

JULY 2019

PRODUCT CATALOGUE - VERSADRIVE



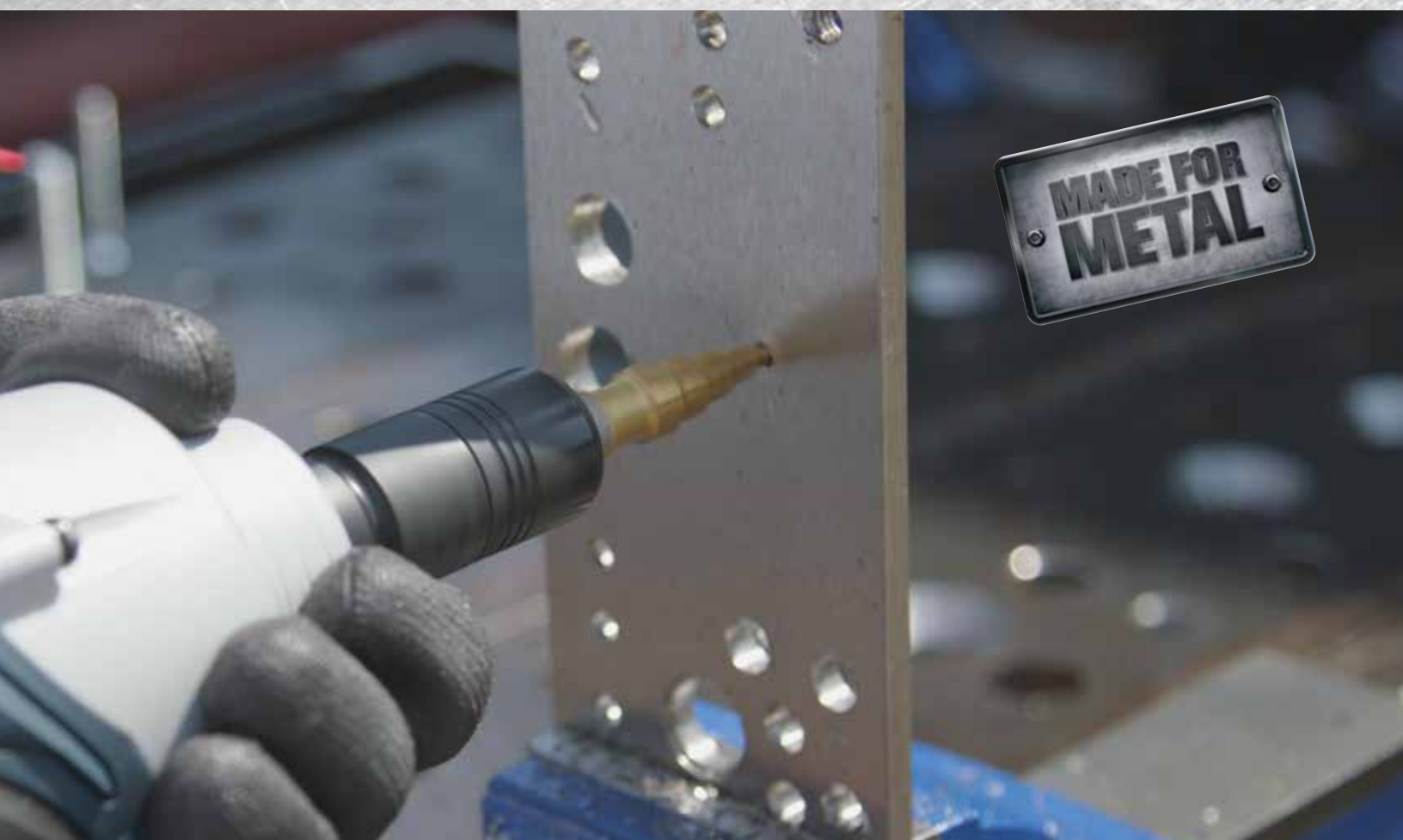
VERSADRIVE[®]
PATENT PENDING

THE WHOLE SYSTEM

Metal workers face multiple challenges in drilling, reaming, and tapping different sized holes in metal.

VersaDrive is a modular, quick-change, system of cutting accessories optimized for cordless, corded and air tools. VersaDrive provides ways to create holes easily, safely, efficiently and economically.

Creating or modifying the connection holes that hold together metal components brings along some special challenges. VersaDrive's unique cutting accessories, backed by expert advice, bring solutions to keep the job moving by speeding up the process.



FEIN Canadian Power Tool Company

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HMT & FEIN CANADA

HMT

Based in the United Kingdom, Holemaker Technology (HMT) was founded in late 2013 by 2 brothers, Piers and Hugh Crane. Drawing on many years of experience, they recognized a need in the marketplace to speed up the essential everyday task of creating and modifying the holes that connect metal components. This led to the unique patent-pending VersaDrive product range reflected in this catalogue.

HOLEMAKER-TECHNOLOGY.COM
HMT

VersaDrive is the only range of cutting accessories optimized for cordless power tools as well as workshop equipment, because you never know what challenges you are going to face next.

Advantages of working with VersaDrive

The only Impact-Wrench rated double-hardened cutting accessories.

Up to 15X faster results than current everyday methods.

Quick change adaptors for faster working.

Non-slip 11.0mm hex shank on all accessories.

Designed to fit all standard drill chucks for pistol drills and drill presses.

Modular system with a choice of drive methods and adaptors.

Safer working with impact wrench anti-kickback.

High grade tool steel, optimized design.

FEIN CANADA

For over 150 years, the FEIN brand has stood for application solutions and premium quality. Today this long-established company is a power tool manufacturer with an international reputation as a first class German manufacturer that develops and produces products that provide solutions for the metalworking, interior construction and automotive sectors. FEIN is the specialist for professional and extremely reliable power tools for industry and skilled trades. Each and every FEIN high performance power tool meets the challenge of solving an application with an operator-oriented approach, living up to the FEIN reputation for durability and performance.

Since 1964, the FEIN Canadian Power Tool Company has followed closely in the footsteps of history and tradition by offering the Canadian market quality products. With a high level of application expertise and service, FEIN Canada is recognized as the solution provider to the industrial and renovation markets.



FEIN is the declared solution provider, as confirmed by professionals.

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TurboTip Drill Bits**

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**VersaDrive 1/4"
Impact Driver Adaptor**

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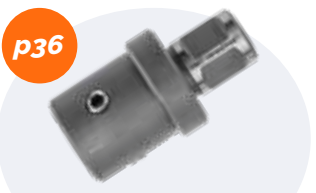
**VersaDrive
Extension Arbor**

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**Selecting the right Impact
Wrench or Impact Driver**

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Up to 15X faster results than current everyday methods.

Quick change adaptors for faster working.

Modular system with a choice of drive methods and adaptors.

Designed to fit all standard drill chucks for pistol and pillar drills.

High grade steel with titanium coating for up to 6x longer life.

IMPACT RATED

15 x Faster than standard tools

WHY IMPACT?

The Impact rated range of VersaDrive tools are designed to cut with the edges of the cutting face rather than the tip. Double hardened & combined with the controlled power of an impact wrench they provide phenomenal cutting performance



IMPACT
DRIVER
ADAPTOR



1/2" HD
IMPACT WRENCH
ADAPTOR



3/4" IMPACT
DRIVER
ADAPTOR



IMPACT RATED

These Versadrive tools work best with an Impact Wrench or Impact Driver. These cordless power tools have become one of the most popular in the world in recent years. These Versadrive tools are the only Impact-Rated cutting tools, using the range of adaptors listed above.



VersaDrive is the worlds first modular cutting tool system to increase productivity for the professional site metalworker

This new armory of solutions is the first cutting tool system designed for use with todays high-performance cordless power tools.

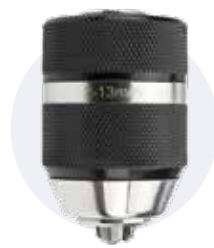
First launched in 2015, VersaDrive has now grown to over 100 different cutting tool solutions, with 40,000 cutting tools sold in 2018, making this the fastest growing range of tooling on the market.

ROTARY RATED

Non-Slip Tri-Lock Shank

WHY ROTARY?

The Rotary rated range of VersaDrive tools are designed to cut with the point or tip of the tool using flutes for tool clearance. Used with high powered rotary-drilling tools like Magnet Drills and Pistol Drills, they will provide excellent cutting performance, outlasting any comparable tool on the market.



DRILL CHUCKS



EXTENSION ARBOR



SDS+ ADAPTOR



MAGNETIC DRILL ADAPTOR



MORSE TAPER ARBORS

VERSADRIVE COBALT DRILL BITS



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VERSADRIVE BLACKSMITH DRILL BITS



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VERSADRIVE TCT HOLESAWS



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VERSADRIVE COUNTERSINK BITS



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VERSADRIVE DRILLSINK



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VERSADRIVE HD DRILL TAPS



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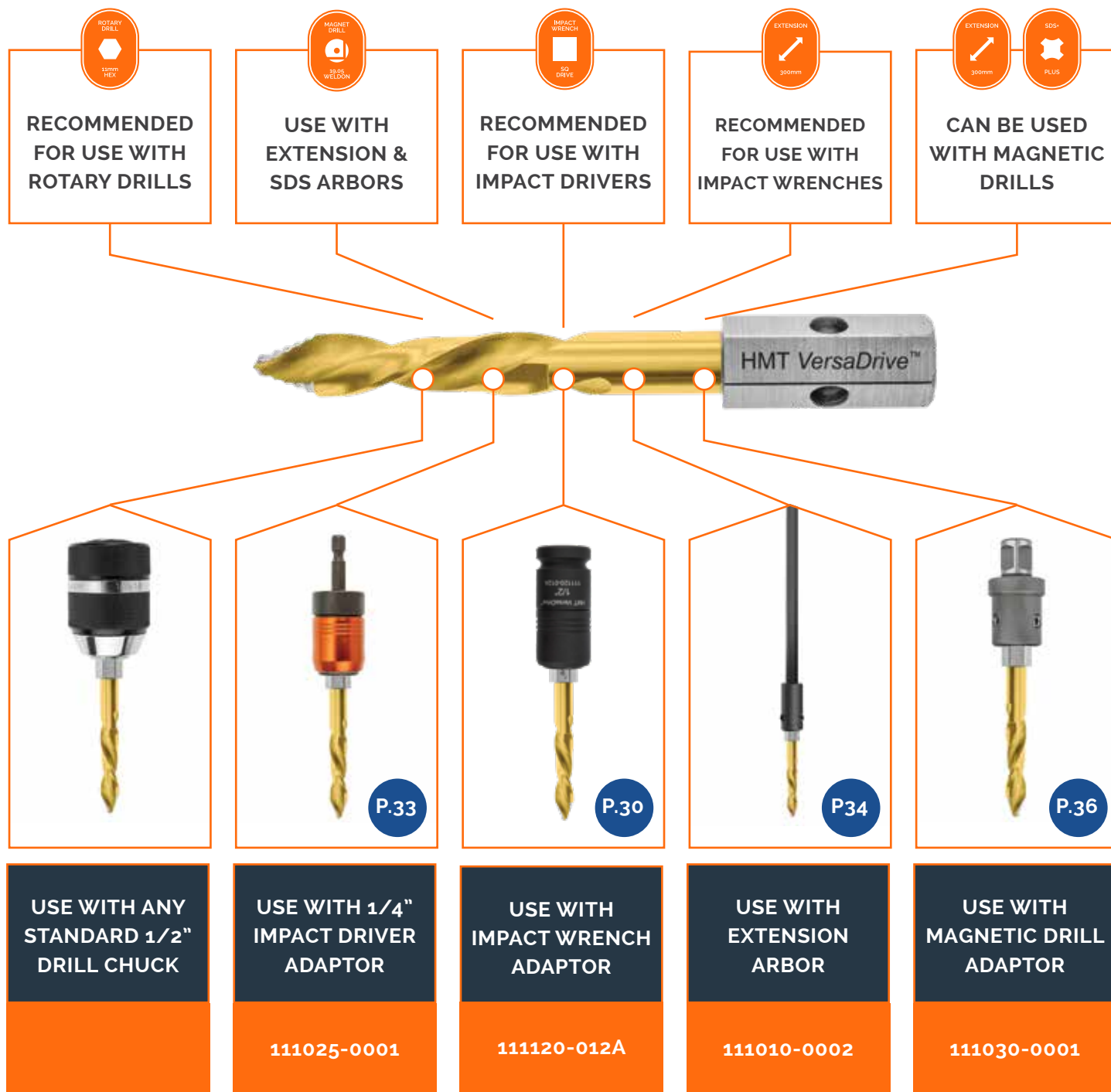
THE VERSADRIVE PATENT PENDING SHANK SYSTEM

Versadrive Patent-Pending Hex Tri-Lock shank. The Versadrive Hexagon shank design fits into all standard drill chucks. No slipping in the chuck like standard tools. Three concentric lock positions give perfect alignment and accuracy when the tooling is used in any of the modular adaptors to optimise metalworking processes and increase the tools working life.

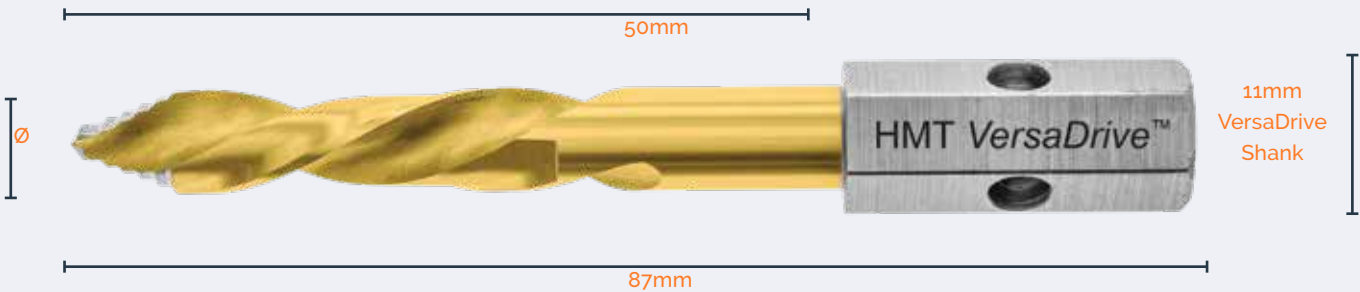
- Patented Drill Point - 50% Faster Drilling with 30% less pressure
- Incredible Finished Hole quality
- Instant drill start with no slipping
- No 'snatch' when drill bit breaks through
- Fantastic Tool Life
- Fully Impact Rated on structural steel



STEPPED TIP DRILLS AT 2X THE SPEED WITH NO PILOT DRILLING NEEDED



Details & Dimensions



Part No	Ø D mm	Tap Size (Metric Coarse)
209015-0060	6.0mm	M8
209015-0068	6.8mm	
209015-0070	7.0mm	
209015-0080	8.0mm	
209015-0085	8.5mm	M10
209015-0090	9.0mm	
209015-0100	10.0mm	
209015-0105	10.5mm	
209015-0110	11.0mm	M14
209015-0120	12.0mm	
209015-0130	13.0mm	
209015-0140	14.0mm	

**SPECIAL
ORDER**

TurboTip Drill Bit Sets

Part No	Contents
209015-SET1	4 piece TurboTip Drill Bit Set contains: 6mm, 8mm, 10mm, 12mm
209015-SET2	7 piece TurboTip Drill Bit Set contains: 6mm, 7mm, 8mm, 9mm, 10mm, 11mm, 12mm
209015-SET3	7 piece TurboTip Drill Bit Set contains: 6.8mm, 8mm, 8.5mm, 10mm, 10.5mm, 12mm, 14mm



- Drill & Countersink in one easy operation.
- Perfect concentricity creates the perfect Countersink.
- High-Grade tool steel with ground flutes for high accuracy and long life.
- GoldMax low-friction titanium coating to stop burn-out.
- High strength, non-slip shank design.

