

**Recommended Operating Speeds for Hole Saws and Cutters.** These guidelines are provided by Disston Company as information on the generally recommended operating speeds for hole saws and cutters. Disston Company recommends that users always follow the specific recommendations of the hole saw manufacturer concerning hole saw and cutter use and operating speeds.

**Recommended Bi-Metal Hole Saw Operating Speeds (RPM Table)**

inches	mm	Length (ft)	Mild Steel	Tool Steel & Stainless	Cast Iron	Brass	Aluminum	Wood
9/16	14	0.147	580	300	400	790	900	3000
5/8	16	0.164	550	275	365	730	825	3000
11/16	17	0.180	500	250	330	665	750	3000
3/4	19	0.196	460	230	300	600	690	3000
-	20	0.213	440	220	290	580	660	3000
7/8	22	0.229	390	195	260	520	585	3000
1	25	0.262	350	175	235	470	525	2700
1 1/16	27	0.278	325	160	215	435	480	2700
1 1/8	29	0.295	300	150	200	400	450	2700
1 3/16	30	0.311	285	145	190	380	425	2400
1 1/4	32	0.327	275	140	180	360	410	2400
1 5/16	33	0.344	260	135	175	345	390	2400
1 3/8	35	0.360	250	125	165	330	375	2400
1 7/16	37	0.376	240	120	160	315	360	2400
1 1/2	38	0.393	230	115	150	300	345	2400
1 9/16	40	0.409	220	110	145	290	330	2100
1 5/8	41	0.425	210	105	140	280	315	2100
1 11/16	43	0.442	205	100	135	270	305	2100
1 3/4	44	0.458	195	95	130	260	295	2100
1 13/16	46	0.475	190	95	125	250	285	2100
1 7/8	48	0.491	180	90	120	240	270	2100
2	51	0.524	170	85	115	230	255	2000
2 1/16	52	0.540	165	80	110	220	245	2000
2 1/8	54	0.556	160	80	105	210	240	2000
2 1/4	57	0.589	150	75	100	200	225	2000
2 5/16	59	0.605	145	75	95	195	225	2000
2 3/8	60	0.622	140	70	90	190	220	2000
2 1/2	64	0.655	135	65	85	180	205	1850
2 9/16	65	0.671	130	65	85	175	200	1850
2 5/8	67	0.687	130	65	85	170	195	1800
-	68	0.704	130	65	80	170	190	1800
2 3/4	70	0.720	125	60	80	160	185	1800
2 7/8	73	0.753	120	60	75	160	180	1800
3	76	0.785	115	55	70	150	170	1800
3 1/8	79	0.818	110	55	70	140	165	1500
3 1/4	83	0.851	105	50	65	140	155	1500
3 3/8	86	0.884	100	50	65	130	150	1500
3 1/2	89	0.916	95	45	60	130	145	1200
3 5/8	92	0.949	90	45	60	120	140	1200
3 3/4	95	0.982	90	45	60	120	135	1200
3 7/8	98	1.014	90	45	60	120	135	1200
4	102	1.047	85	40	55	110	130	1000
4 1/8	104	1.080	80	40	55	110	120	1000
4 1/4	108	1.113	80	40	55	110	120	900
4 3/8	111	1.145	80	40	50	100	120	900
4 1/2	114	1.178	75	35	50	100	105	900
4 3/4	121	1.244	75	35	50	92	95	900
5	127	1.309	65	30	45	90	90	800
5 1/2	140	1.440	60	25	40	85	85	800
5 3/4	146	1.505	55	25	35	75	75	800
6	152	1.571	55	25	35	75	75	800

Lead times may vary. Please contact your Sales Representative for more information.

**Blu-Mol® TCT Cutter Operating Speeds (RPM Table)**

DIAMETER		MATERIAL	
inches	mm	Steel	Stainless Steel
11/16 to 13/16	18mm to 21mm	700-1000	300-700
7/8 to 1-3/16	22mm to 30mm	500-800	200-450
1-1/4 to 1-9/16	31mm to 40mm	300-600	175-315
1-5/8 to 2	41mm to 50mm	200-500	120-225
2-1/16 to 2-3/8	51mm to 60mm	200-400	95-195
2-7/16 to 3	61mm to 76mm	150-300	80-150

**RemGrit® Hole Saw Operating Speeds (RPM Table)**

inches	mm	Brick Ceramic	Slate	Reinforced Plastics	Fiberglass
5/8	16	620	1540	2140	920
3/4	19	510	1280	1790	770
-	20	470	1180	1660	715
7/8	22	430	1090	1530	660
1	25	380	960	1340	580
1 1/8	29	340	850	1190	510
1 1/4	32	310	770	1070	460
1 3/8	35	280	700	980	420
1 1/2	38	260	640	890	390
1 3/4	44	220	550	770	330
1 7/8	48	200	510	720	310
2	51	190	480	670	290
2 1/8	54	180	450	630	280
2 1/4	57	170	430	600	270
2 3/8	60	160	400	570	250
2 1/2	64	150	380	540	230
2 3/4	70	140	350	500	210
3	76	130	320	450	190
3 1/4	83	120	295	415	180
3 3/8	86	115	285	400	175
3 3/4	95	102	255	350	160
4	102	95	240	330	150
4 1/2	114	82	215	290	125

**Metal Cutting Safety (read this before using products)**

Modern metal cutting operations involve high energy, high spindle or cutter speeds, and high temperatures and cutting forces. Hot, flying chips may be projected from the workpiece during metal cutting. Although advanced cutting tool materials are designed and manufactured to withstand the high cutting forces and temperatures that normally occur in these operations, they are susceptible to fragmenting in service, particularly if they are subjected to over-stress, severe impact or otherwise abused. Therefore, precautions should be taken to adequately protect workers, observers and equipment against hot, flying chips, fragmented cutting tools, broken workpieces or other similar projectiles. Machines should be fully guarded and personal protective equipment should be used at all times.

Disston has no control over the end use of its products or the environment into which those products are placed. Disston urges that its customers adhere to the recommended standards of use of their metal cutting operations. The information included throughout this catalog under the heading "Technical Data" and other recommendations on machining practices referred to herein are only advisory in nature and do not constitute representations or warranties and are not necessarily appropriate for any particular work environment or application.