charger

All versions supplied with protective site case & Auxiliary side handle for improved control and reduced strain & kickback. Kits also supplied with, 2 batteries and a charger

VERSADRIVE® PATENT PROTECTED

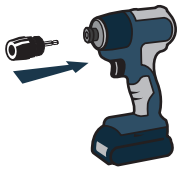
Versadrive adapters have been custom engineered to rapidly fit Versadrive cutting tools to a wide range of standard site and workshop drive tools, including Impact Wrenches, Magnet Drills and cordless Combi Drills.

This unique system means that Versadrive tooling offers the greatest flexibility of use of any metal cutting tools as it can be used with almost any power tool using cordless, mains or air power.

- *Rapid-Lock, single handed loading*
- *Quick Release collar for swift tool changeover*
- *Impact rated for high speed operation - up to 15x faster than traditional methods*
- *Impact rated system stops dangerous kickback when drilling with handheld drills*
- *Knurled design for easy grip in damp and greasy conditions*
- *Collar design prevents contact with work piece and accidental tool release*
- *Hardened steel components with rust resistant finish*
- *Industrial strength to easily handle the high torque of modern Impact tools*
- *Converts a wide range of powertools for use with Versadrive*

Versadrive Rapid-Lock ¼" Impact Driver Adapter

Converts standard ¼" Impact Drivers for use with Versadrive

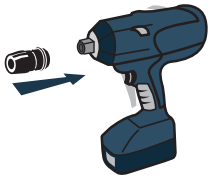


Part No	Ø (mm)	L (mm)
111027-014A	28	75

Versadrive Rapid-Lock ½" Impact Wrench Adapter

Rapid-Lock Versadrive adapter to convert ½" Impact Wrenches for use with Versadrive

Supplied with retention pin & securing ring



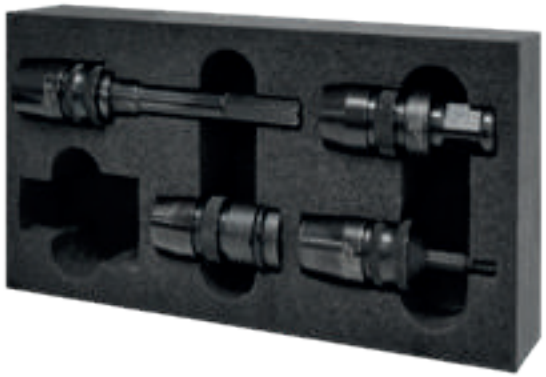
Part No	Ø (mm)	L (mm)
111130-012A	28	55

Versadrive Rapid-Lock Adapter Set

Small InsertFoam to fit ***STAKIT*** ETOP2 or ETOP4 top cases - See page 112

Contains:

¼" Versadrive Impact Driver Adapter
½" Versadrive Impact Wrench Adapter
Versadrive Magnet Drill Weldon Adapter
Versadrive 130mm Extension Arbor

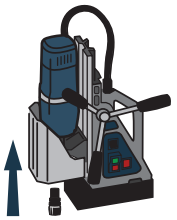


Part No	Product
111005-SET1	Versadrive Rapid-Lock Adapter InsertFoam Set 4pc

Versadrive Rapid-Lock Magnet Drill Adapter

Converts Magnet Drills for use with Versadrive

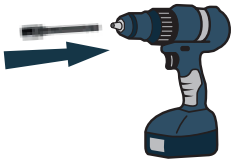
Fits all standard Magnet Drills with 19.05mm (3/4") Weldon arbor



Part No	Ø (mm)	L (mm)
111035-01	28	66

Versadrive Rapid-Lock Extension Arbor 130mm

Extends working reach of all Versadrive tools & bypasses obstacles
Can be used in conjunction with other Versadrive adapters
11mm Hex shank for non-slip use in drill chucks
Rated for Impact and Rotary use

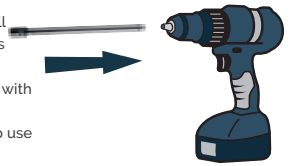


Part No	Ø (mm)	L (mm)
111016-130	28	130

VERSADRIVE® PATENT PROTECTED

Versadrive Rapid-Lock Extension Arbor 300mm

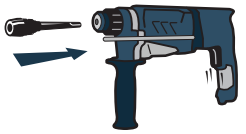
Extends working reach of all Versadrive tools & bypasses obstacles
Can be used in conjunction with other Versadrive adapters
11mm Hex shank for non-slip use in drill chucks
Rated for Impact and Rotary use



Part No	Ø (mm)	L (mm)
111016-300	28	300

Versadrive Rapid-Lock SDS+ Adapter

Converts standard SDS+ Drills for use with Versadrive
(Use in Rotary mode only)



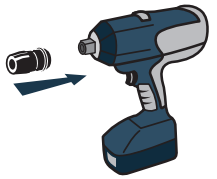
Part No	Ø (mm)	L (mm)
112010-01	28	140

Versadrive Heavy Duty ⅜" Impact Wrench Adapter

Heavy Duty Versadrive adapter to convert high-power ⅜" Impact Wrenches for use with Versadrive

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring



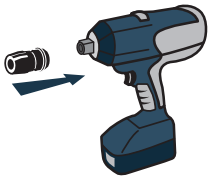
Part No	Ø (mm)	L (mm)
111120-038A	25	50

Versadrive Heavy-Duty ½" Impact Wrench Adapter

Heavy Duty Versadrive adapter to convert high-power ½" Impact Wrenches for use with Versadrive

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring

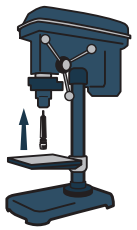


Part No	Ø (mm)	L (mm)
111120-012A	25	55

Versadrive Rapid-Lock Morse Taper Arbor

Ideal for workshop use with Morse Taper Pillar Drills & Magnet Drills

Available in Morse Taper 2 & 3



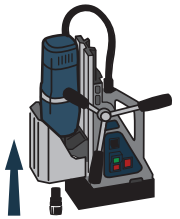
Part No	Drive	Ø (mm)	L (mm)
111045-02	MT2	28	130
111045-03	MT3	28	147

Versadrive Magnet Drill Adapter - 19.05mm

Converts Magnet Drills for use with Versadrive

Recommended for use drilling very hard materials when high precision with minimal runout is required

Fits all standard Magnet Drills with 19.05mm (3/4") Weldon arbor



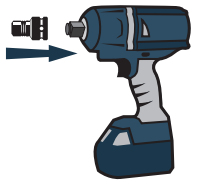
Part No	Ø (mm)	L (mm)
111030-0002	26	60.5

Versadrive Heavy Duty ¾" Impact Wrench Adapter

Heavy Duty Versadrive adapter to convert high-power ¾" Impact Wrenches for use with Versadrive

Rust resistant Manganese Phosphate finish

Supplied with retention pin & securing ring



Part No	Ø (mm)	L (mm)
111120-034A	38	60

Versadrive Heavy Duty Adapter Set 4pc

Small InsertFoam to fit ***STAKIT*** ETOP2 or ETOP4 top cases.

Contains:
Versadrive ½" Heavy Duty Impact Wrench Adapter
Versadrive ¾" Heavy Duty Impact Wrench Adapter
Versadrive Rapid-Lock Magnet Drill Adapter
Versadrive 130mm Extension Arbor

Part No	Size
111005-SET2	Versadrive HD Adapter InsertFoam Set 4pc

TECHNICAL DATA & USER ADVICE P120 - P143

101030 TCT HoleCutter Sets
Metric Sizes

Part No	Set contents
101030-SET1	14, 18 & 22mm
101030-SET2	14, 17, 18, 21 & 22mm

101030 TCT HoleCutter Sets
Fractional Sizes

Part No	Set contents
101030-INSET1	9/16, 11/16, 13/16"
101030-INSET2	9/16, 11/16, 13/16, 15/16, 1-1/16"

101050 TCT SheetCutter Sets
Metric Sizes

Part No	Set contents
101050-SET1	14, 18 & 22mm
101050-SET2	14, 18, 20, 22 & 26mm
101050-SET4	16, 20, 25 & 32mm

101035 Extra Long TCT HoleCutter Sets

Part No	Set contents
101035-SET1	14, 18, 20, 22, 24 & 26mm
101035-SET2	9/16, 11/16, 7/8, 15/16"

TCT SheetCutter Pilot Drill Bits

101050 Pilot Drills	
101050P-0001	Replacement SheetCutter Pilot Drill Bits Pack of 2

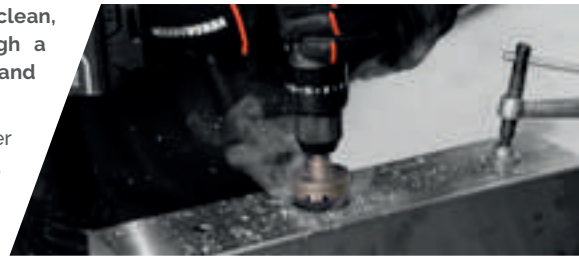
TCT HoleCutter Pilot Drill Bits & Pins

101030 Pilot Drills & Pins	
101030P-0130	Pilot Drill for 12 & 13mm HoleCutters (2pk) (Supplied WITHOUT ejection spring)
101030P-0001	Pilot Drill for 14-80mm HoleCutters (2pk) (Supplied WITH ejection spring)
101030P-0003	Versadrive HoleCutter Magnet Broaching / MultiSink Pilot Pin, (2pk)

101035 Pilot Drills & Pins	
101035P-01	Extra Long TCT HoleCutter Pilot Drills 6.35x165mm, (2pk)
101035P-02	Extra Long HoleCutter Guide Pin 6.35x205mm, (2pk)

Versadrive TCT SheetCutter Holesaws deliver clean, precise holes quickly and efficiently through a variety of materials including mild steel and stainless steel up to 4mm thick.

Individually brazed tungsten carbide teeth offer exceptional durability and cutting performance, giving up to 10x longer life than standard bi-metal holesaws and faster, easier cuts up to 76mm diameter.



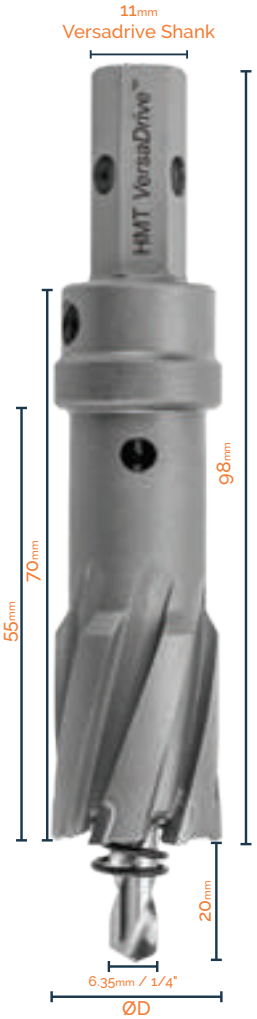
- *Up to 4mm depth of cut on Mild Structural Steel*
- *Excellent for use on Stainless Steel up to 4mm thick*
- *Use on Aluminium up to 4mm thick*
- *Premium quality Tungsten Carbide teeth with adjacent swarf discharge grooves for clean, clog-free cuts*
- *Use in standard 1/2" drill chuck*
- *New design step-tip pilot drill*
- *Safety collar design for controlled hole break-through*
- *One piece design inc. arbor & (replaceable) stepped pilot drill that dampens breakthrough impact & prevents teeth damage*

Part No	ØD (mm)	ØD (")
101050-0140	14	9/16”
101050-0160	16	5/8”
101050-0170	17	11/16”
101050-0180	18	
101050-0190	19	3/4”
101050-0200	20	
101050-0210	21	13/16”
101050-0220	22	7/8”
101050-0250	25	1”
101050-0260	26	
101050-0280	28	
101050-0290	29	1-1/8”
101050-0300	30	1-3/16”
101050-0320	32	1-1/4”
101050-0350	35	1-3/8”
101050-0380	38	1-1/2”
101050-0400	40	
101050-0440	44	1-3/4”
101050-0500	50	
101050-0510	51	2”
101050-0640	64	
101050-0760	76	

Versadrive TCT HoleCutters are a high performance solution for cutting larger diameter holes quickly and effectively. Premium grade Tungsten Carbide teeth provide ultimate cutting performance in a wide range of metals including Stainless Steel and Cast Iron.

The go-to solution for fabricators and steel erectors needing to drill through heavy steel.

- *Massive 70mm reach with 55mm depth of cut*
- *Perfect for drilling heavy steel in remote locations*
- *Premium quality Tungsten Carbide teeth*
- *Combine with MultiSink to broach & countersink in 1 pass*
- *Use with Magnet Drill adapter*
- *Use in standard 1/2" drill chuck*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Rotary Rated - not recommended for Impact use*



Part No	ØD (mm)	ØD (")	Set Screw
101030-0120	12		M5
101030-0130	13		
101030-0140	14	9/16"	
101030-0150	15		
101030-0160	16	5/8"	
101030-0170	17	11/16"	M6
101030-0175	17.5		
101030-0180	18		
101030-0190	19	3/4"	
101030-0200	20		
101030-0210	21	13/16"	M8
101030-0220	22	7/8"	
101030-0230	23		
101030-0240	24	15/16"	
101030-0250	25	1"	
101030-0260	26		
101030-0270	27	1-1/16"	
101030-0280	28		
101030-0290	29	1-1/8"	
101030-0300	30	1-3/16"	
101030-0310	31		
101030-0320	32	1-1/4"	
101030-0330	33	1-5/16"	
101030-0340	34		

Part No	ØD (mm)	ØD (")	Set Screw
101030-0350	35	1/3-8"	M8
101030-0360	36		
101030-0370	37	1-7/16"	
101030-0380	38	1-1/2"	
101030-0390	39	1-9/16"	
101030-0400	40		
101030-0410	41	1-5/8"	
101030-0420	42		
101030-0430	43	1-11/16"	
101030-0440	44	1-3/4"	
101030-0450	45		
101030-0460	46	1-13/16"	
101030-0470	47		
101030-0480	48	1-7/8"	
101030-0490	49		
101030-0500	50		
101030-0510	51	2"	
101030-0520	52	2-1/16"	
101030-0550	55	2-5/32"	
101030-0600	60	2-3/8"	
101030-0650	65	2-9/16"	
101030-0700	70	2-3/4"	
101030-0750	75		
101030-0800	80	3-5/32"	

See P32 for Sets

Extra Long reach version of the popular Versadrive HoleCutter. Perfect for drilling through steelwork sections using a Pistol Drill where a separate extension isn't practical.

Ideal for applications where a metal plate is encountered amongst wood joists or where both sides of a steel beam require drilling.

- *Massive 120mm reach with 100mm depth of cut*
- *Perfect for drilling heavy steel in remote locations*
- *Perfect for drilling box section with inaccessible sides*
- *Premium quality Tungsten Carbide teeth*
- *Use with Magnet Drill adapter*
- *Use in standard 1/2" drill chuck*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Rotary Rated - not recommended for Impact use*

Part No	ØD (mm)	ØD (")	Set Screw
101035-0140	14	9/16"	M5
101035-0170	17	11/16"	M6
101035-0180	18		
101035-0200	20		
101035-0210	21	13/16"	M8
101035-0220	22	7/8"	
101035-0240	24	15/16"	
101035-0260	26		

See P32 for Sets

Versadrive Impact Step Drill Bit 3pc Set
Metric Sizes

Part No	Set contents
505020-SET1	12, 22, 30mm

Versadrive Impact Step Drill Bit 3pc Set
Fractional Sizes

Part No	Set contents
505030-SET1	1/2, 7/8, 1-3/8"

Versadrive Impact Step Drill Bit 4pc Set
Metric Sizes

Part No	Set contents
505020-SET2	12, 22, 30, 40mm

Versadrive Cone Cutter 3 pc Set
Metric Sizes

Part No	Set contents
505050-SET1	20, 25, 32mm

Versadrive TurboTip ImpactaStep Cutter 3pc Sets

Part No	Set contents
506040-SET1	16, 22, 26mm
506050-SET1	9/16, 13/16, 1-1/16"

Versadrive TurboTip ImpactaStep Cutter 4pc Set
Metric Sizes

Part No	Set contents
506040-SET2	16, 22, 26, 32mm

The first step drill optimised for use with Impact Wrenches & Impact Drivers allowing the user to create holes in seconds.

Featuring a spiral flute design with self-starting drill tip, for fast, smooth drilling with a rotary drill or Impact Wrench and market leading 5mm thick drilling capacity.

- *Market leading 5mm step thickness*
- *118° split point angle for easy hole start & pilot accuracy*
- *Spiral flute design and size markings at each step*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)	l1 (mm)	L (mm)	Step Diameters (mm)
505020-0120	12	47	75	4, 6, 8, 10, 12
505020-0220	22	58	86	4, 6, 8, 10, 12, 14, 16, 18, 20, 22
505020-0300	30	77	105	4, 6, 8, 10, 12, 14, 16, 18, 20, 22, 24, 26, 28, 30
505020-0400	40	72	101	6, 8, 10, 12,16, 18, 20, 25,29, 32, 36, 40
Electrician's Step Drill 4 - 32.5mm				
505040-0320	32.5	70	99	4, 6, 8.5, 10.5, 12.5, 14.5, 16, 18.5, 20.5, 23.5, 25, 30.5, 32.5
Fractional	**ØD (")**	**l1 (")**	**L (")**	**Step Diameters (")**
505030-0010	1/2	1-1/2	2-43/64	3/16, 1/4, 5/16, 3/8, 7/16, 1/2
505030-0020	7/8	2-9/32	3-15/32	3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8
505030-0030	1-3/8	1-31/32	3 5/32	1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1-1/8, 1-1/4, 1-3/8

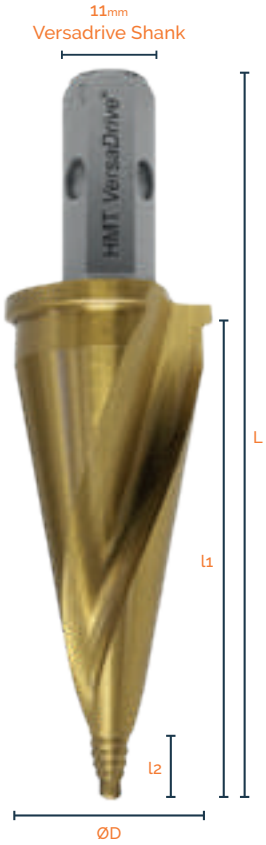
TurboTip Impact ConeCutters

VERSADRIVE® PATENT PROTECTED

The Impact-rated TurboTip ConeCutter is designed for thin materials such as electrical boxes or sheet metalwork.

Ideal to enlarge an undersized hole to fit an electrical gland. The TurboTip stepped tip allows for fast hole starting with no pilot drill needed The short drill length allows use in tight spaces.

- *Safety collar prevents injury & damage*
- *Spiral flute design*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Versadrive patented shank and modular adapters provide unbeatable jobsite flexibility*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*



Metric	ØD (mm)	ØD (")	l1 (mm)	l2 (mm)	L (mm)	Diameter range (mm)
505050-0200	20	13/16"	52	9.5	81	8 - 20
505050-0250	25	1"	67	9.5	95.5	8 - 25
505050-0320	32	1-1/4"	68	14.5	97	16 -32

InsertFoam Sets	
505050-SET1	20, 25, 32mm

Note: Versadrive Cone Cutters are designed for use in sheet metal and should not be used in material exceeding 2-3mm in thickness

TurboTip ImpactaStep Cutters

VERSADRIVE® PATENT PROTECTED

The Impact-rated TurboTip ImpactaStep cutters are a unique combination drill bit. The innovative TurboTip stepped design now allows for fast pilot drilling with low feed pressure with superb accuracy and hole finish.

Each ImpactaStep cutter features 5 stepped hole sizes with each size clearly marked inside the flute, and offers combined drilling and reaming on materials up to 12mm thick.

- *5 heavy duty drill bits in one tool*
- *Drill new & enlarge existing holes in metal up to 12mm thick*
- *Safety collar prevents injury & damage when using the largest step*
- *Upgraded spiral-flute design for increased performance and swarf clearance*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *Use on Impact to prevent dangerous kickback*

Metric	ØD (mm)	l1 (mm)	l2 (mm)	L (mm)	Step Diameters (mm)
506040-0160	16	82	10	112	8, 10, 12 14, 16
506040-0220	22	85.5	12.5	115	14, 16, 18, 20, 22
506040-0260	26	89.5	16	118	18, 20, 22, 24, 26
506040-0320	32	94	20.5	123	24, 26, 28, 30, 32

Fractional	ØD (")	l1 (")	l2 (")	L (")	Step Diameters (")
506050-0010	9/16"	3-5/16"	3/8"	4-27/64"	5/16", 3/8", 7/16", 1/2", 9/16"
506050-0020	13/16"	3-17/32"	27/64"	4-5/8"	9/16", 5/8", 11/16", 3/4", 13/16"
506050-0030	1-1/16"	3-3/4"	13/16"	4-55/64"	13/16", 7/8", 15/16", 1", 1-1/16"

See P36 for Sets
Metric step depth = 12mm
Fractional Step Depth = 1/2"

Versadrive Reamer 3pc Sets

Part No	Set contents
501030-3SET	14, 18, 22mm
501040-3SET	1/2, 5/8, 3/4"

Versadrive Reamer 5pc Sets

Part No	Set contents
501030-SET	12, 14, 18, 22, 26mm
501040-5SET	1/2, 5/8, 3/4, 7/8, 1-1/16"
501040-SET7	9/16, 11/16, 13/16, 15/16, 1-1/16"

Versadrive Reamer 6pc Set
Metric Sizes

Part No	Set contents
501030-SET3	8, 10, 12, 14, 16, 18mm

Versadrive Reamer 6pc Set
Metric Sizes

Part No	Set contents
501030-SET4	18, 20, 21, 22, 24, 26mm

Versadrive Reamer 10pc ETOP4 Set
Fractional Sizes

Part No	Set contents
501040-SET10	1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8, 15/16, 1, 1-1/16"

Versadrive Reamer 11pc ETOP4 Set
Metric Sizes

Part No	Set contents
501030-SET11	8, 10, 12, 14, 16, 18, 20, 21, 22, 24, 26mm

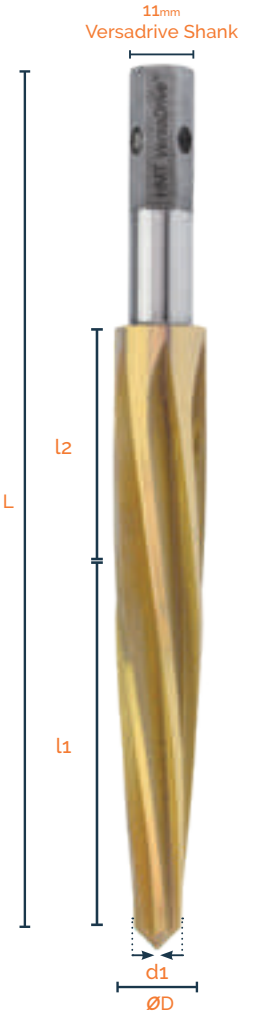
Impact Reamers
VERSADRIVE® PATENT PROTECTED

Versadrive reamers are the perfect hole alignment and enlarging tool for metalworkers & steel erectors for keeping the job moving when a hole is misaligned or the incorrect size for the fixing.

Featuring a specially designed 6 flute cutting geometry and Titanium coating, Versadrive Reamers are fully Impact rated and perform fastest when used with an Impact Wrench.

- *Precision 6-flute design for smooth cutting*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Edge cutting design for hole enlargement, giving much better results that a drill bit*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)	Ød1 (mm)	l1 (mm)	l2 (mm)	L (mm)
501030-0080	8	4.5	34	34	106
501030-0100	10	6.3	34	36	108
501030-0120	12	7.5	47	56.5	142
501030-0140	14	8.5	63	43.5	144
501030-0160	16	8.5	58	56.5	152.5
501030-0180	18	10	58	63.5	171
501030-0200	20	11.6	61	75	185.5
501030-0210	21	12	61	66	178.5
501030-0220	22	13	66	70	185
501030-0240	24	15	66	71	185
501030-0260	26	16	64	71	185
Fractional	**ØD (")**	**Ød1 (")**	**l1 (")**	**l2 (")**	**L (")**
501040-0040	1/2 (12.7mm)	19/64	1-15/16	2-1/16	5-1/2
501040-0050	9/16 (14.3mm)	9/32	2-1/16	1-15/16	5-1/2
501040-0060	5/8 (15.9mm)	5/16	2-11/64	2-21/64	6
501040-0070	11/16 (17.5mm)	3/8	2-1/4	2-1/4	6
501040-0080	3/4 (19.05mm)	13/32	2-31/64	2-33/64	7
501040-0085	13/16 (20.63mm)	15/32	2-33/64	2-31/64	7
501040-0090	7/8 (22.2mm)	17/32	2-19/32	2-13/32	7
501040-0100	15/16 (23.8mm)	19/32	2-43/64	2-21/64	7
501040-0110	1 (25.4mm)	5/8	2-43/64	2-21/64	7
501040-0120	1-1/16 (27mm)	45/64	2-9/16	2-7/16	7



Versadrive TurboTip 4pc Sets

Part No	Set contents
209015-SET1	6, 8, 10, 12mm
209016-SET1	3/16, 1/4, 5/16, 1/2"
209016-SET2	#7, #F, 5/16, 27/64"

Versadrive TurboTip 7pc Sets
Metric Sizes

Part No	Set contents
209015-SET2	6, 7, 8, 9, 10, 11, 12mm
209015-SET3	6.8, 8, 8.5, 10, 10.5, 12, 14mm
209015-SET4	6, 8, 10, 12, 14, 18, 22mm
209015-SET7	11, 12, 13, 14, 16, 18, 20mm

Versadrive TurboTip 8pc Set
Metric Sizes

Part No	Set contents
209015-SET6	6, 6.8, 7, 8, 8.5, 9, 10, 10.5mm

Versadrive TurboTip 3" Flute 6pc Set
Fractional Sizes

Part No	Set contents
209016-SET3	17/32, 9/16, 5/8, 11/16, 3/4, 13/16"

Versadrive TurboTip 12pc Set
Fractional Sizes

Part No	Set contents
209016-SET12	3/16, #7, 7/32, 1/4, #F, 9/32, 5/16, 11/32, 3/8, 27/64, 7/16, 1/2"

Versadrive TurboTip 16pc Set
Metric Sizes

Part No	Set contents
209015-SET16	6, 6.8, 7, 8, 8.5, 9, 10, 10.5, 11, 12, 13, 14, 16, 18, 20, 22mm

TurboTip Drill Bits
VERSADRIVE® PATENT PROTECTED

Versadrive TurboTip Impact drill bits are stepped tip bits that drill at twice the speed of standard bits without the need for pilot drilling while cutting a perfectly round hole.

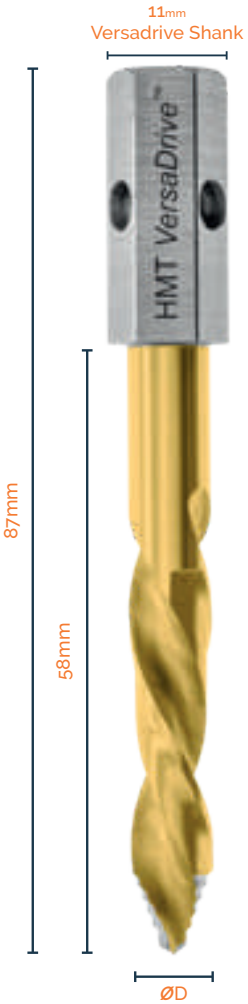
Turbocharge your drilling performance by using this revolutionary tool with an Impact Wrench or Impact Driver. Double hardened and titanium coated for faster drilling & reduced wear.