The DrillSink is an innovative addition to the VersaDrive product range. Saving metalworkers time & increasing hole accuracy by drilling and then countersinking holes in one operation.

Ensures smooth countersinking and perfect accuracy every time. Prevents the chattering and reduced tool life commonly experienced with standard countersinks.

ULTIMATE PRECISION FOR COUNTERSUNK HOLES

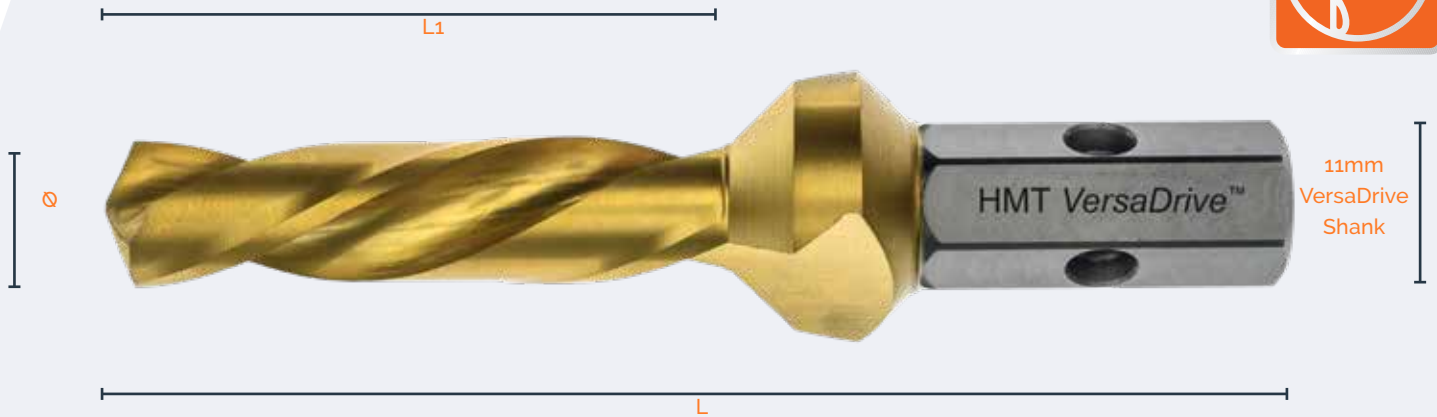
The diagram illustrates the VersaDrive DrillSink tool, a combination drill and countersink tool. It features a gold-colored body with a silver-colored shank. The shank is labeled 'HMT VersaDrive™'. The tool is shown with various callouts indicating its compatibility and features:

- RECOMMENDED FOR USE WITH ROTARY DRILL**: Indicated by a 'ROTARY DRILL' icon with a 1/2" hex shank.
- RECOMMENDED FOR USE WITH MAGNETIC DRILLS**: Indicated by a 'MAGNETIC DRILL' icon with a 3/8" hex shank.
- CAN BE USED WITH IMPACT WRENCHES Up to 16.5mm**: Indicated by an 'IMPACT WRENCH' icon with a 1/2" hex shank.
- USE WITH EXTENSION & SDS ARBORS**: Indicated by an 'EXTENSION' icon with a 300mm length and an 'SDS' icon.
- USE WITH VERSADrive ACCESSORIES**: Indicated by an 'SDS+ PLUS' icon.

The tool is shown with five callouts pointing to specific features on the shank, which are detailed in the bottom row of the diagram:

- USE WITH ANY STANDARD 1/2" DRILL CHUCK**: Callout 1, showing a standard drill chuck. Part number: 111030-0001.
- USE WITH MAGNETIC DRILL ADAPTOR**: Callout 2, showing a magnetic drill adaptor. Part number: 111120-012A.
- USE WITH IMPACT WRENCH ADAPTOR up to 16.5mm**: Callout 3, showing an impact wrench adaptor. Part number: 111010-0002.
- USE WITH EXTENSION ARBOR**: Callout 4, showing an extension arbor. Part number: 111020-0001.
- USE WITH SDS+ ADAPTOR (ROTARY ONLY)**: Callout 5, showing an SDS+ adaptor. Part number: 111020-0001.

Details & Dimensions



Clearance Hole Sizes

Part No	Ø Drill Size	Countersink Size	L1 mm	L mm	Shank mm	Countersunk Screw	Point Angle
603070-08124	8mm	12.4mm	47mm	96mm	11.0	M6	90°
603070-10165	10mm	16.5mm	47mm	85mm	11.0	M8	90°
603070-11205	11mm	20.5mm	47mm	88mm	11.0	M10	90°
603070-12205	12mm	20.5mm	47mm	88mm	11.0	M10	90°
603070-13250	13mm	25mm	47mm	92mm	11.0	M12	90°
603070-14250	14mm	25mm	47mm	92mm	11.0	M12	90°

SPECIAL ORDER

Tap Hole Sizes

Part No	Ø Drill Size	Countersink Size	L1 mm	L mm	Shank mm	Countersunk Screw	Point Angle
603070-68165	6.8mm	16.5mm	47mm	85mm	11.0	M8 (Tapped)	90°
603070-85205	8.5mm	20.5mm	47mm	89mm	11.0	M10 (Tapped)	90°
603070-102250	10.2mm	25mm	47mm	93mm	11.0	M12 (Tapped)	90°

DrillSink Set

Part No	Contents
603070-SET4	Set contains: VersaDrive DrillSink Bits 8/12.4mm, 10/16.5mm, 12/20.5mm, 14/25mm



- Market Leading 5mm thick drilling capacity
- Fast, smooth drilling with minimal kickback.
- Specially hardened for impact wrench use.
- Precision ground flutes with easy chip clearance
- 135° split point angle for easy starting & accuracy.
- GoldMax low-friction titanium coating to stop burn out.
- High strength, non-slip shank design.

The first step drill optimised for use with impact wrenches & impact drivers; create holes in seconds.

Spiral flute design with self-starting drill tip, for fast, smooth drilling with a rotary drill or impact wrench. Market leading 5mm thick drilling capacity. VersaDrive™ Step Drills have a reinforced hex shank with increased strength for greater feed rates. The non-slip shank design provides a secure hold with all standard drill chucks, preventing slippage.

CREATES HOLES IN STEEL IN SECONDS

ROTARY DRILL
MINI HEX

RECOMMENDED
FOR USE WITH
ROTARY DRILLS

IMPACT WRENCH
SD DRIVE

RECOMMENDED
FOR USE WITH
IMPACT WRENCHES

IMPACT WRENCH
SD DRIVE

RECOMMENDED
FOR USE WITH
IMPACT DRIVERS

EXTENSION
300mm

USE WITH
EXTENSION &
SDS ARBORS

EXTENSION
300mm

SDS+
PLUS

USE WITH
VERSADRIVE
ACCESSORIES

USE WITH ANY
STANDARD 1/2"
DRILL CHUCK

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USE WITH
IMPACT WRENCH
ADAPTOR

111120-012A

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USE WITH 1/4"
IMPACT DRIVER
ADAPTOR

111025-0001

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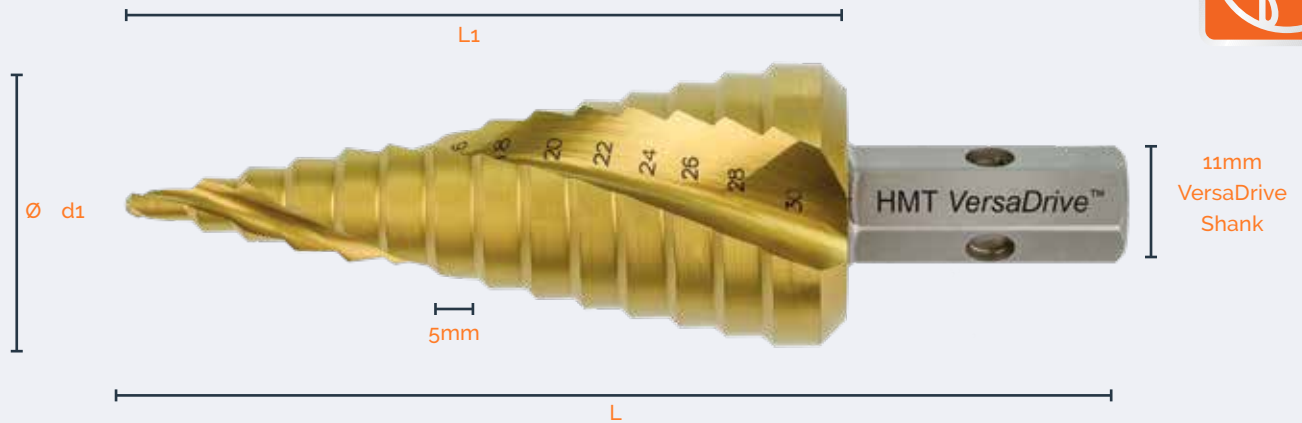
USE WITH
EXTENSION
ARBOR

111010-0002

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USE WITH
SDS+ ADAPTOR
(ROTARY ONLY)

111020-0001



Metric Step Drills

Part No	Ø D	d1	L1	L	Step Diameters	Step Depth	Shank mm
505020-0120	12mm	4mm	47	75	4, 6, 8, 10, 12mm	5mm	11.0
505020-0220	22mm	4mm	58	86	4, 6, 8, 10, 12, 14, 16, 18, 22mm	5mm	11.0
505020-0300	30mm	4mm	77	105	4, 6, 8, 10, 12, 14, 16, 18, 22, 24, 26, 28, 30mm	5mm	11.0
505020-0400	40mm	6mm	72	101	6, 8, 10, 12, 16, 20, 25, 29, 32, 36, 40mm	6mm	11.0








Inch size Step Drills

Part No	Ø D	d1	L1	L	Step Diameters	Step Depth	Shank mm
505030-0010	1/2"	3/16"	1-1/2"	2-43/64	3/16, 1/4, 5/16, 3/8, 7/16, 1/2"	3/16"	11.0
505030-0020	7/8"	3/16"	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"	3/16"	11.0
505030-0030	1-3/8"	1/4"	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"	3/16"	11.0

Step Drill Sets

Part No:	Set Contents
505020-SET1	3 piece Set contains: Step Drills 12mm, 22mm, 30mm
505030-SET1	3 piece Set contains: Step Drills 1/2", 7/8", 1-3/8"




-  Fast drilling with minimal kickback.
-  Dual hardened for impact wrench use up to 10mm.
-  Precision Ground Flutes with easy chip chip clearance.
-  135° Split Point for easy starting and high accuracy.
-  8% Cobalt for long life and endurance.
-  GoldMax low-friction titanium coating to stop burn out.
-  High Strength, Non-Slip Shank Design.


Simply the best long-life twist drill bits for Metal.

All VersaDrive™ Drill Bits can be used in any standard 1/2" drill chuck for cordless or pistol drill use, or adapted for use in a Magnet Drill or Impact Wrench.


Market leading fabricators drill bit with high spec of 8% Cobalt with full titanium coating.

HEAVY DUTY COBALT DRILL BITS







**RECOMMENDED
FOR USE WITH
ROTARY DRILLS**




**RECOMMENDED
FOR USE WITH
MAGNETIC DRILLS**




**CAN BE USED WITH
IMPACT WRENCHES
4.2-10.5mm**




**CAN BE USED WITH
IMPACT DRIVERS
4.2-10.5mm**






**USE WITH
EXTENSION &
SDS ARBORS**




**USE WITH ANY
STANDARD 1/2"
DRILL CHUCK**



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**USE WITH
MAGNETIC DRILL
ADAPTOR**


111030-0001



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**USE WITH
MORSE TAPER
ARBOR**


111040-



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**USE WITH
SDS+ ADAPTOR
(ROTARY ONLY)**

111020-0001



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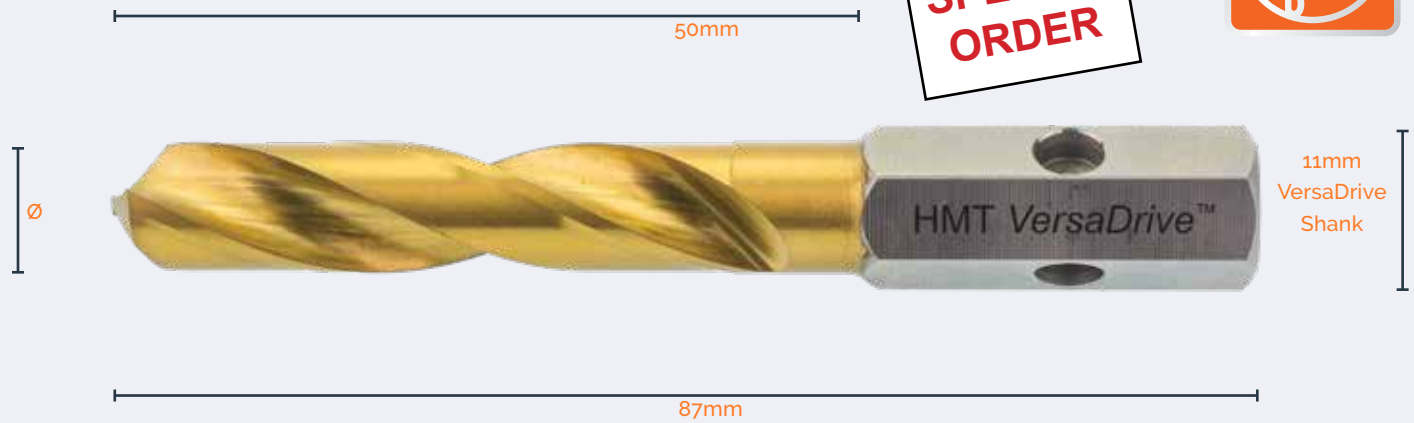
**USE WITH
EXTENSION
ARBOR**

111010-0002

Details & Dimensions



**SPECIAL
ORDER**



Part No	Ø D mm	Tap Size (Metric Coarse)	Fitted Length in Magnet Drill Adaptor
209010-0042	4.2mm	M5	98mm
209010-0050	5.0mm	M6	98mm
209010-0055	5.5mm	-	98mm
209010-0060	6.0mm	-	98mm
209010-0065	6.5mm	-	98mm
209010-0068	6.8mm	M8	98mm
209010-0070	7.0mm	-	98mm
209010-0075	7.5mm	-	98mm
209010-0080	8.0mm	-	98mm
209010-0085	8.5mm	M10	98mm
209010-0090	9.0mm	-	98mm
209010-0095	9.5mm	-	98mm
209010-0100	10mm	-	98mm
209010-0102	10.2mm	M12	98mm
209010-0105	10.5mm	-	98mm
209010-0110	11mm	-	98mm
209010-0115	11.5mm	-	98mm
209010-0120	12mm	M14	98mm
209010-0125	12.5mm	-	98mm
209010-0130	13mm	-	98mm

VersaDrive Drill Bit Sets

Part No	Contents
209010-SET1	4 piece VersaDrive Drill Bit Set contains: 6mm 8mm 10mm 12mm
209010-SET2	4 Piece VersaDrive Drill Bit Set contains: 5mm, 6.8mm, 8.5mm, 10.2mm
209010-SET3	7 piece VersaDrive Drill Bit Set contains: 5mm, 6mm, 6.8mm, 8mm, 8.5mm, 10mm, 10.2mm

SET 1.



SET 2.



SET 3.



