Petersen Products Company

Quality Products for Professionals
Since 1916 ISO9001:2015

Hole Saw Instructions

DO Operate hole saw at recommended speed. See RPM table, over.

DO Apply sufficient pressure to cause continuous chip formation.

DO Set pilot drill far enough (about 1/8") beyond cutting edge of the saw to establish and maintain a solid center.

DO Use cutting oil or coolant to assure cleaner, cooler cuts and longer blade life.

DO Chuck the hole saw properly.

DO Hold the saw perpendicular to the surface of the material being cut.

DO Hold the hole saw drive unit firmly. A drill press or lathe is best when possible.

DO Be sure that drive pins on pin drive arbors are properly engaged.

DO Wear safety glasses and keep idle hands away from the sawing operation.

DON'T Run the hole saw too fast. Excessive speed will cause premature wear.

DON'T Allow the tooth tips to rub across the surface of the work. Rubbing increases heat, dulls teeth, and will work harden some materials.

DON'T Operate a hole saw without a pilot drill or with a pilot drill set too shallow.

DON'T Operate a hole saw dry (except in cast iron). Dry cuts generate more heat and decrease the life of the hole saw.

DON'T Chuck the hole saw too loosely or off center.

DON'T Try to saw holes at an angle to the work surface. If the teeth contact the work unevenly, the hole saw will twist off center and break the pilot drill or saw.

DON'T Allow the hole saw and drive unit to wobble or orbit around the pilot drill. This can cause the hole saw to jam or skip resulting in breakage.

DON'T Allow the drive pins to become loose and disengage from the hole saw cap.

DON'T Let loose clothing or long hair get near a revolving hole saw.

CAUTION: Failure to operate tool correctly may result in tool breakage or bodily injury.

RPM

Size Inches	Size mm	Mild Steel	Tool / Stainless Steels	Cast Iron	Brass	Aluminum	Size Inches	Size mm	Mild Steel	Tool / Stainless Steels	Cast Iron	Brass	Aluminum
9/16	14	550	300	400	790	900	2 1/8	54	160	80	105	210	240
5/8	16	530	275	365	730	825	2 1/4	57	150	75	100	200	230
11/16	17	500	250	330	665	750	2 5/16	59	145	75	100	195	225
3/4	19	460	230	300	600	690	2 3/8	60	140	70	95	190	220
13/16	21	425	210	280	560	630	2 1/2	64	135	70	90	180	205
7/8	22	390	195	260	520	585	2 9/16	65	130	65	85	175	200
15/16	24	370	185	245	495	555	2 5/8	67	130	65	85	170	195
1	25	350	175	235	470	525	2 3/4	70	125	60	80	160	185
1 1/16	27	325	160	215	435	480	2 7/8	73	120	60	80	160	180
1 1/8	29	300	150	200	400	450	3	76	115	55	75	150	170
1 3/16	30	285	145	190	380	425	3 1/8	79	110	55	70	145	165
1 1/4	32	275	140	180	360	410	3 1/4	83	105	50	70	140	155
1 3/8	35	250	125	165	330	375	3 3/8	86	100	50	65	130	150
1 1/2	38	230	115	150	300	345	3 1/2	89	95	45	60	125	145
1 1/4	32	275	140	180	360	410	3 5/8	92	95	45	60	120	140
1 5/16	33	260	135	175	345	390	3 3/4	95	90	45	60	120	135
1 3/8	35	250	125	165	330	375	3 7/8	98	90	45	60	115	130
1 7/16	37	240	120	160	315	360	4	102	85	40	55	115	125
1 1/2	38	230	115	150	300	345	4 1/8	105	85	40	55	110	120
1 9/16	40	220	110	145	290	330	4 1/4	108	80	40	55	110	115
1 5/8	41	210	105	140	280	315	4 3/8	111	80	40	50	100	110
1 11/16	43	205	100	135	270	305	4 1/2	114	75	35	50	100	105
1 3/4	44	195	95	130	260	295	4 3/4	121	70	35	45	90	95
1 13/16	46	190	95	125	250	285	5	127	65	30	40	85	90
1 7/8	48	180	90	120	240	270	5 1/2	140	60	30	35	80	85
2	51	170	85	115	230	255	5 3/4	146	55	25	35	75	80
2 1/16	52	165	80	110	220	245	6	152	55	25	35	75	80

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