- *No pilot drilling needed due to patented stepped-tip drill point*
- *Faster drilling with 1/3 less feed pressure required*
- *Reduces fatigue for the operator*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)
209015-0060	6
209015-0068	6.8
209015-0070	7
209015-0080	8
209015-0085	8.5
209015-0090	9
209015-0100	10
209015-0102	10.2
209015-0105	10.5
209015-0110	11
209015-0120	12
209015-0130	13
209015-0140	14
209015-0160	16
209015-0175	17.5
209015-0180	18
209015-0200	20
209015-0210	21
209015-0220	22

Fractional	ØD (")
209016-0010	3/16
209016-0020	#7
209016-0030	7/32
209016-0040	1/4
209016-0050	#F
209016-0060	9/32
209016-0070	5/16
209016-0080	11/32
209016-0090	3/8
209016-0100	27/64
209016-0120	7/16
209016-0130	1/2
209016-0140	17/32**
209016-0150	9/16**
209016-0160	5/8**
209016-0170	11/16**
209016-0180	3/4**
209016-0190	13/16**

**3" flute length



Versadrive Cobalt Drill Bit 4pc Sets

Part No	Set contents
209010-SET1	6, 8, 10, 12mm
209010-SET2	5, 6.8, 8.5, 10.2mm
209013-SET1	1/4, 5/16, 3/8, 1/2"
209013-SET2	#7, #F, 5/16, 3/8"

Versadrive Cobalt Drill Bit 7pc Set
5 - 10.2mm

Part No	Set contents
209010-SET3	5, 6, 6.8, 8, 8.5, 10, 10.2mm

Versadrive Cobalt Drill Bit 7pc Sets
Metric Blacksmith Sizes

Part No	Set contents
209010-SET4	12, 13, 14, 16, 18, 20, 22mm
209010-SET7	10.2, 11.5, 12, 13, 14, 16, 18mm

Versadrive Cobalt Drill Bit 7pc Set
Fractional Blacksmith Sizes

Part No	Set contents
209013-SET3	#7, 1/4, #F, 5/16, 3/8, 27/64, 1/2"

Versadrive Cobalt Drill Bit 8pc Set
5 - 10mm

Part No	Set contents
209010-SET6	5, 6, 6.8, 7, 7.5, 8, 9, 10mm

Versadrive Cobalt Drill Bit 8pc Set
3/16 - 9/16"

Part No	Set contents
209013-SET4	3/16, 1/4, 5/16, 3/8, 27/64, 7/16, 1/2, 9/16"

Cobalt Drill Bits
VERSADRIVE® PATENT PROTECTED

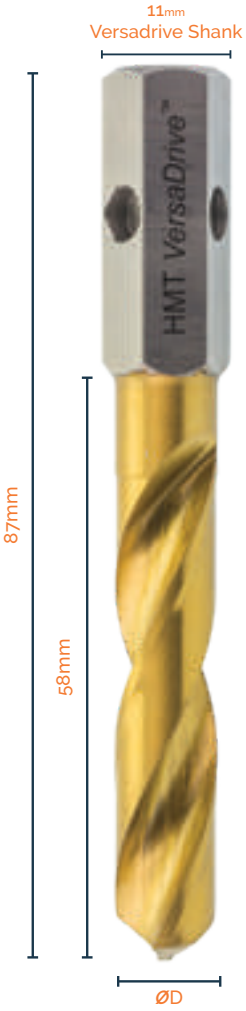
Versadrive Cobalt Drills are a premium grade 8% Cobalt drill bit with fully ground flutes, 135˚ Split point and Titanium coating for faster drilling & reduced wear.

Suitable for heavy fabrication use, this Cobalt drill bit can also be used to drill stainless steel, mild steel, cast iron and a wide range of other structural materials.

- *Precision ground flute design provide easy chip clearance*
- *8% Cobalt tool steel for long life & endurance with 135° split point for easy starting & high accuracy*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

Metric	ØD (mm)
209010-0042	4.2
209010-0050	5
209010-0055	5.5
209010-0060	6
209010-0065	6.5
209010-0068	6.8
209010-0070	7
209010-0075	7.5
209010-0080	8
209010-0085	8.5
209010-0090	9
209010-0095	9.5
209010-0100	10
209010-0102	10.2
209010-0105	10.5
209010-0115	11.5
209010-0120	12
209010-0125	12.5
209010-0130	13
209010-0140	14
209010-0155	15.5
209010-0160	16
209010-0175	17.5
209010-0180	18
209010-0200	20
209010-0210	21
209010-0220	22

Fractional	ØD (")
209013-0010	3/16
209013-0020	#7
209013-0030	7/32
209013-0040	1/4
209013-0050	#F
209013-0060	9/32
209013-0070	5/16
209013-0080	11/32
209013-0090	3/8
209013-0100	27/64
209013-0120	7/16
209013-0130	1/2
209013-0140	9/16

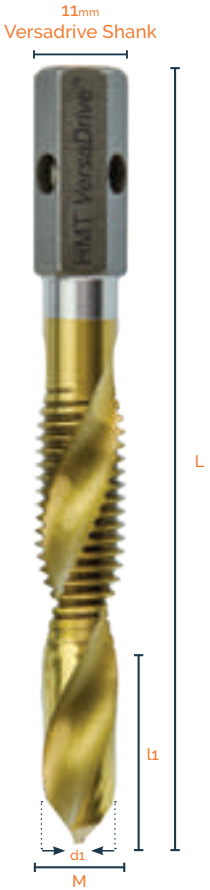


Impact Drill Taps

Versadrive Drill Taps are a time saving solution for pilot drilling & tapping in one easy operation. The Titanium coating provides wear resistance and faster cutting performance.

Recommended for use with Impact Drivers for high drilling and tapping productivity.

- *Drill pilot holes and then tap in one fast, easy operation*
- *Dual hardened for impact use*
- *Ground flute twist drill creates the correct pilot hole size*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Up to 15X faster speed than traditional methods*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Impact Chipbreaker action for effective swarf evacuation*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*



Metric	M Thread Size & Pitch	Max Material Thickness**	Ød1 (mm)	L (mm)	l1 (mm)
301125-0030	M3 x 0.50	3mm	2.5	54	4.8
301125-0040	M4 x 0.70	4mm	3.3	68.5	7
301125-0050	M5 x 0.80	5mm	4.2	70	11
301125-0060	M6 x 1.00	6mm	5.0	73.5	13
301125-0080	M8 x 1.25	8mm	6.8	80.5	15
301125-0100	M10 x 1.50	10mm	8.5	89	18
301125-0120	M12 x 1.75	12mm	10.2	102.5	25
Fractional	**M Thread Size & Pitch**	**Max Material Thickness**	**Ød1 (")**	**L (")**	**l1 (")**
301126-0010	4-40 UNC	3/32	3/32	2-11/64	15/64
301126-0020	6-32 UNC	1/8	7/64	2-23/64	23/64
301126-0030	8-32 UNC	5/32	9/64	2-23/64	23/64
301126-0040	10-24 UNC	13/64	5/32	2-51/64	33/64
301126-0045	12-24 UNC	13/64	5/32	2-51/64	33/64
301126-0050	1/4-20 UNC	1/4	13/64	2-61/64	19/32
301126-0060	5/16-18 UNC	5/16	1/4	3-15/64	45/64
301126-0070	3/8-16 UNC	3/8	5/16	3-5/8	55/64
301126-0080	1/2-13 UNC	1/2	27/64	4-1/64	1-7/64

InsertFoam Sets

301125-SET1	M5, M6, M8, M10, M12
301126-SET1	1/4, 5/16, 3/8, 1/2" UNC

***Rated for material thickness no greater than the diameter of the drill-tap*

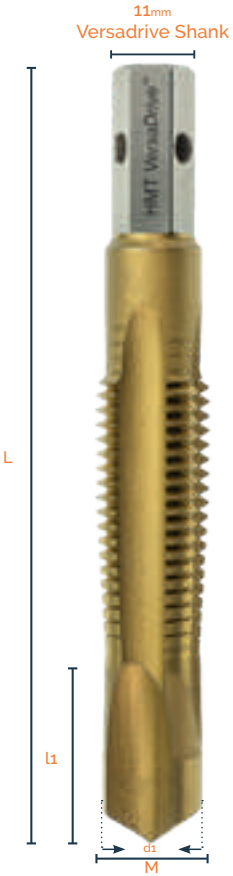
Heavy Duty DrillTaps

Versadrive Heavy Duty Drill Taps are an industrial metalwork or fabrication tool for drilling and tapping heavy steel in one easy operation.

Primarily designed to be used with a reversible Magnet Drill, they can be adapted for use with an Impact Wrench to enlarge and tap existing holes.

Not recommended for use in a Pistol Drill.

- *Impact Chipbreaker action for effective swarf evacuation*
- *Ground flute twist drill creates the correct pilot hole size*
- *Rated for heavy duty plate thicknesses*
- *Heavy duty straight flute design creates a strong and durable tool*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*



Metric	M Thread Size & Pitch	Ød1 (mm)	L (mm)	l1 (mm)	MTD** (mm)
301130-0080	M8 x 1.25	6.8	117	28.5	20
301130-0100	M10 x 1.50	8.5	118	27	20
301130-0120	M12 x 1.75	10.2	117	27	25
301130-0160	M16 x 2.00	14	117	25	25
301130-0200	M20 x 2.50	17.5	135	27.5	35
301130-0240	M24 x 3.00	21	150	32	40
Fractional	**M Thread Size & Pitch**	**Ød1 (")**	**L (")**	**l1 (")**	**MTD** (")**
301140-0001	1/2-13 UNC	27/64	4-23/32	1-3/8	1
301140-0002	5/8-11 UNC	17/32	5-1/8	1-29/64	1
301140-0003	3/4-10 UNC	21/32	5-33/64	1-37/64	1-3/8
301140-0005	1-8 UNC	7/8	6-19/64	1-49/64	1-37/64

InsertFoam Sets

301130-SET1	M12, M16, M20, M24
301130-SET2	M8, M10, M12, M16, M20, M24
301140-SET1	1/2, 5/8, 3/4, 1"

***Max Tapping Depth*

Versadrive ImpactaTap Sets
Metric Sizes

Part No	Set contents
308010-SET1	M6, M8, M10, M12, M16
308010-SET2	M12, M16, M20, M24

Versadrive ImpactaTap Set
Metric Sizes

Part No	Set contents
308010-SET3	M6, M8, M10, M12, M16, M20, M24

Versadrive ImpactaTap Set
Fractional Sizes

Part No	Set contents
308050-SET1	1/4, 5/16, 3/8, 1/2, 5/8" UNC

Versadrive ImpactaTap Sets
Fractional Sizes

Part No	Set contents
308050-SET2	1/2, 5/8, 3/4, 1" UNC

Versadrive TurboTip & ImpactaTap Combi Set

Part No	Set contents
328015-SET1	6.8, 8.5, 10.5, 14mm TurboTips + M8, M10, M12, M16 ImpactaTaps

Versadrive TurboTip & ImpactaTap Combi Set

Part No	Set contents
328016-SET2	#7, #F, 5/16, 27/64" TurboTips + 1/4, 5/16, 3/8, 1/2" ImpactaTaps

ImpactaTaps VERSADRIVE® PATENT PROTECTED

Versadrive ImpactaTaps are the first range of taps that are suitable to be driven by Impact Wrenches and Impact Drivers, providing at least 15x faster performance than tapping by hand.

With a specially designed twin-lead, cutting geometry, specialist Titanium coating and dual hardened body, ImpactaTaps provide an optimised solution for quickly & easily tapping holes in steel.

- *Impact Chipbreaker action for effective swarf evacuation*
- *Unique twin-point cutting geometry with ground flutes*
- *Create internal threaded holes with speed and precision*
- *Quickly clean out & repair damaged or fouled internal threads*
- *Impact-rated due to dual hardening process*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Allows up to 15X faster speed than traditional methods*

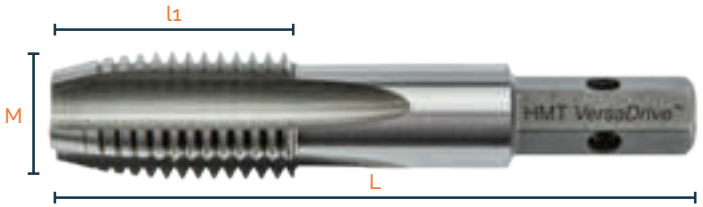
Metric Coarse	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308010-0050	M5 x 0.80	56	18	4.2
308010-0060	M6 x 1.00	58	20	5
308010-0080	M8 x 1.25	60	22	6.8
308010-0100	M10 x 1.50	70	24	8.5
308010-0120	M12 x 1.75	80	29	10.2
308010-0140	M14 x 2.00	90	32	12
308010-0160	M16 x 2.00	90	32	14
308010-0180	M18 x 2.50	100	37	15.5
308010-0200	M20 x 2.50	100	37	17.5
308010-0240	M24 x 3.00	110	45	21
308010-0270	M27 x 3.00	130	47	24
308010-0300	M30 x 3.50	130	48	26.5
UNC	**M Thread Size & Pitch**	**L (")**	**l1 (")**	**Tap Hole Size**
308050-0010	1/4 x 20 UNC	2-9/32	25/32	#7 (5.1mm)
308050-0020	5/16 x 18 UNC	2-23/64	55/64	#F (6.6mm)
308050-0030	3/8 x 16 UNC	2-3/4	15/16	5/16" (8mm)
308050-0040	1/2 x 13 UNC	3-5/32	1-9/64	27/64" (10.8mm)
308050-0050	5/8 x 11 UNC	3-1/2	1-17/64	17/32" (13.5mm)
308050-0060	3/4 x 10 UNC	4	1-29/64	21/32" (16.5mm)
308050-0065	7/8 x 9 UNC	4-9/64	1-37/64	49/64" (19.5mm)
308050-0070	1 x 8 UNC	4-21/64	1-49/64	7/8" (22.25mm)

ImpactaTaps Long Series - Metric Coarse

Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	l2 (mm)	Tap Hole Size (mm)
308015-0080	M8 x 1.25	140	45	112	6.8
308015-0100	M10 x 1.50	155	50	127	8.5
308015-0120	M12 x 1.75	180	55	152	10.2
308015-0160	M16 x 2.0	200	65	172	14
308015-0200	M20 x 2.5	230	70	202	17.5
308015-0240	M24 x 3.0	260	75	232	21

Spiral Point Taps for fast chip ejection in through holes.

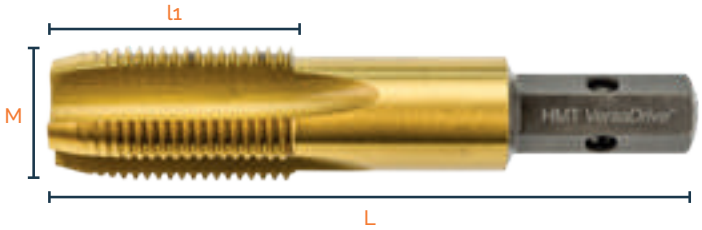
ImpactaTaps - Metric Coarse Oversized - For use with Galvanised Fixings



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (Metric Coarse thread - mm)
308020-0050	M5.4 x 0.80	55	18	4.2
308020-0060	M6.4 x 1.00	55	20	5.0
308020-0080	M8.4 x 1.25	60	22	6.8
308020-0100	M10.4 x 1.50	70	24	8.5
308020-0120	M12.4 x 1.75	80	29	10.2
308020-0160	M16.4 x 2.00	90	32	14.0
308020-0200	M20.4 x 2.50	100	37	17.5
308020-0240	M24.4 x 3.00	110	45	21.0
308020-0300	M30.4 x 3.50	130	48	26.5
InsertFoam Set				
308020-SET1	6 Pc Set: M5.4, M6.4, M8.4, M10.4, M12.4, M16.4			

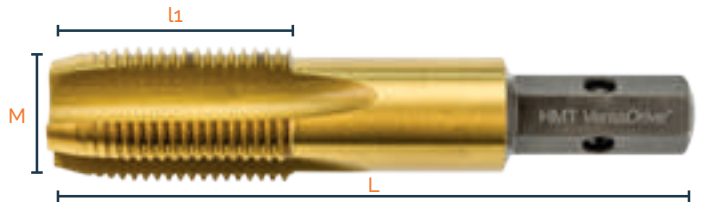
ImpactaTaps VERSADRIVE® PATENT PROTECTED

ImpactaTaps - Metric Fine Thread



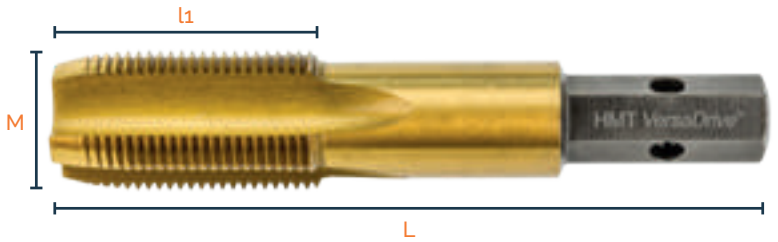
Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308030-0060	M6 x 0.75 MF	60	19	5.2
308030-0800	M8 x 1.00 MF	70	22	7.0
308030-0100	M10 x 1.25 MF	70	24	8.8
308030-0120	M12 x 1.50 MF	80	29	10.5
308030-0160	M16 x 1.50 MF	90	32	14.5
308030-0180	M18 x 1.50 MF	100	37	16.5
308030-0200	M20 x 1.50 MF	100	37	18.5
308030-0240	M24 x 1.50 MF	120	92	22.5

ImpactaTaps - UNF Thread



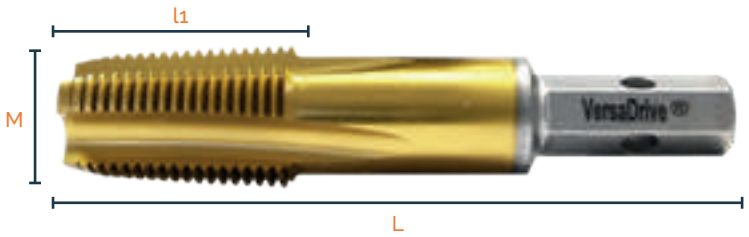
Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size
308051-0010	1/4 x 28 UNF	58	20	#3
308051-0020	5/16 x 24 UNF	60	22	#I
308051-0030	3/8 x 20 UNF	70	24	#Q
308051-0040	1/2 x 20 UNF	80	29	29/64"
308051-0050	5/8 x 18 UNF	90	32	37/64"
308051-0060	3/4 x 16 UNF	100	37	11/16"
308051-0065	7/8 x 14 UNF	105	40	13/16"
308051-0070	1 x 12 UNF	110	45	59/64"

ImpactaTaps - BSP Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308070-0010	1/8 x 28 BSP	70	24	8.8
308070-0020	1/4 x 19 BSP	90	32	11.8
308070-0030	3/8 x 19 BSP	90	32	15.25
308070-0040	1/2 x 14 BSP	100	37	19
308070-0050	5/8 x 14 BSP	100	37	21
308070-0060	3/4 x 14 BSP	100	37	24.5
308070-0070	1 x 11 BSP	110	45	30.75

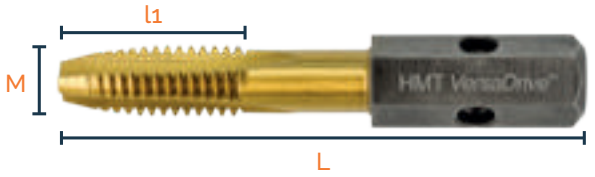
ImpactaTaps - NPT Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size
308075-0010	1/8 x 27 NPT	70	19	#R
308075-0020	1/4 x 18 NPT	90	27	7/16"
308075-0030	3/8 x 18 NPT	90	27	37/64"
308075-0040	1/2 x 14 NPT	100	35	23/32"
308075-0050	3/4 x 14 NPT	100	35	59/64"
308075-0060	1 x 11.5 NPT	110	44	1-5/32"

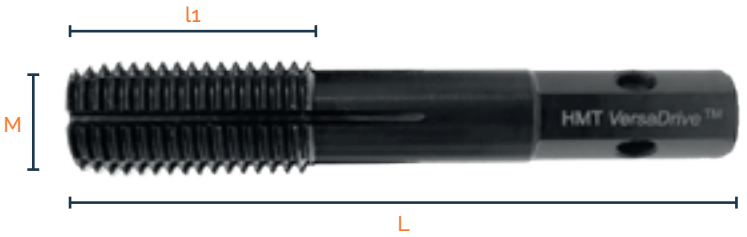
ImpactaTaps VERSADRIVE® PATENT PROTECTED

ImpactaTaps - BSW Thread



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
308060-0010	1/4 x 20 BSW	58	20	5.1
308060-0015	5/16 x 18 BSW	60	22	6.5
308060-0020	3/8 x 16 BSW	70	24	7.9
308060-0030	1/2 x 12 BSW	80	29	10.5
308060-0040	5/8 x 11 BSW	90	32	13.5
308060-0050	3/4 x 10 BSW	100	37	16.25
308060-0060	1 x 8 BSW	110	45	22

ImpactaTaps - Thread Chaser Taps



Part No.	M Thread Size & Pitch	L (mm)	l1 (mm)	Tap Hole Size (mm)
309210-0060	M6 x 1.0	61	25	5.2
309210-0080	M8 x 1.25	60	23.5	7
309210-0100	M10 x 1.5	70	25.5	8.8
309210-0120	M12 x 1.75	80	32	10.2
309210-0160	M16 x 2.0	90	32.5	14.5
309210-0200	M20 x 2.5	100	38	18.5
309210-0240	M24 x 3.0	110.5	46	22.5
InsertFoam Sets	**Contents**			
309210-SET1	5Pc Set: M6, M8, M10, M12, M16			
309210-SET2	4Pc Set: M12, M16, M20, M24			
309210-SET	7Pc Set: M6, M8, M10, M12, M16, M20, M24			

Tap blind holes without breaking the tap.

The Versadrive clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-power, reversible Morse Taper magnetic drill, insert a Versadrive Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.

- *Quick change system accepts all Versadrive Taps*
- *Adapters pre-set to appropriate clutch settings*
- *Collar design prevents accidental tool release*
- *Options for tapping blind holes from M8 - M30*
- *Optimised for use with Versadrive Spiral Flute Taps*
- *Collar finished in rust resistant Manganese Phosphate*

Part No	Drive size	For hole sizes (Metric Coarse)	For hole sizes (" UNC)	d1 (mm)	D (mm)	L (mm)
132002-0812	MT2	M8 - M12	5/16" - 1/2"	29	47	186
132002-1216	MT2	M12 - M16	1/2" - 5/8"	29	61	194
132002-1620	MT2	M16 - M20	5/8" - 3/4"	29	61	194
132003-2024	MT3	M20 - M24	3/4" - 1"	29	61	220
132003-M30	MT3	M30	1-3/16"	29	61	220

NEW Size

Sets	
132000-SET2	MT2 Clutched Adapter (M8 - M12) + MT2 Clutched Adapter (M12 - M16) + MT2 Clutched Adapter (M16 - M20) + M8 - M20 Versadrive Spiral Flute Taps
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) + MT2 Clutched Adapter (1/2" - 5/8" UNC) + MT3 Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC Versadrive Spiral Flute Taps

Impact Tap blind holes without breaking the tap.

The Versadrive clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-torque Impact Wrench, insert a Versadrive Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.

- *Quick change system accepts all Versadrive Taps*
- *Adapters pre-set to appropriate clutch settings*
- *Collar design prevents accidental tool release*
- *Collar finished in rust resistant Manganese Phosphate*
- *Options for tapping blind holes from M8 - M24*
- *Optimised for use with Versadrive Spiral Flute Taps*
- *Supplied with retention pin & securing ring*

Part No	Drive size	For hole sizes (Metric Coarse)	For hole sizes (" UNC)	d1 (mm)	D (mm)	L (mm)
131012-0812	½"	M8 - M12	5/16" - 1/2"	29	47	101
131012-1216	½"	M12 - M16	1/2" - 5/8"	29	61	116
131034-2024	¾"	M20 - M24	3/4" - 1"	29	61	125

Sets	
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) + 1/2" Impact Wrench Clutched Adapter (M12 - M16) + 3/4" Impact Wrench Clutched Adapter (M20 - M24) + M8 - M24 Versadrive Spiral Flute Taps
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) + 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) + 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC Versadrive Spiral Flute Taps

Versadrive Spiral Flute Tap Sets
Metric Sizes

Part No	Set contents
309010-SET1	M6, M8, M10, M12, M16
309010-SET2	M12, M16, M20, M24

Versadrive Spiral Flute Tap Sets
Fractional Sizes

Part No	Set contents
309020-SET1	1/4, 5/16, 3/8, 1/2, 5/8" UNC
309020-SET2	1/2, 3/4, 1" UNC

Versadrive Impact Wrench Clutched Adapter Set
Metric Coarse

Part No	Set contents
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) 1/2" Impact Wrench Clutched Adapter (M12 - M16) 3/4" Impact Wrench Clutched Adapter (M20 - M24) M8 - M24 Versadrive Spiral Flute Taps

Versadrive Impact Wrench Clutched Adapter Set
Fractional UNC

Part No	Set contents
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) 5/16 - 1" UNC Versadrive Spiral Flute Taps

Versadrive Morse Taper Clutched Adapter Set
Metric Coarse

Part No	Set contents
132000-SET1	MT2 Clutched Adapter (M8 - M12) MT2 Clutched Adapter (M12 - M16) MT3 Clutched Adapter (M20 - M24) M8 - M24 Versadrive Spiral Flute Taps

Versadrive Morse Taper Clutched Adapter Set
Fractional UNC

Part No	Set contents
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) MT2 Clutched Adapter (1/2" - 5/8" UNC) MT3 Clutched Adapter (3/4" - 1" UNC) 5/16 - 1" UNC Versadrive Spiral Flute Taps

Versadrive Spiral Flute Taps are designed for tapping blind holes.

They can be adapted for use in a reversible Magnet Drill, Impact Wrench, cordless pistol drill or even used with any standard Hand Tap wrench.

Recommended for use with Versadrive Clutched Tapping Adapters.

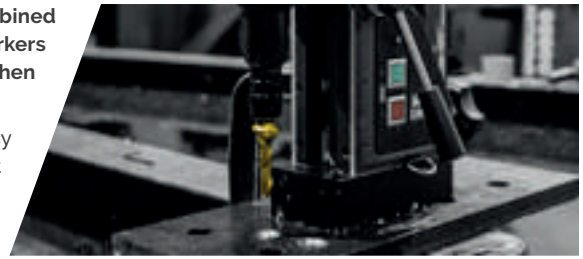
- *Ground flutes create the perfect tapped hole*
- *Safer tapping with minimal kickback*
- *Create internal threaded holes with speed and precision*
- *Quickly clean out & repair damaged or fouled internal threads*
- *Impact-rated due to dual hardening process*
- *Use on Impact to prevent dangerous kickback caused by handheld rotary tools*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Allows up to 15X faster speed than traditional methods*

Metric Coarse	M Thread Size & Pitch	L (mm)	l1 (mm)	THS**	THS***
309010-0060	M6 x 1.00	58	20	5.0	-
309010-0080	M8 x 1.25	60	22	6.8	-
309010-0100	M10 x 1.50	70	24	8.5	-
309010-0120	M12 x 1.75	80	29	10.2	-
309010-0160	M16 x 2.00	90	32	14.0	-
309010-0200	M20 x 2.50	100	37	17.5	-
309010-0240	M24 x 3.00	110	45	21.0	-
309010-0300	M30 x 3.50	130	48	26.5	-
Fractional	**M Thread Size & Pitch**	**L (*)**	**l1 (*)**	**THS****	**THS*****
309020-0010	1/4 x 20 UNC	2-3/8	63/64	5.1	#7
309020-0020	5/16 x 18 UNC	2-3/8	63/64	6.6	#F
309020-0030	3/8 x 16 UNC	2-3/4	1	8	5/16
309020-0040	1/2 x 13 UNC	3-1/8	1-3/64	10.8	27/64
309020-0050	5/8 x 11 UNC	3-1/2	1-5/64	13.5	17/32
309020-0060	3/4 x 10 UNC	3-31/32	1-9/64	16.5	21/32
309020-0065	7/8 x 9 UNC	4-1/8	1-13/16	19.5	49/64
309020-0070	1 x 8 UNC	4-3/8	2	22.25	7/8
309020-0110	1-1/4 x 7 UNC	5	2	28	1-7/64

*** Tap Hole Size (mm)* *** Tap Hole Size (")*

The Versadrive DrillSink is an innovative combined drilling & countersinking tool to save metalworkers time & increase hole accuracy by drilling & then countersinking fixing holes in one operation.

