

STANDARD STOCK SIZES

Cutmaster High Speed	Complete Cut	Complete Cut Extra Depth	Complete Cut Carbide Tipped	Diameter (Inch)	Diameter (mm)	Use Arbor Number	Pipe* Tap Size (Inch)	Pipe* Entrance Size (Inch)	Speed R.P.M.	
									Mild Steel	Cast Iron
A09	TA09			$\frac{3}{16}$	14				580	400
A10	TA10			$\frac{3}{8}$	16				550	365
A11	TA11			$\frac{11}{16}$	17				500	330
A12	TA12	TAD12	TAT12	$\frac{3}{4}$	19			$\frac{3}{8}$	460	300
A13	TA13	TAD13	TAT13	$\frac{13}{16}$	21				425	280
A14	TA14	TAD14	TAT14	$\frac{7}{8}$	22	M24K	$\frac{3}{4}$	$\frac{1}{2}$	390	260
A15	TA15	TAD15	TAT15	$\frac{15}{16}$	24	or			370	245
A16	TA16	TAD16	TAT16	1	25	M34			350	235
A17	TA17	TAD17	TAT17	$\frac{11}{16}$	27	or			325	215
A18	TA18	TAD18	TAT18	$\frac{11}{16}$	29	M44	1	$\frac{3}{4}$	300	200
A19	TA19	TAD19	TAT19	$\frac{13}{16}$	30	or			285	190
A204				$\frac{11}{4}$	32	M44K			275	180
A224				$\frac{13}{8}$	35			1	250	165
A244				$\frac{11}{2}$	38		$\frac{11}{4}$		230	150
A20	TA20	TAD20	TAT20	$\frac{11}{4}$	32				275	180
A21	TA21	TAD21	TAT21	$\frac{15}{16}$	33				260	175
A22	TA22	TAD22	TAT22	$\frac{13}{8}$	35	M44K		1	250	165
A23	TA23	TAD23	TAT23	$\frac{17}{16}$	37	or			240	160
A24	TA24	TAD24	TAT24	$\frac{11}{2}$	38	M45	$\frac{11}{4}$		230	150
A25	TA25	TAD25	TAT25	$\frac{19}{16}$	40	or			220	145
A26	TA26	TAD26	TAT26	$\frac{15}{8}$	41	M45P			210	140
A27	TA27	TAD27	TAT27	$\frac{111}{16}$	43	or			205	135
A28	TA28	TAD28	TAT28	$\frac{13}{4}$	44	M55P	$\frac{11}{2}$	$\frac{11}{4}$	195	130
A29	TA29	TAD29	TAT29	$\frac{113}{16}$	46				190	125
A30	TA30	TAD30	TAT30	$\frac{17}{8}$	48				180	120
A32	TA32	TAD32	TAT32	2	51			$\frac{11}{2}$	170	115
A33	TA33	TAD33	TAT33	$\frac{21}{16}$	52				165	110
A34	TA34	TAD34	TAT34	$\frac{21}{8}$	54				160	105
A36	TA36	TAD36	TAT36	$\frac{21}{4}$	57		2		150	100
A37	TA37	TAD37	TAT37	$\frac{25}{16}$	59				145	100
A38	TA38	TAD38	TAT38	$\frac{23}{8}$	60				140	95
A40	TA40	TAD40	TAT40	$\frac{21}{2}$	64	M44K		2	135	90
A41	TA41	TAD41	TAT41	$\frac{23}{16}$	65	or			130	85
A42	TA42	TAD42	TAT42	$\frac{25}{8}$	67	M45P	$\frac{21}{2}$		130	85
A44	TA44	TAD44	TAT44	$\frac{23}{4}$	70	or			125	80
A46	TA46	TAD46	TAT46	$\frac{27}{8}$	73	M55P			120	80
A48	TA48	TAD48	TAT48	3	76			$\frac{21}{2}$	115	75
A50	TA50	TAD50	TAT50	$\frac{31}{8}$	79				110	70
A52	TA52	TAD52	TAT52	$\frac{31}{4}$	83		3		105	70
A54	TA54	TAD54	TAT54	$\frac{33}{8}$	86				100	65
A56	TA56	TAD56	TAT56	$\frac{31}{2}$	89				95	65
A58	TA58	TAD58	TAT58	$\frac{35}{8}$	92	M44K		3	95	60
A60	TA60	TAD60	TAT60	$\frac{33}{4}$	95	or	$\frac{31}{2}$		90	60
A62	TA62	TAD62	TAT62	$\frac{37}{8}$	98	M45P			90	60
A64	TA64	TAD64	TAT64	4	102	or			85	55
A66	TA66	TAD66	TAT66	$\frac{41}{8}$	105	M55P		$\frac{31}{2}$	80	55
A68	TA68	TAD68	TAT68	$\frac{41}{4}$	108				80	55
A70	TA70	TAD70	TAT70	$\frac{43}{8}$	111				80	50
A72	TA72	TAD72	TAT72	$\frac{41}{2}$	114			4	75	50
A76	TA76	TAD76	TAT76	$\frac{43}{4}$	121		$\frac{41}{2}$		75	50
A80	TA80	TAD80	TAT80	5	127				65	45
A88	TA88	TAD88	TAT88	$\frac{51}{2}$	140				60	40
A92	TA92	TAD92	TAT92	$\frac{53}{4}$	146				55	35
A96	TA96	TAD96	TAT96	6	152				55	35

*All pipe sizes listed in the "Pipe Tap Size" and "Pipe Entrance Size" columns are standard industry sizes. All pipes are sized by the nominal inside diameter.

Pipe Tap Size — The sizes listed in this column provide the necessary information whenever a pipe is to be threaded into tanks, boilers, etc. To secure the best results, the hole should be reamed before tapping with a reamer having a taper of $\frac{3}{4}$ " per foot.

Pipe Entrance Sizes — The sizes listed in this column provide the necessary information for any given pipe size to have sufficient clearance to pass through beams, walls, bulkheads, etc.

OPERATING TIPS

SPEEDS—For efficient cutting, it is essential to operate the hole saw at the proper speed. Each size hole saw has a recommended RPM for cutting specific materials. Operating at higher or lower speeds than those recommended will shorten the life of the saw and produce very inefficient cutting. For questions regarding speeds or materials, please call our order desk.

FEEDS—Sufficient feed pressure to take a chip must be applied. Variables in material, work configuration, etc. should be considered. A rule of thumb is to apply 80-100 pounds per inch of hole saw diameter when sawing in metals. Insufficient feed pressure will dull tooth points prematurely. Too much pressure can destroy teeth.

LUBRICANT—Cutting oil serves two purposes when sawing in metals. It cools both the saw and the work and it removes chips from the kerf. Cutting oil therefore reduces heat and abrasion which can shorten cutting life. An exception to this rule is cast iron, which is cut dry.