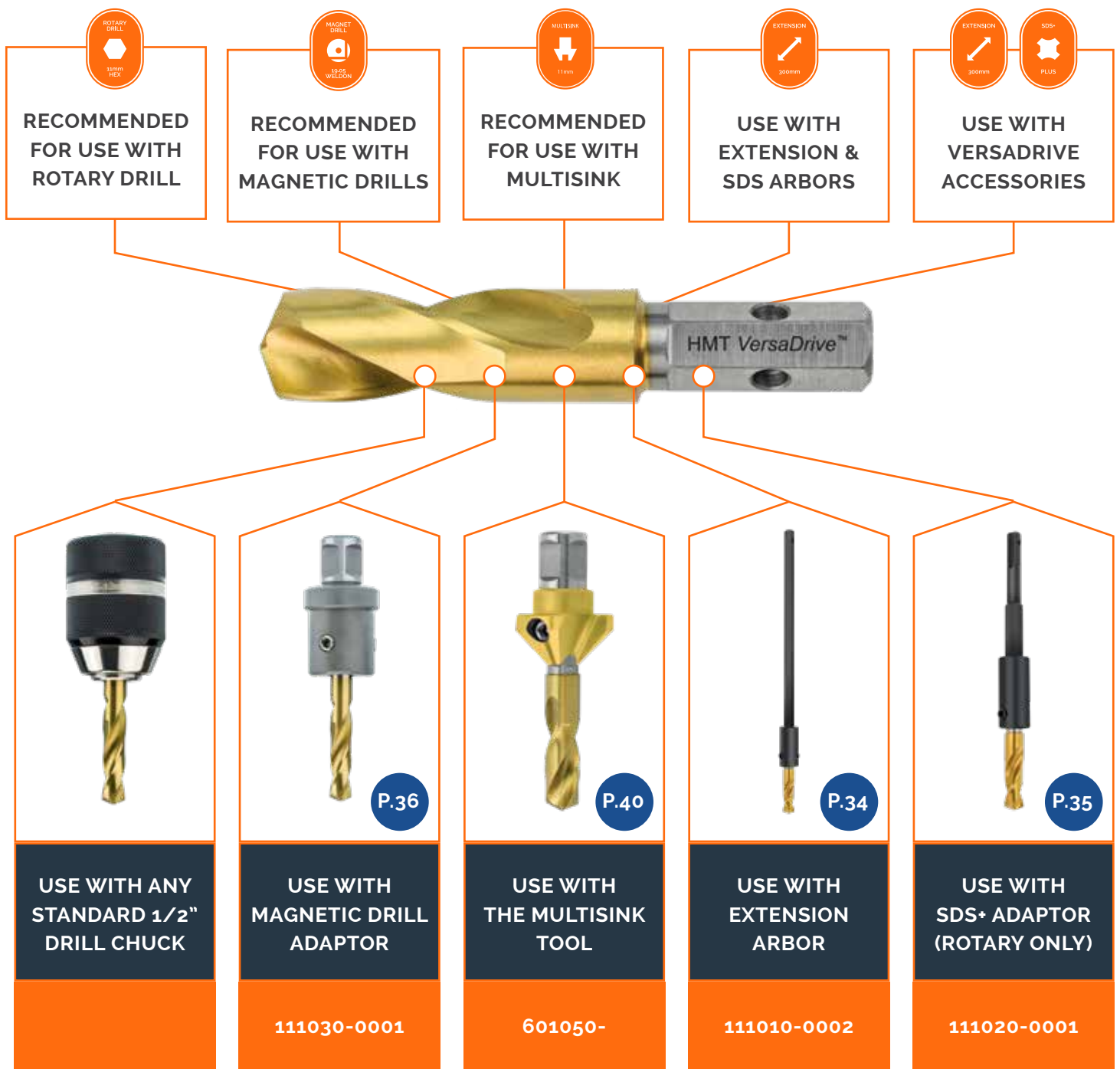
- Fast drilling with minimal kickback.
- Precision Ground Flutes.
- 135° Split Point for easy starting and high accuracy.
- 8% Cobalt for long life and endurance.
- GoldMax low-friction titanium coating to stop burn out.
- High Strength, Non-Slip Shank Design.

Simply the best long-life twist drill bits for Metal.

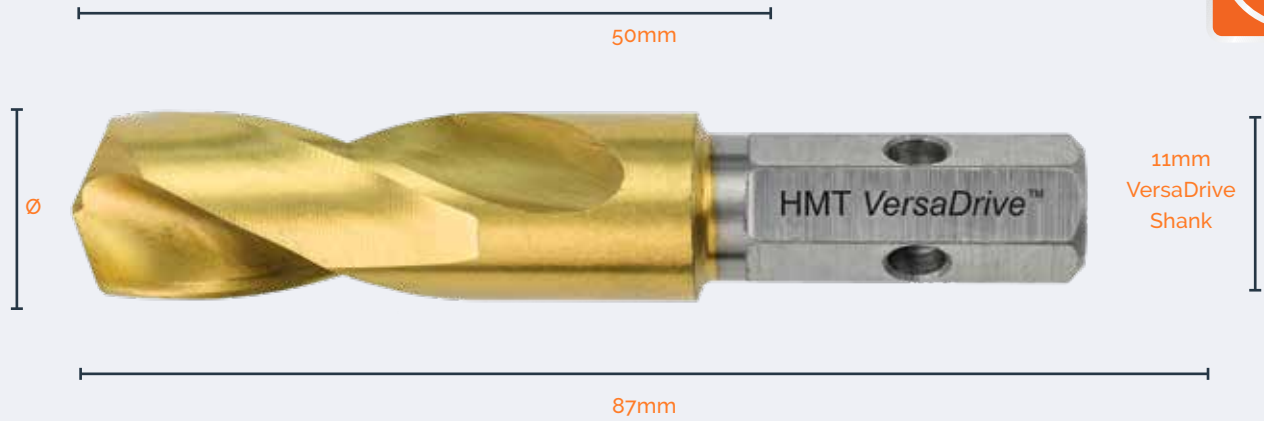
All VersaDrive™ Drill Bits can be used in any standard 1/2" drill chuck for cordless or pistol drill use, or adapted for use in a Magnet Drill or Impact Wrench.

Market leading fabricators drill bit with high spec of 8% Cobalt with full titanium coating.

HEAVY DUTY COBALT DRILL BITS



Details & Dimensions



Part No	Ø D mm	Total Length in Magnet Drill Adaptor	Tap Size (Metric Coarse)
209010-0140	14mm	98mm	M16
209010-0160	16mm	98mm	-
209010-0175	17.5mm	98mm	M20
209010-0180	18mm	98mm	-
209010-0200	20mm	98mm	-
209010-0210	21mm	98mm	M24
209010-0220	22mm	98mm	-

Blacksmith Drill Bit Set

209010-SET4

7 Piece VersaDrive Drill Bit Set contains:
12mm, 13mm, 14mm, 16mm, 18mm, 20mm, 22mm



**SPECIAL
ORDER**

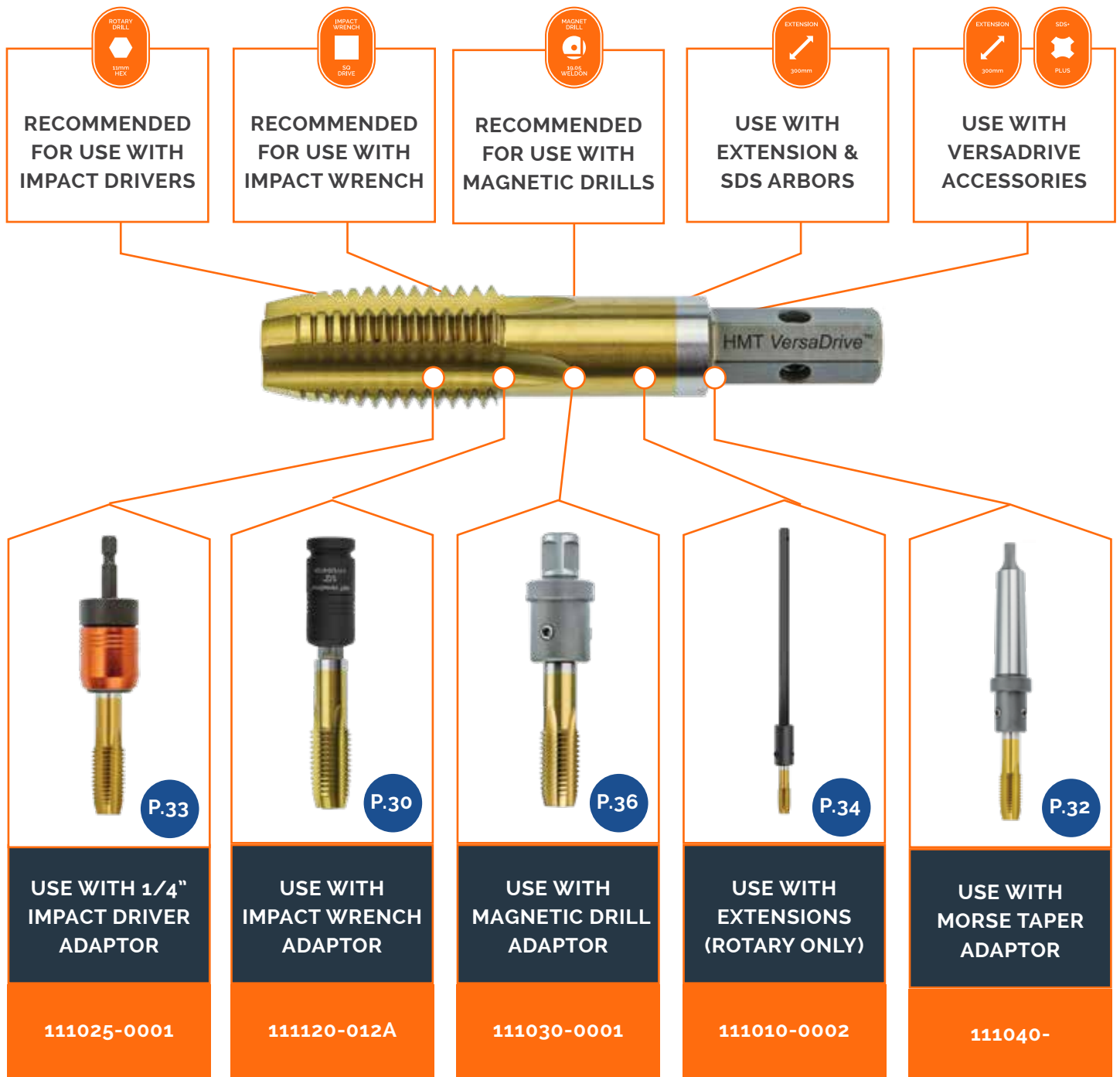


- ✓ Safer tapping with minimal kickback.
- ✓ Specially hardened for impact wrench use.
- ✓ High grade tool steel for high accuracy & long life.
- ✓ Goldmax low friction titanium coating to stop burn out.
- ✓ High strength, non slip shank design.

15X Faster than Hand Tapping.

VersaDrive™ ImpactaTaps perform best when adapted for use with an Impact wrench for Tapping through holes. However, they can also be adapted for use in a reversible Magnet Drill, or radial arm tapping machines.

15x FASTER THAN HAND TAPPING



Details & Dimensions



Metric Coarse Thread

Part No	M Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size (Metric Coarse thread)
308010-0050	M5 x 0.80	55	18	11.0	4.2mm
308010-0060	M6 x 1.00	55	20	11.0	5.0mm
308010-0080	M8 x 1.25	60	22	11.0	6.8mm
308010-0100	M10 x 1.50	70	24	11.0	8.5mm
308010-0120	M12 x 1.75	80	29	11.0	10.2mm
308010-0140	M14 x 2.00	90	32	11.0	12.0mm
308010-0160	M16 x 2.00	90	32	11.0	14.0mm
308010-0200	M20 x 2.50	100	37	11.0	17.5mm
308010-0240	M24 x 3.00	110	45	11.0	21.0mm
308010-0270	M27 x 3.00	130	48	11.0	24.0mm
308010-0300	M30 x 3.50	130	48	11.0	26.5mm

SET 1.



SET 2.



ImpactaTap®

Part No	Contents
308010-SET1	5 piece Set contains: VersaDrive ImpactaTaps M6, M8, M10, M12, M16
308010-SET2	4 piece Set contains: VersaDrive ImpactaTaps M12, M16, M20, M24





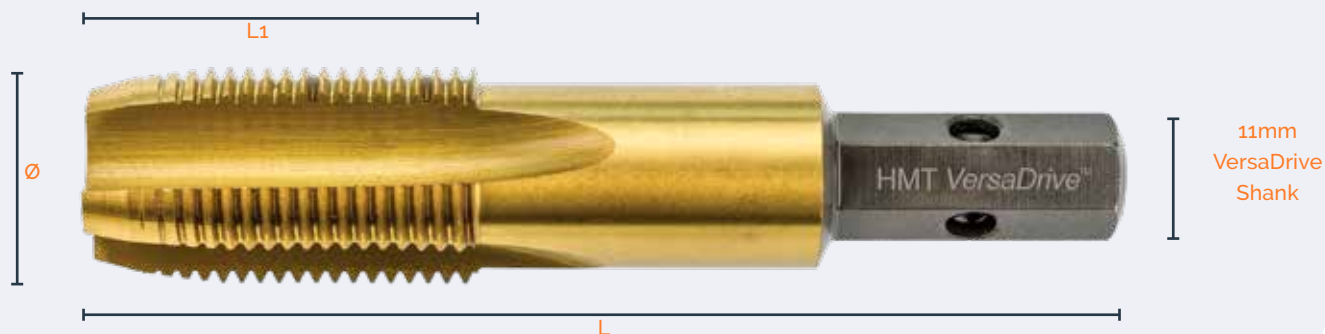
UNC ImpactaTaps

Part No	Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size
308050-0010	1/4 x 20 UNC	58	20	11.0	13/64"
308050-0020	5/16 x 18 UNC	60	22	11.0	17/64"
308050-0030	3/8 x 16 UNC	70	24	11.0	5/16"
308050-0040	1/2 x 13 UNC	80	29	11.0	27/64"
308050-0050	5/8 x 11 UNC	90	32	11.0	17/32"
308050-0060	3/4 x 10 UNC	100	37	11.0	21/32"
308050-0065	7/8 x 9 UNC	105	40	11.0	49/64"
308050-0070	1 x 8 UNC	110	45	11.0	7/8"

UNC ImpactaTap Sets

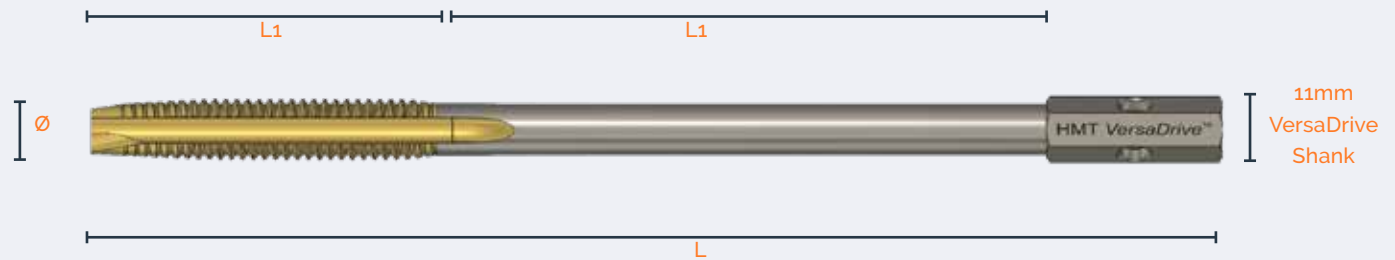
Part No	308050-SET1	SET: 1/4 x 20, 5/16 x 18, 3/8 x 16, 1/2 x 13, 5/8 x 11 UNC
Part No.	308050-SET2	SET: 1/2 x 13, 3/8 x 16, 3/4 x 10, 1 x 8 UNC

ImpactaTap® Metric Fine Thread



Part No	M Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size
308030-0060	M6 x 0.75 MF	60	19	11.0	5.25mm
308030-0800	M8 x 1.00 MF	70	22	11.0	7.50mm
308030-0100	M10 x 1.25 MF	70	24	11.0	8.8mm
308030-0120	M12 x 1.50 MF	80	29	11.0	10.5mm
308030-0160	M16 x 1.50 MF	90	32	11.0	15.0mm
308030-0180	M18 x 1.50 MF	100	37	11.0	16.8mm
308030-0200	M20 x 1.50 MF	100	37	11.0	18.5mm
308030-0240	M24 x 1.50 MF	120	92	11.0	22.5mm

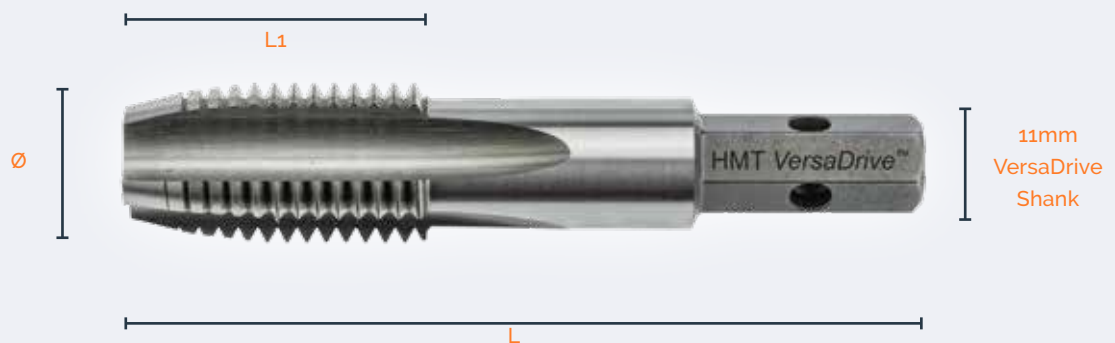
ImpactaTaps® Long Series - Metric Coarse



Spiral Point Taps for fast chip ejection in through holes.