This provides perfect countersinking accuracy every time by locating the drilled hole in perfect alignment to the countersink. This helps prevent tool chatter and blunting commonly found with standard countersinks.



- *Drill & countersink in one easy operation*
- *Ground flutes for high accuracy & long life*
- *Perfect concentricity for accurate countersinking*
- *Integrated pilot drill prevents the chattering of standard countersinks*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*

Clearance Hole	Ø D (mm)	Countersink Size (mm)	l1 (mm)	L (mm)	Countersunk Screw	CSK Angle
603070-08124	8	12.4	45	91.2	M6	90°
603070-10165	10	16.5	44.5	84	M8	90°
603070-11205	11	20.5	44	89	M10	90°
603070-12205	12	20.5	44.5	88.5	M10	90°
603070-13250	13	25	44	92	M12	90°
603070-14250	14	25	42	91.7	M12	90°
Tapped Hole	**Ø D (mm)**	**Countersink Size (mm)**	**l1 (mm)**	**L (mm)**	**Countersunk Screw**	**CSK Angle**
603070-68165	6.8	16.5	47	85	M8 (Tap)	90°
603070-85205	8.5	20.5	47	89	M10 (Tap)	90°
603070-102250	10.2	25	47	93	M12 (Tap)	90°

InsertFoam Set

603070-SET4	8/12.4, 10/16.5, 12/20.5, 14/25mm

The Versadrive Countersink is a premium quality countersink with fully ground flutes and GoldMax Titanium coating to help reduce wear and blunting.

Utilise the convenience and power of an Impact Wrench to quickly debur and countersink holes up to 16.5mm with minimal torque kick-back against the operator.

- *Perfect concentricity for accurate countersinking*
- *Versadrive patented shank and modular adapters provide unbeatable jobsite flexibility*
- *Quality results on stainless steels and Inox - rotary application recommended*
- *Ground flutes for high accuracy & long life*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Industrial grade Titanium Nitride coating reduces heat buildup and burn-out*

Metric 90°	ØD (mm)	Ød1 (mm)	l1 (mm)	L (mm)	Countersunk Screw	CSK Angle
603060-0063	6.3	1.5	5.5	45	M3	90°
603060-0083	8.3	2.0	6	50	M4	90°
603060-0104	10.4	2.5	8	50	M5	90°
603060-0124	12.4	2.8	8	56	M6	90°
603060-0165	16.5	3.2	11.5	60	M8	90°
603060-0205	20.5	3.5	12	63	M10	90°
603060-0250	25	3.8	15	67.5	M12	90°
603060-0310	31	4.2	18	69	M16	90°
Fractional 82°	**ØD (")**	**Ød1 (")**	**l1 (")**	**L (")**	**Countersunk Screw**	**CSK Angle**
603065-0100	1/4	1/16	7/64	1-27/32	-	82°
603065-0200	3/8	7/64	5/32	2-3/64	-	82°
603065-0300	1/2	7/64	7/32	2-9/32	-	82°
603065-0400	5/8	1/8	9/32	2-7/16	-	82°
603065-0500	3/4	1/8	11/32	2-9/16	-	82°
603065-0600	1	11/64	31/64	2-23/32	-	82°

InsertFoam Sets

603060-5SET	12.4, 16.5, 20.5, 25, 31mm - 90°
603065-5SET	3/8, 1/2, 5/8, 3/4, 1" - 82°

Versadrive ImpactaBurr TCT Chamfer Tool

The ImpactaBurr chamfer tool has tungsten carbide inserts designed to chamfer the outside edge of tube and round bar.

This removes dangerous burrs and also prepares the facing edge ready to receive an external thread or fastener.

- *Quick and effective deburring and chamfering*
- *Impact rated to reduce dangerous kickback*
- *Compatible with the Versadrive adapter range*
- *60° angle*
- *Impact & Rotary rated*

Part No	For use with	Ø	L
115200-0190	4 - 18mm Bar	29mm	57mm
115200-0360	19 - 36mm Bar	46mm	61mm

Versadrive ImpactaDie Kit
M6 - M12 Threads // 1/4 - 1/2" UNC Threads

The ImpactaDie Impact Die threading kit is a complete solution for creating and repairing external threads on metal bar.

Faster, more efficient and less fatiguing than traditional hand threading practices, the ImpactaDie system can be used to quickly and accurately cut new or repair damaged external threads using an Impact Wrench or Magnetic Drill*.

Along with all necessary dies and guides for threading at sizes M6 - M12 (¼ - ½"), the kit contains the unique Versadrive ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading. Supplied in a Versadrive ***STAKIT*** compatible ETOP2 half top case.

*(requires Versadrive Impact Wrench Adapter or Versadrive Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-SET	ImpactaDie Holder, Guide Collar, Flush Collar, M6/8/10/12 Guides, M6/8/10/12 Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case
115820-SET	ImpactaDie Holder, Guide Collar, Flush Collar, 1/4, 5/16, 3/8, 1/2" Guides, 1/4, 5/16, 3/8, 1/2" UNC Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case

ImpactaDie (Impact Die Threader) VERSADRIVE® PATENT PROTECTED

Create external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- *Guide collar ensures straight & true threading*
- *Create external threads from M6 - M12*
- *Create external threads up to 50mm long*
- *Impact chipbreaker action for effective swarf evacuation*
- *Versadrive patented shank & modular adapters provide unbeatable jobsite flexibility*
- *Use with Impact Wrenches (prevents dangerous kickback)*
- *Clean out existing external threads*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*

ImpactaDie Holder

Flush Collar
(for repairing threads)

Guide Collar
(for creating threads)

ImpactaDie Hex Die Nut

ImpactaDie Guide

Versadrive ImpactaDie Holder (body only)

Part No	Suitable for
115100-01	M6 - M12 Threads 1/4-20 - 1/2-13 UNC

Versadrive ImpactaDie Collars

Part No	Product
115100-02	Guide Collar for creating M6 - M12 & 1/4-20 - 1/2-13 UNC Threads
115100-03	Flush Collar for repairing M6 - M12 & 1/4-20 - 1/2-13 UNC Threads

ImpactaDie Hex 24mm Die Nut

Part No	To create or repair threads sized
302810-0060	M6 x 1.0
302810-0080	M8 x 1.25
302810-0100	M10 x 1.5
302810-0120	M12 x 1.75
302820-0010	1/4-20 UNC
302820-0020	5/16-18 UNC
302820-0030	3/8-16 UNC
302820-0040	1/2-13 UNC

ImpactaDie Guides

Part No	For thread sizes
115110-0060	M6
115110-0080	M8
115110-0100	M10
115110-0120	M12
115120-0010	1/4"
115120-0020	5/16"
115120-0030	3/8"
115120-0040	1/2"

11mm
Versadrive Shank

Total assembled length of holder + guide collar + guide = 121mm

Versadrive ImpactaDie XL Kits
M16 - M24 Threads // M16-M25 Metric Fine Threads

Create or repair large diameter external threads on metal bar or conduit with Versadrive ImpactaDie XL kits.

Offering fast, easy impact-thread cutting in a variety of sizes from M16 - M25 & 5/8" - 1", the ImpactaDie XL system speeds up the challenging and traditionally time-consuming process of creating large external threads.

Kits include the Versadrive ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a Versadrive ***STAKIT*** compatible ETOP2 half top case.

*(requires Versadrive Impact Wrench Adapter or Versadrive Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-XL-SET1 (Metric Coarse)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24 Guides, M16/20/24 Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case
115810-XL-SET2 (Metric fine for electrical conduit)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/25 Guides, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case
115820-XL-SET (UNC)	ImpactaDie Holder, Guide Collar, Flush Collar, 5/8, 3/4, 7/8, 1" Guides, 5/8, 3/4, 7/8, 1" UNC Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case

Versadrive ImpactaDie XL Complete Kit
M16-M24 Metric Coarse & M16-M25 Metric Fine Threads

The Versadrive ImpactaDie XL complete kit is the ultimate solution for creating and repairing large diameter external threads in both Metric Coarse and Metric Fine sizes.

Comprising dies and guides in both Metric Coarse M16 - M24 and Metric Fine M16 - M25, this kit offers fast, easy thread cutting for fixings on standard metal bar as well as electrical conduit.

Whatever the job and whatever the challenges, the ImpactaDie XL complete kit will ensure you have the tools needed to quickly and easily tackle the issue whether it be unexpected last minute modifications, every-day workshop use or emergency on-site repairs.

The Versadrive ImpactaDie XL system can be used with high-torque impact wrenches and high-power magnetic drills*.

The complete kit also includes the unique Versadrive ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading and comes supplied in a Versadrive ***STAKIT*** compatible ETOP2 half top case.

*(requires Versadrive Impact Wrench Adapter or Versadrive Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
115810-XL-SET3	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24/25 Guides, M16/20/24 Metric Coarse Hex Die Nuts, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case

ImpactaDie XL (Impact Die Threader) VERSADRIVE® PATENT PROTECTED

Create XL external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- *Guide collar ensures straight & true threading*
- *Create external threads from M16 - M25*
- *Create external threads up to 75mm long*
- *Impact chipbreaker action for effective swarf evacuation*
- *Use with Impact Wrenches (prevents dangerous kickback)*
- *Clean out existing external threads*
- *Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods*
- *Versadrive patented shank & modular adapters provide unbeatable jobsite flexibility*

ImpactaDie XL Holder

59.5mm

Flush Collar
(for repairing threads)

Guide Collar
(for creating threads)

ImpactaDie XL Hex Die Nut

ImpactaDie XL Guide

Versadrive ImpactaDie XL Holder (body only)

Part No	Suitable for
115300-01	M16 - M25 Threads 5/8" - 1" UNC

Versadrive ImpactaDie XL Collars

Part No	Product
115300-02	Guide Collar for creating M16 - M25 & 5/8" - 1" UNC Threads
115300-03	Flush Collar for repairing M16 - M25 & 5/8" - 1" UNC Threads

ImpactaDie XL Hex 36mm Die Nut

Part No	To create or repair threads sized
303810-0160	M16 x 2.0
303810-0200	M20 x 2.5
303810-0240	M24 x 3.0
303815-0160	M16 x 1.5 Metric Fine
303815-0200	M20 x 1.5 Metric Fine
303815-0250	M25 x 1.5 Metric Fine
302830-0050	5/8" UNC
302830-0060	3/4" UNC
302830-0070	7/8" UNC
302830-0080	1" UNC

ImpactaDie XL Guides

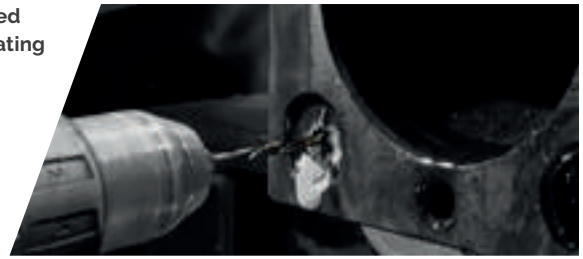
Part No	For thread sizes
115310-0160	M16
115310-0200	M20
115310-0240	M24
115310-0250	M25
115320-0050	5/8"
115320-0060	3/4"
115320-0070	7/8"
115320-0080	1"

11mm
Versadrive Shank
Also available with Versadrive MAX shank on request (115400-01)

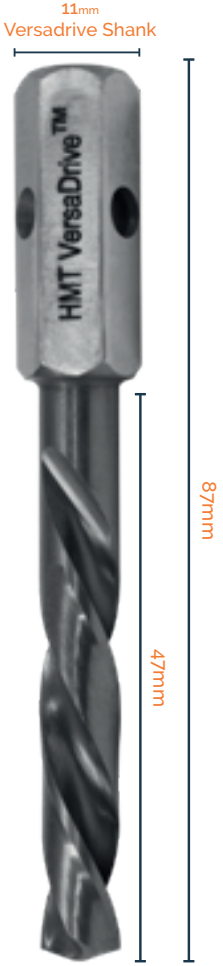
Total assembled length of XL holder + XL guide collar + XL guide = 146.5mm

Premium specification drill bits with left-handed spiral flute. 8% Cobalt with advanced TiAln coating to reduce friction and heat generation. Can be used both on Rotary and Impact settings.

To be used for drilling the pilot holes in broken bolts and seized studs ready for Versadrive Bolt extractors. Designed to run in reverse to help loosen the seized item at the same time as creating the pilot hole.



- *Premium 8% Cobalt with advanced TiAln coating*
- *For use on hardened bolts & studs*
- *Loosen seized or sheared bolts and studs*
- *Impact Rated for high speed operation*
- *Drill pilot holes ready for ImpactaBite bolt extractors to be inserted*
- *Versadrive patented shank & adapters provide multiple modular solutions*
- *Use on impact to prevent dangerous kickback caused by handheld rotary tools*



Part No.	Pilot Drill No.	Use with bolt sizes	Use with bolt sizes
209011-030	3	M5 - M6	7/32 - 9/32"
209011-040	4	M8 - M10	5/16 - 3/8"
209011-050	5	M12 - M14	1/2 - 9/16"
209011-060	6	M16 - M20	5/8 - 3/4"
209011-070	7	M22 - M26	7/8 - 1-1/8"

Pilot Drill & Bolt Extractor Combination Set

Part No.	Pcs.	Contents	Suitable for
2040EX-SET1	8 pcs	Left Hand Pilot Drill Bits #3, #4, #5, #6 Bolt Extractors #3, #4, #5, #6	Extract bolts M5 - M20 & 7/32 - 7/8"

Extract broken bolts and seized studs with the new Versadrive impact rated bolt extractor. A vast improvement to using traditional hand operated eazy-outs.

ImpactaBite uses the impact feature to break the grip caused by corroded or damaged threads.

Use once the pilot holes have been created with ImpactaBite Left Hand Drill Bits.

- *Extract seized or sheared bolts and studs*
- *Impact Rated for high speed operation*
- *Solid one piece steel design for heavy duty applications*
- *Heavy-duty hex shank design for secure non-slip operation*
- *Versadrive patented shank & adapters provide multiple modular solutions*
- *Use on impact to prevent dangerous kickback caused by handheld rotary tools*

Part No.	Bolt Extractor No.	Use with bolt sizes	Use with bolt sizes	l1 (mm)	L (mm)
403010-030	3	M5 - M6	7/32 - 9/32"	25	65
403010-040	4	M8 - M10	9/32 - 3/8"	35	74
403010-050	5	M12 - M14	3/8 - 5/8"	39	77
403010-060	6	M16 - M20	5/8 - 7/8"	46	84
403010-070	7	M22 - M26	7/8 - 1-1/8"	49	90

***STAKIT* Pilot Drill & Bolt Extractor ETOP2 12pc Set**

Part No.	Pcs.	Contents	Suitable for
2040EX-SET2	12 pcs	Left Hand Pilot Drill Bits #3, #4, #5, #6, #7 Bolt Extractors #3, #4, #5, #6, #7 Versadrive Rapid-Lock 1/2" Impact Wrench Adapter Versadrive Rapid-Lock Magnet Drill Adapter Versadrive ***STAKIT*** ETOP2 Half Top Case	Extract bolts M5 - M26 & 7/32 - 1-1/8"

The Versadrive MAX new product range develops the patented Versadrive shank into new territory for the most demanding industrial applications.

The standard Versadrive Shank measures 11mm Hex, whilst the heavy-duty Versadrive MAX shank is 20mm Hex meaning it can be used in thicker materials with higher torque application.

Heavy Duty Shank

This increased shank strength means that Versadrive MAX can be used to power larger diameter cutting tools, for example 41mm diameter reamers and M42 Taps.

VERSADRIVE 11mm SHANK

VERSADRIVE MAX 20mm SHANK

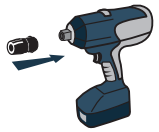
Versadrive MAX adapters have been designed to accommodate the larger 20mm Versadrive MAX shank & can withstand the highest levels of torque.

Adapters are available to fit Versadrive MAX tooling to both Impact Wrenches & high power Magnet Drills.

- *Use with the highest torque drive tools*
- *Impact adapters supplied with retention ring & pin*
- *Impact adapters are made to a trusted heavy-duty design with pull forward locking collar*

Versadrive MAX HD Impact Wrench Adapter ½" Drive

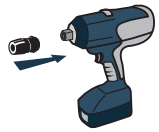
Heavy Duty adapter to convert high-power ½" Impact Wrenches for use with Versadrive MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-012A	35	30	65

Versadrive MAX HD Impact Wrench Adapter ¾" Drive

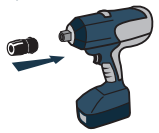
Heavy Duty adapter to convert high-power ¾" Impact Wrenches for use with Versadrive MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-034A	35	38	75

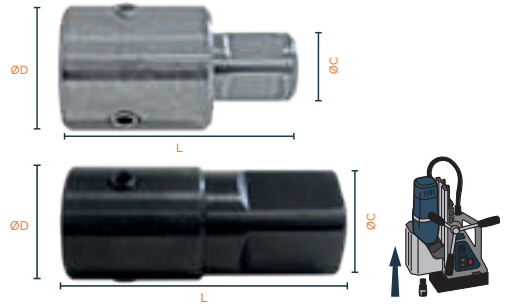
Versadrive MAX HD Impact Wrench Adapter 1" Drive

Heavy Duty adapter to convert high-power 1" Impact Wrenches for use with Versadrive MAX
- Rust resistant Manganese Phosphate finish
- Supplied with retention pin & securing ring



Part No	ØD (mm)	ØC (mm)	L (mm)
111140-100A	35	54	80

Versadrive MAX HD Magnet Drill Adapters



Part No	ØC (Weldon Shank mm)	ØD (mm)	L (mm)
111031-01	19.05 (¾")	34	63
111031-02	31.75 (1-¼")	34	80

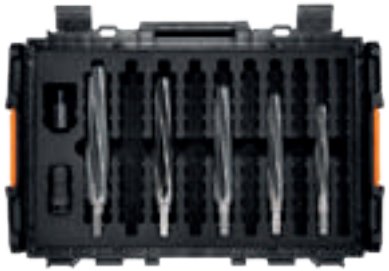
Versadrive MAX Reamer ETOP2 Kits
Metric Sizes

Part No	Reamers	Set contents
501050-3SET	3pcs	18, 22, 26mm + 3/4" Impact Adapter
501050-4SET	4pcs	18, 22, 24, 26mm + 3/4" Impact Adapter

Versadrive MAX Reamer ETOP2 Kits
Fractional Sizes

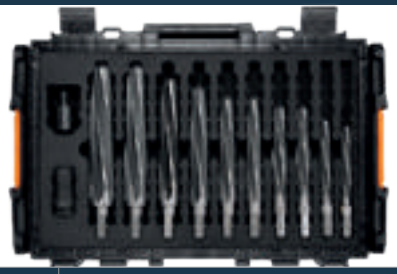
Part No	Reamers	Set contents
501051-SET1	3pcs	11/16, 13/16, 15/16" + 3/4" Impact Adapter
501051-SET2	4pcs	11/16, 13/16, 15/16, 1-1/16" + 3/4" Impact Adapter

Versadrive MAX Impact Reamer STAKIT Kit - 5pc



Part No	Set contents
STC-EMID-MAX02	22, 26, 30, 32, 36mm Versadrive MAX Reamers, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter
STC-EMID-INMAX02	15/16, 1-1/16, 1-3/16, 1-5/16, 1-3/8" Versadrive MAX Impact Reamers, ¾" Versadrive MAX Impact Wrench Adapter, ¾" Weldon Shank Magnet Drill Adapter

Versadrive MAX Impact Reamer STAKIT Kit - 10pc



Part No	Set contents
STC-EMID-MAX01	14, 18, 20, 22, 24, 26, 30, 32, 36, 39mm Versadrive MAX Reamers, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter
STC-EMID-INMAX01	11/16, 13/16, 15/16, 1-1/16, 1-3/16, 1-5/16, 1-3/8, 1-7/16, 1-1/2, 1-9/16" Versadrive MAX Reamers, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX Broach, Tap & Ream Set - 15pc
Metric Sizes

Part No	Set contents
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm Versadrive MAX Reamers, M24, M27, M30, M33, M36 Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX Broach, Tap & Ream Set - 15pc
Fractional Sizes

Part No	Set contents
STC-EMID-INMAX04	1, 1-1/8, 1-5/16, 1-3/8, 1-5/8" CarbideMax 55 TCT Broach Cutters, 15/16, 1-1/16, 1-3/16, 1-3/8, 1-7/16" Versadrive MAX Reamers, 1-1/8, 1-1/4, 1-3/8, 1-1/2, 1-3/4" Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX reamers offer a heavy duty solution for enlarging and aligning holes in thick metal plate (e.g. 20mm and above) or at large diameters.

Specially designed cutting geometry and a unique 20mm shank mean they can be used with high torque Impact Wrenches and the most powerful Magnet Drills for superior performance and portability, allowing the job to be completed on-site and not removed for reworking.

- *Ideal for steel erection & bridge work*
- *Ideal for modifying & enlarging holes*
- *Prepare holes for TCB & friction grip bolt*
- *Use with 1/2", 3/4" & 1" high torque Impact Wrenches*
- *Use with high torque, low speed Magnetic Drills*
- *6 flute design for a faster, smoother cut*

Metric	ØD (mm)	Ød1 (mm)	l1 (mm)	l2 (mm)	L (mm)
501050-0140	14	8.8	52	56	158
501050-0180	18	12.2	58	73	181
501050-0200	20	13.4	66	85	201
501050-0220	22	15.4	66	85	201
501050-0230	23	16.4	66	85	201
501050-0240	24	16.8	72	94	216
501050-0260	26	18.8	72	94	216
501050-0280	28	20.2	78	103	231
501050-0300	30	22.2	78	103	231
501050-0320	32	23.6	84	112	246
501050-0330	33	23.6	84	112	246
501050-0350	35	24	92	124	266
501050-0360	36	25	92	124	266
501050-0370	37	26	92	124	266
501050-0380	38	27	92	124	266
501050-0390	39	27	92	124	266
501050-0400	40	28	92	124	266
501050-0410	41	29	92	144	286
Fractional	**ØD (")**	**Ød1 (")**	**l1 (")**	**l2 (")**	**L (")**
501051-0010	11/16	15/32	2-9/32	2-7/8	7-1/8
501051-0020	13/16	39/64	2-19/32	3-11/32	7-29/32
501051-0030	15/16	21/32	2-27/32	3-45/64	8-1/2
501051-0040	1-1/16	47/64	3-5/64	3-45/64	9-3/32
501051-0050	1-3/16	7/8	3-5/64	4-1/16	9-3/32
501051-0060	1-5/16	63/64	3-5/16	4-13/32	9-11/16
501051-0070	1-3/8	29/32	3-5/8	4-7/8	10-15/32
501051-0080	1-7/16	31/32	3-5/8"	4-7/8	10-15/32
501051-0090	1-1/2	1-1/32	3-5/8	4-7/8	10-15/32
501051-0100	1-9/16	1-3/32	3-5/8	4-7/8	10-15/32
501051-0110	1-5/8	1-5/32	3-5/8	5-43/64	11-1/4

Versadrive MAX Broach & Tap Set - 10pc
Metric Sizes

Part No	Set contents
STC-EMID-MAX03	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, M24, M27, M30, M33, M36 Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX Broach & Tap Set - 10pc
Fractional Sizes

Part No	Set contents
STC-EMID-INMAX03	1, 1-⅛, 1-5/16, 1-⅜, 1-5/8" CarbideMax 55 TCT Broach Cutters, 1-⅛, 1-¼, 1-⅜, 1-½, 1-¾" Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX Broach, Tap & Ream Set - 15pc
Metric Sizes

Part No	Set contents
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm Versadrive MAX Reamers, M24, M27, M30, M33, M36 Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

Versadrive MAX Broach, Tap & Ream Set - 15pc
Fractional Sizes

Part No	Set contents
STC-EMID-INMAX04	1, 1-⅛, 1-5/16, 1-⅜, 1-5/8" CarbideMax 55 TCT Broach Cutters, 15/16, 1-1/16, 1-3/16, 1-⅜, 1-7/16" Versadrive MAX Reamers, 1-⅛, 1-¼, 1-⅜, 1-½, 1-¾" Versadrive MAX ImpactaTaps, ¾" Versadrive MAX Impact Wrench Adapter, 19.05mm Versadrive MAX Magnet Drill Adapter

MAX ImpactaTaps
VERSADRIVE® PATENT PROTECTED

Versadrive MAX taps are heavy duty, impact rated taps for use in challenging industrial applications.

Based on the bestselling ImpactaTaps, they are double hardened with a unique cutting geometry that makes them suitable for use with impact wrenches.

- *Thread new holes effectively with high-torque impact wrenches*
- *Ideal for cleaning and rethreading pre-threaded holes*
- *Used in commercial vehicle and transportation repair applications*
- *Can also be used with heavy duty, reversible magnetic drills*
- *Swarf chipbreaker action for effective use on through holes*
- *6 flute design for a faster, smoother cut*

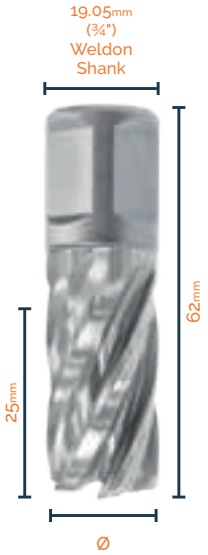
FURTHER SIZES AVAILABLE ON REQUEST

Metric	M Thread Size & Pitch	L (mm)	l1 (mm)
308610-0240	M24 x 3.0	135	45
308610-0270	M27 x 3.0	136	48
308610-0300	M30 x 3.5	138	48
308610-0330	M33 x 3.5	151	51
308610-0360	M36 x 4.0	162	57
308610-0390	M39 x 4.0	170	60
308610-0420	M42 x 4.5	170	60
Fractional	**M Thread Size & Pitch**	**L (")**	**l1 (")**
308650-0105	1-1/8 x 7 UNC	4-9/16	1-7/8
308650-0110	1-1/4 x 7 UNC	5	2
308650-0120	1-3/8 x 6 UNC	5-3/8	2-1/4
308650-0130	1-1/2 x 6 UNC	5-5/8	2-3/8
308650-0140	1-3/4 x 5 UNC	6-1/4	2-5/8

SilverMax 25 is a cost-effective HSS annular cutter with 25mm depth — suited to everyday holemaking in mild and structural steel.

As the entry-level Steelbor broaching cutter, SilverMax 25 offers reliable performance for standard site drilling tasks. Ground from M2 HSS and designed to exceed industry standards, it's a practical choice for general fabrication, baseplates, and installation work.

