HOLEMAKER-TECHNOLOGY.COM

HMT

Cutting Tool Innovation

Speed up Metalworking

Edition 10: 2021

UNPRICED

JOIN THE REVOLUTION

VERSADRIVE®
PATENT PROTECTED

New V35 compact machine added to VersaDrive Magnet Drill range

UK Built

ImpactaStep Cutter

Weldon shank countersinks

VersaDrive Cutting Tools

VersaDrive Magnetic Drills

CarbideMax Broach Cutters

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HMT

Cutting Tool Innovation

Speed up Metalworking

OUR STORY

The background to the forming of Holemaker Technology was in a small family-run welding & engineering supplies business, where we worked with engineering contractors & steel erectors in the South of England.

Over the years we received a stream of requests for specialist metal drilling tools to overcome problems with a challenging project. We would hunt high & low to try and help our customers out, but frequently find that the products needed were just not available. We realised this was a constant and ongoing challenge for metalworkers.

Drilling or modifying the connection holes that hold steel components together when limited only to the use of portable or hand-held tools seemed to us to be the biggest pain point in the industry, often contributing to missed deadlines and painful project over-runs caused by changes to specification or drawings, fabrication errors or even emergency repairs.

By 2014 we realised the time had come to make a difference. We put everything on the line to start a new company dedicated to filling this gap in the market, with one aim: To speed up metalworking through cutting tool innovation.

Combining our pioneering, impact rated and now patented VersaDrive system with the latest generation of high-torque cordless power tools has created a revolutionary level of drilling speed & performance, never before possible with portable tools.

After 7 years, around 400,000 tools, and one patent, our products are now sold widely through distributors in over 42 countries. There is a long way still to go and we invite you to join our journey and help us continue to improve and speed up metalworking.

Regards
Piers Crane & Hugh Crane - Co-Founders

WHAT WE DO

Holemaker Technology is a specialist manufacturer of cutting and drilling products

We believe in cutting tool innovation to speed up metalworking.

We believe that Construction creates, connects, and improves the world we live in.

Creating & maintaining steel structures and components needs specialist skills and tooling.

Portable Cutting & Drilling tools is our specialist area, where you have to take the tools to the job to create and modify the connection holes which hold our world together.

A relentless investment focus on product innovation and improvement provides the metalwork and fabrication industries with a new and unique range of tooling to speed up any task that involves working with connection holes.

OUR MISSION & VALUES

HMT MISSION

To speed up metalworking through cutting tool innovation

HMT VISION

To be the leading brand of fabricator's cutting tools

THE 5 HMT VALUES

Innovate, Specialise, Optimise, Be Agile and Be Nice

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HMT

WORKING WITH US

We want every experience that you have with HMT to be effortless and enjoyable. Here's the 4 pillars we constantly work on and improve to deliver this.

TEAM

A hand picked team full of energy and enthusiasm, with industry experience drawn from market leading industrial brands.

PRODUCTS

The motto here is - if the products are right, then the success will follow. A relentless focus on quality control and Patent-protected innovation means that each HMT product is created to be a market leader in its own right.

SERVICE

With a stock holding of more than £1M we have over 95% stock availability on catalogue items meaning orders placed by 3PM will be shipped to you the same day. Your order will be processed & confirmed within 2 hours and courier tracking will be emailed on dispatch of goods. Barcoded warehousing technology ensures total picking accuracy.

SUPPORT

One of our core values is "Optimise", and this means helping users get the best out of their HMT tooling, with training, demonstrations and site visits in addition to data sheets and training videos. Over 250 dealers make the products available throughout 45 countries.

VERSADRIVE©
PATENT PROTECTED

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VersaDrive ImpactaStep p14
VersaDrive Step Drills p16
VersaDrive Reamers p18

VersaDrive TurboTips p20
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VersaDrive UNC, BSP & BSW ImpactaTaps p26

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VersaDrive HoleCutters p38
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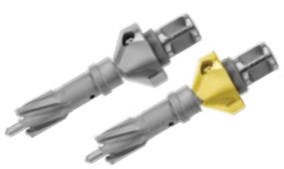

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

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V60T & V85T Magnet Drills p50
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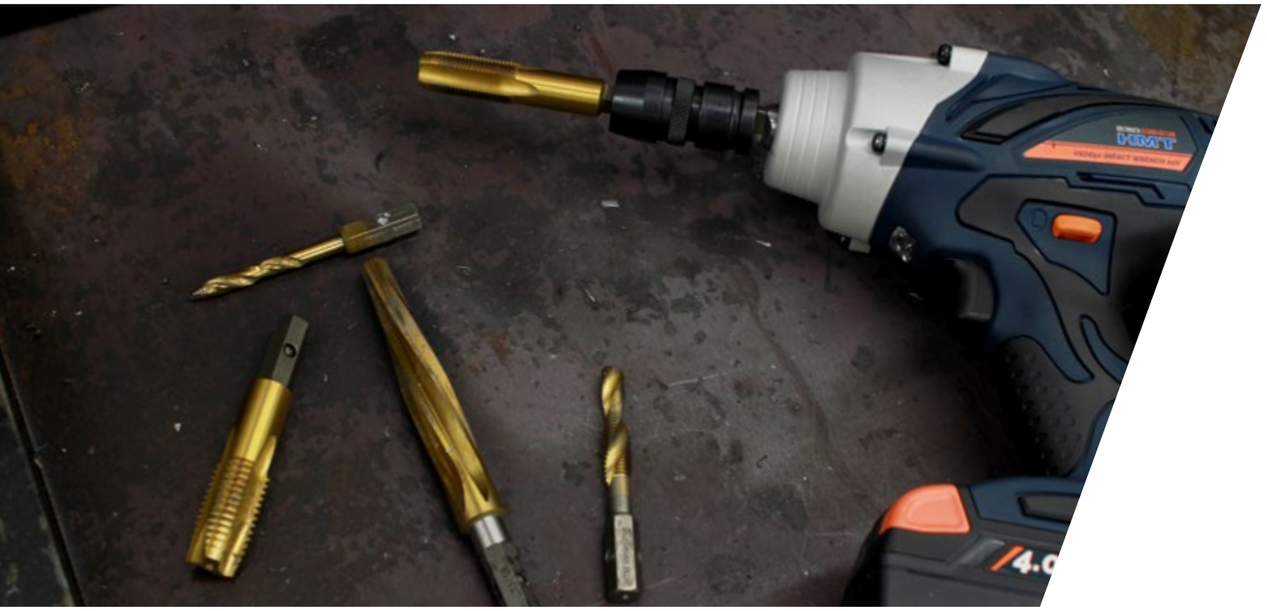


VERSADRIVE©

PATENT PROTECTED

VersaDrive by Holemaker Technology is the 1st modular cutting system in the world that allows cutting tools to be used across Impact Wrenches/Drivers as well as Rotary drills like Magnet drills, Hand-Held drills and Pillar drills.

This innovative system features a range of Impact rated and Rotary rated cutting tools as well as a collection of specially designed and custom engineered adapters to rapidly fit cutting tool to power tool, with fast tool changeover.

Tools in the range have also been specifically designed and developed to outperform and outlast the closest comparable products. With faster cuts, longer life and more holes per product VersaDrive tools save time, money & increase productivity.

The world's 1st modular quick-change cutting & drilling system for use with both Impact and Rotary tools

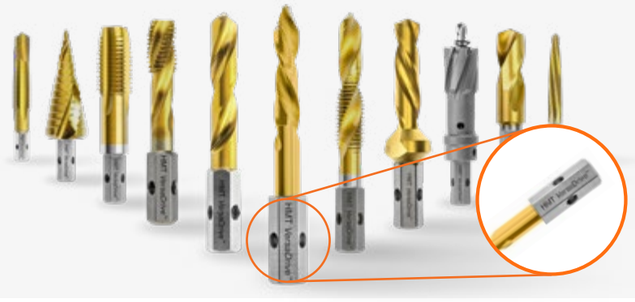
ROTARY RATED

WHY ROTARY?

For slow speed applications like heavy duty tapping, countersinking or broaching with a holesaw optimum performance can be achieved by cutting with the tip and flutes of the tool.

Our rotary rated range of tools have been designed to do just this and provide excellent cutting performance whilst outlasting any comparable tool on the market.

DRILL CHUCKS | SDS+ ADAPTER | RAPID-LOCK EXTENSION | EXTENSION ARBORS | RAPID-LOCK MAGNET DRILL ADAPTER | MORSE TAPER ADAPTERS



The VersaDrive Patent Protected Shank System

VersaDrive Patent-Protected Hex 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 adapters to optimise metalworking processes and increase the tools working life.

IMPACT RATED

WHY IMPACT?

For high speed applications like drilling, reaming and tapping VersaDrive's range of Impact Rated tools and adapters offer precision performance alongside the speed, safety and controlled power offered by Impact drivers and wrenches.

Phenomenal cutting performance is achieved through the design of the tool, cutting with the double hardened edges of the cutting face rather than the tip.