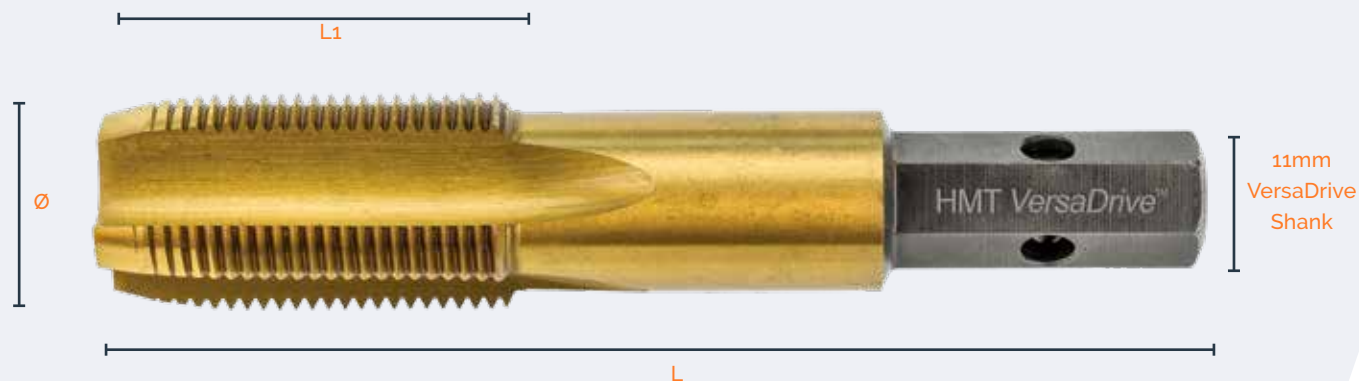
Part No	M Thread Size & Pitch	L mm	L1 mm	I2 mm	Shank mm	Tap Hole Size
308015-0080	M8 x 1.25	140	45	112	11.0	6.8mm
308015-0100	M10 x 1.50	155	50	127	11.0	8.5mm
308015-0120	M12 x 1.75	180	55	152	11.0	10.2mm
308015-0160	M16 x 2.0	200	65	172	11.0	14.0mm
308015-0200	M20 x 2.5	230	70	202	11.0	17.5mm
308015-0240	M24 x 3.0	260	75	232	11.0	21.0mm

Metric Coarse Oversized ImpactaTaps®



Used for tapping holes used with Galvanized Fixings

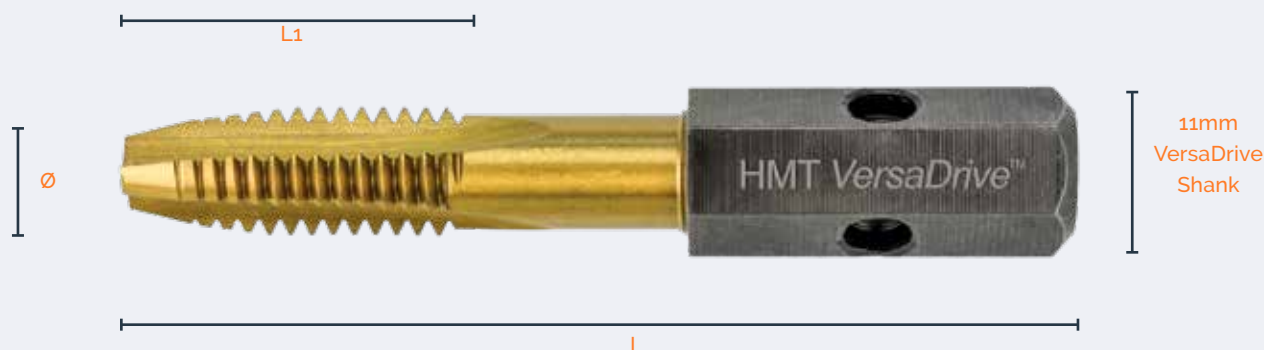
Part No	M Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size (Metric Coarse thread)
308020-0050	M5 x 0.80 (+ 0.015")	55	18	11.0	4.2
308020-0060	M6 x 1.00 (+ 0.015")	55	20	11.0	5.0
308020-0080	M8 x 1.25 (+ 0.015")	60	22	11.0	6.8
308020-0100	M10 x 1.50 (+ 0.015")	70	24	11.0	8.5
308020-0120	M12 x 1.75 (+ 0.015")	80	29	11.0	10.2
308020-0160	M16 x 2.00 (+ 0.015")	90	32	11.0	14.0
308020-0200	M20 x 2.50 (+ 0.015")	100	37	11.0	17.5
308020-0240	M24 x 3.00 (+ 0.015")	110	45	11.0	21.0
308020-0300 *	M30 x 3.50 (+ 0.015")	130	48	11.0	26.5



BSP: British Standard Pipe

Part No	Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size
308070-0010	1/8 x 28 BSP	70	24	11.0	11/32"
308070-0020	1/4 x 19 BSP	90	32	11.0	29/64"
308070-0030	3/8 x 19 BSP	90	32	11.0	19/32"
308070-0040	1/2 x 14 BSP	100	37	11.0	3/4"
308070-0050	5/8 x 14 BSP	100	37	11.0	54/64"
308070-0060	3/4 x 14 BSP	100	37	11.0	31/32"
308070-0070	1 x 11 BSP	110	45	11.0	1-13/64"

ImpactaTap® BSW Thread



BSW: British Standard Whitworth

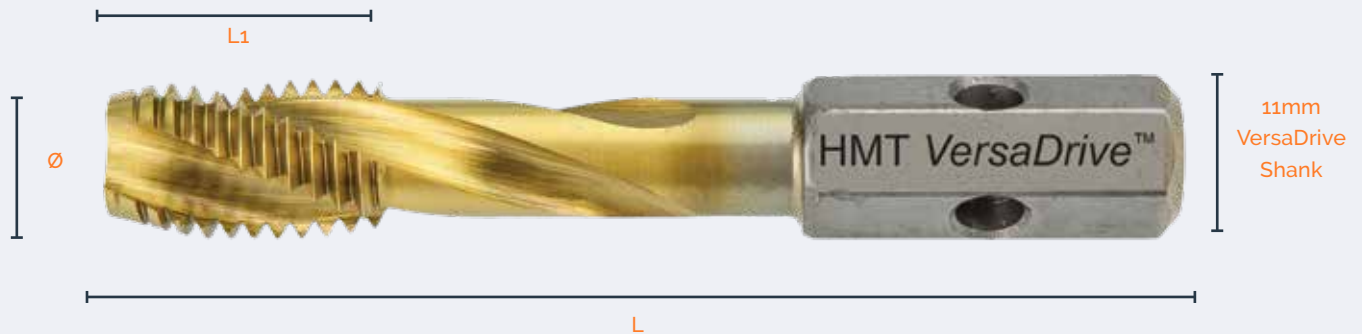
Part No	Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size
308060-0010	1/4 x 20 BSW	58	20	11.0	13/64"
308060-0015	5/16 x 18 BSW	60	22	11.0	17/64"
308060-0020	3/8 x 16 BSW	70	24	11.0	5/16"
308060-0030	1/2 x 12 BSW	80	29	11.0	27/64"
308060-0040	5/8 x 11 BSW	90	32	11.0	17/32"
308060-0050	3/4 x 10 BSW	100	37	11.0	41/64"
308060-0060	1 x 8 BSW	110	45	11.0	7/8"

VersaDrive Spiral Flute Taps - Metric Coarse



Part No	M Thread Size & Pitch	L mm	L1 mm	Shank mm	Tap Hole Size
309010-0060	M6 x 1.00	58	20	11.0	5.0mm
309010-0080	M8 x 1.25	60	22	11.0	6.8mm
309010-0100	M10 x 1.50	70	24	11.0	8.5mm
309010-0120	M12 x 1.75	80	29	11.0	10.2mm
309010-0160	M16 x 2.00	90	32	11.0	14.0mm
309010-0200	M20 x 2.50	100	37	11.0	17.5mm
309010-0240	M24 x 3.00	110	45	11.0	21.0mm
309010-0300	M30 x 3.50	130	48	11.0	26.5mm

VersaDrive Spiral Flute Taps - UNC Thread



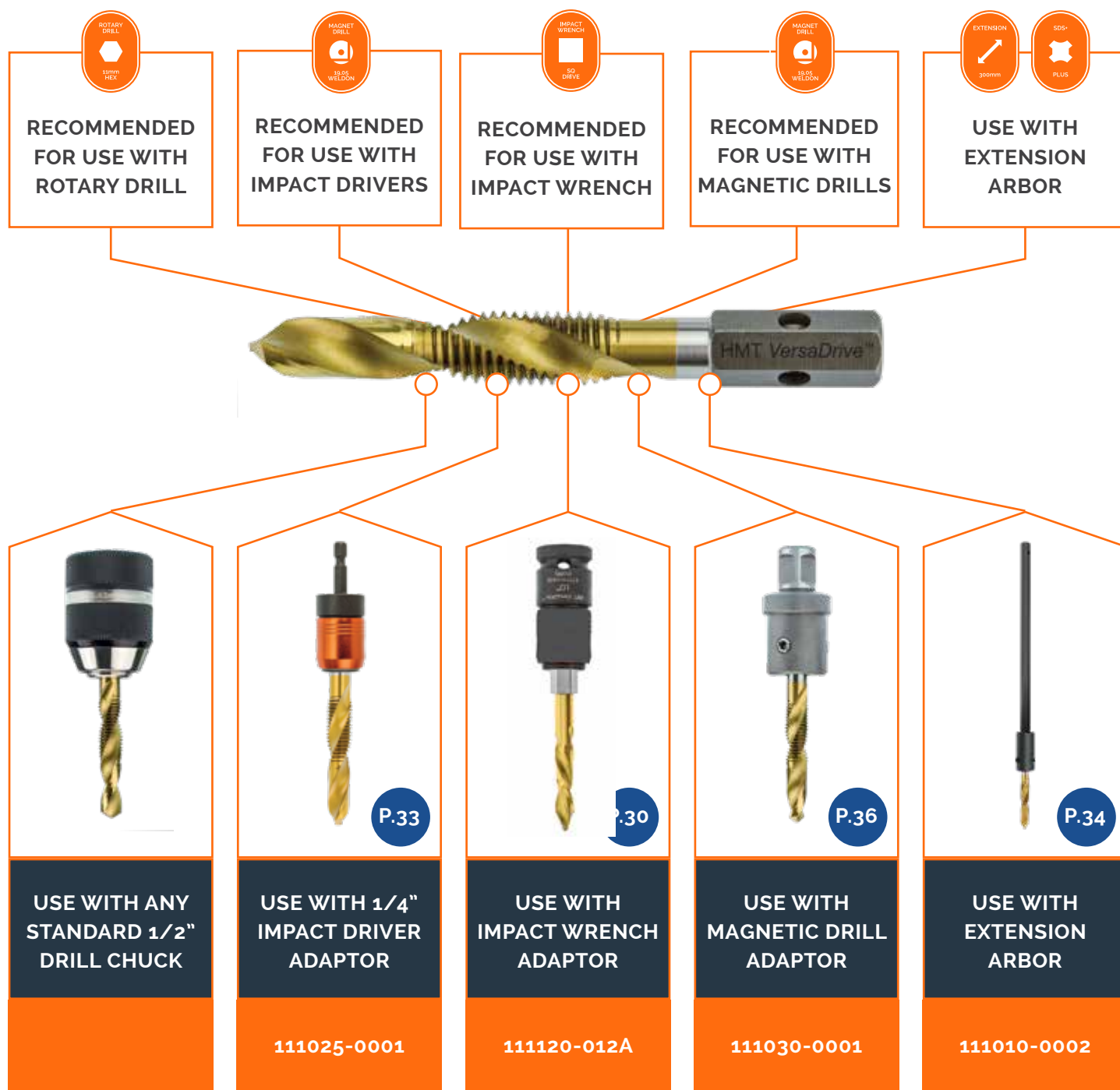
Part No	Thread Size & Pitch	L	L1	Shank	Tap Hole Size
309020-0010	1/4 x 20 UNC	2-9/32"	13/16"	11.0	13/64"
309020-0020	5/16 x 18 UNC	2-7/8"	7/8"	11.0	17/64"
309020-0030	3/8 x 16 UNC	2-3/4"	1"	11.0	5/16"
309020-0040	1/2 x 13 UNC	3-3/16"	1-1/8"	11.0	27/64"
309020-0050	5/8 x 11 UNC	3-1/2"	1-1/4"	11.0	17/32"
309020-0060	3/4 x 10 UNC	3-15/16"	1-7/16"	11.0	21/32"
309020-0065	7/8 x 9 UNC	4-1/8"	1-9/16"	11.0	49/64"
309020-0070	1 x 8 UNC	4-5/16"	1-3/4"	11.0	7/8"
309020-0110	1-1/4 x 7 UNC	5"	1-5/8"	11.0	1-7/64"

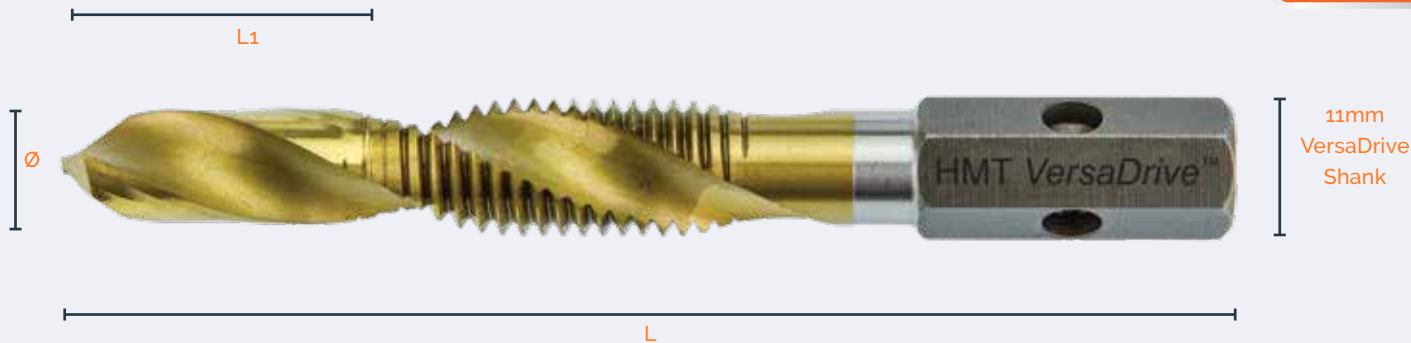
- Ground flute twist drill creates the perfect tapping hole.
- Safer tapping with minimal kickback.
- Specially hardened for impact wrench use.
- High grade tool steel for high accuracy & long life.
- Goldmax low friction titanium coating to stop burn out.
- High strength, non slip shank design.