- *25mm cutting depth for standard structural drilling tasks*
- *Ground from M2 high-speed steel for consistent performance*
- *Reliable entry-level cutter for mild steel applications*
- *Compatible with all standard 19mm Weldon shank mag drills*
- *Steady cutting action with reduced vibration*
- *Suited to general fabrication, installation and site use*



Part No	D Ø (mm)	Part No	D Ø (mm)
107020-0120	12mm	107020-0320	32mm
107020-0130	13mm	107020-0330	33mm
107020-0140	14mm	107020-0340	34mm
107020-0150	15mm	107020-0350	35mm
107020-0160	16mm	107020-0360	36mm
107020-0170	17mm	107020-0370	37mm
107020-0180	18mm	107020-0380	38mm
107020-0190	19mm	107020-0390	39mm
107020-0200	20mm	107020-0400	40mm
107020-0210	21mm	107020-0410	41mm
107020-0220	22mm	107020-0420	42mm
107020-0230	23mm	107020-0430	43mm
107020-0240	24mm	107020-0440	44mm
107020-0250	25mm	107020-0450	45mm
107020-0260	26mm	107020-0460	46mm
107020-0270	27mm	107020-0470	47mm
107020-0280	28mm	107020-0480	48mm
107020-0290	29mm	107020-0490	49mm
107020-0300	30mm	107020-0500	50mm
107020-0310	31mm		

Pilot Pins For 12-50mm cutters	ØD	Length	Unit of sale
107020P-0500	6.35mm	77mm	Pack 2
107020P-0500-P10	6.35mm	77mm	Pack 10

InsertFoam Sets	
107020-SET	14, 18, 22mm + Pilot Pin
107020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

SilverMax 50 is a cost-effective HSS annular cutter with 50mm depth — suited to everyday holemaking in mild and structural steel.

As the entry-level Steelbor broaching cutter, SilverMax 50 offers reliable performance for standard site drilling tasks. Ground from M2 HSS and designed to exceed industry standards, it's a practical choice for general fabrication, baseplates, and installation work.

- *50mm cutting depth for standard structural drilling tasks*
- *Ground from M2 high-speed steel for consistent performance*
- *Reliable entry-level cutter for mild steel applications*
- *Compatible with all standard 19mm Weldon shank mag drills*
- *Steady cutting action with reduced vibration*
- *Suited to general fabrication, installation and site use*

Part No	D Ø (mm)	Part No	D Ø (mm)
107010-0120	12mm	107010-0320	32mm
107010-0130	13mm	107010-0330	33mm
107010-0140	14mm	107010-0340	34mm
107010-0150	15mm	107010-0350	35mm
107010-0160	16mm	107010-0360	36mm
107010-0170	17mm	107010-0370	37mm
107010-0180	18mm	107010-0380	38mm
107010-0190	19mm	107010-0390	39mm
107010-0200	20mm	107010-0400	40mm
107010-0210	21mm	107010-0410	41mm
107010-0220	22mm	107010-0420	42mm
107010-0230	23mm	107010-0430	43mm
107010-0240	24mm	107010-0440	44mm
107010-0250	25mm	107010-0450	45mm
107010-0260	26mm	107010-0460	46mm
107010-0270	27mm	107010-0470	47mm
107010-0280	28mm	107010-0480	48mm
107010-0290	29mm	107010-0490	49mm
107010-0300	30mm	107010-0500	50mm
107010-0310	31mm		

Pilot Pins For 12-50mm cutters	ØD	Length	Unit of sale
107010P-0500	6.35mm	103mm	Pack 2
107010P-0500-P10	6.35mm	103mm	Pack 10

InsertFoam Sets	
107010-SET	14, 18, 22mm + Pilot Pin
107010-5SET	12, 14, 18, 22, 26mm + 2 Pilots

Carbidemax 40 is the premium TCT annular cutter with 40mm cutting depth — engineered for faster cutting and extended tool life in structural and alloy steels.

With advanced triple-cut geometry and precision Tungsten Carbide tips, it delivers quieter, smoother drilling and up to 10x the life of traditional HSS cutters.

- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *40mm cutting depth for structural & through-hole applications*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter-free performance for cleaner, more accurate holes*
- *19mm Weldon shank fits all standard magnetic drills*

Part No	D Ø (mm)
108030-0120	12
108030-0130	13
108030-0140	14
108030-0150	15
108030-0160	16
108030-0170	17
108030-0180	18
108030-0190	19
108030-0200	20
108030-0210	21
108030-0220	22
108030-0230	23
108030-0240	24
108030-0250	25
108030-0260	26
108030-0270	27
108030-0280	28
108030-0290	29
108030-0300	30
108030-0310	31
108030-0320	32
108030-0330	33
108030-0340	34

Part No	D Ø (mm)
108030-0350	35
108030-0360	36
108030-0370	37
108030-0380	38
108030-0390	39
108030-0400	40
108030-0410	41
108030-0420	42
108030-0430	43
108030-0440	44
108030-0450	45
108030-0460	46
108030-0470	47
108030-0480	48
108030-0490	49
108030-0500	50
108030-0550	55
108030-0600	60
108030-0650	65
108030-0700	70
108030-0750	75
108030-0800	80

Pilot Pins	ØD	Length	Unit of sale
For 12-17mm cutters			
108030P-0170	6.34mm	90mm	Pack 2
108030P-0170-P10	6.34mm	90mm	Pack 10
For 18-80mm cutters			
108030P-0600	7.98mm	90mm	Pack 2
108030P-0600-P10	7.98mm	90mm	Pack 10

InsertFoam Sets	
108030-SET	14, 18, 22mm + 2 Pilot Pins
108030-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

Carbidemax 55 is the premium TCT annular cutter with 55mm cutting depth — engineered for faster cutting and extended tool life in structural and alloy steels.

With advanced triple-cut geometry and precision Tungsten Carbide tips, it delivers quieter, smoother drilling and up to 10× the life of traditional HSS cutters.

- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *55mm cutting depth for structural & through-hole applications*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter-free performance for cleaner, more accurate holes*
- *19mm Weldon shank fits all standard magnetic drills*

Part No	D Ø (mm)
108020-0120	12
108020-0130	13
108020-0140	14
108020-0150	15
108020-0160	16
108020-0170	17
108020-0175	17.5
108020-0180	18
108020-0190	19
108020-0200	20
108020-0210	21
108020-0220	22
108020-0230	23
108020-0240	24
108020-0250	25
108020-0260	26
108020-0265	26.5
108020-0270	27
108020-0280	28
108020-0290	29
108020-0300	30
108020-0310	31
108020-0320	32
108020-0330	33
108020-0340	34

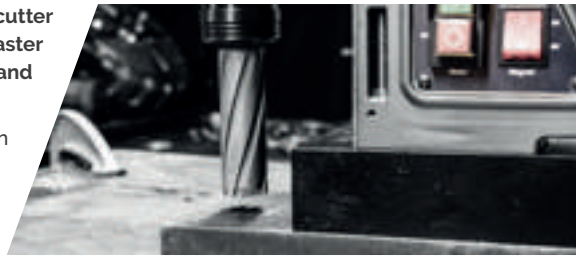
Part No	D Ø (mm)
108020-0350	35
108020-0360	36
108020-0370	37
108020-0380	38
108020-0390	39
108020-0400	40
108020-0410	41
108020-0420	42
108020-0430	43
108020-0440	44
108020-0450	45
108020-0460	46
108020-0470	47
108020-0480	48
108020-0490	49
108020-0500	50
108020-0510	51
108020-0520	52
108020-0530	53
108020-0540	54
108020-0550	55
108020-0560	56
108020-0570	57
108020-0580	58
108020-0590	59
108020-0600	60

Pilot Pins	ØD	Length	Unit of sale
For 12-17mm cutters			
108020P-0170	6.34mm	106mm	Pack 2
108020P-0170-P10	6.34mm	106mm	Pack 10
For 17.5-60mm cutters			
108020P-0600	7.98mm	106mm	Pack 2
108020P-0600-P10	7.98mm	106mm	Pack 10

InsertFoam Sets	
108020-SET	14, 18, 22mm + 2 Pilot Pins
108020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

Carbidemax 80 is the premium TCT annular cutter with 80mm cutting depth — engineered for faster cutting and extended tool life in structural and alloy steels.

With advanced triple-cut geometry and precision Tungsten Carbide tips, it delivers quieter, smoother drilling and up to 10× the life of traditional HSS cutters.



- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *80mm cutting depth for structural & through-hole applications*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter-free performance for cleaner, more accurate holes*
- *19mm Weldon shank fits all standard magnetic drills*

Part No	D Ø (mm)
108010-0120	12
108010-0140	14
108010-0160	16
108010-0180	18
108010-0200	20
108010-0220	22
108010-0240	24
108010-0260	26
108010-0280	28
108010-0300	30
108010-0320	32

Part No	D Ø (mm)
108010-0330	33
108010-0340	34
108010-0350	35
108010-0360	36
108010-0380	38
108010-0390	39
108010-0400	40
108010-0420	42
108010-0450	45
108010-0500	50

Pilot Pins	ØD	Length	Unit of sale
For 12-17mm cutters			
108010P-0170	6.34mm	130mm	Pack 2
For 18-60mm cutters			
108010P-0600	7.98mm	130mm	Pack 2

InsertFoam Sets	
108010-SET	18, 22, 24, 26, 28, 30mm + 2 Pilots

CarbideMax 110 is the premium TCT annular cutter with 110mm cutting depth — engineered for faster cutting and extended tool life in structural and alloy steels.

With advanced triple-cut geometry and precision Tungsten Carbide tips, it delivers quieter, smoother drilling and up to 10× the life of traditional HSS cutters.

- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *110mm cutting depth for structural & through-hole applications*
- *Advanced triple-cut geometry for faster, quieter drilling*
- *Chatter-free performance for cleaner, more accurate holes*
- *19mm Weldon shank fits all standard magnetic drills*

Part No	D Ø (mm)
108040-0140	14
108040-0160	16
108040-0180	18
108040-0190	19
108040-0200	20
108040-0210	21
108040-0220	22
108040-0230	23
108040-0240	24
108040-0250	25
108040-0260	26
108040-0270	27
108040-0280	28
108040-0290	29
108040-0300	30
108040-0320	32
108040-0330	33
108040-0340	34
108040-0350	35
108040-0360	36
108040-0380	38

Part No	D Ø (mm)
108040-0390	39
108040-0400	40
108040-0410	41
108040-0420	42
108040-0430	43
108040-0440	44
108040-0450	45
108040-0460	46
108040-0470	47
108040-0480	48
108040-0490	49
108040-0500	50
108040-0510	51
108040-0520	52
108040-0540	54
108040-0550	55
108040-0560	56
108040-0570	57
108040-0580	58
108040-0590	59
108040-0600	60

Pilot Pins	ØD	Length	Unit of sale
For 14-17mm cutters			
108040P-0171	6.34mm	155mm	Pack 2
For 18-60mm cutters			
108040P-0600	7.98mm	155mm	Pack 2

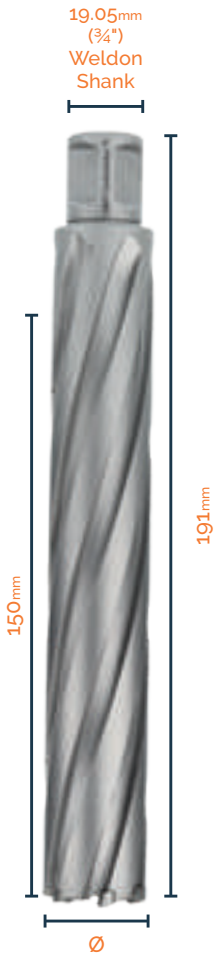
InsertFoam Sets	
108040-SET	14, 18, 22, 24, 26mm + 2 Pilots

Extreme drilling depth with Carbidemax Extra Long.

For the most extreme drilling depths the Carbidemax range offers 150mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any Magnet Drill with sufficient stroke.

- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS Cutters*
- *Drill matching holes through box section in a single pass*
- *Drill matching holes through H section in a single pass*



Part No.	D Ø (mm)
108045-0180	18
108045-0200	20
108045-0220	22
108045-0240	24
108045-0260	26
108045-0280	28
108045-0300	30
108045-0320	32
108045-0330	33
108045-0360	36
108045-0390	39
108045-0500	50

Pilot Pins

Part No.	D Ø	Length	Unit of sale
108045P-0600	7.98mm	205mm	Pack 2

Extreme drilling depth with Carbidemax Extra Long.

For the most extreme drilling depths the Carbidemax range offers 200mm extra long broach cutters.

With precision drilling flutes and a specially engineered geometry for accurate cutting these cutters come with a standard 19.05mm Weldon shank for use in any Magnet Drill with sufficient stroke.

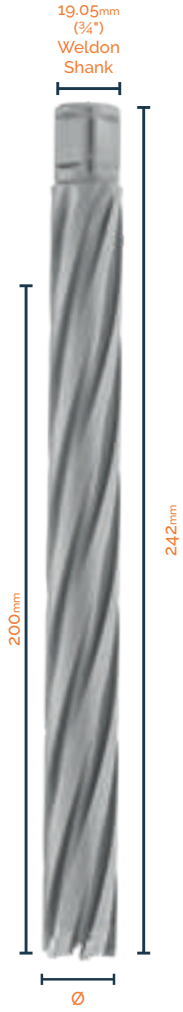
- *Up to 10x longer life than traditional HSS Cutters*
- *64% Faster cuts than HSS Cutters*
- *Drill matching holes through box section in a single pass*
- *Drill matching holes through H section in a single pass*

Part No.	D Ø (mm)
108050-0180	18
108050-0200	20
108050-0220	22
108050-0240	24
108050-0260	26
108050-0300	30
108050-0320	32
108050-0330	33
108050-0360	36
108050-0390	39
108050-0420	42
108050-0450	45
108050-0500	50

Pilot Pins

Part No.	D Ø	Length	Unit of sale
108050P-0600-2P	7.98mm	255mm	Pack 2

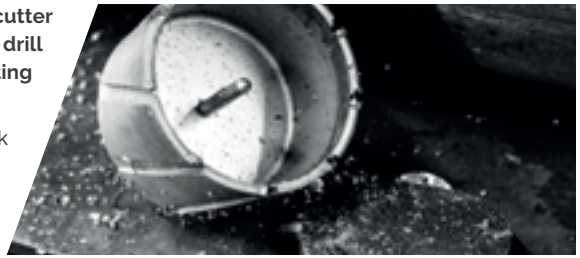
When using the 2 part pilot pin and drilling material greater than 50mm thick, when the pilot pin reaches the extent to which it can retract inside the Magnet Drill arbor, the bottom section of the pilot can be removed to allow the hole to be completed without removing the pilot pin from the cutter.



Carbidemax XL55 Broach Cutter

Carbidemax XL55 is the premium TCT annular cutter for large-diameter broaching — engineered to drill holes from 61mm to 150mm with a 55mm cutting depth.

Featuring a heavy-duty 31.75mm (1 1/4") shank and precision-ground Tungsten Carbide tips, it delivers maximum performance on high-torque machines for heavy-duty applications.



- *For ultra-large diameter holes up to 150mm*
- *Heavy-duty shank built for high-torque industrial use*
- *Adapters available for use with 19.05mm Weldon drills*
- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *55mm cutting depth for structural & plate drilling*

Part No.	D Ø (mm)
108020-0610	61
108020-0620	62
108020-0630	63
108020-0640	64
108020-0650	65
108020-0660	66
108020-0670	67
108020-0680	68
108020-0690	69
108020-0700	70
108020-0750	75
108020-0800	80
108020-0850	85
108020-0900	90

Part No.	D Ø (mm)
108020-0950	95
108020-1000	100
108020-1050	105
108020-1100	110
108020-1150	115
108020-1200	120
108020-1250	125
108020-1270	127
108020-1300	130
108020-1350	135
108020-1400	140
108020-1450	145
108020-1500	150

31.75mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 31.75mm shank cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-55	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 55mm cutters

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"
108020P-1500	CarbideMax55 Pilot Pin, 61-150mm, Pk 2	

Carbidemax XL110 Broach Cutter

Carbidemax XL110 is the premium TCT annular cutter for large-diameter broaching — engineered to drill holes from 61mm to 200mm with a 110mm cutting depth.

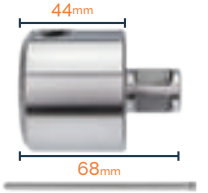
Featuring a heavy-duty 31.75mm (1 1/4") shank and precision-ground Tungsten Carbide tips, it delivers maximum performance on high-torque machines for heavy-duty applications.

- *For ultra-large diameter holes up to 200mm*
- *Heavy-duty shank built for high-torque industrial use*
- *Adapters available for use with 19.05mm Weldon drills*
- *Up to 10x longer life than standard HSS Cutters*
- *Cuts 64% faster than traditional HSS for improved productivity*
- *110mm cutting depth for structural & plate drilling*

Part No.	ØD (mm)
108040-0610	61
108040-0620	62
108040-0630	63
108040-0640	64
108040-0650	65
108040-0660	66
108040-0670	67
108040-0680	68
108040-0690	69
108040-0700	70
108040-0730	73
108040-0750	75
108040-0800	80
108040-0850	85
108040-0900	90
108040-0950	95

Part No.	ØD (mm)
108040-1000	100
108040-1050	105
108040-1100	110
108040-1150	115
108040-1200	120
108040-1250	125
108040-1300	130
108040-1350	135
108040-1400	140
108040-1500	150
108040-1600	160
108040-1700	170
108040-1800	180
108040-1900	190
108040-2000	200

31.75mm to 19.05mm Weldon Shank Adapter & Pilot



Adapts 31.75mm shank cutters to 19.05mm standard Magnet Drill fitting; includes pilot

Part No	Details
103091-1932-110	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 110mm cutters

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"
108040P-1500-2P	CarbideMax110 2 Piece Pilot Pin 61-200mm, Pk2	

Weldon Shank Twist Drill 4pc Set
Metric Sizes

Part No	Set contents
201070-SET	6, 8, 10, 12mm

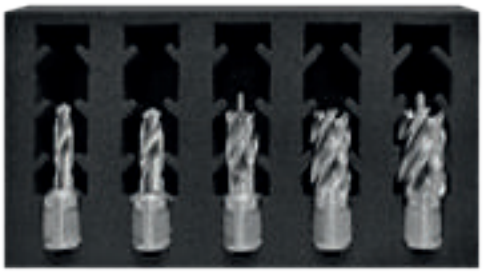
Weldon Shank Tapping Size Twist Drill 4pc Set
Metric Sizes

Part No	Set contents
201070-TSET	5, 6.8, 8.5, 10.2mm

Weldon Shank Twist Drill 5pc Set
Fractional Sizes

Part No	Set contents
201075-SET1	1/4, 5/16, 3/8, 7/16, 1/2"

Drilling & Broaching Kit
10 - 22mm



Part No	Set contents
107020-SS2	10 & 12mm Weldon Shank Twist Drills + 14, 18 & 22mm HSS Broach Cutters + Pilot Pins

SilverMax Weldon Shank Twist Drill Bits STEELBOR®

HSS twist drill bits with integrated Weldon shank for simple and accurate drilling in steel and fast tool changing. Removes the need for using a separate drill chuck in a Magnet Drill.

Where drilling smaller holes in thick steel has been a long and time consuming job in the past, fitting the SilverMax Weldon Shank Twist Drills into a Magnet Drill can suddenly make the job far quicker and safer than struggling with a Pistol Drill and jobber bits.

- *Integrated weldon shank*
- *Simple & accurate drilling in steel*
- *No need for a tool chuck when using a Magnet Drill*
- *Fast tool changing*
- *Quicker and safer than struggling with a Pistol Drill*
- *Fits 19.05mm arbors - use with any standard mag drill*

Metric	D Ø (mm)	Tap Size
201070-0050	5	M6
201070-0060	6	-
201070-0068	6.8	M8
201070-0070	7	-
201070-0080	8	-
201070-0085	8.5	M10
201070-0090	9	-
201070-0100	10	-
201070-0102	10.2	M12
201070-0110	11	-
201070-0120	12	-
Fractional	**D Ø (")**	**Tap Size**
201075-0030	1/4	-
201075-0050	5/16	3/8"
201075-0060	3/8	-
201075-0070	7/16	-
201075-0080	1/2	-

Carbidemax ULTRA 55

Carbidemax ULTRA is the premium TCT cutter range for extreme-duty broaching in the toughest materials, including Hardox®, wear plate, and high-strength structural steels.

Individually brazed carbide teeth and advanced ULTRA coating combine with elaborate cutting geometry to deliver maximum tool life, fast penetration, and precision drilling — even in the most demanding applications.

- *ULTRA coating optimises performance & increases lifespan*
- *Individually brazed, high-quality carbide teeth for durability*
- *55mm cutting depth for structural & wear-plate drilling*
- *Elaborate cutting geometry for faster, smoother drilling*
- *Balanced geometry for reduced vibration & improved accuracy*
- *19.05mm Weldon shank for use with standard magnetic drills*

Part No.	ØD (mm)
108070-0160	16
108070-0170	17
108070-0175	17.5
108070-0180	18
108070-0190	19
108070-0200	20
108070-0210	21
108070-0220	22
108070-0230	23
108070-0240	24
108070-0250	25
108070-0260	26
108070-0265	26.5
108070-0270	27
108070-0280	28
108070-0290	29
108070-0300	30
108070-0310	31
108070-0320	32
108070-0330	33
108070-0340	34
108070-0350	35
108070-0360	36
108070-0370	37

Part No.	ØD (mm)
108070-0380	38
108070-0390	39
108070-0400	40
108070-0410	41
108070-0420	42
108070-0430	43
108070-0440	44
108070-0450	45
108070-0460	46
108070-0470	47
108070-0480	48
108070-0490	49
108070-0500	50
108070-0510	51
108070-0520	52
108070-0530	53
108070-0540	54
108070-0550	55
108070-0560	56
108070-0570	57
108070-0580	58
108070-0590	59
108070-0600	60

Pilot Pins	ØD	Length	Unit of sale
For 12-17mm cutters			
108020P-0170	6.34mm	103mm	Pack 2
For 18-60mm cutters			
108020P-0600	7.98mm	103mm	Pack 2

InsertFoam Sets	
108070-SET2	18, 20, 22, 24, 26mm + 2 Pilots

ULTRA Coated Twist Drill Bits

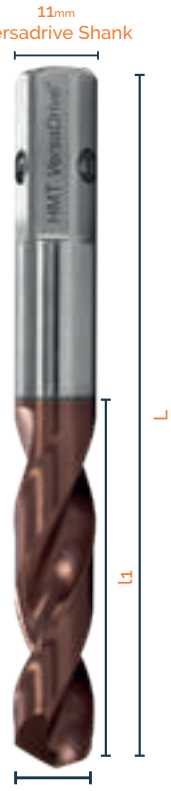
Versadrive Ultra Drill Bits - for Wear Plate, Armour Plate and RailTrack signalling/bonding applications.

The new Versadrive Ultra Drill bits are designed for the toughest applications in the mining, quarrying, and military engineering market. Versadrive Ultra Drill bits are also suitable for use drilling holes for bonding wires in track circuit signalling / bonding and wheel detector applications.

- *High grade tool steel*
- *Specialist high-performance Ultra coating*
- *Drill the toughest materials in the toughest applications*
- *Used in industries like Mining, Quarrying, Military Engineering*

Metric	ØD (mm)	l1 (mm)	L (mm)
209020-0040	4	22	55
209020-0050	5	26	62
209020-0060	6	28	66
209020-0070	7	34	74
209020-0080	8	37	79
209020-0090	9	40	84
209020-0100	10	43	89
209020-0110	11	47	95
209020-0120	12	51	102
209020-0130	13	51	102
209020-0140	14	54	107
Fractional	**ØD (")**	**l1 (")**	**L (")**
209021-0010	1/4	1-3/8	2-1/2
209020-0070	9/32	1-11/32	2-15/16
209021-0020	5/16	1-5/8	2-13/16
209021-0030	3/8	1-13/16	3-1/8
209021-0040	1/2	2-1/4	3-3/4
209021-0050	9/16	2-43/64	4-11/16

InsertFoam Sets	
209020-SET1	6, 8, 10, 12, 14mm
209020-SET2	4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14mm
209021-SET1	1/4, 5/16, 3/8, 1/2, 9/16"



The S36 delivers deeper cuts, faster job turnaround, and site-ready durability — all in a compact, portable form.

Built to outperform other compact drills, the S36 combines a 110mm cutting depth with a high-power Eibenstock motor. Designed for structural steel and access-critical jobs, it pairs perfectly with Versadrive tooling and standard broach cutters for fast, flexible holemaking.

- *110mm cutting depth for deep broaching & countersinking*
- *Drills up to 36mm diameter in structural steel*
- *High-performance motor delivers smooth, fast cutting*
- *Lightweight for easier transport and access work*
- *Weldon shank compatible for full cutter flexibility*
- *Drill & countersink using Versadrive quick-change tools*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	13mm
COUNTERSINKING	25mm
REAMING	N/A
TAPPING	N/A
LENGTH	259mm
WIDTH (Inc Handles)	156mm
HEIGHT (Min-Max)	348 - 495mm
STROKE	147mm
WEIGHT	10 kg
MAGNET (L X W)	160 x 80mm
MAGNETIC FORCE	1015 kgs
MOTOR POWER	1050w
SPEED RPM (No Load)	800
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850236-110	S36 Magnetic Drill Kit 110V
850236-P-110	S36 Magnetic Drill Pro Kit 110V
850236-230	S36 Magnetic Drill Kit 230V
850236-P-230	S36 Magnetic Drill Pro Kit 230V

Standard kits supplied in protective site case.
*PRO kits supplied in **STAKIT** Base 200 case with Versadrive Rapid-Lock adapter*

The V36 delivers cordless freedom with site-safe magnet hold — ideal for faster holemaking in confined, hard-to-reach spaces.

HMT's lightest mag drill, the V36 offers full drilling performance in a compact, battery-powered format. Built for fast, safe work on-site without trailing leads, it's compatible with Makita LXT batteries and the full Versadrive modular cutting system.

- *Cordless operation speeds up setup and reduces trip hazards*
- *Permanent magnet holds safely even if power is lost*
- *140mm stroke allows use of extra-long broach cutters*
- *Weighs just 9.8kg — easy to lift and position*
- *Cuts up to 49 holes per charge (18mm, 9.0Ah battery)*
- *Fully compatible with Versadrive & Weldon shank tooling*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	10 - 25mm
REAMING	N/A
TAPPING	N/A
LENGTH	325mm
WIDTH (Inc Handles)	184mm
HEIGHT (Min-Max)	275 - 415mm
STROKE	140mm
WEIGHT	9.8 kg
MAGNET (L X W)	157 x 85mm
MAGNETIC FORCE	650 kgs
MOTOR POWER	1000w
TOTAL POWER	1000w
SPEED RPM (No Load)	530
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & Makita LXT 18v

Part No	Contents
805036-010	V36-18 Magnet Drill - Bare Machine
805036-025	V36-18 Magnet Drill 4.0Ah Kit
805036-020	V36-18 Magnet Drill 9.0Ah Kit

See P26 for Batteries and Charger

*Kits supplied in **STAKIT**® Base 200 case, with Rapid-Lock Versadrive adapter, 2 batteries & battery charger*

The S50 combines compact power with 2-speed control — ideal for heavy drilling and versatile site work up to 55mm.

Positioned between ultra-compact and high-torque models, the S50 delivers reliable, all-day performance for broaching, reaming and countersinking. With a 160mm stroke, it accepts long cutters and integrates seamlessly with both Versadrive & Weldon tooling systems.