RAPID-LOCK 1/4" IMPACT DRIVER ADAPTER | RAPID-LOCK 1/2" IMPACT WRENCH ADAPTER | HEAVY DUTY IMPACT WRENCH ADAPTER | 3/4" HEAVY DUTY IMPACT WRENCH ADAPTER

Features & Benefits

- *Up to 10x longer life*
- *Up to 15x faster than standard everyday methods*
- *Quick-change, Rapid-Lock adapters*
- *Dual hardened for Impact use*
- *High-Grade tool steel*
- *Non-Slip Hex shank fits all standard 1/2" drill chucks*
- *Safer working - minimal kickback*
- *Precision ground for accurate, clean holes*
- *GoldMax low-friction titanium coating to stop burn-out*

VERSADRIVE©
PATENT PROTECTED

VersaDrive 1/4" Rapid-Lock Impact Driver Adapter

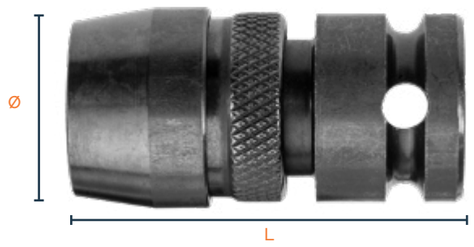
Part No	Drive Size	Ø mm	L mm
111026-014A	**1/4" Hex**	28	75

Adapter Benefits

This upgraded VersaDrive Impact Driver adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/4" Hex Impact Drivers.
- Converts standard 1/4" Impact Drivers for use with VersaDrive

VersaDrive 1/2" Rapid-Lock Impact Wrench Adapter



Part No	Drive Size	Ø mm	L mm
111130-012A	**1/2" Drive**	28	55

Adapter Benefits

Rated to 650nm
Supplied with retention pin & ring

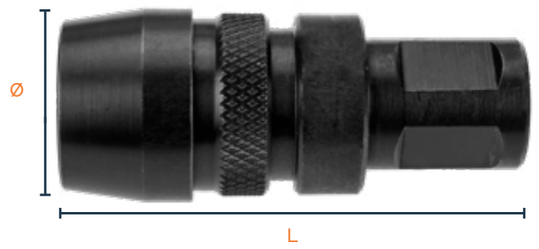
This upgraded VersaDrive Impact Wrench adapter features:

- New Rapid-Lock, single handed loading action
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Increased strength for withstanding the drive forces from the latest generation of high torque 1/2" Impact Wrenches
- Converts standard 1/2" Impact Wrenches for use with VersaDrive

Find a stockist at www.holemaker-technology.com

VERSADRIVE©
PATENT PROTECTED

VersaDrive Rapid-Lock Weldon Adapter



Part No	Shank Size	Ø mm	L mm
111035-01	**19.05mm / 3/4"**	28	66

Adapter Benefits

This upgraded VersaDrive Magnet Drill adapter features:

- New Rapid-Lock, single handed loading
- Improved Quick Release collar mechanism preventing accidental tool release caused by vibrations or contact with the workpiece
- Fits to all standard magnet drills with 19mm (3/4") Weldon magnet drill shank

NEW

VersaDrive Heavy Duty Impact Wrench Adapter

Part No	Drive Size	Ø mm	L mm
111120-012A	**1/2" Drive**	25	55
111120-034A	**3/4" Drive**	38	60

Adapter Benefits

- Impact hardened Manganese Phosphate adapter
- Heavy Duty Pull-Forward Release mechanism with hardened steel collar
- Developed to work with latest generation of high torque cordless impact wrenches capable of generating above 1,000Nm of Torque

For Sales & Technical Support Call Now: +44 1622 522102

VERSADRIVE© PATENT PROTECTED

VersaDrive Rapid-Lock SDS+ Adapter

Part No	Ø mm	L mm
112010-01	28	140

Adapter Benefits

This upgraded SDS+ VersaDrive adapter features:

- New Rapid-Lock, single handed loading action
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- Converts all standard SDS+ Rotary Hammer Drills for use with VersaDrive system (In rotary mode)

VersaDrive Extension Arbor - 300mm

Part No	Ø	L
111010-0002	23mm	300mm

Adapter Benefits

- Join multiple extensions for extra length.
- Will pass through holes larger than 23mm
- Not rated for impact wrench use

VERSADRIVE© PATENT PROTECTED NEW

VersaDrive Rapid-Lock Extension Arbor - 130mm

Part No	Shank Size	Ø mm	L mm
111015-130	11mm	28	130mm

Adapter Benefits

- Extends the working reach of all VersaDrive tools
- Rapid-Lock, single handed loading action and can also be used in combination with other Versadrive adapters
- Hex shank for non-slip use in any drill chuck
- Improved Quick Release collar that prevents accidental tool release caused by vibrations or contact with the workpiece
- Knurled collar - ultimate grip in greasy or damp conditions
- High quality, Heavy Duty steel components
- For use with VersaDrive system in rotary mode

VersaDrive Morse Taper Arbor

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

Adapter Benefits

- 3x M8 doghead grub screws supplied per adapter
- Ideal for workshop use with radial arm drills & pillar drills

VERSADRIVE© PATENT PROTECTED

VersaDrive ImpactaStep Cutter

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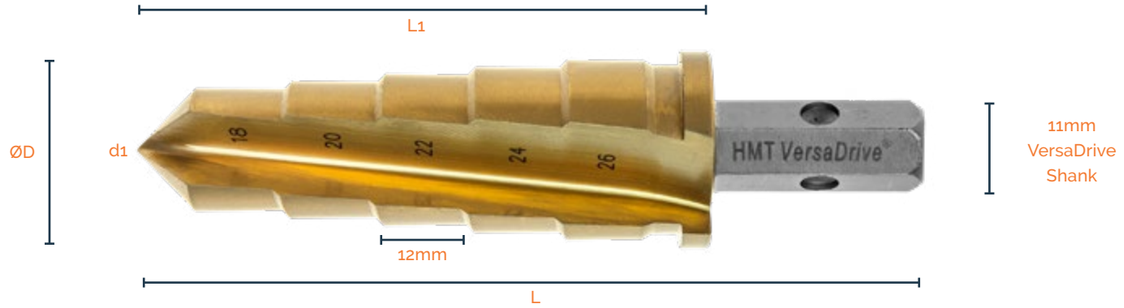
A Versadrive exclusive innovation, the ImpactaStep Cutter offers combined drilling and reaming on materials up to 12mm thick..

Featuring 5 individual cutting diameters and a straight flute design for strength and easy resharpening, the ImpactaStep Cutter is optimised for use with Impact Drivers and Impact Wrenches as well as the latest range of VersaDrive Premium Magnet Drills.

VersaDrive ImpactaStep Cutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *5 drill bits in one*
- *Create & enlarge holes in materials up to 12mm thick*
- *Safety breakthrough collar to prevent injury and damage*
- *Fast, smooth drilling and reaming with minimal kickback*
- *Specially hardened for impact wrench use*
- *GoldMax low-friction titanium coating to stop burn out*
- *High strength, non-slip shank design*



CREATES HOLES IN SECONDS

IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

Impact Driver Adapter
111026-014A
Page 10

Impact Wrench Adapter
111130-012A
Page 10

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 11

SDS+ Adapter
112010-01
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Pilot drilling is recommended for a faster operation and to enhance tool life*
- *When used for reaming, tool should be rotating before starting cut & steady pressure*
- *Refer to the full technical data sheet on Page 84 for more details and RPM information*

VersaDrive ImpactaStep Cutter

	Part No	Ø D mm	d1 mm	l1 mm	L mm	Step Diameters	Step Depth
Metric	506010-0160	16	8	72	107	8 - 10 - 12 - 14 - 16mm	12mm
	506010-0220	22	14	75	110	14 - 16 - 18 - 20 - 22mm	12mm
	506010-0260	26	18	77	112	18 - 20 - 22 - 24 - 26mm	12mm
Inch	506030-0010	9/16"	5/16"	12	4 3/16"	5/16" - 3/8" - 7/16" - 1/2" - 9/16"	12mm
	506030-0020	13/16"	9/16"	12	4 5/16"	9/16" - 5/8" - 11/16" - 3/4" - 13/16"	12mm
	506030-0030	1 1/16"	13/16"	12	4 7/16"	13/16" - 7/8" - 15/16" - 1" - 1 1/16"	12mm

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	○	○	●	●	●
●	○	×	●	●	●
●	×	×	○	●	●
●	○	○	●	●	●
●	○	×	●	●	●
●	×	×	○	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

ImpactaStep Sets

Part No:	Set Contents
506010-SET1	HMT VersaDrive IMPACTASTEP Cutter Set 16, 22, 26mm
506030-SET1	VersaDrive IMPACTASTEP Cutter Set, 9/16, 13/16, 1-1/16"

VERSADRIVE© PATENT PROTECTED

VersaDrive Impact Step Drills

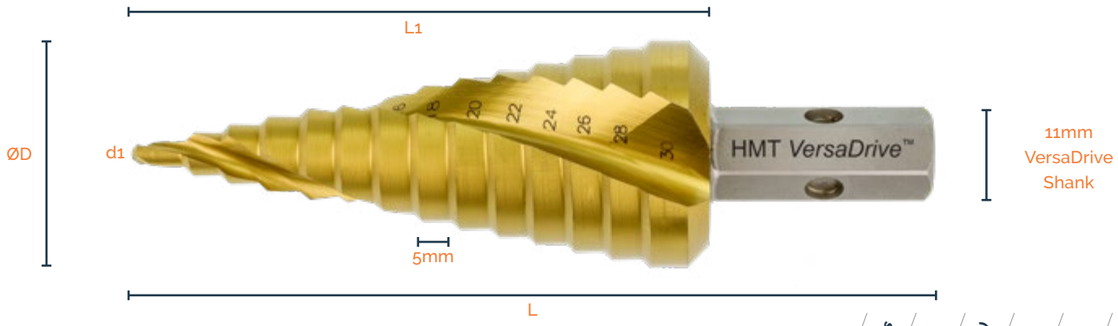
HOLEMAKER-TECHNOLOGY.COM HMT

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.