Drill & Tap in one easy operation

All VersaDrive™ Sheet Metal Impacta-DrillTaps can be used in any standard 1/2" drill chuck for cordless or pistol drill use, or adaptor for use in a Magnet Drill or Impact Wrench.

DRILL & TAP IN ONE EASY OPERATION - WITH AN IMPACT WRENCH





Inch Size Sheet Metal Drill-Taps

Part No	Thread Size & Pitch	d1	L	L1	Max tapping depth with impact wrench
301126-0005	1/4-20 UNC	13/64"	2-61/64"	19/32"	1/4"
301126-0006	5/16-18 UNC	1/4"	3-15/64"	45/64"	5/16"
301126-0007	3/8-16 UNC	5/16"	3-5/8"	55/64"	3/8"
301126-0008	1/2-13 UNC	27/64"	4/16"	1-7/64"	1/2"
301126-0010	4-40 UNC	3/32"	2-11/64"	15/64"	3/32"
301126-0020	6-32 UNC	7/64"	2-23/64"	23/64"	1/8"
301126-0030	8-32 UNC	9/64"	2-23/64"	23/64"	5/32"
301126-0040	10-24 UNC	5/32"	2-51/64"	33/64"	13/64"





Metric Coarse Sheet Metal Drill-Taps

Part No	M Thread Size & Pitch	d1 mm	L mm	L1 mm	Shank mm	Max tapping depth with impact wrench
301125-0030	M3 x 0.50	2.5	55	6	11.0	3.0mm
301125-0040	M4 x 0.70	3.3	60	9	11.0	4.0mm
301125-0050	M5 x 0.80	4.2	71	13	11.0	5.0mm
301125-0060	M6 x 1.00	5.0	75	17	11.0	6.0mm
301125-0080	M8 x 1.25	6.8	82	20	11.0	8.0mm
301125-0100	M10 x 1.50	8.5	92	25	11.0	10.0mm
301125-0120	M12 x 1.75	10.2	103	31	11.0	12.0mm

Sheet Metal Drill-Tap Sets

Part No:	Set Contents
301126-SET1	Inch Size Set contains: Combi Drill Taps 1/4, 5/16, 3/8, 1/2" UNC
301125-SET1	Metric Set contains: Combi Drill-Taps M5, M6, M8, M10, M12

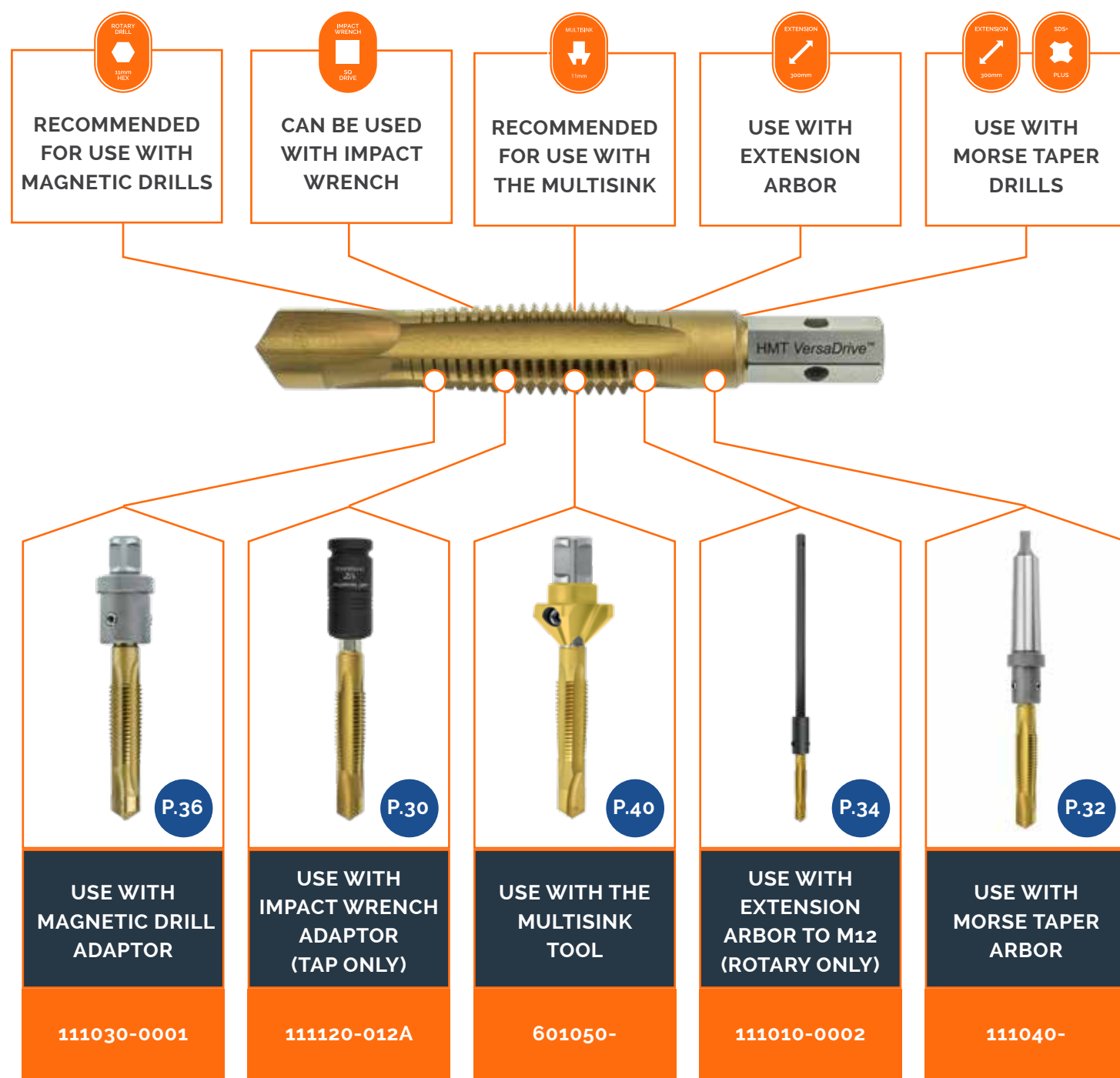


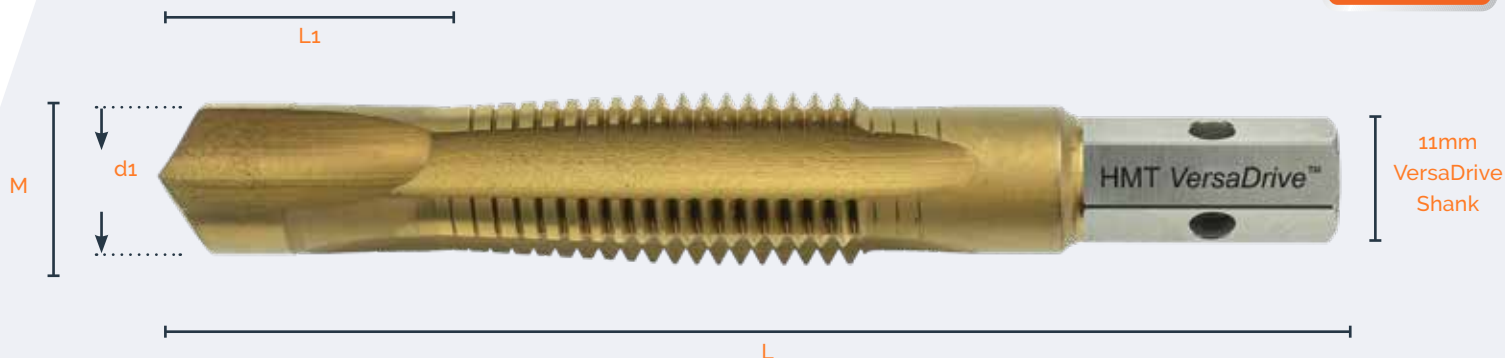
-  Fast Tapping with Minimal Kickback.
-  Specially hardened for Impact Wrench use.
-  Chipbreaker action for Automatic chip clearance when Impact Tapping.
-  Unique Dual-Point Starting Angle for easy alignment and fast cut.
-  High Grade Tool Steel for high accuracy and long life.

VersaDrive™ Heavy Duty Impacta-Drill Taps are primarily designed to be adapted for use with a reversible Magnet Drill to drill and tap heavy plate in 1 easy operation.

However, they can also be adapted for use with an impact wrench to enlarge and tap existing holes. Due the high rotational torque generated by larger thread sizes, Heavy Duty Impacta-DrillTaps are not recommended for use in a pistol drill above M12.

DRILL & TAP IN ONE EASY OPERATION





Metric Coarse - Heavy Duty Drill-Taps

Part No	M Thread Size & Pitch	d1 mm	L mm	L1 mm	Shank mm	Max Tapping Depth
301130-0080	M8 x 1.25	6.8	100	30	11.0	20mm
301130-0100	M10 x 1.50	8.5	105	30	11.0	20mm
301130-0120	M12 x 1.75	10.2	117	35	11.0	25mm
301130-0160	M16 x 2.00	14	117	37	11.0	25mm
301130-0200	M20 x 2.50	17.5	135	40	11.0	35mm
301130-0240	M24 x 3.00	21	148	45	11.0	40mm







UNC Thread - Heavy Duty Drill-Taps

Part No	Thread Size & Pitch	d1	L	L1	Max Tapping Depth
301140-0010	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
301140-0030	3/4-10 UNC	21/32	5-33/64	1-37/64	1-3/8
301140-0050	1-8 UNC	7/8"	6-19/64	1-49/64	1-37/64

Heavy Duty Drill-Tap Sets

Part No:	Set Contents
301130-SET1	Set contains: Heavy Duty Combi Drill-Taps M12, M16, M20, M24
301140-SET1	Set contains: Combi Drill Taps 1/2", 5/8", 3/4", 1" UNC

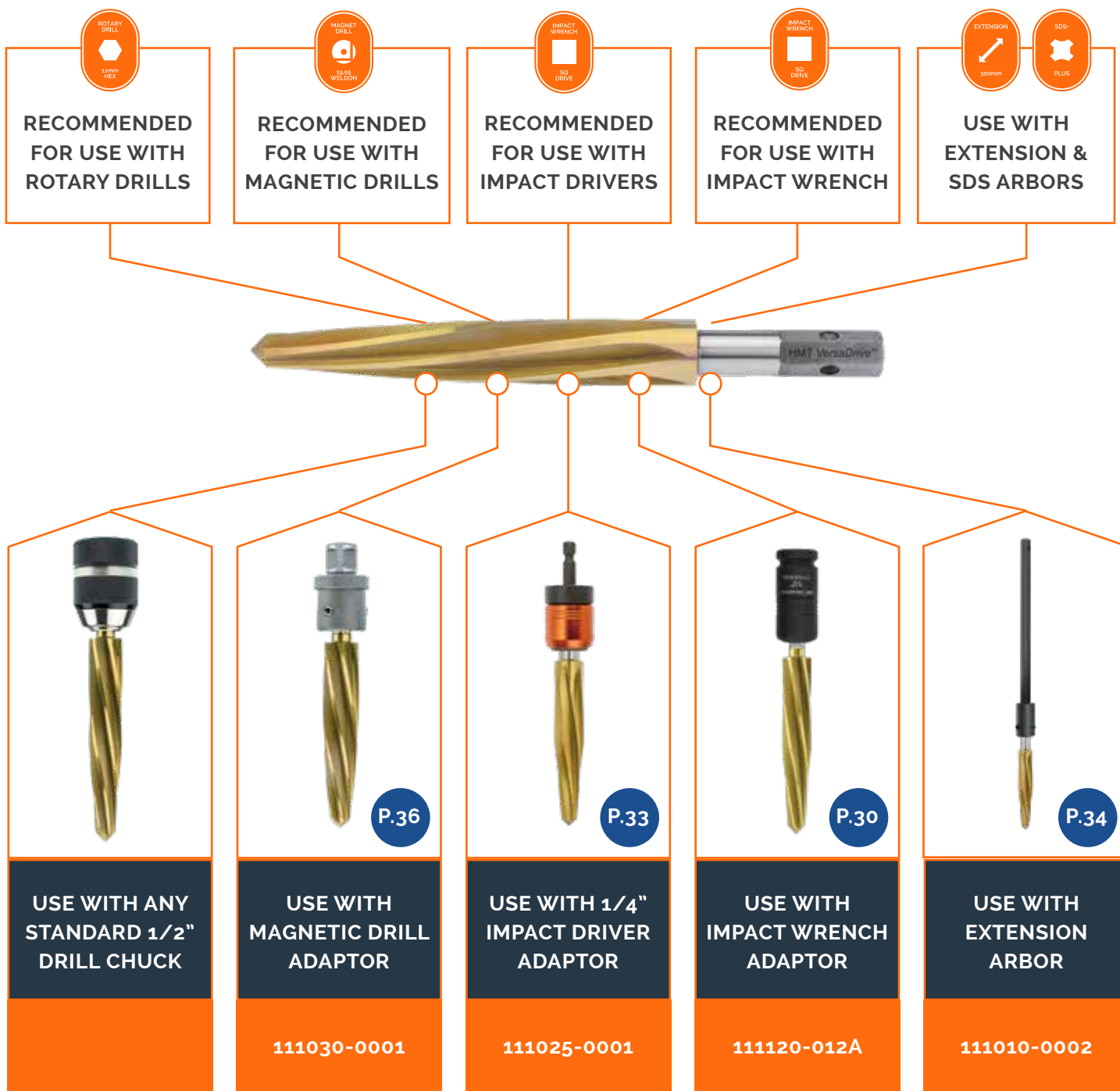


-  Precision 6-flute design for smooth cutting.
-  Safer reaming with minimal kickback.
-  Specially hardened for impact wrench use.
-  High grade tool steel for high accuracy and long life.
-  Goldmax low-friction titanium coating to stop burn-out.
-  High strength, non-slip shank design.

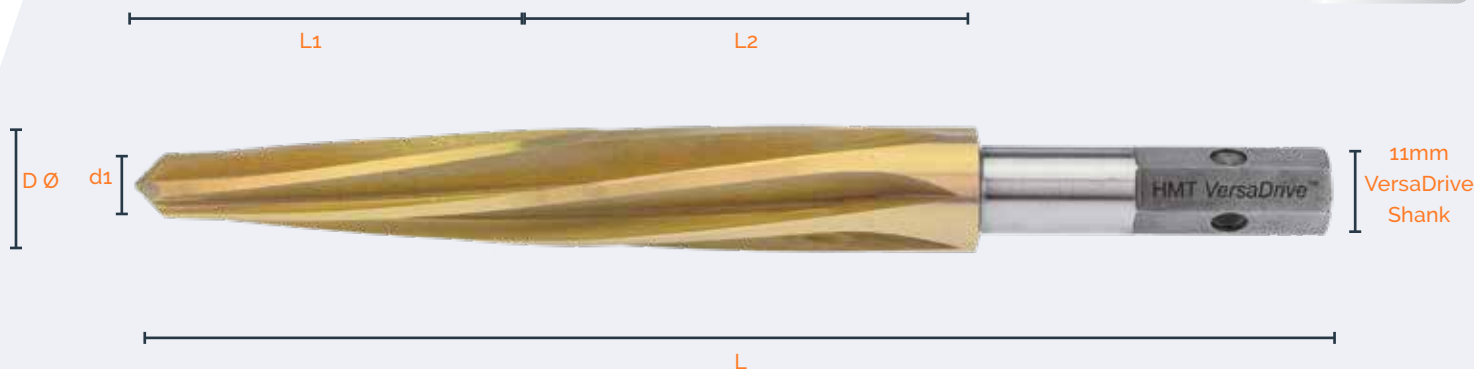
Keep the Job moving when a connection hole is undersized or misaligned.