- *2-speed motor for cutting control and material flexibility*
- *Drills up to 55mm diameter with TCT cutter performance*
- *160mm stroke supports long broach cutters & reamers*
- *Protective case and accessories supplied as standard*
- *Versadrive adapter available for modular system use*
- *Ideal for structural and fabrication shop environments*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	55mm
MAX HSS CUTTER CAPACITY	50mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	1 - 18mm
COUNTERSINKING	32mm
REAMING	18mm
TAPPING	N/A
LENGTH	270mm
WIDTH (Inc Handles)	165mm
HEIGHT (Min-Max)	400 - 560mm
STROKE	160mm
WEIGHT	12.7 kg
MAGNET (L X W)	167 x 80 x 50mm
MAGNETIC FORCE	1250 kgs
MOTOR POWER	1200w
SPEED RPM (No Load)	400 / 720
SPINDLE	¾" Weldon
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850250-110	S50 Magnetic Drill Kit 110V
850250-P-110	S50 Magnetic Drill Pro Kit 110V
850250-230	S50 Magnetic Drill Kit 230V
850250-P-230	S50 Magnetic Drill Pro Kit 230V

Standard kits supplied in protective site case.
*PRO kits supplied in **STAKIT** Base 200 case with Versadrive Rapid-Lock adapter*

The V60T combines high-performance drilling with forward/reverse tapping — ideal for structural and site work up to 60mm.

Built for productivity, the V60T offers 220mm stroke, tapping up to M20, and seamless switching between broaching, countersinking, and reaming. With variable speed control and Versadrive compatibility, it adapts to complex jobs without tool change delays.

- *Forward/reverse motor for accurate, controlled tapping*
- *Tap up to M20 directly into structural steel plates*
- *220mm stroke handles extra-long cutters and reamers*
- *Variable speed for improved control and cut finish*
- *Weldon arbor & Versadrive adapter supplied as standard*
- *Ideal for on-site steelwork and heavy fabrication tasks*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	60mm
MAX HSS CUTTER CAPACITY	55mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
STROKE	220mm
LENGTH	315mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	385 - 605mm
WEIGHT	18kg
MAGNET (L X W)	200 x 100mm
MAGNETIC FORCE	1750kg
MOTOR POWER	1150W
TOTAL POWER	1270W
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19.05mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850060-P-110	V60T Magnetic Drill Kit - 110v
850060-P-230	V60T Magnetic Drill Kit - 230v

Supplied with case, Versadrive Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

The V85T is built for demanding structural work — with deep broaching, advanced tapping, and controlled torque delivery.

Designed for tough fabrication environments, the V85T delivers reliable hole making up to 85mm diameter and M27 tapping. Its variable torque and speed settings ensure accuracy, while safety features protect both the operator and the tool in heavy-duty cycles.

- *Tap up to M27 in thick section steel*
- *85mm cutting diameter with HSS or TCT cutters*
- *Variable torque improves tool control and job safety*
- *Forward/reverse for threading, reaming and deburring*
- *Integrated cooling feeds support cutter life and finish*
- *STAKIT compatible for organised, on-site deployment*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	85mm
MAX HSS CUTTER CAPACITY	75mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	27mm
COUNTERSINKING	55mm
REAMING	24mm
MAX TAP CAPACITY	M27
LENGTH	325mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	425 - 645mm
STROKE	220mm
WEIGHT	20.5 kg
MAGNET (L X W)	200 x 100mm
MAGNETIC FORCE	1750 kgs
MOTOR POWER	1800w
TOTAL POWER	1920w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19.05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850085-P-110	V85T Magnetic Drill Kit - 110v
850085-P-230	V85T Magnetic Drill Kit - 230v

Supplied with case, Versadrive Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

The V100T delivers powerful broaching and M30 tapping — fully integrated with Versadrive for multi-process efficiency.

Engineered for industrial jobs, the V100T tackles hole making up to 100mm and tapping to M30. With variable speed, forward/reverse drive and blind hole compatibility via the Versadrive system, it covers complex tasks without needing multiple machines.

- *Tap up to M30 with blind hole Versadrive tooling*
- *Cut up to 100mm with industrial-grade broach cutters*
- *Variable speed motor for reaming, deburring & countersinking*
- *Forward/reverse function improves tapping safety & accuracy*
- *Weldon and Versadrive ready for full modular flexibility*
- *Ideal for fabrication, maintenance & infrastructure projects*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	100mm
MAX HSS CUTTER CAPACITY	90mm
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	55mm
REAMING	26mm
MAX TAP CAPACITY	M30
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	450 - 730mm
STROKE	280mm
WEIGHT	24.5 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC FORCE	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60 - 140 / 200 - 470
SPINDLE	MT3
ARBOR	19.05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850100-P-110	V100T Magnetic Drill Kit - 110v
850100-P-230	V100T Magnetic Drill Kit - 230v

Supplied with case, Versadrive Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

The V125T delivers 125mm broaching and M32 tapping — combining serious cutting capacity with on-site portability.

A step up in performance, the V125T bridges the gap between portable and industrial mag drills. It handles large-diameter hole making, blind-hole tapping and reaming, all in a jobsite-friendly footprint that integrates with Versadrive tooling systems.

- *Broach up to 125mm for large structural and plate work*
- *Tap up to M32 with controlled reverse functionality*
- *High-torque motor for smooth, reliable holemaking*
- *Suitable for blind holes using Versadrive tooling*
- *Stable base and integrated cooling for precision & tool life*
- *Portable format with full STAKIT & modular compatibility*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	125mm
MAX HSS CUTTER CAPACITY	110mm
MAX CUTTER LENGTH	200mm
TWIST DRILL CAPACITY	32mm
COUNTERSINKING	60mm
REAMING	32mm
MAX TAP CAPACITY	M32
LENGTH	345mm
WIDTH (Inc Handles)	240mm
HEIGHT (Min-Max)	470 - 750mm
STROKE	280mm
WEIGHT	25 kg
MAGNET (L X W)	220 x 115mm
MAGNETIC FORCE	2200 kgs
MOTOR POWER	1800w
TOTAL POWER	1900w
SPEED RPM (No Load)	60-140 / 100-220 / 140-310 / 210-490
SPINDLE	MT3
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850125-P-110	V125T Magnetic Drill Kit - 110v
850125-P-230	V125T Magnetic Drill Kit - 230v

Supplied with case, Versadrive Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap and heavy duty metal guard.

The MAX200T is the world's largest capacity portable mag drill — engineered for extreme holemaking without compromise.

Built for the most demanding industrial applications, the MAX200T offers broaching up to 200mm, countersinking to 110mm, and M56 tapping. Advanced safety features and modular compatibility make it the go-to for heavy steel, offshore, or defence-grade work.

- *Broaches up to 200mm — the largest in its class*
- *Tap up to M56 for heavy fabrication and assembly*
- *110mm countersink capacity for large-scale chamfering*
- *Emergency stop and spindle guard enhance site safety*
- *Lifting eyes and wheeled base for safe handling*
- *Modular tooling support via Versadrive and Weldon shank*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	200mm
MAX HSS CUTTER CAPACITY	175mm
MAX CUTTER LENGTH	200mm
MAX TWIST DRILL	56mm
MAX TAPPING SIZE	M52
COUNTERSINKING	110mm
REAMING	56mm
LENGTH	455mm
WIDTH INC HANDLES	280mm
HEIGHT	730-955mm
STROKE	330mm
WEIGHT	52kg
MAGNET SIZE	295x140x70mm
MAGNETIC FORCE	2700kg
POWER CONSUMPTION	2,850W
SPEED RPM (No Load)	40-60//90-130// 170-240//380-545
SPINDLE	MT5
ARBOR	31.75mm (1-1/4") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
803096-110	HMT MAX200T Magnet Drill 110v
803096-230	HMT MAX200T Magnet Drill 230v

Supplied with a heavy duty site case, morse taper broaching arbor, handles, restraint strap & heavy duty metal guard

The V36 Pipe delivers cordless hole making with secure clamping on curved surfaces — ideal for pipework in any location.

As the world's first cordless pipe mag drill, the V36 Pipe is optimised for steel pipe and tube applications where cables are a hazard. It uses a dual-swivel magnet base for safety and control, and integrates with Versadrive tooling for versatile performance.

- *Designed for pipes from 80mm OD and above*
- *Cordless operation ideal for access-limited job sites*
- *Dual pivoting magnet holds safely on curved surfaces*
- *Swivel base allows easy positioning and tool changes*
- *Weldon arbor and Versadrive compatible as standard*
- *Lightweight and portable with full STAKIT integration*
- *Compatible with Makita LXT 18v Batteries*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	13mm
COUNTERSINKING	10-25mm
REAMING	N/A
MAX TAP CAPACITY	N/A
LENGTH	204mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	315 - 455mm
STROKE	140mm
WEIGHT (with 4Ah battery)	11.35 kg
MAGNET (L X W)	187 x 165 x 83mm
MAGNETIC FORCE	532kg
MOTOR POWER	1000w
TOTAL POWER	1000w
SPEED RPM (No Load)	530
SPINDLE	¾" Weldon
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & Makita LXT 18v

18V

Part No	Contents
805036-T-010	V36 PIPE Bare
805036-T-025	V36 PIPE 4Ah Kit
805036-T-020	V36 PIPE 9Ah Kit

See P26 for Batteries and Charger

Kits supplied with case, 2 x 18v batteries, compact charger, Versadrive Rapid-Lock adapter, restraint strap & heavy duty metal guard

The V60T Pipe delivers powerful drilling and tapping on curved surfaces — with secure magnet hold and full cutter compatibility.

A pipe-optimised version of the V60T, this model combines high torque, reversible tapping, and dual-swivel magnetic mounting for controlled drilling on steel pipe and tube. It's fully compatible with Versadrive tooling and designed for industrial-grade fabrication work.

- *Secure magnet grip on curved surfaces from 80mm OD*
- *Taps up to M20 with forward/reverse control*
- *Swivel-mounted base for precise pipe positioning*
- *220mm stroke handles long cutters and reamers*
- *Weldon arbor and Versadrive system compatible*
- *Coolant-fed arbor supplied for cleaner cutting*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	60mm
MAX HSS CUTTER CAPACITY	55mm
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
LENGTH	320mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	415 - 635mm
STROKE	220mm
WEIGHT	19 kg
MAGNET (L X W)	266 x 239 x 82mm
MAGNETIC FORCE	860kg
MOTOR POWER	1150w
TOTAL POWER	1270w
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
850060-T-110	V60T PIPE Twin Magnet Drill Kit 110v
850060-T-230	V60T PIPE Twin Magnet Drill Kit 230v

Supplied with case, Versadrive Rapid-Lock adapter, morse taper broaching arbor, handles, restraint strap & heavy duty metal guard

The RTQ40 fits where other drills can't — combining compact height with serious cutting power up to 40mm.

Built for structural steelwork and confined access, the RTQ40 is the lowest profile drill in the range. With a ratchet-feed system and powerful motor, it delivers clean broaching in overhead, inside-beam, or baseplate jobs other machines can't reach.

- *Only 180mm tall — perfect for restricted or confined access*
- *40mm cutting capacity with HSS or TCT cutters*
- *Ratchet feed enables controlled drilling in tight areas*
- *Weldon shank compatible for full tooling flexibility*
- *Built-in cooling system extends cutter life and precision*
- *Compact but powerful — ideal for fabrication and site work*

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	40mm
MAX HSS CUTTER CAPACITY	36mm
TWIST DRILL CAPACITY	13mm
COUNTERSINKING	32mm
LENGTH	310mm
WIDTH	135mm
HEIGHT	180mm
STROKE	40mm
WEIGHT	10.8kg
MAGNET (L x W x H)	160x80x37mm
MAGNETIC FORCE	1200kg
MOTOR POWER	1050W
TOTAL POWER	1100W
SPEED RPM (No Load)	700RPM
SPINDLE	Quick change 19.05mm 3/4" Weldon arbor for all standard broaching cutters
COOLANT SYSTEM	Optional Extra
WARRANTY	2yr (When registered)

Part No	Contents
803084-110	RTQ40 Magnetic Drill 110v
803084-230	RTQ40 Magnetic Drill 230v

*Supplied in **STAKIT**® Base 200 case with hex keys, restraint strap and ratchet.*

The RTV36 brings cordless performance to tight-access work — for safe, fast drilling where cables can't go.

Combining a low-height body with battery power, the RTV36 is ideal for steelwork inside beams, platforms, or confined installations. Built around Makita LXT batteries & designed with permanent magnet hold, it ensures safety and flexibility on remote jobs.

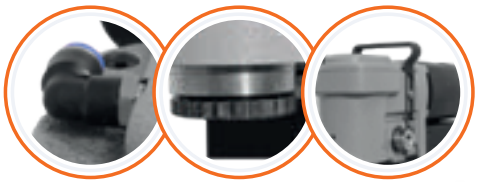
- *Only 198mm tall — built for overhead or inside-beam work*
- *Cordless operation removes trip hazards and setup delays*
- *Permanent magnet base stays secure without external power*
- *Weldon compatible for HSS, TCT and CarbideMax cutters*
- *Cuts up to 49 holes per charge with 9.0Ah battery*
- *Kits include **STAKIT** case for easy transport and storage*
- *Compatible with Makita LXT 18v Batteries*

TECHNICAL SPECIFICATIONS

CUTTER SIZE RANGE	12 -36mm
MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	32mm
LENGTH (Inc 4Ah battery)	385mm
WIDTH	140mm
HEIGHT	177mm
WEIGHT	11.3 kg
STROKE	40mm
MAGNETIC FORCE	650 kg
MOTOR POWER	1000 W
TOTAL POWER	1000 W
SPEED RPM (No Load)	270 - 430
SPINDLE WELDON	19.05mm (¾")
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & Makita LXT 18v

Part No	Contents
805046-010	RTV36 Magnet Drill - Bare Machine
805046-025	RTV36 Magnet Drill 4.0Ah Kit
805046-020	RTV36 Magnet Drill 9.0Ah Kit

See P26 for Batteries and Charger



*Kits supplied in **STAKIT**® Base 200 case with 2 batteries, charger, hex keys, restraint strap and ratchet.*

The HMT OverReach system is a unique Magnetic base, secondary fixing system designed for use with Magnetic Drills.

Overreach provides the capability to reach over, around, and beyond obstructions such as plates or rivet heads which would otherwise prevent convenient access with a conventional Magnetic Drill.

- *High strength magnetic base*
- *Industrial grade swivel, mounting plate*
- *Swivels through 360° for ultimate positioning flexibility*
- *Dual coiled magnet for superior magnetic adhesion*
- *Position magnetic base up to 300mm from worksite*
- *Overcome otherwise impossible worksite challenges*

TECHNICAL SPECIFICATIONS

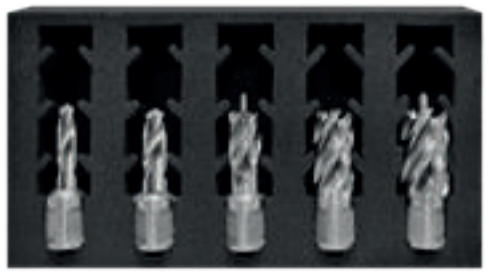
MAX CUTTER CAPACITY	50mm
SWIVEL PLATE THICKNESS	20mm
PLATE AREA	473 x 140mm
WEIGHT	17.85kg
TRAVEL	300mm
MAGNET POWER	2200kgs
MAGNET DIMENSIONS	220 x 115mm
MAX WEIGHT SUPPORTED	18kg

Minimum base material required for OverReach system = 10mm thick, clean, flat, paint & rust free
To be used in accordance with operating instructions contained within Manual

Part No	Contents
861025-110	HMT OverReach 50 Magnet Base Clamp with Slide Plate, 110 Volt
861025-230	HMT OverReach 50 Magnet Base Clamp with Slide Plate, 230 Volt

*Supplied in **STAKIT**® Base 200 case.*

Drilling & Broaching 5pc Set
10 - 22mm



Part No	Set contents
107020-SS2	10 & 12mm Weldon Shank Twist Drills + 14, 18 & 22mm HSS Broach Cutters + Pilot Pins

Broaching Starter Set HSS Short Series
6 - 26mm

Part No	Set contents
107020-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm SilverMax 25 HSS Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

Broaching Starter Set HSS Long Series
6 - 26mm

Part No	Set contents
107010-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm SilverMax 50 HSS Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

Broaching Starter Set TCT
6 - 26mm

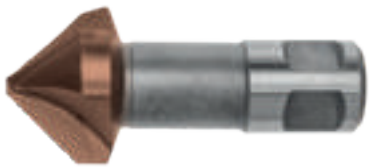
Part No	Set contents
108030-SS1	6, 8, 10, 10.2, 12mm Weldon Twist Drills + 14, 18, 20, 22, 24, 26mm CarbideMax 40 TCT Broach Cutters + Pilot Pins + 30mm GoldMax 90° Countersink

HMT Weldon Shank TCT Countersink

Premium countersink with 3X heavy duty tungsten carbide inserts for maximum life in challenging materials.
Standard 19.05mm (3/4") Weldon shank for use in all standard Magnet Drills.
Use with a 103013 Morse taper arbor to use in a Pillar or Radial Drill.

TCT Countersink	Size	Point Angle	Length
601035-0320	32mm	90°	72mm
601037-0010	1-1/4"	82°	2-7/8"

HMT ULTRA Weldon Shank TCT Countersink



ULTRA version of the TCT Weldon Shank countersink for use on wear plate like Hardox & Raex
Features 3X heavy duty, ULTRA coated tungsten carbide inserts for maximum life in challenging materials.
Standard 19.05mm (3/4") Weldon shank for use in all standard Magnet Drills.
Use with a 103013 Morse taper arbor to use in a Pillar or Radial Drill.

ULTRA Countersink	Size	Point Angle	Length
601036-0320	32mm	90°	72mm
601038-0010	1-1/4"	82°	2-7/8"

GoldMax HSS Weldon Countersink

Specially coated for increased tool life.

Standard 19.05mm (3/4") Weldon shank for use in all standard Magnet Drills.

Part No	Size	Point Angle
601025-0300	30mm	90°
601025-0400	40mm	90°
601025-0550	55mm	90°
601026-0020	1-1/2"	82°
601026-0030	2"	82°

HMT Magnet Drill Countersink
50mm, 60°

High Speed Steel with precision ground flutes.

Standard 19.05mm Weldon shank for use in all standard Magnet Drills.

Part No	Size
601040-0500	50mm

The MultiSink is a worldwide unique Combination Countersink Tool designed and developed by HMT for use with Magnetic Drills.

The tool is designed to combine with the Versadrive product range to Broach & Countersink, Drill & Countersink, Tap & Countersink or even Drill, Tap & Countersink in one operation - providing huge time-saving benefits.

- *Innovative combination countersinking tool*
- *Save time completing countersunk holes*
- *Broach/Drill & countersink in one operation*
- *Suitable for holes 16mm and above*
- *Pilot feature gives a precise, concentric fit for excellent performance*
- *Tap & countersink in one operation*

TCT MultiSink

Part No	D Ø	D2	L	Shank	Point Angle
601055-0400	40mm	14mm	100mm	19.05mm / 3/4"	90°
601055-0550	55mm	14mm	109mm	19.05mm / 3/4"	90°
601057-0010	1-1/2"	9/16"	3-15/16"	3/4" / 19.05mm	82°
601057-0020	2-1/4"	9/16"	4-5/16"	3/4" / 19.05mm	82°

ULTRA MultiSink - *Increased wear resistance & long life performance - for use on wear plate*

Part No	D Ø	D2	L	Shank	Point Angle
601056-0400	40mm	14mm	100mm	19.05mm / 3/4"	90°
601056-0550	55mm	14mm	109mm	19.05mm / 3/4"	90°
601058-0010	1-1/2"	9/16"	3-15/16"	3/4" / 19.05mm	82°
601058-0020	2-1/4"	9/16"	4-5/16"	3/4" / 19.05mm	82°

MultiSink Pilots

Part No	D Ø	L	Shank
601050-0160	16mm	52mm	11mm
601050-0180	18mm		
601050-0200	20mm		
601050-0220	22mm		
601050-0240	24mm		
601050-0260	26mm		
601051-0010	9/16"	2-3/64"	7/16"
601051-0015	5/8"		
601051-0020	11/16"		
601051-0025	3/4"		
601051-0030	13/16"		
601051-0035	7/8"		
601051-0040	15/16"		

Use MultiSink pilot when countersinking bolt holes from 16 - 26mm diameter.
Use MultiSink with variable speed Magnet Drill.
The speed must be reduced when countersinking.

31.75mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	31.75mm / 1 1/4"
103013-0324	MT4	31.75mm / 1 1/4"

31.75mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 31.75mm Shank XL cutters to 19.05mm standard Magnet Drill fitting for use with 19.05mm (3/4") Weldon arbors

Includes pilot pin

Part No	Details
103091-1932-55	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 55mm cutters
103091-1932-110	19.05 Male to 31.75mm Female Weldon Adapter + Pilot for 110mm cutters

Standard Weldon Shank Extension Arbor

Will pass through hole diameters greater than 35mm

Part No	Extension Length	Shank Size
103090-0500	50mm	19.05mm / 3/4"
103090-0750	75mm	19.05mm / 3/4"
103090-1000	100mm	19.05mm / 3/4"

Spring Loaded Extension Arbor

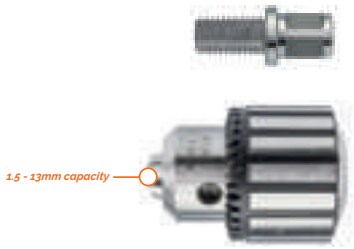
Spring Loaded extension arbor for very deep drilling using multiple extension arbors in series.

The spring loaded design means only the bottom extension needs to be piloted, with standard cutter pilot pin.

Will pass through hole diameters greater than 35mm.

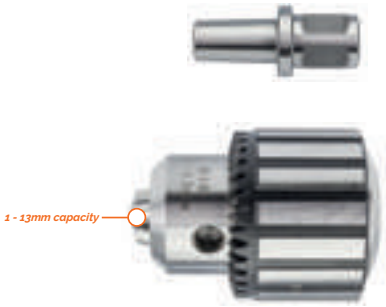
Part No	Extension Length	Shank Size
103095-1000	100mm	19.05mm / 3/4"

Magnet Drill Chuck & Adapter



Part No	Description	Fitting Type
103018	Weldon Shank to UNF Thread Chuck Adapter	19.05mm / 3/4"
103075	Keyed Mag Drill Chuck 1.5-13mm UNF Thread	1/2" Chuck - B16 taper

Heavy Duty Magnet Drill Chuck & Adapter



Part No	Description	Fitting Type
103017	Chuck Adapter	19.05mm / 3/4"
103070	Keyed Chuck	1/2" Chuck - B16 taper

Weldon Shank - Morse Taper Arbor 19.05mm

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0192	MT2	19.05mm / 3/4"
103013-0193	MT3	19.05mm / 3/4"
103013-0194	MT4	19.05mm / 3/4"
103014-0192	MT2 Internal Cooling Arbor 19.05mm	
103014-0193	MT3 Internal Cooling Arbor 19.05mm	

Replacement Set Screws

Spare grub screws to suit virtually all standard Magnet drill arbors, fittings and components

Part No	Thread Size	Hex Key Size	Unit of sale
103060-0606	M6 x 6	3mm	Pack 10
103060-0808	M8 x 8	4mm	Pack 10
103060-1010	M10 x 10	5mm	Pack 10
103060-1212	M12 x 12	6mm	Pack 10

TECHNICAL DATA & USER ADVICE P120 - P143

GoldMax TCT Flame Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402050-0060	6 x 16mm	60mm
402050-0120	12 x 31mm	76mm

GoldMax TCT Cylinder End Cut Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402040-0060	6 x 16mm	60mm
402040-0120	12 x 25mm	69mm

GoldMax TCT Ball Nose Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402020-0060	6 x 16mm	60mm
402020-0120	12 x 25mm	69mm

GoldMax TCT Ball Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402010-0060	6 x 16mm	50mm
402010-0120	12 x 10mm	55mm

GoldMax TCT Tree Burr

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension	Total Length
402060-0060	6 x 16mm	60mm
402060-0120	12 x 25mm	69mm

GoldMax 4 Piece TCT Burr Set

Standard 6mm Shank
Double cut - Titanium Coated

Part No	Head Dimension
4020-SET2	6mm
4020-SET1	12mm

TCT Flame Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402150-0060	6 x 16mm	60mm
402150-0120	12 x 31mm	76mm

TCT Cylinder End Cut Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402140-0060	6 x 16mm	60mm
402140-0120	12 x 25mm	69mm

TCT Ball Nose Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402120-0060	6 x 16mm	60mm
402120-0120	12 x 25mm	69mm

TCT Ball Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402110-0060	6 x 16mm	50mm
402110-0120	12 x 10mm	55mm

TCT Tree Burr

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension	Total Length
402160-0060	6 x 16mm	60mm
402160-0120	12 x 25mm	69mm

4 Piece TCT Burr Set

Standard 6mm Shank
Double cut - Bright Finish

Part No	Head Dimension
4021-SET2	6mm
4021-SET1	12mm

AliCut TCT Flame Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402250-0060	6 x 16mm	60mm
402250-0120	12 x 31mm	76mm

AliCut TCT Cylinder End Cut Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402240-0060	6 x 20mm	50mm
402240-0120	12 x 25mm	70mm

AliCut TCT Ball Nose Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402220-0060	6 x 16mm	60mm
402220-0120	12 x 25mm	70mm

AliCut TCT Ball Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402210-0060	6 x 16mm	50mm
402210-0120	12 x 10mm	55mm

AliCut TCT Tree Burr

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension	Total Length
402260-0060	6 x 16mm	60mm
402260-0120	12 x 25mm	69mm

AliCut 4 Piece TCT Burr Set

Standard 6mm Shank
Aluminium cut - Bright Finish

Part No	Head Dimension
4022-SET2	6mm
4022-SET1	12mm

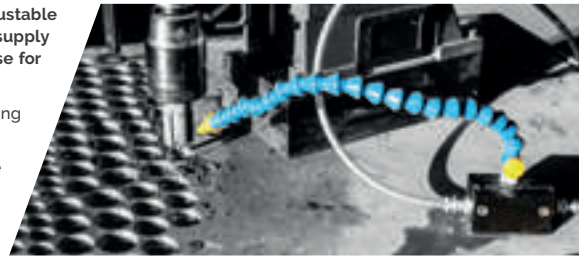
TECHNICAL DATA & USER ADVICE P120 - P143

Cordless Coolant Pump

4 Litre, rechargeable cordless coolant pump with adjustable dispensing arm, magnetic foot and additional coolant supply outlet that can be connected to a magnet drill arbor. Use for both external flooding and through arbor cooling.

Dispensing arm provides hands-free lubrication and cooling for otherwise difficult operations.

The magnetic foot can be secured to any magnetic surface for maximum flexibility of use when working at height, in tight, awkward locations or just where two hands are needed for the job and lubrication wouldn't otherwise be possible.



- *4 Litre capacity*
- *Cordless, with integrated rechargeable battery*
- *Magnetic foot for continuous hands free lubrication*
- *Can also be used to for through-arbor coolant on magnetic drills.*

TECHNICAL SPECIFICATIONS

LENGTH	320mm (Exc. dispensing arm)
WIDTH	155mm
HEIGHT	260mm
WEIGHT	950g (Empty)
BATTERY	2Ah
BATTERY LIFE	Up to 3hrs
CAPACITY	4 Litres

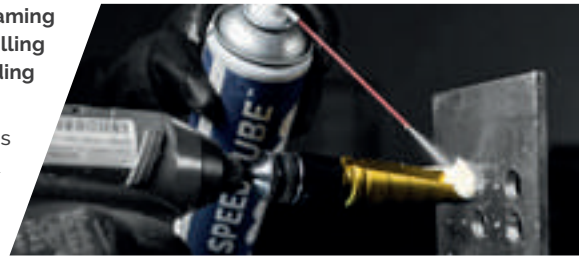
Part No	Contents
103010-KIT	4L Cordless Coolant Pump Kit

For best results use with BioCut Blue lubricant & room temperature tap water.
Suggested mix: 0.5L of BioCut Blue to 3.5L water

SpeedLube

SpeedLube™ is a high performance foaming lubricant suitable for a wide variety of metal drilling applications across a range of materials including stainless steel.