VersaDrive Step Drills have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *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*
- *118° split point angle for easy starting & accuracy.*
- *GoldMax low-friction titanium coating to stop burn out.*
- *High strength, non-slip shank design.*



CREATES HOLES IN SECONDS

IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

Impact Driver Adapter
111026-014A
Page 10

Impact Wrench Adapter
111130-012A
Page 10

Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Excellent life and performance when used with rotary pistol drills or drill presses*
- *Suitable for stainless and harder materials if used at low RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 85 for more details and RPM information*

VersaDrive Step Drill

	Part No	Ø D	l1	L	Step Diameters	Step Depth
Metric	**505020-0120**	**12mm**	47mm	75mm	4, 6, 8, 10, 12mm	5mm
	505020-0220	**22mm**	58mm	86mm	4, 6, 8, 10, 12, 14, 16, 18, 22mm	5mm
	505020-0300	**30mm**	77mm	105mm	4, 6, 8, 10, 12, 14, 16, 18, 22, 24, 26, 28, 30mm	5mm
	505020-0400	**40mm**	72mm	101mm	6, 8, 10, 12, 16, 20, 25, 29, 32, 36, 40mm	6mm
	Electrical Step Drill 4-32.5mm					
	505040-0320	**32.5mm**	70mm	99mm	4, 6, 8.5, 10.5, 12.5, 14.5, 16, 18.5, 20.5, 23.5, 25, 30.5, 32.5mm	5mm
Inch	**505030-0010**	**1/2"**	1-1/2"	2-43/64	3/16, 1/4, 5/16, 3/8, 7/16, 1/2"	3/16"
	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"	3/16"
	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"	3/16"

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
○	×	○	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Step Drill Sets

Part No:	Set Contents
505020-SET1	3 piece Set: 12, 22, 30mm Step Drills
505020-SET2	4 piece Set: 12, 22, 30, 40mm Step Drills
505030-SET1	3 piece Set: 1/2, 7/8, 1-3/8" Step Drills

VERSADRIVE© PATENT PROTECTED

VersaDrive Impact Reamers

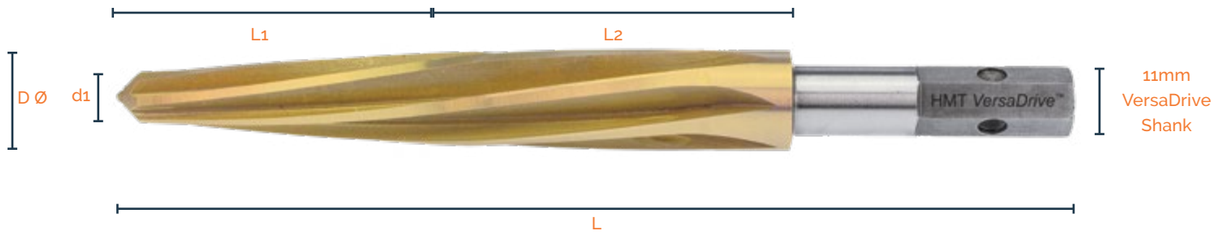
HOLEMAKER-TECHNOLOGY.COM HMT

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 providing ultimate cutting performance with virtually no powertool kickback.

VersaDrive Reamers have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *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*
- *Use on Impact or Rotary*



ENLARGE OR ALIGN EXISTING HOLES WITH AN IMPACT WRENCH

IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

VersaDrive Impact Adapters
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Page 10

Magnet Drill Adapter
111035-01
Page 11

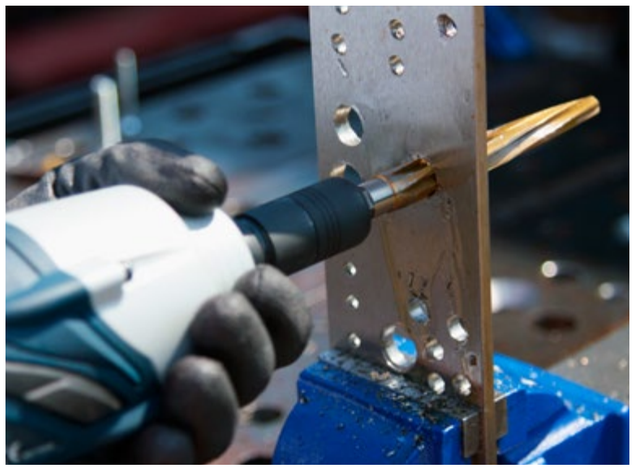
Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Impact driven reamers are not recommended for Flame or Plasma cut holes. Use with a Magnet Drill*
- *Reamer should be rotating before starting the cut & steady feed pressure should be used through the cut*
- *For materials thicker than 20mm use of ImpactaMag reamers is recommended - see page 77*
- *Refer to the full technical data sheet on page 89 for more details and RPM information*



VersaDrive Reamers

	Part No.	D Ø mm	d1 Ø mm	l1 mm	l2 mm	L mm
Metric	501030-0080	8mm	4.4	34	36	108
	501030-0100	10mm	6	34	36	108
	501030-0120	12mm	7.1	43	59	144
	501030-0140	14mm	7.5	52	50	144
	501030-0160	16mm	8.0	58	56	152
	501030-0180	18mm	9.4	58	56	170
	501030-0200	20mm	11.2	61	65	178
	501030-0210	21mm	12.3	61	66	185
	501030-0220	22mm	13.2	61	66	185
	501030-0240	24mm	15.1	63	64	185
	501030-0260	26mm	15.9	61	64	185
Inch	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"

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	●	○	●	●	○
●	●	○	●	●	○
●	●	○	●	●	○
●	●	×	○	●	○
●	●	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	●	●	●	●	○
●	●	●	●	●	○
●	●	×	●	●	○
●	○	×	●	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○
●	○	×	○	●	○

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Reamer Sets

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

VERSADRIVE© PATENT PROTECTED

VersaDrive TurboTip® Drill Bits

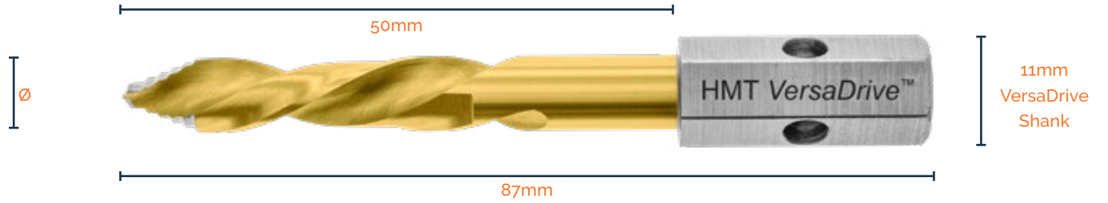
HOLEMAKER-TECHNOLOGY.COM HMT

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.

VersaDrive TurboTip drill bits have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *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*



DRILLS AT 2X THE SPEED WITH NO PILOT DRILLING NEEDED

IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills

CAN ALSO BE USED WITH:

Magnet Drills
SDS+ Adapter
Extension Arbor

ADAPTERS

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 10

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 11

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *For optimum life and accuracy use with pistol drills and magnet drills*
- *Suitable for use on Stainless Steel and harder materials if used at low RPM in rotary tools*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 86 for more details and RPM information*

VersaDrive TurboTips

	Part No.	Ø D mm	Tap Size 308010 ImpactaTap		Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
					Powertool Recommendations (Mild Steel Material)					
Metric	209015-0060	6.0mm			●	●	●	●	●	●
	209015-0068	6.8mm	M8		●	●	●	●	●	●
	209015-0070	7.0mm			●	●	●	●	●	●
	209015-0080	8.0mm			●	●	●	●	●	●
	209015-0085	8.5mm	M10		●	●	●	●	●	●
	209015-0090	9.0mm			●	●	●	●	●	●
	209015-0100	10mm			●	●	●	●	●	●
	209015-0105	10.5mm	M12		●	●	●	●	●	●
	209015-0110	11mm			●	●	●	●	●	●
	209015-0120	12mm	M14		●	●	●	●	●	●
	209015-0130	13mm			●	●	●	●	●	●
	209015-0140	14mm	M16		●	○	●	●	●	●
	209015-0160	16mm			○	×	○	●	●	●
	209015-0180	18mm			○	×	○	○	●	○
	209015-0200	20mm			○	×	○	○	●	○
	209015-0220	22mm			○	×	○	○	●	○
Inch	209016-0010	3/16"	4.8mm		●	●	●	●	●	●
	209016-0020	#7	5.1mm		●	●	●	●	●	●
	209016-0030	7/32"	5.6mm	1/4-20 UNC	●	●	●	●	●	●
	209016-0040	1/4"	6.4mm		●	●	●	●	●	●
	209016-0050	#F	6.6mm	5/16-18 UNC	●	●	●	●	●	●
	209016-0060	9/32"	7.1mm		●	●	●	●	●	●
	209016-0070	5/16"	7.9mm	3/8-16 UNC	●	●	●	●	●	●
	209016-0080	11/32"	8.7mm		●	●	●	●	●	●
	209016-0090	3/8"	9.5mm		●	●	●	●	●	●
	209016-0100	27/64"	10.7mm	1/2-13 UNC	●	●	●	●	●	●
	209016-0120	7/16"	11.1mm		●	●	●	●	●	●
	209016-0130	1/2"	12.7mm		●	●	●	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

TurboTip Drill Bit Sets

Part No	Contents
209015-SET1	4 piece TurboTip Drill Bit Set contains: 6, 8, 10, 12mm
209015-SET2	7 piece TurboTip Drill Bit Set contains: 6, 7, 8, 9, 10, 11, 12mm
209015-SET3	7 piece TurboTip Drill Bit Set contains: 6.8, 8, 8.5, 10, 10.5, 12, 14mm
209015-SET4	7 piece TurboTip Drill Bit Set contains: 6, 8, 10, 12, 14, 18 & 22mm
209016-SET1	TurboTip Impact Drill Bit Set, 3/16, 1/4, 5/16, 1/2"
209016-SET2	TurboTip Tapping Size Impact Drill Bit Set, #7, F, 5/16, 27/64

Find a stockist at www.holemaker-technology.com

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VERSADRIVE© PATENT PROTECTED

VersaDrive Cobalt Drill Bits

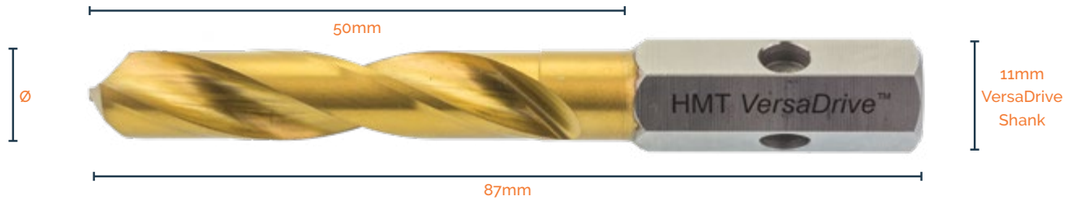
HOLEMAKER-TECHNOLOGY.COM HMT

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.