VersaDrive™ Reamers perform fastest when used with an Impact Wrench. However, they can also be used in any standard 1/2" cordless or pistol drill chuck or fitted into a VersaDrive adaptor for use in a variable speed Magnet Drill.

ENLARGE OR ALIGN EXISTING HOLES WITH AN IMPACT WRENCH



Details & Dimensions



Metric Reamers

Part No	D Ø	d1 Ø	L1	L2	L	Shank mm
501030-0080	8mm	4.4mm	34mm	36mm	108mm	11.0
501030-0100	10mm	6.0mm	34mm	36mm	108mm	11.0
501030-0120	12mm	7.1mm	43mm	59mm	144mm	11.0
501030-0140	14mm	7.5mm	52mm	50mm	144mm	11.0
501030-0160	16mm	8.0mm	58mm	56mm	152mm	11.0
501030-0180	18mm	9.4mm	58mm	56mm	170mm	11.0
501030-0200	20mm	11.2mm	61mm	65mm	178mm	11.0
501030-0210	21mm	12.3mm	61mm	66mm	185mm	11.0
501030-0220	22mm	13.2mm	61mm	66mm	185mm	11.0
501030-0240	24mm	15.1mm	63mm	64mm	185mm	11.0
501030-0260	26mm	15.9mm	61mm	64mm	185mm	11.0

Inch size Reamers

Part No	D Ø	d1 Ø	L1	L2	L	Shank mm
501040-0040	1/2" (12.7mm)	19/64"	1-15/16"	2-1/16"	5-1/2"	11.0
501040-0050	9/16" (14.3mm)	9/32"	2-1/16"	1-15/16"	5-1/2"	11.0
501040-0060	5/8" (15.9mm)	5/16"	2-11/64"	2-21/64"	6"	11.0
501040-0070	11/16" (17.5mm)	3/8"	2-1/4"	2-1/4"	6"	11.0
501040-0080	3/4" (19.05mm)	13/32"	2-31/64"	2-33/64"	7"	11.0
501040-0090	7/8" (22.2mm)	17/32"	2-19/32"	2-13/32"	7"	11.0
501040-0100	15/16" (23.8mm)	19/32"	2-43/64"	2-21/64"	7"	11.0
501040-0110	1" (25.4mm)	5/8"	2-43/64"	2-21/64"	7"	11.0
501040-0120	1-1/16" (27mm)	45/64"	2-9/16"	2-7/16"	7"	11.0

Reamer Sets

Part No:	Set Contents
501030-3SET	Set contains: VersaDrive Reamers 14mm, 18mm, 22mm
501030-SET	Set contains: VersaDrive Reamers 12mm, 14mm, 18mm, 22mm, 26mm
501040-3SET	Set contains: VersaDrive Reamers 1/2", 5/8", 3/4"
501040-5SET	Set contains: VersaDrive Reamers 1/2", 5/8", 3/4", 7/8", 1-1/16"




- 90° Point Angle for Countersunk Bolt Heads.
- Safer use with minimal kickback.
- Specially hardened for impact wrench use up to 16.5mm.
- High-Grade Tool Steel for high accuracy & long life.
- GoldMax low friction Titanium Coating to stop burn out.
- High Strength, Non-slip shank design.

HMT are the first company on the market to develop a countersink that can be used in an impact wrench as well as used in any standard drill chuck or magnetic drill.

Utilize 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.

PRECISION COUNTERSINKING TOOL



RECOMMENDED FOR USE WITH ROTARY DRILLS

RECOMMENDED FOR USE WITH MAGNETIC DRILLS

CAN BE USED WITH IMPACT DRIVERS
Up to 16.5mm

CAN BE USED WITH IMPACT WRENCHES
Up to 16.5mm

USE WITH EXTENSION & SDS ARBORS

USE WITH ANY STANDARD 1/2" DRILL CHUCK

USE WITH MAGNETIC DRILL ADAPTOR
111030-0001

USE WITH 1/4" IMPACT DRIVER ADAPTOR
Up to 16.5mm
111025-0001

USE WITH IMPACT WRENCH ADAPTOR
Up to 16.5mm
111120-012A

USE WITH EXTENSION ARBOR
111010-0002



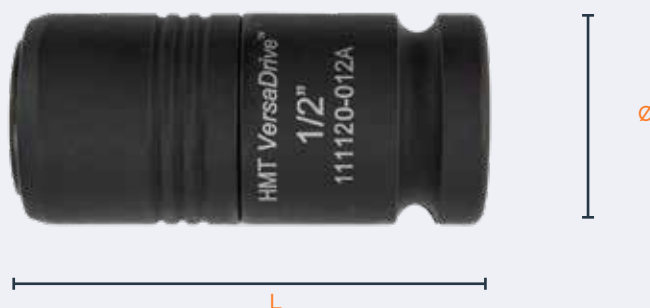
Part No	D Ø mm	Ø d1 mm	L1 mm	L mm	Shank mm	Countersunk Screw	Point Angle
603060-0063	6.3mm	1.5	17	45	11.0	M3	90°
603060-0083	8.3mm	2.0	22	50	11.0	M4	90°
603060-0104	10.4mm	2.5	22	50	11.0	M5	90°
603060-0124	12.4mm	2.8	28	56	11.0	M6	90°
603060-0165	16.5mm	3.2	32	60	11.0	M8	90°
603060-0205	20.5mm	3.5	35	63	11.0	M10	90°
603060-0250	25mm	3.8	39	67	11.0	M12	90°
603060-0310	31mm	4.2	43	71	11.0	M16	90°

Countersink Set

603060-5SET

Set contains: VersaDrive Countersink Bits
12.4mm, 16.5mm, 20.5mm, 25mm, 31mm





Part No	Sq Drive Size	L mm	Ø mm	Unit of sale
111120-012A	1/2" Drive	55	25	1

The new VersaDrive HD impact wrench adaptor has been developed to work with the latest generation of high torque 1/2" drive cordless impact wrenches which are capable of generating in excess of 1000Nm of Torque. This fully impact hardened Manganese Phosphate adaptor features a "pull-forward to release" mechanism which reduces the risk of the tool coming loose in operation.

Adaptor Benefits

- Supplied with retention pin and ring.
- High quality impact rated adaptor.
- Quick release action for ultimate convenience.

Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
ImpactaTaps**



**VersaDrive
Step Drill**



**VersaDrive
Drill Taps**



**VersaDrive
Reamers**

VersaDrive Impact Wrench Adaptor $\frac{3}{4}"$



Part No	Sq Drive Size	L mm	Ø mm	Unit of sale
111110-034A	3/4" Drive	60	38	1

Adaptor Benefits

- Supplied with retention pin and ring.
- High quality impact rated adaptor.
- Quick release action for ultimate convenience.



Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
ImpactaTaps**



**VersaDrive
Step Drill**



**VersaDrive
Drill Taps**



**VersaDrive
Reamers**



Part No	Ø mm	L mm	Shank Size	Unit of sale
111040-0001	30	80	MT2	1
111040-0002	30	99	MT3	1

Adaptor Benefits

- 3 X Stainless Steel M8 doghead grub screws supplied per adaptor
- Ideal for workshop use with radial arm drills and pillar drills



Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
Taps**



**VersaDrive
Holesaws**



**VersaDrive
Drill Taps**



**VersaDrive
Reamers**

VersaDrive 1/4" Impact Driver Adaptor



Part No	Drive Size	L mm	Ø mm	Unit of sale
111025-0001	1/4" Hex	65	25	1

Adaptor Benefits

- High quality impact rated adaptor.
- Quick release action for ultimate convenience.



Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
ImpactaTaps**



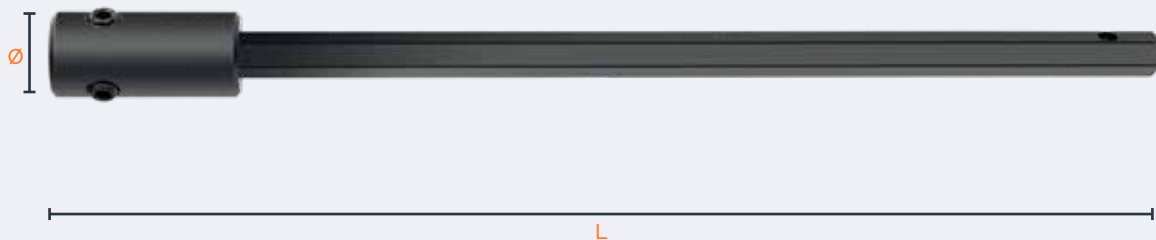
**VersaDrive
Step Drill**



**VersaDrive
Drill Taps**



**VersaDrive
Reamers**



Part No	Ø	L	Units
111010-0002	23mm	300mm	1

Adaptor Benefits

- Not rated for impact wrench use.
- Join multiple extensions for extra length.
- Will pass through holes larger than 15/16" (23mm).

Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
Taps**



**VersaDrive
Step Drill**



**VersaDrive
Drill Taps**



**VersaDrive
Holesaws**

VersaDrive SDS+ Adaptor



Part No	Ø	L	Units
111020-0001	21.5mm	140mm	1

Adaptor Benefits

- Not for hammer use, use on rotary drilling setting only.
- Will pass through holes larger than 7/8" (21.5mm).

Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
Reamers**



**VersaDrive
Step Drill**



**VersaDrive
Countersinks**



**VersaDrive
Holesaws**



Part No	Ø mm	L mm	Shank Size	Unit of sale
111030-0001	30	63.5	3/4" / 19.05mm	1
111000-0001	Spare Grub Screws		M8 x 1.25	Pack 10

Adaptor Benefits

- 3 X Stainless Steel M8 doghead grub screws supplied per adaptor
- Fits into any standard 3/4" (19.05mm) magnetic drill arbor

Use with the VersaDrive Range



**VersaDrive
Drill Bits**



**VersaDrive
Taps**



**VersaDrive
Holesaws**




**VersaDrive
Drill Taps**





**VersaDrive
Reamers**


TCT Holesaws "2-in-1-systems"



 Massive 2 $\frac{3}{4}$ " (70mm) reach with 2 $\frac{5}{32}$ " (55mm) depth of cut

 Premium quality Tungsten Carbide teeth.

 High strength, non-slip shank design.

 Use in any standard 1/2" drill chuck or with the magnet drill adaptor. Combine with the multisink tool to broach and countersink in one operation.

VersaDrive TCT Holesaws are a highly versatile

Tungsten Carbide Holesaw system for use with a range of power tools including rotary hand-held drills, Mag Drills and Pillar Drills.

The perfect heavy duty Holesaw for fabricators and steel erectors needing to drill through heavy steel in otherwise inaccessible locations.

Longer than standard tools, the TCT Holesaw's extended range makes it ideal for drilling into steel through existing holes.

10x LONGER LIFE THAN STARRET HOLESAWS



VersaDrive Hex Tri-Lock shank fits all standard drill chucks as well as Magnetic Drill Adaptors, offering the greatest flexibility and range of applications from a single tool.



Premium grade Sandvik Tungsten carbide teeth for the highest performance cutting and ultimate tool life. 10x greater than standard bi-metal Starrett type holesaws.



Spring-loaded pilot drill centre to stabilize the cutter during drilling and eject metal slug upon completion.

1 Tool - 3 Functions



Heavy Duty Holesaw




Adapt to Broach Cutter




Adapt to Multisink


When using with a Magnetic Drill Adaptor or MultiSink tool, replace supplied pilot drill with 101030P-0002 ejector pin.




**RECOMMENDED
FOR USE WITH
ROTARY DRILLS**



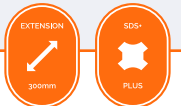
**RECOMMENDED
FOR USE WITH
MAGNETIC DRILLS**




**RECOMMENDED
FOR USE WITH
THE MULTISINK**




**USE WITH
EXTENSION &
SDS ARBORS**




**USE WITH
VERSADRIVE
ACCESSORIES**






**USE WITH ANY
STANDARD 1/2" DRILL CHUCK**




**USE WITH
MAGNETIC DRILL
Adaptor**

111030-0001




**USE WITH
THE MULTISINK
TOOL**

601050-



**USE WITH
EXTENSION
ARBOR**

111010-000



**USE WITH
SDS+ ADAPTOR
(ROTARY ONLY)**

111020-0001

Rated for:

Steel / Structural steels / Stainless steel (inox) / Aluminium / Cast Iron / Brass / Copper / Fibreglass / Composite & sandwich materials / Plastics / Wood

Pilot Drill Bits & Pilot Pins



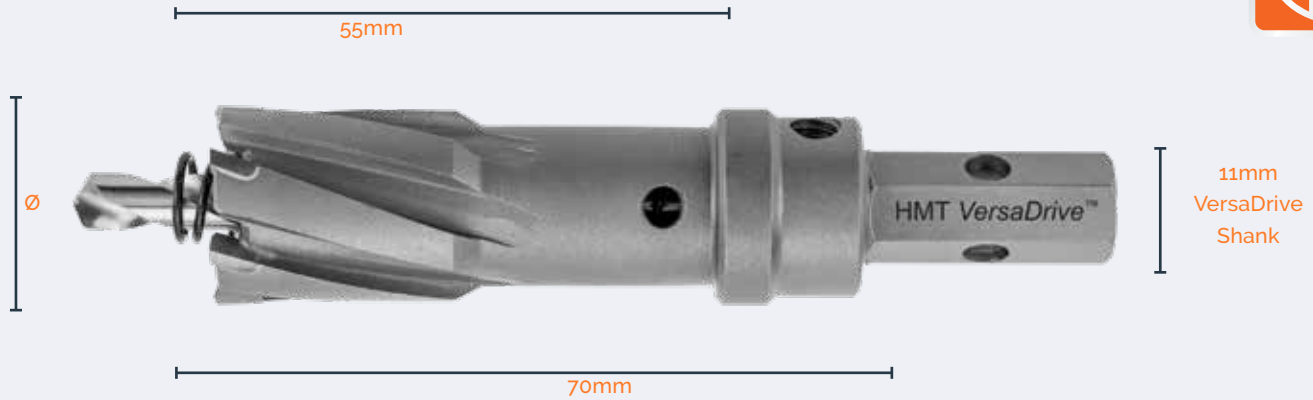
101030P-0001



101030P-0002

Part No	Contents
101030P-0130	Holesaw Pilot Drill for 12 & 13mm Holesaws, Pack 2 (Supplied WITHOUT ejection spring)
101030P-0001	Holesaw Pilot Drill for 14-80mm Holesaws, Pack 2 (Supplied WITH ejection spring)
101030P-0002	VersaDrive Holesaw Magnet Pilot Pin for annular cutter conversion, Pack 2
111030-0001	Magnet Drill Adaptor, Pack 1
111000-0001	Magnet Drill Adaptor, Pack 10

Details & Dimensions



Part No	Ø D mm	Ø D Inch	Tap Size (Metric Coarse)	Uses Grub Screw
101030-0120	12mm		M14	M5
101030-0130	13mm		-	M5
101030-0140	14mm	9/16"	M16	M5
101030-0150	15mm		-	M6
101030-0160	16mm	5/8"	-	M6
101030-0170	17mm	11/16"	-	M6
101030-0175	17.5mm		M20	M6
101030-0180	18mm		-	M6
101030-0190	19mm	3/4"	-	M6
101030-0200	20mm		-	M6
101030-0210	21mm	13/16"	M24	M8
101030-0220	22mm	7/8"	-	M8
101030-0230	23mm		-	M8
101030-0240	24mm	15/16"	M27	M8
101030-0250	25mm	1"	-	M8
101030-0260	26mm		-	M8
101030-0270	27mm	1-1/16"	-	M8
101030-0280	28mm		-	M8
101030-0290	29mm	1-1/8"	-	M8
101030-0300	30mm	1-3/16"	-	M8
101030-0310	31mm		-	M8
101030-0320	32mm	1-1/4"	M36	M8
101030-0330	33mm	1-5/16"	-	M8
101030-0340	34mm		-	M8

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

TCT Holesaw Sets

Part No	Contents
101030-SET1	3 piece Set contains: VersaDrive CarbideMax TCT Holesaws 14mm, 18mm, 22mm

Part No	Contents
101030-SET2	5 piece Set contains: VersaDrive CarbideMax TCT Holesaws 14mm, 17mm, 18mm, 21mm, 22mm



The CarbideMax MultiSink Tool is the Tungsten Carbide Tipped version of the unique HMT combination countersinking tool. Specifically designed for countersinking Hardox, Inox and the hardest structural steels.