Aerosol propellant ensures the lubricant foams on contact to ensure maximum tool coverage & heat dissipation.



- *Easy one-handed application*
- *Fast, efficient lubricant coverage*
- *Unique 360° valve allows spraying from all angles*

Part No	Aerosol Size	Unit of Sale
701010-0002	500ml	Each
701010-0002-P12	500ml	Pack of 12
701010-0002-144	500ml	12 Packs of 12
701010-0002-432	500ml	36 Packs of 12

BioCut Blue Neat Broaching Oil

BioCut Blue is a ultra high-performance cutting fluid designed for metal fabrication broaching, cutting, and drilling tasks.

- Water-soluble fluid supplied ready-for-use.
- Inherently bio-degradable, can be 100% removed with water.
- Synthetic based, chlorine free, with zero mineral oils.
- No adverse affects for welding and galvanising.
- Excellent performance on Stainless Steel & Hardox type materials

Part No	Bottle Size	Unit of Sale
704010-0001	5 Litres	Each
704010-0001-P4	5 Litres	Box of 4
704010-0002	500ml Bottle	Each
704010-0002-P20	500ml Bottle	Box of 20

BioCut Paste - Drilling & Tapping Paste

BioCut Drilling & Cutting paste is specifically formulated for superb performance when used with HMT Impact Wrench cutting tools. Extreme pressure concentration provides accurate hole lubrication. Excellent general purpose paste lubricant when drilling, tapping, countersinking, reaming and broaching. Chlorine Free for safer use. Suitable for use with all grades of steel including Stainless Steel & Aluminium.

Part No	Aerosol Size	Unit of Sale
704030-0001	250g	Each
704030-0001-P16	250g	Pack of 16

TurboTip Jobber Drill Bit 7pc Set

Part No.	Contents
202050-SET4	3, 4, 5, 6, 7, 8, 10mm

TurboTip Jobber Drill Bit 7pc Set

Part No.	Contents
202050-SET3	5, 6, 6.8, 8, 8.5, 10, 10.2mm

TurboTip Jobber Drill Bit 19pc Set

Part No.	Contents
202050-SET1	1, 1.5, 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7, 7.5, 8, 8.5, 9, 9.5, 10mm

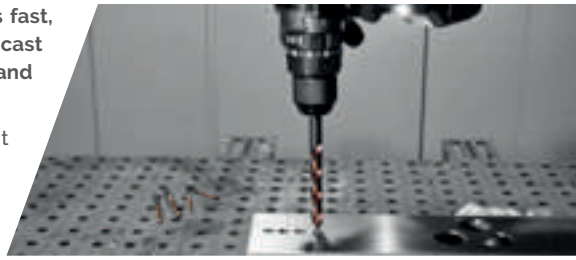
TurboTip Jobber Drill Bit 25pc Set

Part No.	Contents
202050-SET2	1, 1.5, 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7, 7.5, 8, 8.5, 9, 9.5, 10, 10.5, 11, 11.5, 12, 12.5, 13mm

TurboTip Cobalt Jobber Drill Bits
HOLEMAKER TECHNOLOGY HMT

The TurboTip® Cobalt Jobber Drill Bit delivers fast, accurate drilling in steel, stainless steel, and cast iron, with additional capability in aluminium and other non-ferrous materials..

Manufactured from 5% cobalt HSCo steel, it offers outstanding heat and wear resistance, maintaining sharpness and accuracy even under continuous use.



- *Stepped tip design for fast, accurate, pilot-free drilling*
- *Excellent performance in Stainless Steel*
- *Outstanding heat and wear resistance for longer life*
- *Create exact, circular holes with minimal pressure and burr-free finish*
- *3 shank flats provide secure, non-slip operation*
- *Use in any standard 1/2" drill chuck*
- *Use in any Magnet Drill with a standard 1/2" drill chuck*
- *Rotary Rated - not recommended for Impact use*

Part No	ØD (mm)	L (mm)	l1 (mm)	Pack Size
202050-0010-P10	1	34	12	10pcs
202050-0015-P10	1.5	40	18	
202050-0020-P10	2	49	24	
202050-0025-P10	2.5	57	30	
202050-0030-P10	3	61	33	
202050-0032-P10	3.2	65	36	
202050-0033-P10	3.3	65	36	
202050-0035-P10	3.5	70	39	
202050-0040-P10	4	75	43	
202050-0041-P10	4.1	75	43	
202050-0042-P10	4.2	75	43	
202050-0045-P10	4.5	80	47	
202050-0049-P10	4.9	86	52	
202050-0050-P10	5	86	52	
202050-0051-P10	5.1	86	52	
202050-0052-P10	5.2	86	52	
202050-0055-P10	5.5	93	57	

Part No	ØD (mm)	L (mm)	l1 (mm)	Pack Size
202050-0060-P10	6	93	57	10pcs
202050-0065-P10	6.5	101	63	
202050-0068-P10	6.8	109	69	
202050-0070-P10	7	109	69	
202050-0075-P5	7.5	109	69	5pcs
202050-0080-P5	8	117	75	
202050-0085-P5	8.5	117	75	
202050-0090-P5	9	125	81	
202050-0095-P5	9.5	125	81	
202050-0100-P5	10	133	87	
202050-0102-P5	10.2	133	87	
202050-0105-P5	10.5	133	87	
202050-0110-P5	11	142	94	
202050-0115-P5	11.5	142	94	
202050-0120-P5	12	151	101	
202050-0125-P5	12.5	151	101	
202050-0130-P5	13	151	101	

Industry-standard HSS drills with a Morse taper shank for secure, rigid machine fitting.

Manufactured to DIN 345 standards with a 118° point angle and black oxide finish for reduced friction and improved chip flow.

- *Made from durable High-Speed Steel (HSS)*
- *Standardised to DIN 345 for consistent performance*
- *118° point angle for general-purpose drilling*
- *Black finish for improved wear resistance and chip evacuation*
- *Used where blind holes are required for tapping*
- *Ideal for use in large magnetic drills and pillar drills*

Part No.	ØD (mm)	Morse Taper Size
206010-0100	10	MT 1
206010-0105	10.5	MT 1
206010-0110	11	MT 1
206010-0120	12	MT 1
206010-0130	13	MT 1
206010-0140	14	MT 1
206010-0145	14.5	MT 2
206010-0150	15	MT 2
206010-0160	16	MT 2
206010-0170	17	MT 2
206010-0175	17.5	MT 2
206010-0180	18	MT 2
206010-0190	19	MT 2
206010-0200	20	MT 2
206010-0210	21	MT 2
206010-0220	22	MT 2
206010-0230	23	MT 2
206010-0240	24	MT 3

Part No.	ØD (mm)	Morse Taper Size
206010-0250	25	MT 3
206010-0260	26	MT 3
206010-0265	26.5	MT 3
206010-0270	27	MT 3
206010-0280	28	MT 3
206010-0290	29	MT 3
206010-0300	30	MT 3
206010-0320	32	MT 4
206010-0330	33	MT 4
206010-0340	34	MT 4
206010-0350	35	MT 4
206010-0360	36	MT 4
206010-0370	37	MT 4
206010-0380	38	MT 4
206010-0390	39	MT 4
206010-0400	40	MT 4
206010-0420	42	MT 4
206010-0450	45	MT 4
206010-0500	50	MT 4

FURTHER SIZES AVAILABLE ON REQUEST

HMT CarbideMax TCT Morse Taper Shank (MT2) 90° Countersink 31mm

Part No	Product
602030-0310	TCT MT2 90° Countersink 31mm

HMT 90° Carbide Indexable Countersink 76mm

76mm heavy-duty large countersink with Morse Taper shank.
Each countersink is supplied with Premium replaceable carbide inserts for cost effective performance in structural metals.
Supplied with set of 3 tips which are double sided for extended use.

Part No	Product
602040-0760	MT3 Carbide Indexable Countersink
602040-0760R	Single Tungsten Carbide Tip - 2 sided

Morse Taper Drifts

Tapered steel drifts for simple removal of Morse Taper arbors, drill bits and tooling from MT2, MT3 or MT4 machine spindles

Part No	Suits
103012-0002	MT1 & MT2
103012-0003	MT3
103012-0004	MT4

Morse Taper Sleeve Reducer

Morse Taper sleeve reducers have a smaller internal taper size than the machine (drive) end, to allow a smaller morse taper to be fitted.
Hardened and ground, high precision specification.

Part No	Size
103615-R21	MT2 outside, MT1 Inside
103615-R32	MT3 outside, MT2 Inside
103615-R43	MT4 outside, MT3 Inside
103615-R53	MT5 outside, MT3 Inside
103615-R54	MT5 outside, MT4 Inside

Morse Taper Extension

Morse Taper Extensions have an Internal and an External Morse Taper and are used to extend the reach of Magnet Drill Arbors and enable the use of tooling with different size shanks.
Hardened and ground, high precision specification.

Part No	Size
103616-E32	MT3 outside, MT2 inside
103616-E33	MT3 outside, MT3 inside
103616-E34	MT3 outside, MT4 inside
103616E-E43	MT4 outside, MT3 inside
103616-E44	MT4 outside, MT4 inside

Swarf Magnet

The HMT Magnetic Swarf Lifter allows for safe and efficient removal of metal swarf from the work area.

This portable but durable piece of equipment is 400mm in length and features a strong magnet, grooved grip for increased usability in damp and greasy environments and an integrated release handle.

Part No	Total Length	Magnet Length
103011-01	400mm	180mm
103011-01-P12	12 Pack	

Empty ETOP2 Half Top Case

Build your own personalised toolkit with the ETOP2 Half case.
The ultimate in portability & lightweight, easy to transport tooling protection, the ETOP2 fits
2 x Small InsertFoams or
1 x Large InsertFoam

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents
MKC-ETOP2	Empty ***STAKIT*** ETOP2 Half Top Case

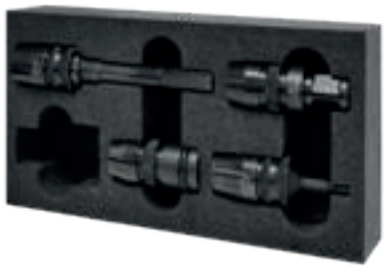
Empty ETOP4 Full Top Case

The ETOP4 Top case gives complete freedom when creating your own unique toolkit. Choose between:
4 x Small InsertFoams or
2 x Large InsertFoams or
2 x Small InsertFoams + 1 x Large InsertFoam

L x W x H (mm) - 540 x 390 x 95

Part No	Set contents
MKC-ETOP4	Empty ***STAKIT*** ETOP4 Full Top Case

Versadrive Rapid-Lock Adapter Set



Part No	Product
111005-SET1	Versadrive Rapid-Lock Adapter InsertFoam Set 4pc

Versadrive Heavy-Duty Adapter Set

Part No	Product
111005-SET2	Versadrive HD Adapter InsertFoam Set 4pc

Versadrive InsertFoam for adapters - 5 spaces

Part No	Product
SETFM-ADP-05	Versadrive Adapter Small InsertFoam

Versadrive InsertFoam for long series tools - 3 spaces

Part No	Product
SETFM-LS-03	Versadrive Long Series Tools InsertFoam

Versadrive STAKIT® Small InsertFoam - 7 spaces

Part No	Product
SETFM-VSD-07	Versadrive InsertFoam Small - 7 Spaces

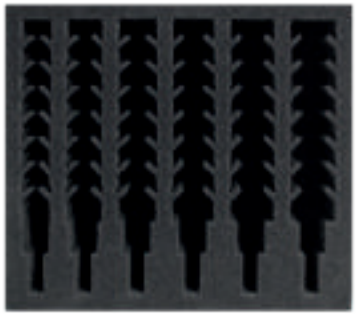
Versadrive STAKIT® Small InsertFoam - 8 spaces

Part No	Product
SETFM-VSD-08	Versadrive InsertFoam Small - 8 Spaces

Carbidemax STAKIT® Small InsertFoam - 5 spaces

Part No	Product
SETFM-WLD-05	CarbideMax InsertFoam Small - 5 Spaces

Versadrive STAKIT® Large InsertFoam - 6 spaces



Part No	Product
SETFM-LS-06	Versadrive Long Series Tools InsertFoam 6 Spaces

ETOP2 Turbo Impact Kit

Compact but fully stocked, the ETOP2 Starter Kit provides all the most commonly needed sizes of drilling, tapping and enlarging tools for hole creation and modification in the field.

Connects to ***STAKIT*** ETOP2 and ETOP4 cases

Metric Kit Contents:

4 x TurboTips	6.8, 8.5, 10.5, 14mm
4 x ImpactaTaps	M8, M10, M12, M16
3 x TurboTip ImpactaSteps	8-16, 14-22, 18-26mm

1 x Versadrive ½" Rapid-Lock Impact Wrench Adapter
1 x Versadrive 130mm Extension Arbor
1 x ***STAKIT*** ETOP2 Half Top Case

Fractional Kit Contents:

4 x TurboTips	#7, #F, 5/16, 27/64"
4 x ImpactaTaps	1/4, 5/16, 3/8, 1/2"
3 x TurboTip ImpactaSteps	9/16, 13/16, 1-1/16"

1 x Versadrive ½" Rapid-Lock Impact Wrench Adapter
1 x Versadrive 5" Extension Arbor
1 x ***STAKIT*** ETOP2 Half Top Case

L x W x H (mm) - 270 x 370 x 95

Part No	Product
STC-ETOP2-IMPACT	ETOP2 Starter Kit - Metric Sizes
STC-ETOP2-IK01	ETOP2 Starter Kit - Fractional Sizes

ETOP2 Turbo Drilling Kit

Brand NEW to the range, the ETOP2 Turbo Drilling Kit features an essential collection of impact rated tooling designed for fast, safe, anti-kickback hole creation in sizes from 6mm - 32mm.
Use Cone Cutters on thin sheet material up to 3mm thick, ImpactaStep on material up to 12mm thick and TurboTips on material up to 50mm thick.

Metric Kit Contents:

4 x TurboTips	6, 8, 10, 12mm
3 x Cone Cutters	20, 25, 32mm
3 x TurboTip ImpactaSteps	8-16, 14-22, 18-26mm

1 x Versadrive ½" Rapid-Lock Impact Wrench Adapter
1 x ***STAKIT*** ETOP2 Half Top Case

Fractional Kit Contents:

4 x TurboTips	1/4, 5/16, 3/8, 1/2"
3 x Cone Cutters	13/16, 1, 1-1/4"
3 x TurboTip ImpactaSteps	9/16, 13/16, 1-1/16"

1 x Versadrive ½" Rapid-Lock Impact Wrench Adapter
1 x ***STAKIT*** ETOP2 Half Top Case

L x W x H (mm) - 270 x 370 x 95

Part No	Product
STC-ETOP2-DRILL	ETOP2 Turbo Drilling Kit - Metric Sizes
STC-ETOP2-DRILL-IN	ETOP2 Turbo Drilling Kit - Fractional Sizes

Create, enlarge and tap holes using Impact Wrenches with the upgraded ***STAKIT*** ETOP4 Impact Kit. The perfect kit for steel erectors, snaggers and site crews looking to keep the job moving.

Connects to ***STAKIT*** ETOP2, ETOP4 and EMID cases

Metric Kit Contents:

7 x TurboTips	6.8, 8, 8.5, 10, 10.5, 12, 14mm
5 x ImpactaTaps	M6, M8, M10, M12, M16
3 x Impact Reamers	14, 18, 22mm
2 x TurboTip ImpactaSteps	8-16, 18-26mm

Fractional Kit Contents:

4 x TurboTips	#7, #F, 5/16, 27/64"
5 x ImpactaTaps	1/4, 5/16, 3/8, 1/2, 5/8"
3 x Impact Reamers	9/16, 11/16, 13/16"
2 x TurboTip ImpactaSteps	9/16, 13/16"

1 x Versadrive ½" Rapid-Lock Impact Wrench Adapter
1 x Versadrive 130mm / 5" Extension Arbor
1 x ***STAKIT*** ETOP4 Full Top Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
STC-ETOP4-IMPACT	ETOP4 Impact Kit - Metric Sizes
STC-ETOP4-IK02	ETOP4 Impact Kit - Fractional Sizes

The ***STAKIT*** SiteCart Compact is a wheeled base unit with retractable handle and robust, water and dust proof construction.

The case can be used on its own for large equipment storage or combined with the rest of the ***STAKIT*** system to transport tooling and cases to and around the job site or workshop.

The case is designed to be tilted and pulled, has a handy narrow size and is easy to manoeuvre. Supplied empty.

L x W x H (mm) - 605 x 405 x 345mm

Part No	Product
STC-SITECART2	Versadrive ***STAKIT*** Wheeled SiteCart Compact

The ***STAKIT*** Site Installation Kit combines an essential set of best-selling Versadrive products to overcome all common site installation and steel erection holemaking challenges.

Keeps the job moving when you find an unexpected challenge.

Presented in an interlocking, stackable, and protective ***STAKIT*** EMID Case.

Connects to ***STAKIT*** ETOP4, EMID and Base cases

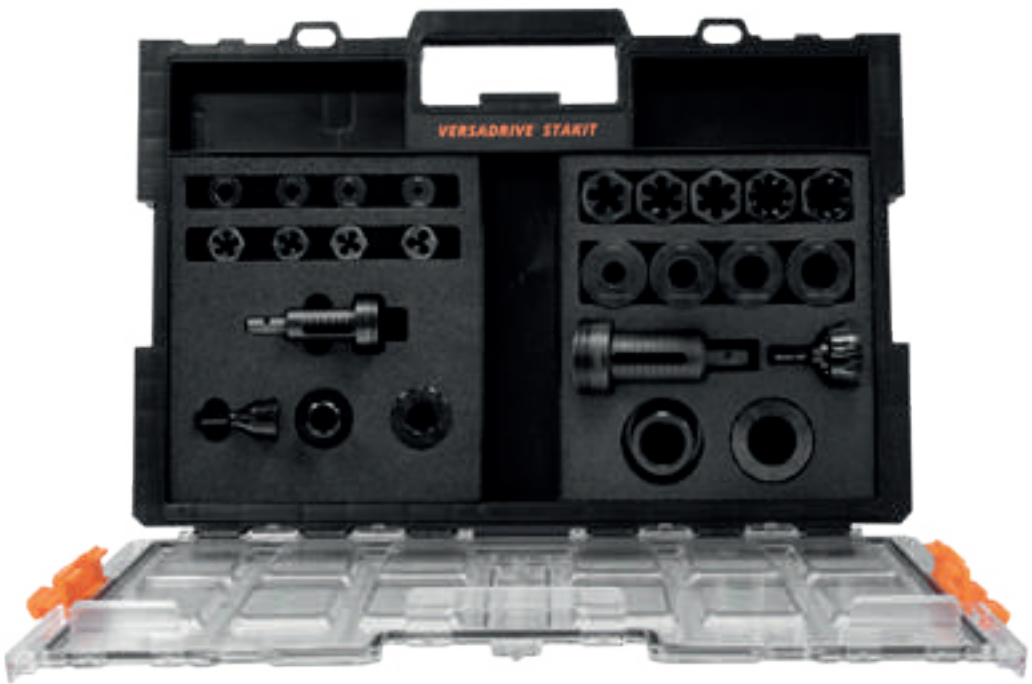
Metric Kit Contents:		***Fractional Kit Contents:***	
6 x TurboTips	6, 6.35, 8, 10.5, 12, 14mm	6 x TurboTips	1/4, 9/32, 5/16, 3/8, 7/16, 1/2"
5 x HoleCutters	14, 17, 18, 20, 22mm	5 x HoleCutters	9/16, 5/8, 3/4, 7/8, 1"
4 x Impact Reamers	12, 14, 18, 22mm	4 x Impact Reamers	1/2, 9/16, 11/16, 13/16"
3 x Impact DrillTaps	M6, M8, M10	3 x Impact DrillTaps	5/16, 3/8, 1/2"
3 x ImpactaTaps	M12, M16, M20	3 x ImpactaTaps	1/2, 5/8, 3/4"
2 x TurboTip ImpactaSteps	8-16, 14-22mm	2 x TurboTip ImpactaSteps	9/16, 13/16"

+ 5x Rapid lock Versadrive adapters

¼" Impact Driver Adapter, ½" Impact Wrench Adapter,
Magnet Drill Adapter, 130mm Extension, 300mm Extension

L x W x H (mm) - 582 x 387 x 131

Part No	Product
STC-EMID-MEIK	Versadrive ***STAKIT*** Installation Kit - Metric Sizes
STC-EMID-INIK	Versadrive ***STAKIT*** Installation Kit - Fractional Sizes



Create or repair external threads on metal bar or conduit with the Versadrive ImpactaDie system.

Offering fast, easy impact-thread cutting in a variety of sizes from M6 - M25, the ImpactaDie complete kit speeds up the challenging and traditionally time-consuming process of creating both small and large external threads.

Utilize the speed and power of high-torque impact wrenches* or the power and precision of magnetic drills* to reduce labour and fatigue, improve productivity and complete jobs in less time.

The kit includes the Versadrive ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a Versadrive ***STAKIT*** compatible ETOP4 top case.

*(requires Versadrive Impact Wrench Adapter or Versadrive Magnetic Drill Adapter).

Kit Contents:

ImpactaDie Holder for M6 - M12 threads
ImpactaDie Holder for M16 - M25 threads
Guide Collar for M6 - M12 threads
Guide Collar for M16 - M25 threads
Flush Collar for M6 - M12 threads
Flush Collar for M16 - M25 threads
M6/8/10/12/16/20/24/25 Guides
M6/8/10/12/16/20/24 Metric Coarse Hex Die Nuts
M16/20/25 Metric Fine Hex Die Nuts
ImpactaBurr 19mm Chamfer Tool
ImpactaBurr 36mm Chamfer Tool
STAKIT ETOP4 Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
115810-CSET	Versadrive ImpactaDie Complete Kit (M6 - M25)

The NEW Versadrive *STAKIT* ULTRA Kit has been developed to offer a comprehensive solution to drilling & countersinking the most challenging materials.

With cutting tools from 6 - 26mm diameter and countersinking options up to 40mm, this kit is a must have for operatives in the quarrying/mining, heavy machinery/plant repair and defence sectors.

Kit Contents:	*Metric Kit:*	*Fractional Kit:*
ULTRA 55 TCT Broach Cutters	18, 20, 22, 24, 26mm	11/16, 3/4, 13/16, 15/16"
Versadrive ULTRA Drill Bits	6, 8, 10, 12, 14mm	1/4, 5/16, 3/8, 1/2, 9/16"
Weldon Shank ULTRA TCT Countersink	32mm, 90°	1-1/4", 82°
ULTRA coated Tungsten Carbide MultiSink	40mm, 90°	1-1/2", 82°
MultiSink Pilots	18, 20, 22, 24, 26mm	11/16, 3/4, 13/16, 15/16"

+

1 x Versadrive Heavy Duty Magnet Drill Adapter
1 x Versadrive ***STAKIT*** ETOP4 Full Top Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product
STC-ULTRA-KIT	***STAKIT*** Ultra Kit - Metric Sizes
STC-ULTRA-KIT-01	***STAKIT*** Ultra Kit - Fractional Sizes

Material	
1.1 Structural Steel	Highly recommended and widely used for drilling structural steel
1.2 Hardened Steel	Feasible for drilling some grades of hardened steel in controlled situations. For best results, the HMT Ultra tooling range is recommended. Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates and extra coolant
1.3 Stainless Steel	While TCT Cutters are suitable for use on Stainless Steel, Magnet Drills will not adhere to Stainless material.
1.4 Non Ferrous	While the cutters are suitable for drilling aluminium and other non ferrous metals, Magnet Drills will not adhere to these materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
	Hot Rivet Drilling: This is a specialist application for both HoleCutters and Annular Broach Cutters where legacy hot rivets need to be removed by drilling through the rivet. Refer to HMT's Rivet Drilling Guidance for best practice
Apparatus / Drilling Machines	
2.1 Impact Wrench	Annular Broach Cutters are not suitable for use on this type of drilling machine
2.2 Rotary Pistol Drill	Annular Broach Cutters are not suitable for use on this type of drilling machine
2.3 Compact Magnet Drill	Normally used with Cutters with diameters from 12mm to 36mm. Typically they are single speed with RPM between 450 and 700 rpm
2.4 Large Magnet/Pillar Drill	These units usually have more powerful motors and lower rotation speeds, so they are recommended for larger size cutters. Pillar drills with Morse Taper spindles can easily be fitted with a Annular Cutter Arbor
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
Thickness	
3.1 Sheet Metal up to 4mm	HMT Annular Broach cutters are suitable for this application but consider that Magnetic Drills will not hold securely to steel below 10mm thickness.
3.2 Standard Plate 5 - 12mm	HMT Annular Broach cutters are suitable for this application but consider that Magnetic Drills will not hold securely to steel below 10mm thickness.
3.3 Medium Plate 12 - 25mm	This application is very typical for Annular Broach Cutters
3.4 Heavy Plate - above 25mm	For drilling holes in steel thicker than 20mm it is recommended to ventilate the hole during the cut to clear the swarf. This means backing the cutter up out of the hole being cut, while the cutting tool is rotating, which will usually remove any swarf build up.
3.5 Additional Notes	HMT Annular Broach cutters are available in cutting lengths (also known as depth-of-cut) up to 200mm
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for general purpose drilling along with harder steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials, Use flood coolant to keep tool & workpiece cool to prevent work hardening.
Accessories	
5.1 Impact Adapters	Annular Broach Cutters are not suitable for this application
5.2 Pistol Drill / Chuck	Annular Broach Cutters are not suitable for this application
5.3 Weldon Adapters	Most Magnetic Drills will have the Universal Weldon shank as standard, for easy fitment of Annular broach cutters
5.4 Morse Taper Adapters	For large magnet drills and Pillar Drills, a MT Arbor is required to use Annular Broach Cutters. Typical sizes are MT2 for up to 60mm diameter, and MT3 for up to 125mm diameter cutters

Broach Cutters - Data Sheet STEELBOR®

Best Practice	
6.1 Do I need a pilot hole or a centre punch?	Centre punch the surface for accurate hole start. This allows the Centre Pilot Pin to engage positively
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Apply the feed slowly and cautiously during the first 1mm of cut. Excess feed pressure will increase heat buildup and reduce cutter life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	For best results & swarf clearance always select a cutter longer than the material thickness
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

TCT Annular Broach Cutters

Diameter Range		Structural Steel (30 m/min)	Hardened Steel (10 m/min)	Stainless Steel (15 m/min)	Non-Ferrous (80 m/min)
12 - 19mm	15/32" – 11/16"	800–505	265–170	400–255	2130–1345
20 - 25mm	3/4" – 1"	480–380	160–125	240–190	1280–960
26 – 32 mm	1-1/16" – 1-1/4"	370–300	125–95	185–150	990–810
33 – 39 mm	1-5/16" – 1-17/32"	300–245	100–80	150–120	810–690
40 – 46 mm	1-9/16" – 1-13/16"	240–210	80–65	120–105	650–575
47 – 53 mm	1-7/8" – 2-3/32	205–180	70–55	105–90	555–475
54 – 60 mm	2-1/8" – 2-3/8"	180–160	60–50	90–80	475–425
61 – 70 mm	2-3/8" – 2-3/4"	160–135	55–45	80–65	425–370
71 – 80 mm	2-13/16" – 3-5/32"	135–120	45–40	65–55	370–335
81 – 90 mm	3-3/16" – 3-17/32"	120–105	40–35	55–50	335–280
91 – 100 mm	3-9/16" – 3-15/16"	105–95	35–30	50–45	280–255
101 – 112 mm	4" – 4-13/32"	95–85	30–25	45–40	255–230
113 – 124 mm	4-7/16" – 4-7/8"	85–75	25–20	40–35	230–205
125 – 136 mm	4-15/16" – 5-11/32"	75–70	25–20	35–30	205–185
137 – 150 mm	5-13/32" – 5-7/8"	70–60	20–15	30–25	185–170
151 – 174 mm	5-15/16" – 6-27/32"	60–50	20–15	25–20	170–145
175 – 200 mm	6-7/8" – 7-7/8"	50–45	15–10	20–15	145–125

HSS Annular Broach Cutters

Diameter Range		Structural Steel (20 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
12–19 mm	15/32"–11/16"	530–335	210–135	315–200	1325–830
20–25 mm	3/4"–1"	320–255	125–100	190–150	800–635
26–32 mm	1-1/16"–1-1/4"	245–200	95–75	145–115	610–500
33–39 mm	1-5/16"–1-17/32"	190–160	75–60	115–95	475–405
40–46 mm	1-9/16"–1-13/16"	160–140	60–50	95–80	400–345
47–53 mm	1-7/8"–2-3/32	140–120	55–45	80–70	345–300
54–60 mm	2-1/8"–2-3/8"	120–105	45–40	70–60	300–265

Material	
1.1 Structural Steel	101030 and 101035 Holecutters are highly recommended for drilling structural steel
1.2 Hardened Steel	Feasible for drilling some grades of hardened steel in controlled situations. For best results, the HMT Ultra tooling range is recommended. Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates & extra coolant
1.3 Stainless Steel	Suitable for drilling most grades of stainless steel. Reduce RPM spindle speed, increase feed pressure, and ensure sufficient coolant supply.
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
	Hot Rivet Drilling: This is a specialist application for both HoleCutters and Annular Broach Cutters where legacy hot rivets need to be removed by drilling through the rivet. Refer to HMT's Rivet Drilling Guidance for best practice
Apparatus / Drilling Machines	
2.1 Impact Wrench	Not recommended for impact use in hard materials such as structural steel, due to the high rotation speed of impact wrenches. Non Ferrous and softer materials can be drilled using impact wrenches / impact drivers
2.2 Rotary Pistol Drill	Rotary Pistol Drills are highly recommended for best results with Holecutters. Generally the best results are achieved with the lower speed settings
2.3 Compact Magnet Drill	Can be used with 111035 Adapter. Check there is enough travel/stroke on the magdrill. Exchange the supplied pilot drill for the 101030P-0003 series Pilot Pin
2.4 Large Magnet/Pillar Drill	Recommended for use with larger holecutters, for example above 50mm diameter. Large magdrills can be fitted with a weldon adapter, as above, however large magdrills and pillar drills can also be fitted with a chuck
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling- (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	101050 TCT SheetCutters are recommended
3.2 Standard Plate 5 - 12mm	101030 HoleCuttters are recommended
3.3 Medium Plate 12 - 25mm	101030 HoleCuttters are recommended. For thicker materials, predrill a 6.35mm pilot first, then use a sprung pilot drill or pilot pin as a guide.
3.4 Heavy Plate - above 25mm	For drilling holes in steel thicker than 20mm it is recommended to ventilate the hole during the cut to clear the swarf. This means backing the cutter up out of the hole being cut, while the cutting tool is rotating, which will usually remove any swarf build up.
3.5 Additional Notes	The standard 101030 HoleCutter has a 55mm cutting depth capacity, and has been used at this max capacity for drilling steel 50mm+ in thickness for structural steel and bridge strengthening projects. 101035 Extra Long HoleCutters have a reach of 120mm with an effective cutting depth of 100mm.
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for general purpose drilling along with harder steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials, Use flood coolant to keep tool & workpiece cool to prevent work hardening.