VersaDrive Drill Bits have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *Fast drilling with minimal kickback*
- *Dual hardened for impact wrench use up to 10mm*
- *Precision Ground Flutes with easy 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*



HEAVY DUTY COBALT DRILL BITS

ROTARY RATED

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
MultiSink

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers (4.2 - 10.5mm)
SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
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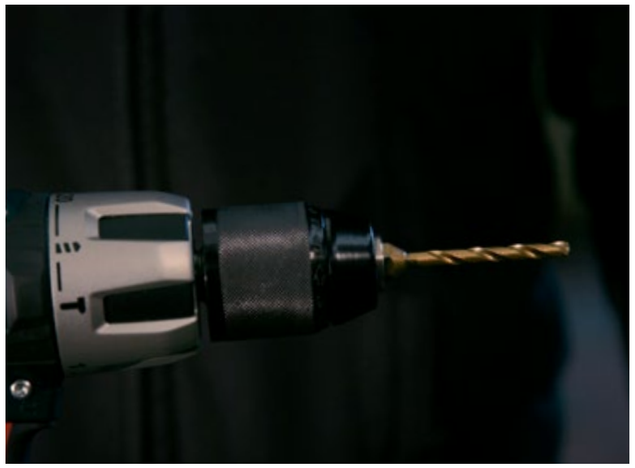
VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 10

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Up to 10mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 86 for more details and RPM information*



VersaDrive Cobalt Drill Bits

	Part No	Ø D mm	Tap Size (Metric Coarse)	Length in Magnet Drill Adapter
Metric	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
	209010-0115	11.5mm	-	98mm
	209010-0120	12mm	M14	98mm
	209010-0125	12.5mm	-	98mm
	209010-0130	13mm	-	98mm
	209010-0140	14mm	M16	98mm
	209010-0160	16mm	-	98mm
	209010-0180	18mm	-	98mm
	209010-0200	20mm	-	98mm
	209010-0210	21mm	M24	98mm
	209010-0220	22mm	-	98mm

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
○	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	○
×	×	○	●	●	○
×	×	○	●	●	○
×	×	○	●	●	○

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

VersaDrive Drill Bit Sets

Part No	Contents
209010-SET1	4 piece VersaDrive Drill Bit Set contains: 6.0, 8.0, 10.0, 12.0mm
209010-SET2	4 Piece VersaDrive Drill Bit Set contains: 5.0, 6.8, 8.5, 10.2mm
209010-SET3	7 piece VersaDrive Drill Bit Set contains: 5.0, 6.0, 6.8, 8.0, 8.5, 10, 10.2mm
209010-SET4	7 Piece VersaDrive Drill Bit Set contains: 12, 13, 14, 16, 18, 20, 22mm

VERSADRIVE© PATENT PROTECTED

VersaDrive ImpactaTaps®

HOLEMAKER-TECHNOLOGY.COM HMT

VersaDrive ImpactaTaps are the first and only 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 - the dual hardening process with Titanium coating provides a fantastic solution for tapping holes in steel.

VersaDrive ImpactaTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills (up to M10) or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills. They can even be used by hand in a socket wrench.

- *Ground Flutes create the perfect tapped 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*
- *Wide range of sizes*

15X FASTER THAN HAND TAPPING

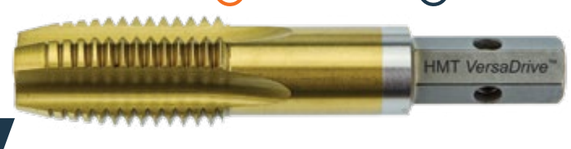
IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Magnet Drills

CAN ALSO BE USED WITH:

Extension Arbor



ADAPTERS

Impact Driver Adapter
111026-014A
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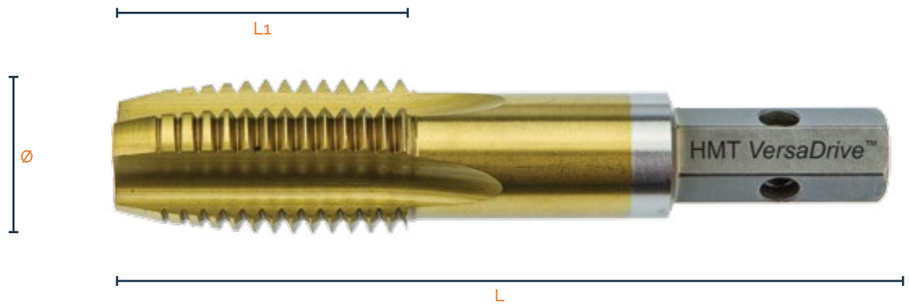
Impact Wrench Adapter
111130-012A
Page 10

Magnet Drill Adapter
111035-01
Page 11

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers*
- *Check the minimum torque requirement*
- *Tapping Stainless Steel requires higher impact torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 87 for more details and RPM information*



VersaDrive ImpactaTaps - Metric Coarse

	Part No	M Thread Size & Pitch	L mm	l1 mm	Shank mm	Tap Hole Size (Metric Coarse thread)
Metric	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
	308010-0180	M18 x 2.50	100	37	11.0	15.5mm
	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

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
●	●	×	●	●	●
●	●	×	●	●	●
●	●	×	●	●	●
●	●	×	○	●	●
●	●	×	○	●	●
●	○	×	×	●	●
●	○	×	×	●	●
●	×	×	×	●	●
●	×	×	×	●	●
●	×	×	×	●	●
●	×	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Impactatap® Sets

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

Impactatap® & TurboTip Set

Part No	Contents
328015-SET1	TurboTip Drill Bit, 6.8, 8.5, 10.5, 14mm & ImpactaTaps, M8, M10, M12, M16 c.w 1/2" Impact Adapter

VERSADRIVE© PATENT PROTECTED

ImpactaTaps® UNC Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size mm	Tap Hole Size Inch
308050-0010	1/4 x 20 UNC	58	20	5.10mm	#7
308050-0020	5/16 x 18 UNC	60	22	6.60mm	#F
308050-0030	3/8 x 16 UNC	70	24	8.00mm	5/16
308050-0040	1/2 x 13 UNC	80	29	10.80mm	27/64
308050-0050	5/8 x 11 UNC	90	32	13.50mm	17/32
308050-0060	3/4 x 10 UNC	100	37	16.50mm	21/32
308050-0065	7/8 x 9 UNC	105	40	19.50mm	49/64
308050-0070	1 x 8 UNC	110	45	22.25mm	7/8

Sets	Contents
308050-SET1	HMT VersaDrive ImpactaTap Set, 1/4, 5/16, 3/8, 1/2, 5/8 UNC
308050-SET2	HMT VersaDrive ImpactaTap Set, 1/2, 5/8, 3/4, 1"

ImpactaTaps® Metric Fine Thread

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

ImpactaTaps® BSP Thread

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

ImpactaTaps® BSW Thread

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

VERSADRIVE© PATENT PROTECTED

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	l2 mm	Tap Hole Size
308015-0080	M8 x 1.25	140	45	112	6.8mm
308015-0100	M10 x 1.50	155	50	127	8.5mm
308015-0120	M12 x 1.75	180	55	152	10.2mm
308015-0160	M16 x 2.0	200	65	172	14.0mm
308015-0200	M20 x 2.5	230	70	202	17.5mm
308015-0240	M24 x 3.0	260	75	232	21.0mm

Metric Coarse Oversized ImpactaTaps®

For use with Galvanised Fixings

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

Sets	Contents
308020-SET1	VersaDrive Oversize Galv ImpactaTap 6 Pc Set: M5, M6, M8, M10, M12, M16

FarrierTap - BSW Thread

FarrierTap - BSW Thread

Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size
308060-0015	5/16 x 18 BSW	60	22	6.5mm
308060-0020	3/8 x 16 BSW	70	24	7.9mm

FarrierTap Combi DrillTap

Part No	M Thread Size & Pitch	d1	L	l1	Max tapping depth with impact wrench
301127-0030	3/8-16 BSW	7.9mm	92mm	22mm	8.5mm

FarrierTap Kit

Part No:	Set Contents
301127-SET1	Set contains: 3/8 BSW FarrierTap, 3/8 BSW Combi Drill Tap, 1/4" VersaDrive Impact Adapter

VERSADRIVE© PATENT PROTECTED

Clutched Tap Collet for Blind Hole Tapping

The HMT VersaDrive Clutched tap collet system is a unique method of effectively threading blind holes.

One collet works with the range of Patented VersaDrive taps. When the tap comes to the bottom of the hole, the clutch system will engage and stop the tap from breaking. The tap is then reversed out of the completed hole.

This system fits a 19.05mm (3/4") magnet drill arbor, or can be adapted for use with a 1/2" or 3/4" impact wrench.