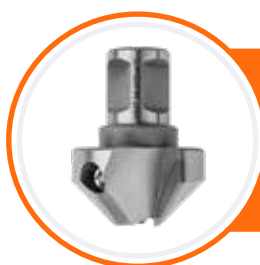
- **Innovative Combination Countersinking Tool.**
- Save Time Completing Countersunk Holes.
- **Drill & Countersink in one operation.**
- Tap & Countersink in one operation.
- **Drill-Tap & Countersink in one operation.**

Order the TCT MultiSink, as a Kit complete with Holesaw & Pilot Pin - ready to use.



Part No	Kit Details
601055-SET4014	40mm TCT MultiSink with 14mm Holesaw & Pin
601055-SET4018	40mm TCT MultiSink with 18mm Holesaw & Pin
601055-SET4022	40mm TCT MultiSink with 22mm Holesaw & Pin
601055-SET5518	55mm TCT MultiSink with 18mm Holesaw & Pin
601055-SET5522	55mm TCT MultiSink with 22mm Holesaw & Pin
601055-SET5526	55mm TCT MultiSink with 26mm Holesaw & Pin

Other holesaw size combinations available to order



**ONE
MULTISINK
TOOL**

MANY COUNTERSINKING SOLUTIONS

 <p>PILOTED COUNTERSINK</p>	 <p>BROACH & COUNTERSINK IN ONE OPERATION 14-26mm</p>	 <p>DRILL & COUNTERSINK IN ONE OPERATION 14-22mm</p>	 <p>TAP & COUNTERSINK IN ONE OPERATION M16-M24</p>	 <p>DRILL, TAP & COUNTERSINK IN ONE OPERATION M16-M24</p>
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Minimum suitable Holesaw size is 14mm.



CarbideMax TCT MultiSink

Part No	D Ø mm	Ø d2 mm	L	Point Angle	Shank
601055-0400	40mm	14mm	100mm	90°	3/4" / 19.05mm
601055-0550	55mm	14mm	109mm	90°	3/4" / 19.05mm

MultiSink Pilot

For countersinking bolt holes from 14 to 26mm diameter. Use MultiSink with variable speed magnet drill. The speed must be reduced when countersinking.

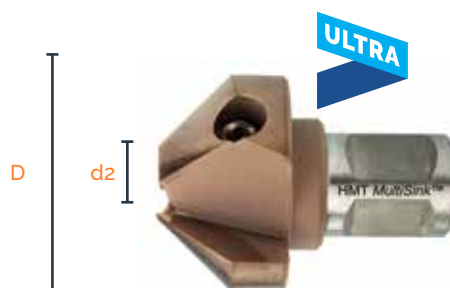
Part No	d1 Ø	Length mm	Shank mm
601050-0140	14mm	52mm	11.0
601050-0160	16mm	52mm	11.0
601050-0180	18mm	52mm	11.0
601050-0200	20mm	52mm	11.0
601050-0220	22mm	52mm	11.0
601050-0240	24mm	52mm	11.0
601050-0260	26mm	52mm	11.0

MultiSink Ejector Pilot Pin

For use with VersaDrive Holesaws



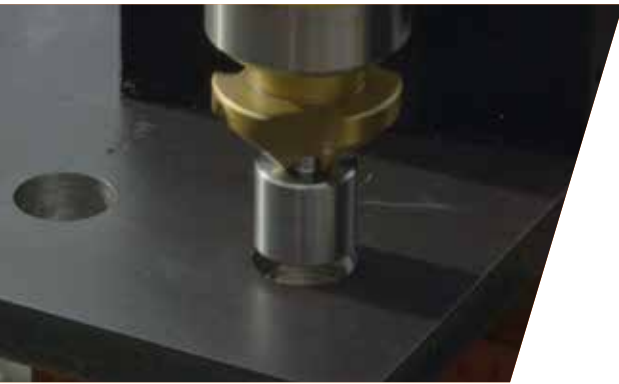
Part No	d1 Ø	l1 mm	Unit of sale
101030P-0002	6.35mm	145mm	Pack 2



Ultra Coated TCT MultiSink

Ultra coated for increased wear resistance countersinking the toughest materials like Hardox.

Part No	D Ø mm	Ø d2 mm	Point Angle	Shank
601056-0400	40mm	14mm	90°	3/4" / 19.05mm
601056-0550	55mm	14mm	90°	3/4" / 19.05mm



- **Innovative Combination Countersinking Tool.**
- Save Time Completing Countersunk Holes.
- **GoldMax low-friction titanium coating to stop burn-out**
- Drill & Countersink in one operation.
- **Tap & Countersink in one operation.**
- Drill-Tap & Countersink in one operation.



Order the TCT MultiSink, as a Kit complete with Holesaw & Pilot Pin - ready to use.

Part No	Kit Details
601055-SET4014	40mm TCT MultiSink with 14mm Holesaw & Pin
601055-SET4018	40mm TCT MultiSink with 18mm Holesaw & Pin
601055-SET4022	40mm TCT MultiSink with 22mm Holesaw & Pin
601055-SET5518	55mm TCT MultiSink with 18mm Holesaw & Pin
601055-SET5522	55mm TCT MultiSink with 22mm Holesaw & Pin
601055-SET5526	55mm TCT MultiSink with 26mm Holesaw & Pin

Other holesaw size combinations available to order.

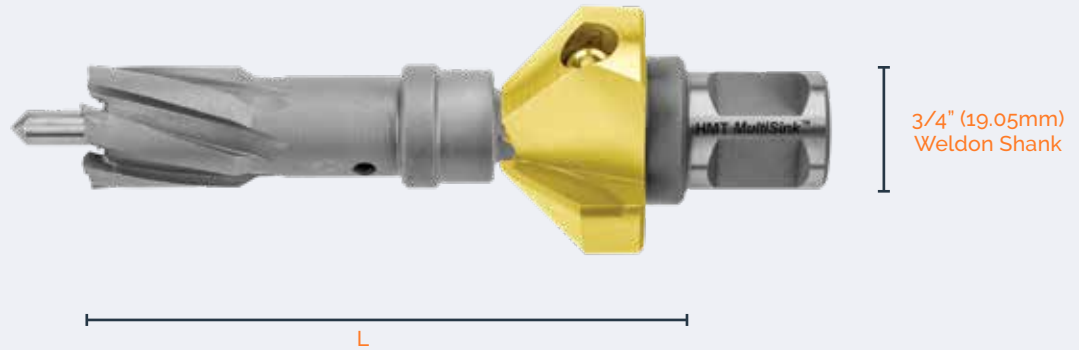


**ONE
MULTISINK
TOOL**

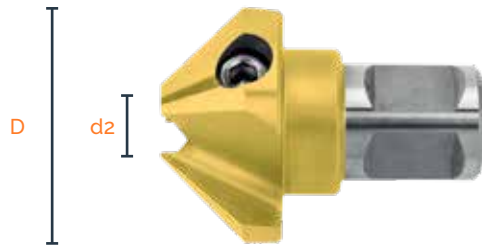
MANY COUNTERSINKING SOLUTIONS

				
<p>PILOTED COUNTERSINK</p>	<p>BROACH & COUNTERSINK IN ONE OPERATION 14-26mm</p>	<p>DRILL & COUNTERSINK IN ONE OPERATION 14-22mm</p>	<p>TAP & COUNTERSINK IN ONE OPERATION M16-M24</p>	<p>DRILL, TAP & COUNTERSINK IN ONE OPERATION M16-M24</p>

The HSS TCT MultiSink System



Minimum suitable Holesaw size is 35/64" (14mm)



SPECIAL ORDER

HSS MultiSink Tool

Part No	D Ø mm	Ø d2 mm	L	Point Angle	Shank
601056-0002	2"	35/64"	3-5/16"	82°	3/4"
601055-0400	40mm	14mm	100mm	90°	3/4" / 19.05mm
601055-0550	55mm	14mm	109mm	90°	3/4" / 19.05mm

MultiSink Pilot

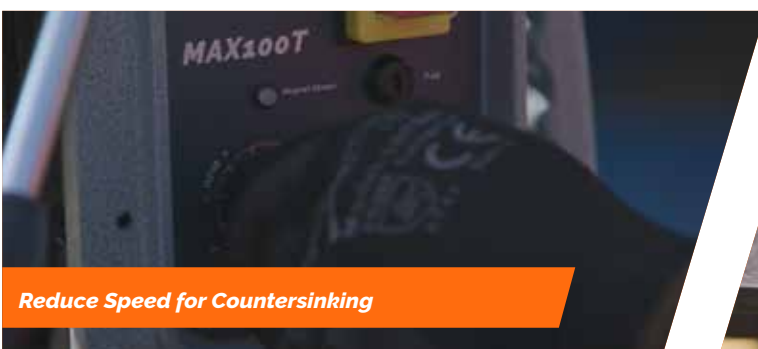
For countersinking bolt holes from 14 to 26mm diameter. Use MultiSink with variable speed magnetic drill. The speed must be reduced when countersinking.

Part No	d1 Ø	Length mm	Shank mm
601050-0140	14mm	52mm	11.0
601050-0160	16mm	52mm	11.0
601050-0180	18mm	52mm	11.0
601050-0200	20mm	52mm	11.0
601050-0220	22mm	52mm	11.0
601050-0240	24mm	52mm	11.0
601050-0260	26mm	52mm	11.0

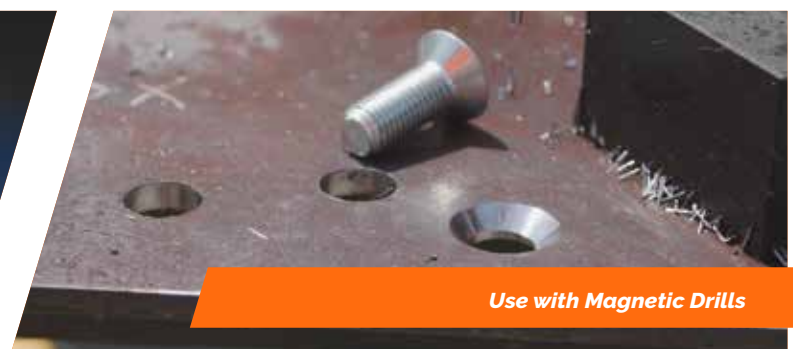
MultiSink Ejector Pilot Pin

For use with VersaDrive Holesaws

Part No	d1 Ø	l1 mm	Unit of sale
101030P-0002	6.35mm	145mm	Pack 2



Reduce Speed for Countersinking



Use with Magnetic Drills



Ultra Coated Holesaws

CarbideMax Ultra cutters are specifically designed for the toughest drilling jobs on the planet, **INCLUDING Hardox steel!** CarbideMax™ Ultra TCT cutters are tipped with individually brazed cutting teeth of the highest quality carbide. They are designed with an elaborate cutting geometry which results in faster, quieter, easier drilling and chatter-free performance.

Successful results machining these materials requires the right combination of equipment including a high torque/ slow speed Magnetic Drill, like the Slugger by FEIN JCM 200U and plenty of lubricant. **PRO TIP- allow the cutter to cool during the cut to avoid overheating and damaging the cutting tips..**

Combine with the Ultra coated MultiSink tool to drill and countersink in one operation.

Part No	Ø D mm	Tap Size (Metric Coarse)	Uses Grub Screw
101031-0140	14mm	M16	M5
101031-0180	18mm	-	M6
101031-0200	20mm	-	M6
101031-0220	22mm	-	M8
101031-0240	24mm	M27	M8
101031-0260	26mm	-	M8

Additional Sizes available to order

Ultra Coated TCT MultiSink

Ultra coated for increased wear resistance countersinking the toughest materials like Hardox.

Part No	D Ø mm	Point Angle	Shank
601056-0400	40mm	90°	3/4" / 19.05mm
601056-0550	55mm	90°	3/4" / 19.05mm

Pilot Pins



Part No	Contents
101030P-0002	VersaDrive Holesaw Magnet Pilot Pin for annular cutter conversion, Pack 2





HOW TO SELECT THE RIGHT IMPACT WRENCH OR IMPACT DRIVER FOR VERSADrive TOOLS

Selecting the Right Impact Wrench or Impact Driver for VersaDrive Tools

Using these increasingly powerful tools for speeding up metal drilling, thread tapping, reaming, and so on is a new skill for many operators. So here is a helpful guide to make it simpler.

1. Identify the torque range (for the cutting tool) required from the data sheet guides that can be found at the back of this VersaDrive catalogue.

Example to tap:

5/16" x 18 UNC in 1/2" plate = data sheet torque of 205 ft/lb and an RPM of 310 to 365.

2. Look up the model number of your impact wrench or impact driver to see its torque range and check if there are speed/torque settings on the tool .
3. Select the closest torque setting on the impact wrench/impact driver ABOVE the torque recommendation. This is for the following 2 reasons:
 - Higher torque will only be used on demand
 - Too low torque will lead to the tool jamming or even snapping as the flutes stop cutting and the torque transfers to the tool





Metric Step Drills

Foot Pound (Ft Lbs)
Impact Torque

							
Step Drill Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics	Impact Torque
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque
3-12 mm	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650	148-206
14-22 mm	597-430	390-270	200-145	600-440	245-180	380-275	243-295
24-30 mm	420-330	260-215	140-110	420-330	175-135	275-180	295-357
32-40 mm	260-230	160-145	85-75	260-230	95-85	150-140	450-553

Inch size Step Drills







Foot Pound (Ft Lbs)
Impact Torque

Step Drill Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics	Impact Torque
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque
3/16-1/2"	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650	270-380
3/16-7/8"	597-430	390-270	200-145	600-440	245-180	380-275	440-540
1/4-1-3/8"	420-330	260-215	140-110	420-330	175-135	275-180	540-660

Best Practice Advice






*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Apply firm, steady feed pressure throughout the cut.		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Avoid lateral movement or tilting which can cause damage to the tool.		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 it is drilling the outside wall. This may cause breakage to the tool.



For Cobalt Drill Bits

								
Drill Bit Diameter	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min	Impact Torque
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque
3- 4MM	3400-2550	1700-1250	850-700	3400-2550	2000-1300	4300-2000	5200-3500	85-95
5 - 9MM	2100-1140	1020-575	760-420	2050-1130	1200-600	1750-1040	3400-1550	95-265
10-15MM	1030-660	520-350	385-225	1020-660	550-340	1025-620	1500-950	N/A
16-20MM	640-490	335-230	220-195	640-510	330-250	600-470	975-745	N/A
21-25MM	460-330	220-140	190-150	500-410	240-200	460-350	730-500	N/A
26-32MM	310-250	140-110	150-120	320-275	200-175	335-320	400-315	N/A







For TurboTip Drill Bits

Impact wrench / Impact Driver Required Ft Lbs Torque										
6mm	6.8mm	7mm	8mm	8.5mm	9mm	10mm	11mm	12mm	13mm	14mm
100	125	140	175	200	265	275	300	310	320	325

*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

Best Practice Advice

	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Apply firm, steady feed pressure throughout the cut.		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Avoid lateral movement or tilting which can cause damage to the tool.		VersaDrive Drill Bits up to 10mm diameter can be driven by an Impact wrench (in rotary mode only).