TCT HoleCutters - Data Sheet
VERSADRIVE® PATENT PROTECTED

Accessories	
5.1 Impact Adapters	Not normally recommended for use with Holecutters
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	Versadrive HoleCutters can be used with Versadrive Weldon shank Magnet Drill Adapters. When used like this the standard pilot drill can be used, or it can be removed and replaced with an extended length pilot pin (eg 101030P-0003) for use as an annular broaching type cutter
5.4 Morse Taper Adapters	All Versadrive Holecutters can be adapted for use in Morse Taper type drills with the 111045 Adapters
Best Practice	
6.1 Do I need a pilot hole or a centre punch?	For an accurate hole start, centre-punch the material to create a positive location point. When using the integral pilot drillbit in the TCT holecutter, it is possible for the cutter to catch and twist unexpectedly when the pilot drill breaks through, which may cause breakage; this is not considered a warranty fault. To minimise this risk, use a separate 1/4" (6.35 mm) drill bit to pre-drill the pilot hole. You can then refit the pilot drill, or alternatively use a solid 101030P-003 Pilot Pin as a stronger pilot guide.
6.2 What is the correct feed pressure?	For hand-held applications; apply firm, steady feed pressure throughout the cut, using extra caution at the beginning of the cut, as the hole is established.
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

TCT Holecutters

Diameter Range		Structural Steel (24 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (65 m/min)
12–17 mm	15/32"–11/16"	635–450	210–150	315–225	1725–1220
18–25 mm	3/4"–1"	420–305	140–100	210–155	1145–825
26–31 mm	1-1/16"–1-1/4"	295–245	100–80	150–120	800–670
32–39 mm	1-5/16"–1-17/32"	240–195	80–60	120–95	645–530
40–46 mm	1-9/16"–1-13/16"	190–165	65–55	95–80	515–450
47–53 mm	1-7/8"–2-3/32"	165–145	55–45	80–70	450–390
54–60 mm	2-1/8"–2-3/8"	145–125	45–40	70–60	390–345
61–70 mm	2-3/8"–2-3/4"	125–110	40–35	60–50	345–300
71–80 mm	2-13/16"–3-5/32"	110–95	35–30	50–45	300–255

TCT SheetCutters

Diameter Range		Structural Steel (50 m/min)	Hardened Steel (8 m/min)	Stainless Steel (30 m/min)	Non-Ferrous (80 m/min)
14–17 mm	15/32"–11/16"	1135–940	N/A	680–565	1815–1480
18–25 mm	3/4"–1"	885–635	N/A	530–380	1415–1010
26–31 mm	1-1/16"–1-1/4"	610–515	N/A	365–310	975–820
32–39 mm	1-5/16"–1-17/32"	500–410	N/A	300–245	800–655
40–46 mm	1-9/16"–1-13/16"	395–345	N/A	235–200	635–555
47–53 mm	1-7/8"–2-3/32"	345–300	N/A	205–175	555–505
54–60 mm	2-1/8"–2-3/8"	300–265	N/A	180–155	505–425
61–70 mm	2-3/8"–2-3/4"	265–230	N/A	155–130	425–365
71–76 mm	2-13/16"–3-5/32"	230–215	N/A	130–120	365–330

Material	
1.1 Structural Steel	For best results use 506040 TurboTip Impactastep cutters (up to 12mm thickness materials)
1.2 Hardened Steel	This category of tooling is not suitable for Hardened steel applications. Consider the HMT Ultra range of broaching and drilling tools
1.3 Stainless Steel	For best results use 202050 or 209010 Cobalt Drill bits on Rotary setting
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
Apparatus / Drilling Machines	
2.1 Impact Wrench	Impact Wrenches and Impact Drivers are recommended for step cutter applications. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P125 / P142. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage.
2.2 Rotary Pistol Drill	All the HMT tools in this category are suitable for pistol drill use. Rotary pistol drills are recommended for Stainless Steels
2.3 Compact Magnet Drill	All the HMT tools in this category can be adapted for use in a compact magnet drill with a Weldon adapter
2.4 Large Magnet/Pillar Drill	All the HMT tools in this category can be adapted for use in a large magnet drill with either a Weldon adapter or a morse taper adapter
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling- (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	HMT Cone Cutters and Step Drills are recommended for this application
3.2 Standard Plate 5 - 12mm	HMT ImpactaStep Cutters are recommended for this application
3.3 Medium Plate 12 - 25mm	Not recommended as the maximum step capacity in this category is 12mm
3.4 Heavy Plate - above 25mm	Not recommended as the maximum step capacity in this category is 12mm
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for general purpose drilling along with harder steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials, Use flood coolant to keep tool & workpiece cool to prevent work hardening.
Accessories	
5.1 Impact Adapters	All the tools in this category are suitable for use in Impact Wrenches and Impact Drivers (See Torque Table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All Versadrive Step Drills and Step Cutters can be adapted for use in Magdrills with the 111130 Adapter
5.4 Morse Taper Adapters	All Versadrive Step Drills and Step Cutters can be adapted for use in Morse Taper type drill with the 111045 Adapters

Step Cutters - Data Sheet
VERSADRIVE® PATENT PROTECTED

Best Practice	
6.1 Do I need a pilot hole or a centre punch?	Step Drills & 8-16mm TurboTip ImpactaStep Cutters generally do not need a pilot hole created. Centre punching can improve hole position accuracy but this is not essential. Pilot Drilling is helpful when the drill size is above 13mm Pilot Drilling to approx. 70% of the starting hole diameter is generally recommended
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	The 4mm Tip on Step drills should be treated with care while starting the initial hole
	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
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive Step Cutters - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
8–10 mm	280–340	315–380	N/A	N/A	1060–955	285–255	425–380	1770–1590
11–13 mm	300–380	335–420	N/A	N/A	795–665	215–180	315–265	1325–1125
14–16 mm	355–445	400–495	N/A	N/A	635–555	170–150	245–225	1060–930
17–19 mm	435–545	485–610	N/A	N/A	530–450	145–120	205–180	885–750
20–22 mm	465–575	520–650	N/A	N/A	455–395	125–110	175–155	760–665
23–25 mm	670–820	750–920	N/A	N/A	400–350	110–95	155–135	665–580
26–28 mm	750–930	840–1030	N/A	N/A	360–315	100–85	140–120	600–525
29–31 mm	930–1130	1040–1270	N/A	N/A	330–300	90–80	125–115	550–500
32–34 mm	1040–1260	1170–1420	N/A	N/A	305–280	80–75	115–105	505–470
35–37 mm	1080–1300	1210–1455	N/A	N/A	275–250	75–65	105–95	465–430
38–40 mm	1180–1420	1320–1585	N/A	N/A	250–225	65–60	100–90	420–395

For Fractional Sizes See P142

Material	
1.1 Structural Steel	For best results use 209015 TurboTip Drill bits
1.2 Hardened Steel	Feasible for drilling some grades of hardened steel in controlled situations. For best results, the HMT Ultra tooling range is recommended. Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates and extra coolant
1.3 Stainless Steel	For best results use 202050 or 209010 Cobalt Drill bits on Rotary setting
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
Apparatus / Drilling Machines	
2.1 Impact Wrench	Impact Wrenches and Impact Drivers can be suitable for drilling applications using the 209015 TurboTip Drill bit. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P127 / P142. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage.
2.2 Rotary Pistol Drill	All HMT drill bits are suitable for pistol drill use. Rotary pistol drills are recommended for Stainless Steels
2.3 Compact Magnet Drill	All Versadrive Drill bits can be adapted for use in a compact magnet drill with a Weldon adapter. Alternatively the 201070 Drill bits have a weldon shank
2.4 Large Magnet/Pillar Drill	All the HMT tools in this category can be adapted for use in a large magnet drill with either a Weldon adapter or a morse taper adapter
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	All HMT drill bits are suitable for this application Also consider Step Drills & Step Cutters for this thickness of material
3.2 Standard Plate 5 - 12mm	All HMT drill bits are suitable for this application
3.3 Medium Plate 12 - 25mm	All HMT drill bits are suitable for this application
3.4 Heavy Plate - above 25mm	All HMT drill bits are suitable for this application Consider using a magnet drill adapter to save fatigue
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for general purpose drilling along with harder steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials, Use flood coolant to keep tool & workpiece cool to prevent work hardening.

Drill Bits - Data Sheet
VERSADRIVE® PATENT PROTECTED

Accessories	
5.1 Impact Adapters	Suitable for using 209015 TurboTip Drill bits in impact wrenches and impact drivers (See Torque Table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All Versadrive drill bits can be adapted for use in Magdrills with the 111130 Adapter. Alternatively the 201070 Drill bits have a weldon shank
5.4 Morse Taper Adapters	All Versadrive drill bits can be adapted for use in Morse Taper type drills with the 111045 Adapters
Best Practice	
6.1 Do I need a pilot hole or a centre punch?	TurboTip drilling products, up to 13mm, generally do not need a pilot hole created. Cobalt split-point drills require pilot holes when above 10mm. Centre punching improves hole position accuracy but is not required for TurboTips. Pilot Drilling is recommended for all drill types when the diameter is above 13mm Pilot Drilling to approx. 70% of the required hole diameter is generally recommended
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	TurboTip Drills are recommended for through hole applications. 209010 Cobalt Split-Point Drills are recommended for blind hole drilling.
	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive Drill Bits - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
4–6 mm	140–160	160–180	240–280	265–310	2385–1590	635–425	955–635	3980–2655
7–9 mm	160–295	195–360	300–520	330–570	1365–1060	365–285	545–425	2275–1770
10–12 mm	320–350	395–430	580–635	640–700	955–795	255–210	380–320	1590–1325
13–15 mm	370–375	445–455	675–690	745–760	735–635	195–170	295–255	1225–1060
16–18 mm	455–580	580–720	880–1120	970–1230	595–530	160–140	240–210	995–885
19–21 mm	685–685	845–845	1245–1245	1370–1370	505–455	135–120	200–180	840–760
22–24 mm	720–720	900–900	1360–1360	1500–1500	435–400	115–105	175–160	725–665

For Fractional Sizes See P142

Material	
1.1 Structural Steel	All HMT tooling in this category are suitable for the common grades of steel
1.2 Hardened Steel	This category of tooling is not suitable for Hardened steel applications. Consider the HMT Ultra range of broaching and drilling tools
1.3 Stainless Steel	When using Reamers on stainless steel, lower RPM and a Rotary setting is recommended, due to the higher RPM of impact wrench tooling which contributes to heat buildup
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems. Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrenches. In this situation ream with a slow speed Magnet Drill
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
Apparatus / Drilling Machines	
2.1 Impact Wrench	Impact Wrenches and Impact Drivers are recommended for reamer applications for enlarging drilled holes in steel material. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P129 / P142. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage.
2.2 Rotary Pistol Drill	Reamers up to 12mm diameter can be used in a Pistol Drill at Low RPM. Sizes above 14mm diameter will generate high levels of kickback- this can be avoided by using an Impact Wrench or Magnetic Drill
2.3 Compact Magnet Drill	Compact Magnet Drills do not usually have enough stroke or working length to use reamers.
2.4 Large Magnet/Pillar Drill	All HMT tools in this category can be adapted for use in a large magnet drill with either a Weldon adapter or a morse taper adapter
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	HMT Reamers are suitable for this application
3.2 Standard Plate 5 - 12mm	HMT Reamers are suitable for this application
3.3 Medium Plate 12 - 25mm	HMT Reamers are suitable for this application
3.4 Heavy Plate - above 25mm	HMT Reamers are suitable for this application, the MAX shank will provide best results in heavy thickness materials.
3.5 Additional Notes	HMT Reamers have a tapered flute for the first half of their length, then the rear section of the reamer gives a parallel finish at the maximum diameter
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for hardened steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened material
Accessories	
5.1 Impact Adapters	All the tools in this category are suitable for use in Impact Wrenches (See Torque Table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All HMT Reamers can be adapted for use in Magdrills.
5.4 Morse Taper Adapters	501030 Reamers can be adapted for use in Morse Taper type drills with the 111045 Adapters

Reamers - Data Sheet
VERSADRIVE® PATENT PROTECTED

Best Practice	
6.1 Selecting the correct diameter of reamer	Do not attempt to increase the existing hole diameter beyond 2-3mm. If a larger, finished hole size is required, use the next size reamer to 'step up' until the finished hole diameter is reached. Reamer should be rotating before starting the cut
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf
6.5 Additional Notes	When reaming box or channel type section, ensure the front tip of the reamer does not collide with the far side of the material, which stops progress of the hole enlargement
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive Reamers - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (26 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (48 m/min)
8–10 mm	280–340	315–380	350–430	385–475	1030–825	315–250	470–375	1880–1500
11–13 mm	300–380	335–420	370–460	410–510	750–635	230–195	345–295	1410–1200
14–16 mm	355–445	400–495	445–545	490–600	590–515	180–160	270–240	1110–980
17–19 mm	435–545	485–610	535–675	590–745	485–435	145–135	220–200	915–830
20–22 mm	465–575	520–650	580–720	640–795	415–375	125–115	190–175	780–715
23–25 mm	670–820	750–920	840–1030	925–1130	365–335	110–100	165–150	690–630
26–28 mm	750–930	840–1030	1040–1280	1150–1420	330–305	95–90	150–135	620–565
29–31 mm	930–1130	1040–1270	1290–1580	1420–1740	295–275	85–80	135–125	555–515
32–34 mm	1040–1260	1170–1420	1450–1765	1600–1940	270–245	80–70	125–110	510–450
35–37 mm	1080–1300	1210–1455	1500–1810	1650–1990	250–230	70–65	110–100	470–430
38–40 mm	1180–1420	1320–1585	1630–1960	1800–2160	230–210	65–60	100–90	430–385
41–42 mm	1260–1520	1420–1720	1740–2115	1915–2330	215–205	60–55	95–85	405–365

For Fractional Sizes See P142

Material	
1.1 Structural Steel	All HMT tooling in this category is suitable for the common grades of steel
1.2 Hardened Steel	Feasible for countersinking some grades of hardened steel in controlled situations. For best results, the HMT Ultra tooling range is recommended. Hardened or heat-affected materials may require higher torque, reduced RPM & feed rates and extra coolant
1.3 Stainless Steel	Suitable for harder materials such as Stainless Steel when used at reduced RPM
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to countersink. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
Apparatus / Drilling Machines	
2.1 Impact Wrench	Versadrive Countersinks are suitable for light chamfering / deburring using an impact wrench. For full depth countersinking, use a rotary drilling machine.
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage. Select the correct torque for Impact tools using the relevant Torque Table on P131 / P142.
2.2 Rotary Pistol Drill	All Versadrive Countersinks & Drillsinks can be used in Pistol drills with a suitably low RPM
2.3 Compact Magnet Drill	As compact magnet drills are normally single speed, they are usually only suitable for the smaller sizes of Countersink eg below 20mm diameter
2.4 Large Magnet/Pillar Drill	Optimum life and performance will generally be achieved from HMT countersinks when used with Magnet Drills or Pillar Drills. Use at low speed Gear setting (for maximum torque)
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	All HMT countersinks are suitable for this application
3.2 Standard Plate 5 - 12mm	All HMT countersinks are suitable for this application
3.3 Medium Plate 12 - 25mm	All HMT countersinks are suitable for this application
3.4 Heavy Plate - above 25mm	All HMT countersinks are suitable for this application
Lubricant	
4.1 SpeedLube	Recommended for all general purpose countersinking applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Not recommended for general purpose countersinking. Recommended for harder steels and stainless steels where heat reduction is critical. Best choice if the material is to be welded or galvanised
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when countersinking thick or harder materials, use flood coolant to keep tool & workpiece cool to prevent work hardening.
Accessories	
5.1 Impact Adapters	Versadrive Countersinks & Drillsinks up to 16.5mm diameter can be used on Impact Wrenches & Impact Drivers (See Torque Table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All HMT Countersinks are suitable for use in Magnet Drills
5.4 Morse Taper Adapters	Versadrive Countersinks & Drillsinks can be adapted for use in Morse Taper drills with 111045 Adapters

Best Practice	
6.1 Do I need a pilot hole or a centre punch?	Not applicable
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf
6.5 Additional Notes	Do not allow the countersink to vibrate over swarf while cutting as this will cause chatter, ultimately causing the cutting edge to chip & blunt
	For best results when countersinking, the countersink should be piloted where possible see MultiSink pilots on P101 Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst rotating
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

HSS Countersinks

Diameter Range		Structural Steel (10 m/min)	Hardened Steel (N/A)	Stainless Steel (6 m/min)	Non-Ferrous (28 m/min)
6–8 mm	1/4"–5/16"	400–745	N/A	200–425	995–1855
9–12 mm	11/32"–1/2"	265–495	N/A	135–285	665–1240
13–17 mm	33/64"–11/16"	185–345	N/A	95–195	470–855
18–22 mm	11/16"–7/8"	145–250	N/A	70–140	360–620
23–30 mm	29/32"–1 3/16"	105–195	N/A	55–110	265–485
31–40 mm	1 1/4"–1 19/32"	80–145	N/A	40–80	200–360
41–55 mm	1 5/8"–2 5/32"	60–110	N/A	30–60	145–270
56–80 mm	2 7/32"–3 5/32"	40–80	N/A	20–45	100–200

TCT Countersinks

Diameter Range		Structural Steel (12.5 m/min)	Hardened Steel (7 m/min)	Stainless Steel (8 m/min)	Non-Ferrous (35 m/min)
32–35 mm	1-1/4"–1-3/8"	115–125	65–70	75–80	320–345
36–40 mm	1-13/32"–1-9/16"	100–110	55–65	65–70	280–310
41–45 mm	1-5/8"–1-3/4"	90–100	50–55	55–60	250–270
46–55 mm	1-13/16"–2-5/32"	70–85	40–50	45–55	195–240
56–63 mm	2-3/16"–2-1/2"	60–70	35–40	40–45	170–200
64–72 mm	2-17/32"–2-27/32"	50–60	30–35	35–40	145–175
73–80 mm	2-7/8"–3-5/32"	45–50	25–30	30–35	130–150

Material	
1.1 Structural Steel	All HMT tooling in this category are suitable for the common grades of steel
1.2 Hardened Steel	This category of tooling is not generally suitable for Hardened steel applications
1.3 Stainless Steel	Suitable for harder materials such as stainless steel when used at reduced RPM (Rotary drilling machines) or higher torque settings (Impact Wrenches)
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
	Flame cut/punched/profiled holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage
Apparatus / Drilling Machines	
2.1 Impact Wrench	Impact Wrenches and Impact Drivers can be suitable for through hole tapping applications Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P133 / P142. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage.
2.2 Rotary Pistol Drill	ImpactaTaps in this category are suitable for pistol drill use up to around M10 Diameter. Larger diameters of taps used on Rotary Pistol Drills can generate high levels of resistance & drill kickback Select the correct RPM when using rotary drive tools using the table on P133 / P142.
2.3 Compact Magnet Drill	Compact Magnet Drills are not usually suitable for Tapping as they do not usually have the correct features such as reverse or variable speed
2.4 Large Magnet/Pillar Drill	These units are suitable for tapping if they have gear speed options, variable speed, and reversing feature
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	All HMT Taps in this category are suitable for this application. Standard practice is for the thread depth to match the thread diameter — Eg an M10 thread typically requires around 10 mm of thread depth.
3.2 Standard Plate 5 - 12mm	All HMT Taps in this category are suitable for this application. Standard practice is for the thread depth to match the thread diameter — Eg an M10 thread typically requires around 10 mm of thread depth.
3.3 Medium Plate 12 - 25mm	All HMT Taps in this category are suitable for this application. Standard practice is for the thread depth to match the thread diameter — Eg an M10 thread typically requires around 10 mm of thread depth.
3.4 Heavy Plate - above 25mm	Consider using heavy duty tapping options such as 308015 Long series taps
3.5 Additional Notes	This page of advice refers to Through Hole tapping. For Blind hole tapping, Spiral Flute ImpactaTaps are primarily recommended along with a Versadrive clutched adapter to prevent the Tap breaking when it makes contact with the bottom of the hole
Lubricant	
4.1 SpeedLube	Recommended for all general purpose tapping applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Not recommended for general purpose tapping.
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials

ImpactaTaps - Data Sheet
VERSADRIVE® PATENT PROTECTED

Accessories	
5.1 Impact Adapters	All the tools in this category are suitable for use in Impact Wrenches (See Torque Table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm and 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All Versadrive taps can be adapted for use in Magnet Drills with the 111130 Adapter. Magnet Drills must have a reverse function to be suitable for tapping
5.4 Morse Taper Adapters	All Versadrive taps can be adapted for use in Morse Taper drills with the 111045 Adapters
Best Practice	
6.1 Do I need a pilot hole or a centre punch?	Pilot drill the exact tapping size hole for best results When tapping into box section ensure the tip of the tooling does not contact the far side of the box section at the same time
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Standard ImpactaTaps are recommended for through hole applications only - for blind hole tapping see P137 Tap the hole in one pass where possible, applying adequate lubrication before you start. If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading, remove the tap from the adapter and locate it in the thread by hand,before reversing.
6.5 Additional Notes	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. To avoid damage to the tap, it is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque
	Ensure the Tap is inserted squarely to the hole Poorly aligned or off-centre taps will greatly increase the risk of breakage
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive ImpactaTaps - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (10 m/min)	Hardened Steel (5 m/min)	Stainless Steel (8 m/min)	Non-Ferrous (30 m/min)
M3–M4	105–120	160–180	N/A	N/A	1060–800	530–400	850–640	3180–2390
M5–M6	135–140	200–240	N/A	N/A	640–530	320–265	510–425	1910–1590
M8–M10	150–170	280–300	430–480	512–544	400–320	200–160	320–255	1190–955
M12–M14	185–190	320–340	512–544	576–640	265–230	130–115	210–180	795–685
M16–M20	200–315	360–400	576–640	960–1184	200–160	100–80	160–130	600–480
M24–M27	N/A	600–740	960–1184	1200–1400	135–120	70–60	110–95	400–355
M30–M33	N/A	800–980	1200–1400	1640–1940	105–95	55–45	85–75	320–290
M36–M42	N/A	N/A–N/A	1640–1940	1990-2450	90–75	45–40	70–60	265–230

For Fractional Sizes See P142

Material	
1.1 Structural Steel	All HMT tooling in this category is suitable for the common grades of steel
1.2 Hardened Steel	This category of tooling is not generally suitable for Hardened steel applications
1.3 Stainless Steel	Suitable for harder materials such as Stainless Steel when used at reduced RPM & Higher Torque settings
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, in-crease feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
	Flame cut/punched/profiled holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage
Apparatus / Drilling Machines	
2.1 Impact Wrench	Impact Wrenches and Impact Drivers are widely used for through Drill Tap applications. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P135. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage.
2.2 Rotary Pistol Drill	DrillTaps in this category are suitable for pistol drill use up to around M10 Diameter. Larger diameters of Drill Taps used on Rotary Pistol Drills can generate high levels of resistance and drill kickback. Select the correct RPM when using rotary drive tools using the table on P135 / P142.
2.3 Compact Magnet Drill	Compact Magnet Drills are not usually suitable for Drill-Tapping as they do not usually have the correct features such as reverse or variable speed
2.4 Large Magnet/Pillar Drill	These units are suitable for Drill-tapping if they have gear speed options, variable speed, and reversing feature
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling - (min 10mm)
	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque
Thickness	
3.1 Sheet Metal up to 4mm	301125 Drill-Taps are suitable for this application . Maximum tapping thickness for 301125 is the same as the drilltap diameter. Typically a tap hole specification is threaded to the same depth as the diameter
3.2 Standard Plate 5 - 12mm	301125 Drill-Taps are suitable for this application . Maximum tapping thickness for 301125 is the same as the drilltap diameter. Typically a tap hole specification is threaded to the same depth as the diameter
3.3 Medium Plate 12 - 25mm	301130 Drill-Taps in this category are suitable for this application. Typically a tap hole specification is threaded to the same depth as the diameter
3.4 Heavy Plate - above 25mm	301130 Drill-Taps in this category are suitable for this application . Typically a tap hole specification is threaded to the same depth as the diameter
Lubricant	
4.1 SpeedLube	Recommended for all general purpose drilling and tapping applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Recommended for general purpose drilling - before using SpeedLube for Tapping operation.
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials.