- *Quick change system accepts all VersaDrive taps*
- *Collets are pre-set to the appropriate clutch settings*
- *Further Clutch adjustment options available*
- *For blind hole tapping with VersaDrive Spiral Flute Taps*
- *For use with variable speed, reversible magnet drill, pillar drill, or impact wrench*

VERSATILE BLIND HOLE TAPPING

IMPACT RATED

CLUTCHED TAP REPLACEMENT COLLET

120010 COLLET HOLDER

Part No	Description
120010	Weldon Shank Tap Collet Holder, 19.05mm / 3/4

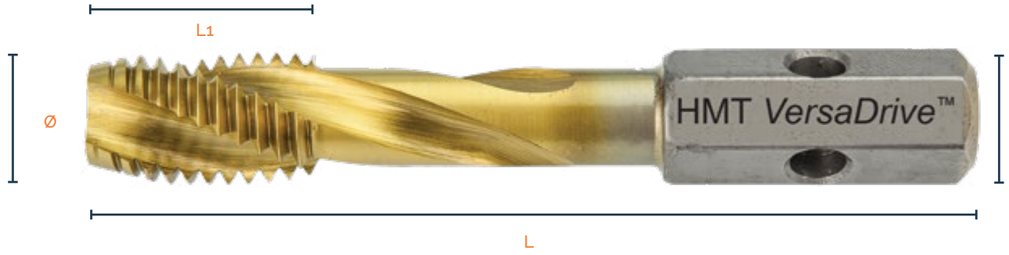
121015-M12	Clutched Blind Hole Tap Collet M6-M12 Capacity
121015-M24	Clutched Blind Hole Tap Collet M16-M24 Capacity

00200-12A-19	1/2" Drive Impact Adapter for Blind Hole Tapping
00200-34A-19	3/4" Drive Impact Adapter for Blind Hole Tapping

121015-SET12	Blind Hole Tapping Kit M6-M24 Capacity includes 1/2" Impact Adapter
121015-SET34	Blind Hole Tapping Kit M6-M24 Capacity includes 3/4" Impact Adapter

VERSADRIVE© PATENT PROTECTED

VersaDrive Spiral Flute Taps



VersaDrive Spiral Flute Taps

	Part No	M Thread Size & Pitch	L mm	l1 mm	Tap Hole Size (mm)	Tap Hole Size (")
Metric Coarse	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	-
Inch	309020-0010	1/4 x 20 UNC	58	20	5.1	#7
	309020-0020	5/16 x 18 UNC	60	22	6.6	#F
	309020-0030	3/8 x 16 UNC	70	24	8	5/16
	309020-0040	1/2 x 13 UNC	80	29	10.8	27/64
	309020-0050	5/8 x 11 UNC	90	32	13.5	17/32
	309020-0060	3/4 x 10 UNC	100	37	16.5	21/32
	309020-0065	7/8 x 9 UNC	105	40	19.5	49/64
	309020-0070	1 x 8 UNC	110	45	22.25	7/8
	309020-0110	1-1/4 x 7 UNC	128	41	28.17	1-7/64

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
○	○	×	○	●	●
○	○	×	○	●	●
○	○	×	○	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Spiral Flute Tap Sets

Part No:	Set Contents
309010-SET1	Spiral Flute ImpactaTap Set M6, M8, M10, M12, M16
309010-SET2	Spiral Flute ImpactaTap Set M12, M16, M20, M24
309020-SET1	Spiral Flute ImpactaTap Set 1/4, 5/16, 3/8, 1/2, 5/8" UNC
309020-SET2	Spiral Flute ImpactaTap Set 1/2, 3/4, 1" UNC

VERSADRIVE© PATENT PROTECTED

VersaDrive Impacta Drill Taps

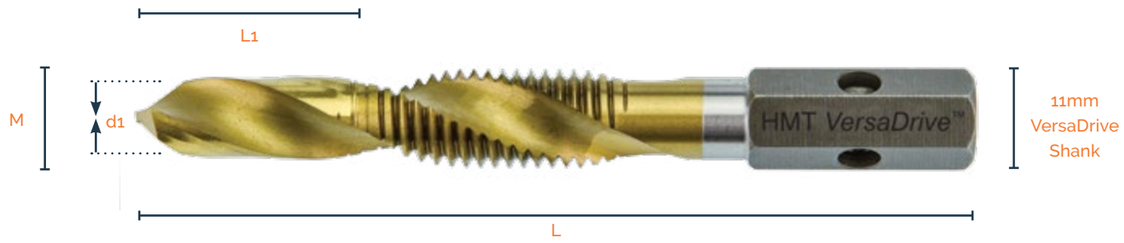
HOLEMAKER-TECHNOLOGY.COM HMT

VersaDrive Combi 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.

VersaDrive Sheet Metal Impacta-DrillTaps have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

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

- *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*



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

IMPACT RATED

RECOMMENDED FOR USE WITH:

Impact Drivers
Impact Wrenches
Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 10

Magnet Drill Adapter
111035-01
Page 11

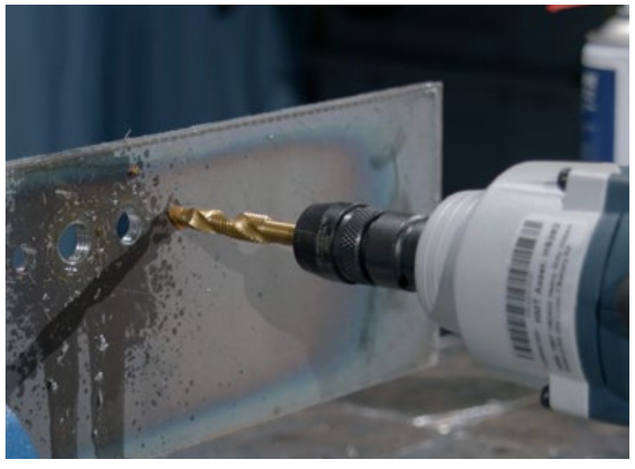
Use with any standard drill chuck

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *For fastest performance use on impact wrenches & impact drivers (Check minimum torque requirement)*
- *Maximum tapping thickness is the thread diameter of the drill-tap*
- *Tapping Stainless Steel requires higher impact torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on page 88 for more details and RPM information*



VersaDrive Drill Taps

	Part No	M Thread Size & Pitch	d1	L	l1	Max Tapping Depth
Metric	301125-0030	M3 x 0.50	2.5mm	55mm	6mm	3mm
	301125-0040	M4 x 0.70	3.3mm	60mm	9mm	4mm
	301125-0050	M5 x 0.80	4.2mm	71mm	13mm	5mm
	301125-0060	M6 x 1.00	5.0mm	75mm	17mm	6mm
	301125-0080	M8 x 1.25	6.8mm	82mm	20mm	8mm
	301125-0100	M10 x 1.50	8.5mm	92mm	25mm	10mm
	301125-0120	M12 x 1.75	10.2mm	103mm	31mm	12mm
Inch	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"
	301126-0050	1/4-20 UNC	13/64"	2-61/64"	19/32"	1/4"
	301126-0060	5/16-18 UNC	1/4"	3-15/64"	45/64"	5/16"
	301126-0070	3/8-16 UNC	5/16"	3-5/8"	55/64"	3/8"
	301126-0080	1/2-13 UNC	27/64"	4/16"	1-7/64"	1/2"

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	●	●	●
○	●	×	○	●	●
●	○	×	○	●	●
●	○	×	○	●	●
●	○	×	○	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Sheet Metal Drill-Tap Sets

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

VERSADRIVE© PATENT PROTECTED

Heavy Duty Impacta Drill Taps

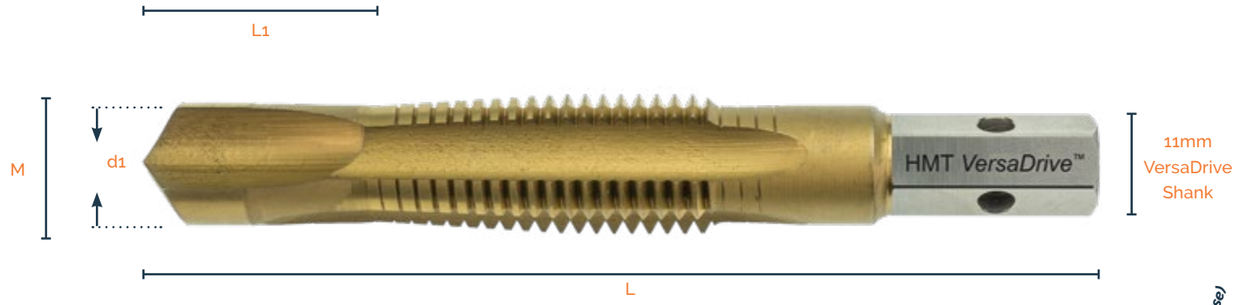
HOLEMAKER-TECHNOLOGY.COM HMT

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

Primarily they are designed to be used with a reversible Magnet drill, although they can also be adapted for use with an impact wrench to enlarge and tap existing holes.

With a drill point optimised for use in fixed drilling machines like Magnetic Drills or Pillar drills, these are not recommended for use in a pistol drill. Where they are to used with an impact wrench to enlarge and tap holes pilot drilling is recommended with a separate drill bit.

- *Fast 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*
- *Unique Dual-Point Starting Angle for easy alignment & fast cut.*
- *Chipbreaker action for Automatic chip clearance when Impact Tapping.*



DRILL & TAP IN ONE EASY OPERATION

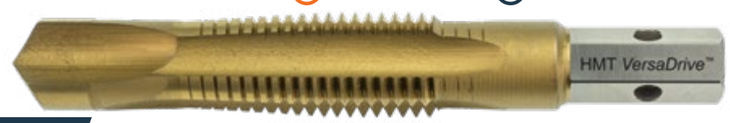
ROTARY RATED

RECOMMENDED FOR USE WITH:

Magnet Drills
MultiSink

CAN ALSO BE USED WITH:

Impact Wrench
Extension Arbor
Morse Taper Drills



ADAPTERS

Magnet Drill Adapter
111035-01
Page 11

MultiSink
601050-
Page 44

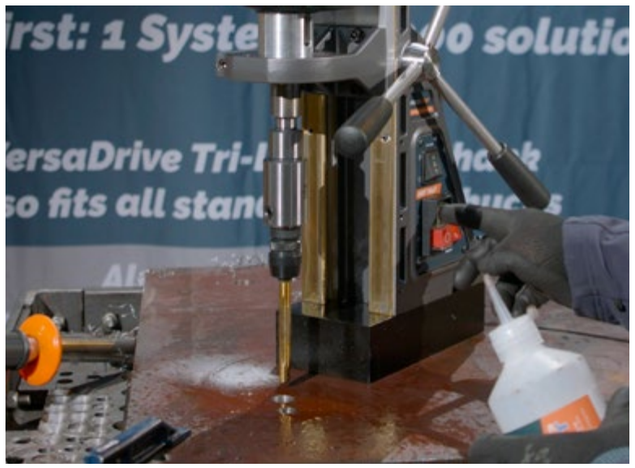
Impact Wrench Adapter
111130-012A
Page 10