GUIDE RANGE:
Foot Pound (Ft Lbs)
Impact Torque

											
Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque 6mm Thick Steel	Impact Tapping Torque 12mm Thick Steel	Impact Tapping Torque 25mm Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque	Ft Lbs Torque
M3	960	809	650	2700	1295	2550	1620	1700	77	118	N/A
M4	730	610	490	2060	975	1950	1220	1285	88	133	N/A
M5	585	485	385	1750	780	1555	970	1020	100	147	N/A
M6	485	405	325	1455	650	1295	810	855	107	177	295
M8	365	310	245	1095	485	970	610	650	110	206	330
M10	295	245	195	870	390	780	485	510	125	221	354
M12	240	200	162	730	330	645	410	430	136	236	377
M14	210	175	140	625	275	560	350	370	140	250	401
M16	185	155	125	550	243	485	310	330	147	265	425
M20	145	125	100	440	194	385	245	260	232	295	472
M24	120	100	85	370	165	325	210	225	n/a	442	708
M27	105	90	75	330	145	290	180	190	n/a	546	873
M30	95	80	60	310	130	275	160	170	n/a	590	885

Best Practice Advice












*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

1. 	ImpactaTaps are recommended for through hole applications only.	7. 	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2. 	Pilot drill the exact tapping size hole for best results.	8. 	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
3. 	Select the correct torque power for impact wrench/drivers using the data range above. If exact match is not available, select the closest torque setting Above the recommendation.	9. 	Flame cut/punched 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.
4. 	Apply firm, steady feed pressure throughout the cut.	10. 	Tap the hole in one pass where possible, applying adequate lubrication before you start.
5. 	Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage.	11. 	If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing.
6. 	When using cordless tools, consider that the torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 3.	12. 	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the existing thread by hand before driving it through at the correct torque range.













Foot Pound (Ft Lbs)
Impact Torque

											
Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque 1/4\" Thick Steel	Impact Tapping Torque 1/2\" Thick Steel	Impact Tapping Torque 1\" Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque	Ft Lbs Torque
1/4	485	405	325	1455	650	1295	810	855	105	175	295
5/16	365	310	245	1095	485	970	610	650	110	205	330
3/8	295	245	195	870	390	780	485	510	125	220	355
1/2	240	200	162	730	330	645	410	430	135	235	375
5/8	185	155	125	550	243	485	310	330	145	365	425
3/4	145	125	100	440	194	385	245	260	230	295	470
7/8	130	115	92	410	180	355	225	240	N/A	370	710
1"	120	100	85	370	165	325	210	225	N/A	445	735

*GUIDELINE PARAMETERS ONLY.










Actual parameters may vary depending on operating conditions

Best Practice Advice

1. 	ImpactaTaps are recommended for through hole applications only.	7. 	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2. 	Pilot drill the exact tapping size hole for best results.	8. 	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
3. 	Select the correct torque power for impact wrench/drivers using the data range above. If exact match is not available, select the closest torque setting Above the recommendation.	9. 	Flame cut/punched 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.
4. 	Apply firm, steady feed pressure throughout the cut.	10. 	Tap the hole in one pass where possible, applying adequate lubrication before you start.
5. 	Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage.	11. 	If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing.
6. 	When using cordless tools, consider that the torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 3.	12. 	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the existing thread by hand before driving it through at the correct torque range.















Foot Pound (Ft Lbs)
Impact Torque

										
Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque 12mm Thick Steel	Impact Tapping Torque 25mm Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque
M3	960	809	650	2700	1295	2550	1620	1700	118	N/A
M4	730	610	490	2060	975	1950	1220	1285	132	N/A
M5	585	485	385	1750	780	1555	970	1020	147	N/A
M6	485	405	325	1455	650	1295	810	855	177	N/A
M8	365	310	245	1095	485	970	610	650	206	N/A
M10	295	245	195	870	390	780	485	510	221	N/A
M12	240	200	162	730	330	645	410	430	236	377
M14	210	175	140	625	275	560	350	370	250	401
M16	185	155	125	550	243	485	310	330	265	425
M20	145	125	100	440	194	385	245	260	295	472
M24	120	100	85	370	165	325	210	225	442	708
M27	105	90	75	330	145	290	180	190	545	873

Best Practice Advice









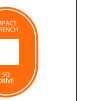
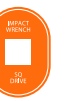
*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

	Impact Taps are recommended for through hole applications only.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Pilot drill the exact tapping size hole for best results.		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Select correct NM torque power for impact wrench applications.		Flame cut/punched 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.
	Apply firm, steady feed pressure throughout the cut.		Tap the hole in one pass where possible, applying adequate lubrication before you start.
	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.		301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench.
	When tapping material thicker than 15-20mm, to speed up the process it is advisable to pilot drill the hole first, before drill-tapping the hole.		301130- Heavy Duty Drill Taps are designed for use with Magnetic Drills/Pillar Drills, or for tapping pre-drilled holes with an impact wrench. They are not designed for drill-tapping with hand-held rotary tools.















Foot Pound (Ft Lbs)
Impact Torque

										
Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque 1/2" Thick Steel	Impact Tapping Torque 1" Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque
M3	960	809	650	2700	1295	2550	1620	1700	120	N/A
M4	730	610	490	2060	975	1950	1220	1285	130	N/A
M5	585	485	385	1750	780	1555	970	1020	145	N/A
1/4	485	405	325	1455	650	1295	810	855	175	295
5/16	365	310	245	1095	485	970	610	650	205	330
3/8	295	245	195	870	390	780	485	510	220	355
1/2	240	200	162	730	330	645	410	430	235	375
5/8	185	155	125	550	243	485	310	330	365	425
3/4	145	125	100	440	194	385	245	260	295	470
7/8	130	115	92	410	180	355	225	240	370	710
1"	120	100	85	370	165	325	210	225	445	735

*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

Best Practice Advice

	Impact Taps are recommended for through hole applications only.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Pilot drill the exact tapping size hole for best results.		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Select correct NM torque power for impact wrench applications.		Flame cut/punched 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.
	Apply firm, steady feed pressure throughout the cut.		Tap the hole in one pass where possible, applying adequate lubrication before you start.
	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.		301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench.
	When tapping material thicker than 15-20mm, to speed up the process it is advisable to pilot drill the hole first, before drill-tapping the hole.		301130- Heavy Duty Drill Taps are designed for use with Magnetic Drills/Pillar Drills, or for tapping pre-drilled holes with an impact wrench. They are not designed for drill-tapping with hand-held rotary tools.











Foot Pound (Ft Lbs)
Impact Torque

									
Reamer Diameter	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque
8mm	940	540	410	1020	550	1020	1320	147	280
10mm	900	510	380	1005	530	1005	1300	162	295
12MM	875	490	370	995	520	980	1275	206	309
14MM	690	360	305	700	450	695	1025	236	354
16MM	640	335	225	660	340	600	975	250	367
18MM	535	290	210	550	305	545	860	265	398
20MM	490	230	195	510	250	470	745	280	420
21mm	480	225	190	500	240	460	730	287	427
22MM	460	210	180	470	235	445	675	295	442
24MM	360	150	140	430	215	395	540	383	575
26MM	310	140	135	375	200	330	410	400	620
28MM	295	130	125	340	190	285	385	442	663
30MM	275	120	110	290	180	260	340	479	719
32MM	250	110	100	275	170	220	315	501	752
33MM	240	105	95	270	165	215	310	512	763
36MM	215	95	80	255	150	200	295	545	803
39MM	195	80	65	240	135	185	280	664	848

Best Practice Advice










*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.		Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation the hole can be reamed out with a slow speed Magnetic Drill with a ImpactaMag or VersaDrive reamer.
	To maximize tool life, do not attempt to increase the existing hole diameter beyond 2 to 3mm. If a larger, finished hole size is required, then the next size reamer should be used to 'step up' until the finished hole diameter is reached.		Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
	Avoid lateral movement or tilting which can cause damage to the tool.		Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when using a Magnetic Drill.
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		Regularly check that Magnetic Drill slides, handles, arbors and movable parts have not vibrated loose over time.











Foot Pound (Ft Lbs)
Impact Torque

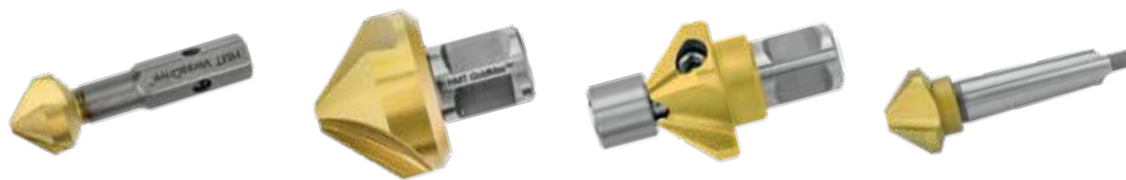
									
Reamer Diameter	Structural Steel <500Nm 32m/min	Structural Steel <1000Nm 18m/min	Stainless Steel INOX 12m/min	Brass 32m/min	Cast Iron 16m/min	Plastics 30m/min	Aluminium 45m/min	Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque
1/2"	875	490	370	995	520	980	1275	205	310
9/16"	690	360	305	700	450	695	1025	235	355
5/8"	640	335	225	660	340	600	975	250	375
11/16"	535	290	210	550	305	545	860	265	400
3/4"	490	230	195	510	250	470	745	280	420
7/8"	460	210	180	470	235	445	675	295	440
15/16"	360	150	140	430	215	395	540	380	575
1"	310	140	135	375	200	330	410	390	620
1-1/16"	295	130	125	340	190	285	385	440	660






*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

Best Practice Advice

	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.		Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation the hole can be reamed out with a slow speed Magnetic Drill with a ImpactaMag or VersaDrive reamer.
	To maximize tool life, do not attempt to increase the existing hole diameter beyond 2 to 3mm. If a larger, finished hole size is required, then the next size reamer should be used to 'step up' until the finished hole diameter is reached.		Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
	Avoid lateral movement or tilting which can cause damage to the tool.		Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when using a Magnetic Drill.
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		Regularly check that Magnetic Drill slides, handles, arbors and movable parts have not vibrated loose over time.












						
Countersink Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
6.3 mm	765	505	265	1250	500	850
8.3 mm	565	375	190	955	405	705
10.4 mm	460	300	145	765	315	530
12.4 mm	385	255	110	635	265	480
16.5 mm	295	185	80	485	210	345
20.5 mm	230	155	50	385	165	280
25 mm	185	130	50	315	130	225
30 mm	155	105	35	265	105	185
40 mm	120	80	30	205	80	140
55 mm	95	60	25	145	70	120
63 mm	80	55	20	130	55	90
80 mm	65	40	20	100	45	75







Best Practice Advice

*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.		Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when using a Magnetic Drill.
	Apply firm, steady feed pressure throughout the cut.		Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
	Avoid lateral movement or tilting which can cause damage to the tool.		Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use at correct RPM (if unsure use tachometer to check drill speed)
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant		












						
Countersink Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Plastics
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
12.4 mm	385	255	110	635	265	480
16.5 mm	295	185	80	485	210	345
20.5 mm	230	155	50	385	165	280
25 mm	185	130	50	315	130	225
31 mm	155	105	35	265	105	185












*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

Best Practice Advice

	The DrillSink should be used with a Variable speed motor, and the drill and countersink operations should be run at the appropriate speed for each process		Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when using a Magnetic Drill.
	Apply firm, steady feed pressure throughout the cut		Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
	Avoid lateral movement or tilting which can cause damage to the tool		Best countersinking results are achieved using a variable speed drill that allows the correct speed to be set. Use at correct RPM (if unsure use tachometer to check drill speed)
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant		Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage













											
Holesaw Diameter	Structural Steel <500Nm Based on mm/R Feed of 0.10	Structural Steel <1000Nm Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Aluminium	Cast Iron (Grey)	Brass	Copper	Fibreglass	Composite	Plastics	Wood
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
13-17MM	1350-850	840-585	500-360	2210-1575	900-625	1245-890	900-640	780-705	1350-850	900-640	1495-1010
18-25MM	850-625	580-420	350-250	1575-1125	600-455	865-640	620-450	700-520	850-625	620-450	990-895
26-31MM	620-500	415-325	240-195	1080-885	435-345	630-510	440-345	500-405	620-500	440-345	895-850
32-39MM	480-410	320-275	195-160	875-740	330-285	500-415	345-280	400-330	480-410	345-280	850-740
40-46MM	390-340	270-220	160-145	730-620	285-240	410-350	175-235	315-275	390-340	175-235	740-610
47-53MM	335-300	220-180	140-120	615-545	235-215	345-305	235-215	275-245	335-300	235-215	600-505
54-60MM	295-260	180-165	115-100	525-485	210-180	300-270	210-185	240-215	295-260	210-185	500-460
61-70MM	260-225	165-155	100-90	475-415	180-160	265-235	180-160	205-185	260-225	180-160	455-400
71-80MM	220-195	155-140	90-75	410-365	155-140	230-205	155-140	180-160	220-195	155-140	395-360

Best Practice Advice

*GUIDELINE PARAMETERS ONLY.

Actual parameters may vary depending on operating conditions

	Centre punch or pilot drill the surface for accurate hole start.		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.
	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.		When using a Magnetic Drill, regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time.
	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.		Ensure a debris-free surface of sufficient steel thickness for strong magnet hold when using a Magnetic Drill.
	Avoid lateral movement or tilting which can cause damage to the tool		For drilling holes in steel thicker than 25mm, it is recommended to ventilate the hole frequently to clear the swarf.
	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.		For thicker materials, pre-drill 6.35mm pilot drill first and use then sprung pilot drill or pilot pin as a guide.

FEIN Canada guarantees that VersaDrive products are free of manufacturers defects. However, in certain cases, a problem may arise. In order to determine whether this is a warranty or wear and tear situation, we require that you follow these steps:

1. Complete the information sheet below in full, all questions must be answered.
2. Submit it to FEIN Canada by email to fein@fein.ca or by fax to 905-890-1866.

VersaDrive Product Warranty Request

Date reported:

Company	
Contact name	
Contact Email	
Contact telephone #	
Product part number	
Product description	
Date purchased	
Dealer purchased from	
Power tool or machine used	
Type of material (if known)	
Number of holes before failure	
Diameter of hole	
Thickness of steel	
RPM speed or Nm torque (if known)	
Lubricant used	
Customer comments	

Submit pictures of application / Failed tool



VersaDrive accessories are compatible with:

FEIN cordless drill-drivers ASCM, ABS, ASB
FEIN cordless impact wrenches ASCD
FEIN cordless hammer drill ABH
FEIN cordless / corded hand drills ABOP, BOP
FEIN hand-held core drill KBH
All Slugger by FEIN core drills



Other manufacturers

FEIN cordless drill-drivers: unbeatable in metal!

Better drilling, tapping, screwdriving and fastening that you can feel. FEIN cordless drill/drivers impress from the first moment you work with them. What really counts is the results. Metalworking professionals can tell the difference immediately. The extremely powerful FEIN cordless drill/driver product range offers the highest quality, durability and uncompromising performance that proves itself in your work day after day.



Core drilling as never before; always and everywhere.

With more precision, speed and ease of use than ever before, Slugger by FEIN core drills deliver the best results in the shortest time. Since they don't require pre-drilling or retooling, they offer rapid work performance and reduce effort to a minimum. All this saves time, energy and money. Combine Slugger core drills with our range of cutters and accessories to create a core drilling system that can meet the challenge of any application.

**AUTOMATIC
UNIVERSAL
COMPACT
ENDURANCE
MOBILE**



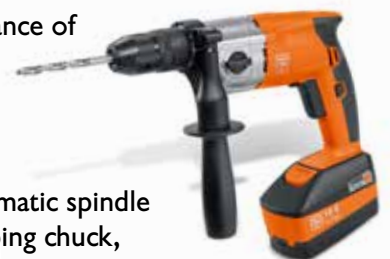
FEIN hand drills feature a powerful barrel design, metal gear heads and fast-acting keyless 3-jaw chucks.

Corded BOP

FEIN high performance motor with excellent speed stability for steady drilling. Mechanical two-speed gearbox with optimum speed adjustment for a wide range of uses. BOP 10-2 two-speed model with 3/8" capacity and ideal speed ranges for steel and stainless steel.

**Cordless ABOP**

Battery power and performance of a corded tool with excellent speed stability for metal construction. High quality with high concentricity for precise drilling results. Automatic spindle lock, single-shell rapid-clamping chuck, and metal gear head.





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