Accessories	
5.1 Impact Adapters	Most of the tools in this category can be suitable for use in Impact Wrenches & Impact Drivers (See Torque table)
5.2 Pistol Drill / Chuck	The Versadrive Hex shank fits into any standard drill chuck. 130mm & 300mm Versadrive Extension Arbors will fit into all drill chucks
5.3 Weldon Adapters	All Versadrive DrillTaps can be adapted for use in Magnet Drills with the 111130 Adapter. Magnet Drills must have a reverse function to be suitable for tapping
5.4 Morse Taper Adapters	All Versadrive Drill-taps can be adapted for use in Morse Taper drills with the 111045 Adapters
Best Practice	
6.1 Do I need a pilot hole or a centre punch?	301125 Spiral-Flute DrillTaps do not require a pilot hole. 301130 Heavy Duty DrillTaps require a pilot hole over M10. When pilot drilling, drilling to approx. 70% of the required hole diameter is generally recommended
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application. HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	When Drill-tapping into box section ensure the tip of the tooling does not contact the far side of the box section at the same time
	Ensure the Drill-Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive Drill Bits - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
4–6 mm	140–160	160–180	240–280	265–310	1860–2655	210–320	850–1215	2660–3980
7–9 mm	160–295	195–360	300–520	330–570	1240–1590	140–185	565–730	1770–2280
10–12 mm	320–350	395–430	580–635	640–700	930–1120	105–130	425–510	1330–1590
13–15 mm	370–375	445–455	675–690	745–760	795–860	85–100	365–390	1060–1225
16–18 mm	455–580	580–720	880–1120	970–1230	620–695	70–80	285–320	885–995
19–21 mm	685–685	845–845	1245–1245	1370–1370	530–555	60–70	245–255	760–835
22–24 mm	720–720	900–900	1360–1360	1500–1500	505–505	50–60	160–175	665–725

Versadrive ImpactaTaps - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
M3–M4	95–110	105–120	160–180	N/A	730–960	610–809	490–650	2060–2700
M5–M6	125–130	135–140	200–240	N/A	485–585	405–485	325–385	1455–1750
M8–M10	140–160	150–170	280–300	430–480	295–365	245–310	195–245	870–1095
M12–M14	170–180	185–190	320–340	512–544	210–240	175–200	140–162	625–730
M16–M20	190–295	200–315	360–400	576–640	145–185	125–155	100–125	440–550
M24–M27	N/A	N/A	600–740	960–1184	105–120	90–100	75–85	330–370
M30–M33	N/A	N/A	800–N/A	1200–1400	84–95	68–80	51–60	265–310
M36–M42	N/A	N/A	N/A–N/A	1640–2440	40–72	32–58	24–44	126–228

For Fractional Sizes See P142

Material	
1.1 Structural Steel	Highly recommended and widely used for tapping structural steel Torque Settings are based on these materials
1.2 Hardened Steel	This category of tooling is not generally suitable for Hardened steel applications
1.3 Stainless Steel	This category of tooling is not generally suitable for Stainless steel applications, where more torque is required.
1.4 Non Ferrous	While the Taps are suitable for tapping aluminium and other non ferrous metals, magnet drills will not adhere to these materials. Torque settings are factory set for structural steels
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Plasma or Flame Cut holes: Flame cut or profiled holes can often be tapered or have a poor finish. Specify drilled holes to avoid these problems.
	Punched holes: When reworking holes that have been created by punching, note that the edge will have been hardened by the shearing action of the punch which affects the structure of the material
	Flame cut/punched/profiled holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage
Apparatus / Drilling Machines	
2.1 Impact Wrench	1/2" & 3/4" Impact Wrenches can be suitable for blind hole tapping applications Ensure correct torque settings are selected on the Impact Wrench (Never use the Nutbuster setting) When using Impact Wrenches, use: - Low torque settings for smaller taps (M8-M10) - Medium torque for M12-M16 - Higher torque for M20-M24
2.2 Rotary Pistol Drill	Clutched Tapping Adapters are not suitable for use in this category of drilling machine
2.3 Compact Magnet Drill	Clutched Tapping Adapters are not suitable for use in this category of drilling machine
2.4 Large Magnet/Pillar Drill	These units are suitable for Blind hole Clutched Adapter tapping if they have gear speed options, variable speed, and reversing feature. Check the drilling machine has enough stroke/working length to accommodate both the clutched adapter and the tap
2.5 Additional Notes	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time. Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling (min 10mm)
	If the drilling machine has a variable electronic speed dial (once the appropriate gear setting has been selected) it is recommended to use the full speed, or very close to full speed, as this will give constant spindle speed and the full motor torque available
Thickness	
3.1 Sheet Metal up to 4mm	Clutched Tap Adapters are not suitable for use on this thickness material
3.2 Standard Plate 5 - 12mm	Clutched Tap Adapters can be suitable for this application. Considering the thickness of the material the usual tapping range would be M6-M8
3.3 Medium Plate 12 - 25mm	Clutched Tap Adapters are suitable for this application. Considering the thickness of the material the usual tapping range would be M6-M20.
3.4 Heavy Plate - above 25mm	Clutched Tap Adapters are suitable for this application.
Lubricant	
4.1 SpeedLube	Recommended for all blind hole tapping applications
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Not Recommended for blind hole tapping
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or harder materials.
Accessories	
5.1 Impact Adapters	Select the 131- series of adapters which are compatible with Impact Wrenches
5.2 Pistol Drill / Chuck	N/A
5.3 Weldon Adapters	N/A
5.4 Morse Taper Adapters	Select the 132- series of adapters which are fitted with Morse Taper type arbors

Clutched Adapter - Data Sheet
VERSADRIVE® PATENT PROTECTED

Best Practice	
6.1 Do I need a pilot hole or a centre punch?	Pilot drill the exact tapping size hole to depth required for best results. Use 209010 or 206010 series drill bits
6.2 What is the correct feed pressure?	Apply firm, steady starting pressure in Forward (Right Hand) rotation. The tap will then feed in itself. When clutch engages, switch off the motor, set to Reverse (Left Hand) rotation, re-start motor and tap will reverse out
6.3 How many holes can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of holes, however, due to the demanding nature of some portable drilling applications, this can vary widely depending on the application.
	HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	When the blind hole is fully tapped to the required depth, do not allow the clutch to engage for more than a few seconds, this can cause heat build up and excess vibration can cause the tap to break. Stop the machine and reverse out the tap.
	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. To avoid damage to the tap it is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque
	Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

Versadrive ImpactaTaps - Metric Sizes

Diameter Range	Impact Torque - Nm				Spindle Speed - Rotary RPM			
	Sheet up to 4mm thick	Plate 5 - 12mm thick	Plate 12 - 25mm thick	Plate over 25mm thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
M3–M4	95–110	105–120	160–180	N/A	730–960	610–809	490–650	2060–2700
M5–M6	125–130	135–140	200–240	N/A	485–585	405–485	325–385	1455–1750
M8–M10	140–160	150–170	280–300	430–480	295–365	245–310	195–245	870–1095
M12–M14	170–180	185–190	320–340	512–544	210–240	175–200	140–162	625–730
M16–M20	190–295	200–315	360–400	576–640	145–185	125–155	100–125	440–550
M24–M27	N/A	N/A	600–740	960–1184	105–120	90–100	75–85	330–370
M30–M33	N/A	N/A	800–N/A	1200–1400	84–95	68–80	51–60	265–310
M36–M42	N/A	N/A	N/A–N/A	1640–2440	40–72	32–58	24–44	126–228

For Fractional Sizes See P142

Material	
1.1 Structural Steel	N/A
1.2 Hardened Steel	N/A
1.3 Stainless Steel	N/A
1.4 Non Ferrous	N/A
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use a rotary drilling machine with a powerful motor
	Designed for use in left hand direction (Reverse) only.
Apparatus	
2.1 Impact Wrench	Impact Wrenches can be suitable for this application. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P139. If exact match is not available select the closest torque setting above the recommendation. Attach Versadrive Impact Adapter and use on left hand rotation (Reverse Mode)
2.2 Rotary Pistol Drill	Versadrive shank tooling can be used in a standard drill chuck. This category of drilling machine is suitable for left hand drill bits. But due to the high rotational forces generated, do not use 403010 Bolt extractors with pistol drills
2.3 Compact Magnet Drill	Compact Magnet Drills are not usually suitable for this application as they do not usually have the correct features such as reverse or variable speed
2.4 Large Magnet/Pillar Drill	Where the application allows, using the Left Hand drills in a reversible Magnet Drill will make the drilling process faster and more stable.
2.5 Additional Notes	For larger diameter drill bit sizes (#6/#7) or when drilling particularly hard materials, using a rotary or magnetic drill may provide better results than an Impact wrench.
Thickness	
3.1 Sheet Metal up to 4mm	N/A
3.2 Standard Plate 5 - 12mm	N/A
3.3 Medium Plate 12 - 25mm	N/A
3.4 Heavy Plate - above 25mm	N/A
Lubricant	
4.1 SpeedLube	Ensure ample application of lubricant (SpeedLube/BioCut Blue) during the drilling process to prevent overheating & work hardening of the fastener.
4.2 BioCut Paste	Recommended for overhead drilling and other applications where liquid lubricant is not suitable
4.3 BioCut Blue	Ensure ample application of lubricant (SpeedLube/BioCut Blue) during the drilling process to prevent overheating & work hardening of the fastener.
4.4 Additional Notes	
Accessories	
5.1 Impact Adapters	All the tools in this category are suitable for use in Impact Wrenches (See Torque Table)
5.2 Pistol Drill / Chuck	Versadrive shank tooling can be used in a standard drill chuck. This category of drilling machine is suitable for left hand drill bits. But due to the high rotational forces generated, do not use 403010 Bolt extractors with pistol drills
5.3 Weldon Adapters	All tooling in this category can be adapted for use in Magnet Drills with the 111130 Adapter. Magnet Drills must have a reverse function to be suitable for left hand drilling
5.4 Morse Taper Adapters	All tooling in this category can be adapted for use in Morse Taper drills with the 111045 Adapters

ImpactaBite Bolt Extractors - Data Sheet
VERSADRIVE® PATENT PROTECTED

Best Practice	
6.1 Do I need a pilot hole or a centre punch?	To assist with successful extraction it is important that the pilot hole is drilled square to the centre of the fastener to avoid the extractor running off plane when reversing out, and potentially breaking or coming loose.
	Wherever possible use a scribed or drawn mark to find the exact center of the fastener to be drilled
6.2 What is the correct feed pressure?	Apply firm, steady feed pressure throughout the cut. Excess feed pressure will increase heat buildup and reduce tool life
6.3 How many holes can I expect the cutting tool to last?	Due to the many variables of this application, there are no guarantees or life-span guidance.
6.4 How can I prevent chipping or breakage	For best results drill all the way through the bolt/stud before inserting the Screw Extractor. Tip breakage of the extractor can occur if the hole is not drilled to the correct depth
6.5 Additional Notes	For best results drilling through hardened bolts and materials, it is recommended to start with a small diameter drill bit and step up to the finished diameter with increasingly larger drill bits
	Drill correct sized pilot hole in seized bolt using Versadrive Left Hand bits Then use a soft-face hammer to securely tap the extractor into pilot hole
	Whilst the Versadrive extractors are superior to standard stud extractors readily available, it is recognised that stud/fastener extraction is a very challenging task and a complete success cannot be guaranteed in all circumstances. Using heating methods and/or penetrant (releasing) fluids can often assist with the removal process.
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

ImpactaBite Bolt Extractor		
ImpactaBite Drill bits & Bolt Extractors	Impact Torque Nm	Impact Torque Ft Lb
#3	140-160	103-118
#4	200-280	148-206
#5	220-300	162-221
#6	430-580	317-428
#7	550-700	406-516

Material	
1.1 Structural Steel	All HMT tooling in this category are suitable for the common grades of steel
1.2 Hardened Steel	This category of tooling is not generally suitable for Hardened steel applications
1.3 Stainless Steel	Suitable for harder materials such as Stainless Steel when used at reduced RPM and Higher Torque settings
1.4 Non Ferrous	All HMT tooling in this category is suitable for Non Ferrous materials
1.5 Additional Notes	Heat Affected Zones (HAZ) are areas of metal that have been exposed to welding, flame cutting or other high temperatures and are often harder to drill, enlarge or re-work. In these situations it usually helps to reduce RPM speeds, increase feed pressure, and use higher torque settings
Apparatus	
2.1 Impact Wrench	Impact Wrenches are recommended for impact die threading applications. Ensure correct torque settings are used. Select the correct torque for Impact tools using the relevant Torque Table on P141. If exact match is not available select the closest torque setting above the recommendation
	When using Impact Wrenches, this tooling will perform best on higher torque settings. Low torque can lead to the cutting tool stalling during the cut, which can lead to a breakage
2.2 Rotary Pistol Drill	Impactadie is not recommended for use on pistol drills
2.3 Compact Magnet Drill	Not recommended. This application will generate high levels of resistance and drill kickback.
2.4 Large Magnet/Pillar Drill	These units can be suitable for threading, if they have gear speed options, variable speed, and reversing feature.
2.5 Additional Notes	When using cordless power-tools, regularly check that sufficient battery charge is still available. Low battery charge results in torque drop, which can damage cutting tools.
	If the drilling machine has a variable speed trigger switch (once the appropriate gear setting has been selected) it is recommended to use the full speed available by fully depressing the trigger switch. Feathering the trigger will give inconsistent spindle speed and torque.
Thickness	
The ImpactaDie 115100 holder can create external threads up to 50mm in length The ImpactaDie 115300 holder can create external threads up to 75mm in length	
Lubricant	
4.1 SpeedLube	Recommended for ImpactaDie applications
4.2 BioCut Paste	Not recommended for die threading
4.3 BioCut Blue	Not normally recommended for ImpactaDie threading
4.4 Additional Notes	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials
Accessories	
5.1 Impact Adapters	All the ImpactaDie tools in this category are suitable for use in Impact Wrenches (See Torque Table)
5.2 Pistol Drill / Chuck	Not recommended. This application will generate high levels of resistance and drill kickback
5.3 Weldon Adapters	Not normally applicable for ImpactaDie applications
5.4 Morse Taper Adapters	Not normally applicable for ImpactaDie applications

ImpactaDie Die Threader - Data Sheet
VERSADRIVE® PATENT PROTECTED

Best Practice	
6.1 Preparing the workpiece	Before cutting the thread, the ImpactaBurr chamfer tool must be used to ensure that the fastener/ workpiece has a consistent 60 degree bevel/chamfer.
6.2 What is the correct feed pressure?	Firm forward pressure is recommended both for starting/cutting the thread and when reversing the tool to remove the Die Threader from the fastener.
6.3 How many threads can I expect the cutting tool to last?	There are many customer reports of HMT tooling lasting for hundreds of threads, however, due to the demanding nature of some portable threading applications, this can vary widely depending on the application.
	HMT can take the MATLAS details of your application and provide an estimate of tool life
6.4 How can I prevent chipping or breakage	Avoid lateral movement or tilting which can cause damage to the tooling. Do not use excessive feed pressure. Steady feed pressure will mean the tool is better controlled and held at 90° to the cut. This helps prevent snagging, chipping or kick-back Try to maintain a consistent flow of swarf.
6.5 Additional Notes	To ensure best results for the life of the Die (and to avoid the thread cutting unevenly on the workpiece), ensure the tool is held square in alignment with the workpiece.
	Periodically check Die and ImpactaDie Holder/Collar and remove Swarf as required.
	When cutting a new thread use the Guide collar and Guide to help keep the Die in alignment with the fastener/workpiece.
	For cleaning/repairing or rethreading applications, the flush collar is intended to allow the die to cut a full length thread.
	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tool breakage or thread damage. To avoid damage to the tap, it is advisable to insert/start the die into the thread by hand before driving it through at the correct torque
	Ensure the use of appropriate PPE at all times when using cutting tools (Safety Glasses, Gloves etc).
	Take care when handling ImpactaDie and workpiece as threaded components may get very hot.
	Drilling operations take place in a wide variety of environments, each with different risks and requirements. For this reason, safe working practices and specific risk assessments or method statements must be determined by the user. Always select and use appropriate PPE, follow correct operating procedures for all equipment, and inspect tooling before use.

ImpactaDie Die Threader					
Metric Die Nut Size	Impact Torque Nm		Fractional Die Nut Size	Impact Torque Ft Lb	
	Thread Cutting	Thread Cleaning		Thread Cutting	Thread Cleaning
M6	220	130	1/4"	162	110
M8	250	150	5/16"	184	125
M10	300	180	3/8"	221	155
M12	380	200	1/2"	280	198
M16	580	350	5/8"	428	300
M20	640	390	3/4"	472	330
M24	1100	700	7/8"	812	570
M25	1180	770	1"	871	610

Versadrive Drill Bits - Fractional Sizes

Diameter Range	Impact Torque - Ft Lbs				Spindle Speed - Rotary RPM			
	Sheet up to 5/32" thick	Plate 5/32 - 1/2" thick	Plate 1/2 - 1" thick	Plate over 1" thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
5/32"–15/64"	105–120	120–135	175–205	195–230	2385–1590	635–425	955–635	3980–2655
9/32"–23/64"	120–220	145–265	220–385	245–420	1365–1060	365–285	545–425	2275–1770
25/64"–15/32"	235–260	290–320	430–470	470–515	955–795	255–210	380–320	1590–1325
33/64"–19/32"	275–280	330–340	500–510	550–560	735–635	195–170	295–255	1225–1060
5/8"–23/32"	335–430	430–530	650–825	715–905	595–530	160–140	240–210	995–885
3/4"–27/32"	505–505	625–625	920–920	1010–1010	505–455	135–120	200–180	840–760
7/8"–15/16"	530–530	665–665	1005–1005	1110–1110	435–400	115–105	175–160	725–665

Versadrive Reamers - Fractional Sizes

Diameter Range	Impact Torque - Ft Lbs				Spindle Speed - Rotary RPM			
	Sheet up to 5/32" thick	Plate 5/32 - 1/2" thick	Plate 1/2 - 1" thick	Plate over 1" thick	Structural Steel (26 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (48 m/min)
5/16"–13/32"	205–250	235–280	260–320	285–350	1030–825	315–250	470–375	1880–1500
7/16"–33/64"	220–280	245–310	275–340	300–380	750–635	230–195	345–295	1410–1200
9/16"–5/8"	260–330	295–365	330–400	360–445	590–515	180–160	270–240	1110–980
11/16"–3/4"	320–400	355–450	395–500	435–550	485–435	145–135	220–200	915–830
25/32"–7/8"	345–425	380–480	430–530	470–590	415–375	125–115	190–175	780–715
29/32"–1"	495–605	555–680	620–760	680–835	365–335	110–100	165–150	690–630
1-1/32"–1-3/32"	555–685	620–760	770–945	850–1050	330–305	95–90	150–135	620–565
1-1/8"–1-7/32"	685–835	770–935	950–1165	1050–1285	295–275	85–80	135–125	555–515
1-1/4"–1-11/32"	770–930	865–1045	1070–1305	1180–1430	270–245	80–70	125–110	510–450
1-3/8"–1-15/32"	795–960	890–1075	1110–1340	1220–1470	250–230	70–65	110–100	470–430
1-1/2"–1-19/32"	870–1050	975–1170	1200–1445	1325–1590	230–210	65–60	100–90	430–385
1-5/8"–1-21/32"	930–1120	1050–1270	1280–1560	1410–1720	215–205	60–55	95–85	405–365

Versadrive ImpactaTaps - Fractional Sizes

Diameter Range	Impact Torque - Ft Lbs				Spindle Speed - Rotary RPM			
	Sheet up to 5/32" thick	Plate 5/32 - 1/2" thick	Plate 1/2 - 1" thick	Plate over 1" thick	Structural Steel (10 m/min)	Hardened Steel (5 m/min)	Stainless Steel (8 m/min)	Non-Ferrous (30 m/min)
1/8"–5/32"	75–90	120–135	N/A	N/A	1060–800	530–400	850–640	3180–2390
3/16"–7/32"	100–105	150–175	N/A	N/A	640–530	320–265	510–425	1910–1590
5/16"–3/8"	110–125	205–220	315–355	380–400	400–320	200–160	320–255	1190–955
15/32"–9/16"	135–140	235–250	380–400	425–470	265–230	130–115	210–180	795–685
5/8"–3/4"	150–230	265–295	425–470	710–875	200–160	100–80	160–130	600–480
15/16"–1-1/16"	N/A	445–545	710–875	885–1035	135–120	70–60	110–95	400–355
1-3/16"–1-5/16"	N/A	590–725	885–1035	1210–1430	105–95	55–45	85–75	320–290
1-7/16"–1-5/8"	N/A	N/A	1210–1430	1470–1805	90–75	45–40	70–60	265–230

Versadrive Step Cutters - Fractional Sizes

Diameter Range	Impact Torque - Ft Lbs				Spindle Speed - Rotary RPM			
	Sheet up to 5/32" thick	Plate 5/32 - 1/2" thick	Plate 1/2 - 1" thick	Plate over 1" thick	Structural Steel (30 m/min)	Hardened Steel (8 m/min)	Stainless Steel (12 m/min)	Non-Ferrous (50 m/min)
5/16"–13/32"	205-250	230-280	N/A	N/A	1060–955	285–255	425–380	1770–1590
7/16"–33/64"	220-280	245-310	N/A	N/A	795–665	215–180	315–265	1325–1125
9/16"–5/8"	260-330	295-365	N/A	N/A	635–555	170–150	245–225	1060–930
11/16"–3/4"	320-400	360-450	N/A	N/A	530–450	145–120	205–180	885–750
25/32"–7/8"	345-425	385-480	N/A	N/A	455–395	125–110	175–155	760–665
29/32"–1"	495-605	555-680	N/A	N/A	400–350	110–95	155–135	665–580
1-1/32"–1-3/32"	555-685	620-760	N/A	N/A	360–315	100–85	140–120	600–525
1-1/8"–1-7/32"	685-835	765-935	N/A	N/A	330–300	90–80	125–115	550–500
1-1/4"–1-11/32"	765-930	865-1045	N/A	N/A	305–280	80–75	115–105	505–470
1-3/8"–1-15/32"	795-960	890-1075	N/A	N/A	275–250	75–65	105–95	465–430
1-1/2"–1-19/32"	870-1045	975-1170	N/A	N/A	250–225	65–60	100–90	420–395

Metric to Fractional

mm	Fractional Inch	Decimal Inch
0.8	1/32	0.031
1.6	1/16	0.063
2.4	3/32	0.094
3.2	1/8	0.125
4.0	5/32	0.156
4.8	3/16	0.188
6.4	1/4	0.250
7.1	9/32	0.281
7.9	5/16	0.313
8.7	11/32	0.344
9.5	3/8	0.375
10.3	13/32	0.406
11.1	7/16	0.438
11.9	15/32	0.469
12.7	1/2	0.500
13.5	17/32	0.531
14.3	9/16	0.563
15.1	19/32	0.594
15.9	5/8	0.625
16.7	21/32	0.656
17.5	11/16	0.688
18.3	23/32	0.719
19.1	3/4	0.750
19.8	25/32	0.781
20.6	13/16	0.813
21.4	27/32	0.844
22.2	7/8	0.875
23.0	29/32	0.906
23.8	15/16	0.938
24.6	31/32	0.969
25.4	1	1.000

Metric Coarse Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M5	0.8mm	4.2mm
M6	1.0mm	5.0mm
M8	1.25mm	6.8mm
M10	1.5mm	8.5mm
M12	1.75mm	10.2mm
M14	2.0mm	12mm
M16	2.0mm	14mm
M18	2.5mm	15.5mm
M20	2.5mm	17.5mm
M24	3.0mm	21mm
M27	3.0mm	24mm
M30	3.5mm	26.5mm
M30	3.5mm	26.5mm
M33	3.5mm	29.5mm
M36	4.0mm	32mm
M39	4.0mm	35mm
M42	4.5mm	37.5mm

Metric Fine Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M6	0.75mm	4.5mm
M8	1.0mm	7.0mm
M10	1.25mm	8.8mm
M12	1.5mm	10.5mm
M16	1.5mm	14.5mm
M18	1.5mm	16.5mm
M20	1.5mm	18.5mm
M24	1.5mm	22.0mm

Metric Coarse Galvanised Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
M5.4	0.8mm	4.2mm
M6.4	1.0mm	5.0mm
M8.4	1.25mm	6.8mm
M10.4	1.5mm	8.5mm
M12.4	1.75mm	10.2mm
M16.4	2.0mm	14mm
M20.4	2.5mm	17.5mm
M24.4	3.0mm	21mm
M30.4	3.5mm	26.5mm

UNC Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	20	5.1mm
5/16"	18	6.6mm
3/8"	16	8.0mm
1/2"	13	10.8mm
5/8"	11	13.5mm
3/4"	10	16.5mm
7/8"	9	19.5mm
1"	8	22.2mm
1-1/8"	7	25.0mm
1-1/4"	7	28.0mm
1-3/8"	6	31.0mm
1-1/2"	6	34.0mm
1-3/4"	5	39.5mm

UNF Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	28	5.5mm
3/8"	20	8.5mm
1/2"	20	11.5mm
5/8"	18	14.5mm
3/4"	16	17.5mm
7/8"	14	20.5mm
1"	12	23.5mm

NPT Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/8"	27	8.5mm
1/4"	18	11.0mm
3/8"	18	14.5mm
1/2"	14	18.0mm
3/4"	14	23.0mm
1"	11.5	29.0mm

BSW Pitch & Hole Size chart

Tap Diameter	Tap Pitch / TPI	Drill Size
1/4"	20	5.1mm
5/16"	18	6.5mm
3/8"	16	7.9mm
1/2"	12	10.5mm
5/8"	11	13.5mm
3/4"	10	16.25mm
1"	8	22.0mm

BSP Pitch & Hole Size chart

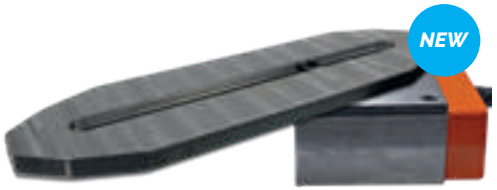
Tap Diameter	Tap Pitch / TPI	Drill Size
1/8"	28	8.8mm
1/4"	19	11.8mm
3/8"	19	15.25mm
1/2"	14	19mm
5/8"	14	21mm
3/4"	14	24.5mm
1"	11	30.75mm

V18-120 Cordless Combi Drill - P27

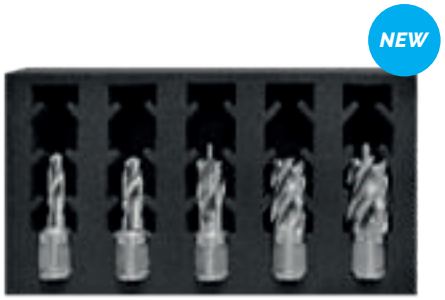
V36 Cordless Pipe Magnet Drill - P94

Steelbor S36 Compact Magnet Drill - P86

OverReach System - P98



HSS Drilling & Broaching Set - P82



Versadrive STAKIT® Turbo Drilling Kit - P114

TurboTip Cobalt Jobber Drill Bits - P108

Versadrive TCT SheetCutters - P33

Morse Taper Shank Drill Bits - P110

Morse Taper Shank Countersinks - P111

Versadrive Morse Taper Clutched Adapter - P54

Magnet Drill Chuck - P102

HOLEMAKER TECHNOLOGY

HMT

Join the Revolution!

Subscribe & access all the latest content

YouTube

Don't miss out on the latest product demos, tutorials & customer success stories.

Stay connected & get the latest updates

@holemakertechnology

/company/holemaker-technology

/holemakertechnology

Find your local dealer at
www.holemaker-technology.com

sales@holemaker-technology.com
03330 110 382

5 061043 637351