Extension - 300mm
111010-0002
Page 12

Morse Taper Arbor
111040-
Page 13

Quick Guide

- *Correct RPM is critical for good performance on larger drill taps*
- *Ideal for use in drill presses and magnet drills*
- *For impact wrench use, pilot drilling the hole with a separate drill bit is necessary*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on page 88 for more details and RPM information*



VersaDrive Heavy Duty Drill Taps

	Part No	M Thread Size & Pitch	d1 mm	L mm	l1 mm	Max Tapping Depth
Metric	301130-0080	M8 x 1.25	6.8	100	30	20mm
	301130-0100	M10 x 1.50	8.5	105	30	20mm
	301130-0120	M12 x 1.75	10.2	117	35	25mm
	301130-0160	M16 x 2.00	14	117	37	25mm
	301130-0200	M20 x 2.50	17.5	135	40	35mm
	301130-0240	M24 x 3.00	21	148	45	40mm
Inch	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

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill (w. reverse)
Powertool Recommendations (Mild Steel Material)					
○	○	×	○	●	●
○	○	×	○	●	●
○	×	×	○	●	●
○	×	×	×	●	●
○	×	×	×	●	●
○	×	×	×	●	●
●	●	×	○	●	●
●	●	×	×	●	●
●	●	×	×	●	●
●	●	×	×	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Heavy Duty Drill-Tap Sets

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

VERSADRIVE© PATENT PROTECTED

VersaDrive DrillSink Tool

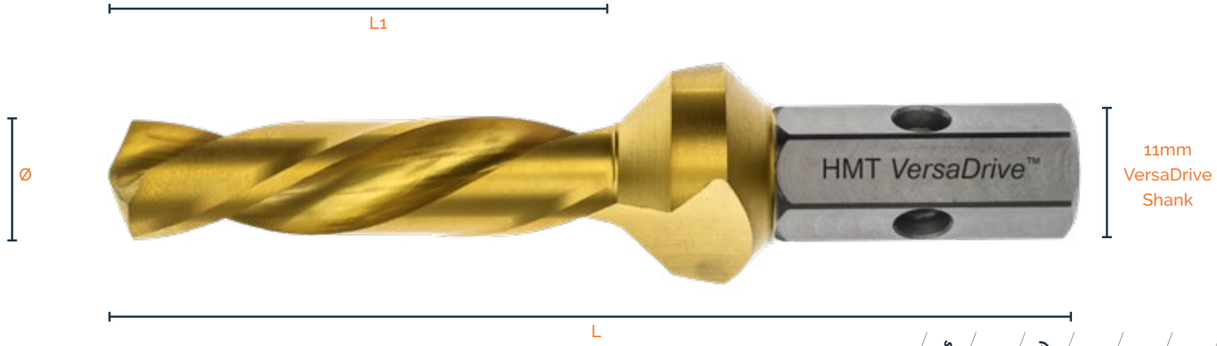
HOLEMAKER-TECHNOLOGY.COM HMT

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 combination tool 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.

VersaDrive DrillSinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *Drill & Countersink in one easy operation*
- *Perfect concentricity creates the perfect Countersink*
- *Ground flutes for high accuracy and long life*
- *High-Grade tool steel*
- *High strength, non-slip shank design*
- *GoldMax low-friction titanium coating to stop burn-out*
- *Prevents the chattering of standard countersinks*



ULTIMATE PRECISION FOR COUNTERSUNK HOLES

ROTARY RATED

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills

CAN ALSO BE USED WITH:

Impact Wrenches/Drivers (up to 16.5mm)
SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 11

Impact Wrench Adapter
111130-012A
Page 10

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *Optimum life and performance when used with rotary pistol drills or drill presses*
- *Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on page 90 for more details and RPM information*

VersaDrive DrillSink

	Part No	Ø Drill Size	Countersink Size	l1 mm	L mm	Countersunk Screw	Point Angle
Clearance Hole Sizes	603070-08124	8mm	12.4mm	47mm	96mm	M6	90°
	603070-10165	10mm	16.5mm	47mm	85mm	M8	90°
	603070-11205	11mm	20.5mm	47mm	88mm	M10	90°
	603070-12205	12mm	20.5mm	47mm	88mm	M10	90°
	603070-13250	13mm	25mm	47mm	92mm	M12	90°
	603070-14250	14mm	25mm	47mm	92mm	M12	90°
Tap Hole Sizes	603070-68165	6.8mm	16.5mm	47mm	85mm	M8 (Tapped)	90°
	603070-85205	8.5mm	20.5mm	47mm	89mm	M10 (Tapped)	90°
	603070-102250	10.2mm	25mm	47mm	93mm	M12 (Tapped)	90°

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
○	○	○	●	●	●
○	○	○	●	●	●
×	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
●	○	○	●	●	●
○	○	○	●	●	●
×	○	○	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

DrillSink Set

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

VERSADRIVE© PATENT PROTECTED

VersaDrive Countersinks

HOLEMAKER-TECHNOLOGY.COM HMT

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

VersaDrive Countersinks have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

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.

- *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*
- *1st Impact rated countersinks on the market*

PRECISION COUNTERSINKING TOOL

ROTARY RATED

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
Pillar Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard drill chuck

Magnet Drill Adapter
111035-01
Page 11

VersaDrive Impact Adapters
111026-014A & 111130-012A
Page 10

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *Optimum life and performance when used with rotary pistol drills or drill presses*
- *Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
- *Suitable for harder materials such as stainless steel when used at reduced RPM*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on page 91 for more details and RPM information*

VersaDrive Countersinks

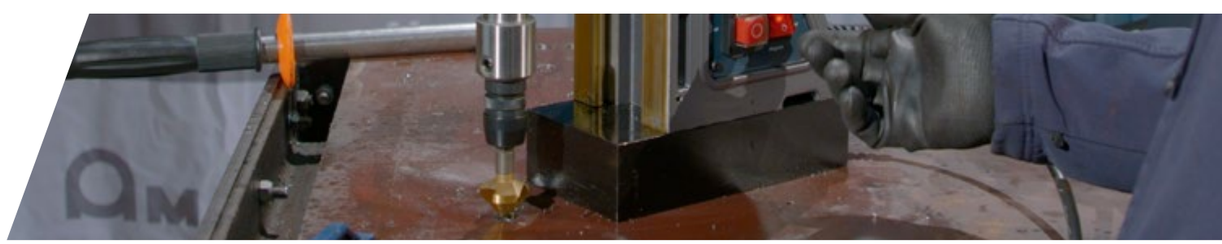
	Part No	D Ø mm	Ø d1 mm	l1 mm	L mm	Countersunk Screw	Point Angle
Metric - 90°	603060-0063	6.3mm	1.5	17	45	M3	90°
	603060-0083	8.3mm	2.0	22	50	M4	90°
	603060-0104	10.4mm	2.5	22	50	M5	90°
	603060-0124	12.4mm	2.8	28	56	M6	90°
	603060-0165	16.5mm	3.2	32	60	M8	90°
	603060-0205	20.5mm	3.5	35	63	M10	90°
	603060-0250	25mm	3.8	39	67	M12	90°
	603060-0310	31mm	4.2	43	71	M16	90°
Inch - 82°	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°

Impact Wrenches	Impact Drivers	SDS Drill (Rotary)	Cordless Drill	Pillar Drill Press	Magnet Drill
Powertool Recommendations (Mild Steel Material)					
●	●	○	●	●	●
●	●	○	●	●	●
●	●	○	●	●	●
●	●	○	●	●	●
○	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
○	○	○	●	●	●
×	×	○	●	●	●
×	×	○	●	●	●

● *Optimal* ○ *Possible (Refer to data sheet)*
× *Not Recommended*

Countersink Set

Part No:	Set Contents
603060-5SET	Set contains: 12.4, 16.5, 20.5, 25, 31mm VersaDrive 90° Countersink Bits
603065-SET	Set contains: 1/4", 3/8", 1/2", 5/8", 3/4", 1" VersaDrive 82° Countersink Bits



TCT HOLECUTTER®

TUNGSTEN CARBIDE TECHNOLOGY

VersaDrive TCT HoleCutters offer a fast, efficient and cost effective holemaking solution that outperform and outlast traditional HSS holesaws by up to 10 times!

Highly versatile and perfect for heavy duty applications VersaDrive HoleCutters are compatible with the VersaDrive system of extensions and adapters and feature cutting teeth manufactured from premium-grade Tungsten Carbide, one of the strongest materials for cutting tools. This ensures the highest levels of performance and durability, with faster cuts and increased life spans.

A complete hole cutting solution, the range offers Standard HoleCutters, Extra Long HoleCutters & the HMT exclusive HoleCutter and MultiSink combination.

THE RANGE

THE COMPLETE SOLUTION

VersaDrive HoleCutters offer the widest range of hole cutting solutions on the market.

Our flagship TCT HoleCutter is the ideal choice for inaccessible and heavy duty holemaking challenges.

For specialist jobs that require extended depth drilling our innovative Extra Long HoleCutters offer a 100mm cutting depth.

Meanwhile all VersaDrive HoleCutters can be combined with the HMT exclusive multiSink system allowing you to broach and countersink in one pass as well as the complete range of VersaDrive Rotary adapters for use on Magnet Drills and SDS+ drills.

SIZES AVAILABLE

Standard HoleCutter:

Diameter (Ø) : *12mm - 80mm*

Cutting Length (L) : *55mm*

Extra Long HoleCutter:

Diameter (Ø) : *14mm - 26mm*

Cutting Length (L) : *100mm*

Total Length: *149mm*

HoleCutter & MultiSink:

HoleCutter (Ø) : *16mm - 32mm*

MultiSink (Ø): *40 / 55mm*

REPLACING MAGNET DRILLS

Many steel erectors and fabricators tell us that they are able to replace heavy and awkward magnetic drills with a standard cordless drill fitted with a VersaDrive hole cutter.

This means:

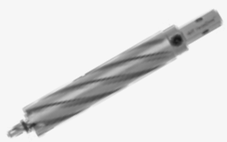
No risk of a heavy magnet drill falling from height

Quick to position and drill

Carry less equipment, saving weight and increasing mobility

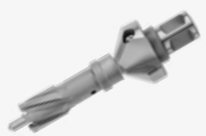
Hole cutter products available

Standard HoleCutter



Extra Long HoleCutter

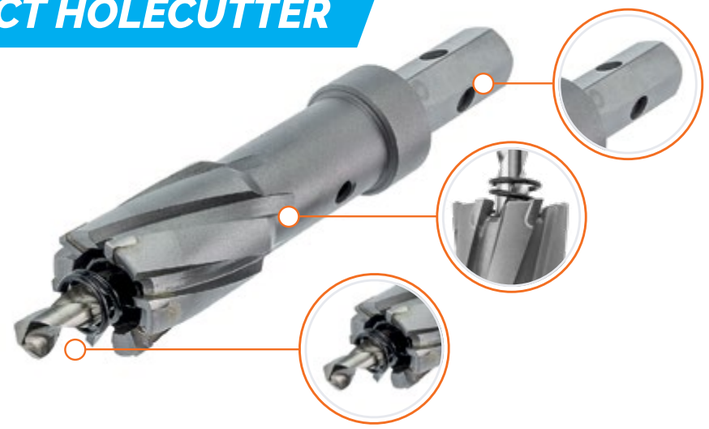
HoleCutter with HSS MultiSink



HoleCutter with TCT MultiSink

Find a stockist at www.holemaker-technology.com

TCT HOLECUTTER



RAPID-LOCK SHANK

VersaDrive Hex shank fits all standard drill chucks, Rapid-lock adapters and extension arbors, offering the greatest flexibility & applications from a single tool.

TUNGSTEN CARBIDE TEETH

Premium grade Sandvik Tungsten carbide teeth for the highest performance cutting & 10x greater life than standard holesaws.

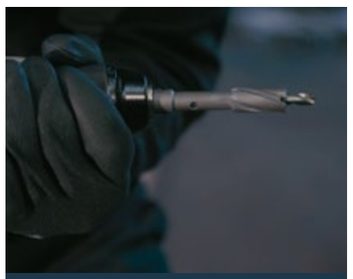
SPRING LOADED PILOT DRILL

Centres and stabilises cutter during drilling & ejects metal slug upon completion

1 HOLECUTTER - 3 SOLUTIONS

USE AS HOLECUTTER

For use in many construction materials, especially structural steel.



Use as Hole Cutter

USE AS BROACH CUTTER

Quickly adapted to become a magnet drill broach cutter.*

Adapt to Broach Cutter

USE AS MULTISINK

Quickly adapted to become a broaching cutter for the MultiSink system.*

Adapt to MultiSink

*When using with a magnet drill adapter or multiSink tool replace supplied pilot drill with 101030P-0003 ejector pin

For Sales & Technical Support Call Now: +44 1622 522102

VERSADRIVE© PATENT PROTECTED

VersaDrive TCT HoleCutters

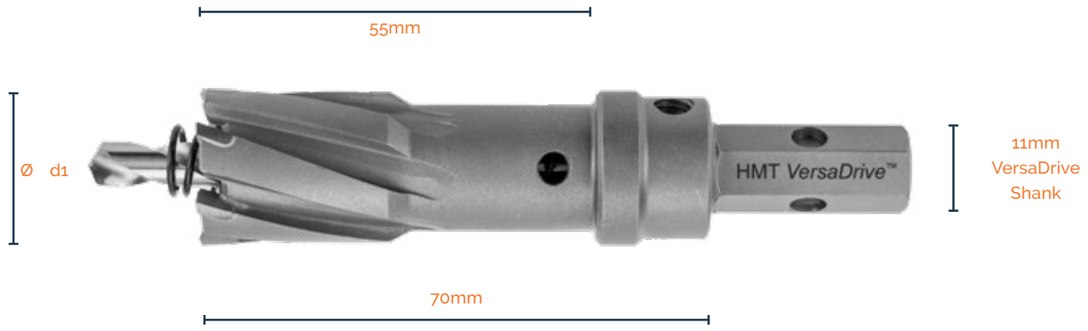
HOLEMAKER-TECHNOLOGY.COM HMT

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 Structural steels including Stainless Steel and Cast Iron.

These are rapidly becoming the go-to, alternative solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and possibly safer than a Magnetic drill.

VersaDrive TCT HoleCutters have a patented non-slip, Hex shank suitable for use in any standard 1/2" drill chuck for cordless or pistol drills or used with a VersaDrive Rapid Lock adapter for use in a wide range of powertools such as Magnetic Drills.

- *Massive 70mm reach with 55mm depth of cut*
- *Premium quality Tungsten Carbide teeth*
- *Perfect for drilling heavy steel in remote locations.*
- *High strength, non-slip shank design.*
- *Use in standard 1/2" drill chuck or with magnet drill adapter*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Combine with the multisink tool to broach & countersink in one operation*



10X LONGER LIFE THAN STANDARD HOLESAWS

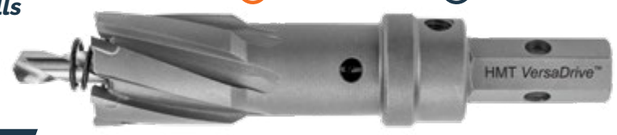
ROTARY RATED

RECOMMENDED FOR USE WITH:

Rotary Drills
Magnet Drills
HMT MultiSink
Pillar Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor



ADAPTERS

Use with any standard 1/2" drill chuck

Magnet Drill Adapter
111035-01
Page 11

MultiSink Tool
601050
Page 44

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Good results can be achieved with SDS Drills when used in Rotary Only mode*
- *Replace supplied pilot drill with 101030P-0003 ejector pin for use with a Magnet Drill or MultiSink*
- *Suitable for use on Stainless Steel*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 83 for more details and RPM information*

Part No	Ø D mm	Ø D Inch
101030-0120	12mm	
101030-0130	13mm	
101030-0140	14mm	9/16”
101030-0150	15mm	
101030-0160	16mm	5/8”
101030-0170	17mm	11/16”
101030-0175	17.5mm	
101030-0180	18mm	
101030-0190	19mm	3/4”
101030-0200	20mm	
101030-0210	21mm	13/16”
101030-0220	22mm	7/8”
101030-0230	23mm	
101030-0240	24mm	15/16”
101030-0250	25mm	1”
101030-0260	26mm	
101030-0270	27mm	1-1/16”
101030-0280	28mm	
101030-0290	29mm	1-1/8”
101030-0300	30mm	1-3/16”
101030-0310	31mm	
101030-0320	32mm	1-1/4”
101030-0330	33mm	1-5/16”
101030-0340	34mm	
101030-0350	35mm	1/3-8”
101030-0360	36mm	

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

TCT HoleCutter Sets

Part No	Contents
101030-SET1	3 piece Set: 14, 18, 22mm HoleCutters
101030-SET2	5 piece Set: 14, 17, 18, 21, 22mm HoleCutters

Pilot Drill Bits & Pilot Pins

101030P-0001

101030P-0003

Part No	Contents
101030P-0130	HoleCutter Pilot Drill for 12 & 13mm HoleCutters - Pack of 2 (Supplied WITHOUT ejection spring)
101030P-0001	HoleCutter Pilot Drill for 14-80mm HoleCutters Pack of 2 (Supplied WITH ejection spring)
101030P-0003	VersaDrive HoleCutter Magnet Broaching/MultiSink Pilot Pin, Pk2

VERSADRIVE©
PATENT PROTECTED

VersaDrive Extra Long HoleCutters

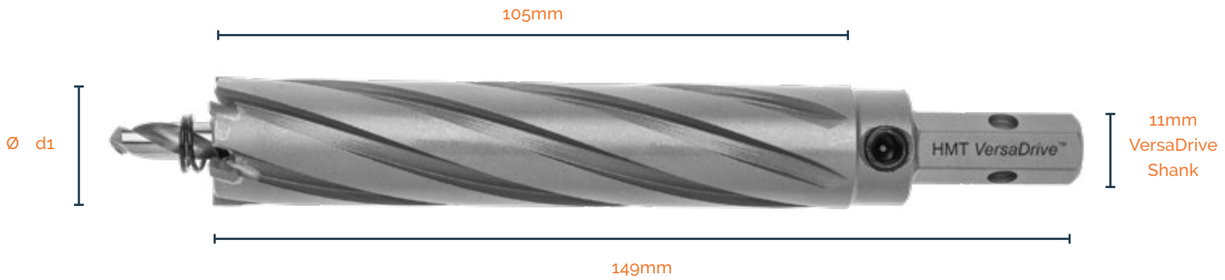
HOLEMAKER-TECHNOLOGY.COM
HMT

Extra Long reach version of the popular VersaDrive HoleCutter. Perfect for small diameter drilling through steelwork 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.

These are rapidly becoming the go-to, alternative solution for fabricators and steel erectors needing to drill through heavy steel in locations and on projects where a rotary drill is more convenient and possibly safer than a Magnetic drill.

- *120mm reach with 100mm depth of cut*
- *Premium quality Tungsten Carbide teeth*
- *Perfect for drilling box section with inaccessible sides*
- *High strength, non-slip shank design.*
- *Use in standard 1/2" drill chuck or with magnet drill adapter*
- *One piece design includes arbor & (replaceable) pilot drill*
- *Combine with other VersaDrive adapters for ultimate flexibility of working*



EXTRA LONG CUTTING CAPABILITY

ROTARY RATED

RECOMMENDED FOR USE WITH:

Rotary Drills
Cordless Drills
SDS Drills

CAN ALSO BE USED WITH:

SDS+ Adapter
Extension Arbor

ADAPTERS

Use with any standard 1/2" drill chuck

Magnet Drill Adapter
111035-01
Page 11

SDS+ Adapter
112010-01
Page 12

Extension - 300mm
111010-0002
Page 12

Quick Guide

- *Optimum life and performance when used with rotary pistol drills*
- *Good results can be achieved with SDS Drills when used in Rotary Only mode*
- *Replace supplied pilot drill with 101035P-02 ejector pin for use with a Magnet Drill or MultiSink*
- *Suitable for use on Stainless Steel*
- *Use appropriate lubrication and correct RPM to achieve long tool life*
- *Refer to the full technical data sheet on Page 83 for more details and RPM information*

NEW

Part No	Ø D mm	Ø D Inch
101035-0140	14mm	9/16"
101035-0180	18mm	
101035-0200	20mm	
101035-0220	22mm	7/8"
101035-0240	24mm	15/16"
101035-0260	26mm	

Extra Long HoleCutter Sets

Part No	Contents
101035-SET1	HMT VersaDrive TCT HoleCutter Extra Long Series Set, 14, 18, 20, 24, 26mm + Pilots

Pilot Drill Bits

Part No	Contents
101035P-01	HMT VersaDrive Extra Long TCT HoleCutter Pilot Drills, 6.35x165mm, Pk 2
101035P-02	HMT Extra Long VersaDrive HoleCutter Guide Pin, 6.35x205mm, Pk 2

VERSADRIVE© PATENT PROTECTED

The VersaDrive MultiSink® System

HOLEMAKER-TECHNOLOGY.COM HMT

The MultiSink is a worldwide unique new 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.

The MultiSink is available in HSS and Tungsten Carbide Tipped versions. The HSS Multisink features a GoldMax titanium coating to stop burn-out whilst the TCT version is specifically designed for countersinking Inox and the hardest structural steels.

- *Innovative Combination Countersinking Tool.*
- *Save Time Completing Countersunk Holes.*
- *Broach & Countersink in one operation.*
- *Drill & Countersink in one operation.*
- *Tap & Countersink in one operation.*
- *Drill-Tap & Countersink in one operation*
- *GoldMax coated HSS & Tungsten Carbide Tipped versions*

INNOVATIVE COMBINATION COUNTERSINKING TOOL

RECOMMENDED FOR USE WITH:

Magnet Drills

CAN ALSO BE USED WITH:

Pillar Drills
Radial Arm Drills

Piloted Countersink

Broach & Countersink in one operation 16-26mm

Drill & Countersink in one operation 16-22mm

Tap & Countersink in one operation M16-M24

Drill, Tap & Countersink in one operation M16-M24

Quick Guide

- *To Tap & Countersink or Drill, Tap and Countersink requires a Magnet Drill with variable speed and reverse features.*
- *For predrilled holes the MultiSink should always be used with a pilot to avoid damage*
- *When used to drill or broach & countersink it is important to use the correct RPM for each separate operation*
- *When used for multiple operations eg Drill/Tap/ Countersink, the correct RPM should be used for each separate operation*
- *Refer to the full technical data sheets at the back of the brochure for more details and RPM information*

The HSS MultiSink® Tool

Part No	D Ø mm	Ø d2 mm	L	Point Angle	Shank mm
601050-0400	**40mm**	14mm	100mm	90°	19.05mm / 3/4"
601050-0550	**55mm**	14mm	109mm	90°	19.05mm / 3/4"

CarbideMax TCT MultiSink®

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

MultiSink® Pilot

For countersinking bolt holes from 16-26mm diameter. Use Multisink with variable speed magnet drill. The speed must be reduced when countersinking.

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

MultiSink® Ejector Pilot Pin

For use with VersaDrive HoleCutters

Part No	d1 Ø	l1 mm	Unit of sale
101030P-0003	**6.35**	145	Pack 2

VERSADRIVE©
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VersaDrive Showcase Set - 25pc Metric

Part No	Description
VSD-SHOWCASE2	VersaDrive Showcase Set 25pc

The new 2020 showcase set is designed for sales people to present the VersaDrive range of products out in the field. One of every top VersaDrive product is included with typical sizing.
Presented in a high quality ABS case with foam insert.
Includes the following system:

- 1/4" Impact Driver Adapter
- Magnet Drill Adapter
- 300mm Extension Arbor.
- Impact Step Drill x 2
- Drillsink
- Cobalt Blacksmiths Drill Bit
- Sheet Metal Drill Tap x 2
- Long Series ImpactaTap
- 101030 TCT HoleCutters x 2
- Multisink & Broaching Pilot
- 1/2" Impact Wrench Adapter
- SDS Adapter
- Impact Reamer x 2
- M16 ImpactaTap
- Cobalt Drill Bit
- Countersink
- Heavy Duty Drill Tap
- Spiral Flute ImpactaTap
- Pilot Pin & Pilot Drill

VERSADRIVE©
PATENT PROTECTED

VersaDrive Site Installation Kit - 30pc Metric

Part No	Description
VSD-INSET-ME	VersaDrive Site Installation Kit 30pc Metric
VSD-INSET-IN	VersaDrive Site Installation Kit 30pc Inch

The Site Installation Kit is created to combine 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 a high quality ABS case with foam insert.
Includes the following system:

- 1/4" Impact Driver Adapter
- Magnet Drill Adapter
- 300mm Extension Arbor.
- Step Drill 22mm
- TurboTip Drill Bits 6.8mm, 8.5mm, 10.5mm, 12mm, 14mm
- ImpactaTaps M8, M10, M12, M16, M20
- 1/2" Impact Wrench Adapter
- SDS Adapter
- Hex Keys 3, 4, 5mm
- Impact Reamers 10, 14, 18, 22mm
- Countersinks 16.5mm, 20.5mm, 25.0mm
- TCT HoleCutters complete with Arbor & Pilot Drill/Spring 14, 18 22, 26mm
- Spare HoleCutter Pilot Drill & Pilot Pin

VERSADRIVE© PATENT PROTECTED

VersaDrive Magnet Drill Range

Unique benefits from a unique range.

From the lightest, most compact machine on the market to machines with variable speed, variable torque and forward/reverse as standard, VersaDrive magnet drills have been custom engineered to optimise performance.

Designed and built in our Sheffield factory by the expert HMT team, all machines with tapping capacity are powered by a legendary Eibenstock motor and combine with the Patented VersaDrive modular tooling system to extend consumable life and enhance performance for all kinds of broaching, drilling, threading, countersinking and more.

When registered, products are protected by a

2 YEAR WARRANTY

UK Built

V35 V60T V85T V100T V125T

Model	Max Cutter Diameter	Fitting	Weight (Kg)	Stroke	Drilling	Tapping	Countersinking
V35	35mm	19.05mm (3/4")	9.5kg	140mm	12mm	N/A	25mm
V60T	60mm	MT2	18kg	220mm	20mm	M20	40mm
V85T	85mm	MT3	20.5kg	220mm	27mm	M27	55mm
V100T	100mm	MT3	24.5kg	280mm	30mm	M30	55mm
V125T	125mm	MT3	25kg	280mm	32mm	M32	65mm

VERSADRIVE© PATENT PROTECTED

VersaDrive V35 Magnet Drill

Supplied with a quick change VersaDrive adapter

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 35mm
MAX CUTTER CAPACITY	35mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	12mm
COUNTERSINKING	25mm
REAMING	N/A
MAX TAP CAPACITY	N/A
LENGTH	220mm
WIDTH (Inc Handles)	173mm
HEIGHT (Min-Max)	305 - 445mm
STROKE	140mm
WEIGHT	9.5kg
MAGNET (L X W)	160 x 80mm
MAGNETIC ADHESION	1000kg
MOTOR POWER	850W
TOTAL POWER	900W
SPEED RPM (No Load)	750 min^{-1}
SPINDLE	3/4" Weldon
ARBOR	Integral 3/4" Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

Coming Q2 2021

Part No	Contents
850035-110	HMT V35 VersaDrive Magnetic Drill 110v
850035-230	HMT V35 VersaDrive Magnetic Drill 230v

The HMT VersaDrive V35 is the first UK Built portable drilling machine designed for high-performance, low-maintenance, industrial quality drilling up to 35mm diameter. It delivers constant performance in the most challenging drilling environments and fabrication conditions.

This machine fills a gap in the market for extremely light weight, high drilling speed, and long stroke to accept a wide range of VersaDrive Tooling such as twist drills, countersinks, drillsinks, step drills and more.

Supplied with handles, heavy duty metal guard system,, VersaDrive Rapid-Lock adapter, site case and gravity fed coolant system.

MOST VERSATILE COMPACT MACHINE ON THE MARKET

VERSADRIVE© PATENT PROTECTED

VersaDrive V60T Magnet Drill

Supplied with two quick change adapters

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 60mm TCT
MAX CUTTER CAPACITY	60mm TCT
MAX CUTTER LENGTH	150mm
TWIST DRILL CAPACITY	20mm
COUNTERSINKING	40mm
REAMING	20mm
MAX TAP CAPACITY	M20
LENGTH	315mm
WIDTH (Inc Handles)	220mm
HEIGHT (Min-Max)	385 - 605mm
STROKE	220mm
WEIGHT	18 kg
MAGNET (L X W)	200 x 100mm
MAGNETIC ADHESION	1750 kgs
MOTOR POWER	1150w
TOTAL POWER	1270w
SPEED RPM (No Load)	100 - 250 / 180 - 450
SPINDLE	MT2
ARBOR	19,05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V60T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 60mm diameter is combined with a forward reverse, variable speed motor that will tap holes up to M20 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

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

MARKET LEADING PERFORMANCE

VERSADRIVE© PATENT PROTECTED

VersaDrive V85T Magnet Drill

Supplied with two quick change adapters

UK Built

Technical Specifications

CUTTER SIZE RANGE	12 - 85mm TCT
MAX CUTTER CAPACITY	85mm TCT
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 ADHESION	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	Gravity Oil Fed
WARRANTY	2 Year (When registered)

The HMT VersaDrive V85T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 85mm diameter is combined with a forward reverse, variable speed motor that will tap holes up to M27 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

Supplied with handles, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

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

MARKET LEADING PERFORMANCE

VERSADRIVE©
PATENT PROTECTED

VersaDrive V100T Magnet Drill

Supplied with two quick change adapters

UK Built

The HMT VersaDrive V100T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 100mm diameter is combined with a forward reverse, variable speed motor that will tap holes up to M30 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V100T can also be used with the VersaDrive blind hole tapping system up to M30 diameter.

Supplied with handles, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Technical Specifications

CUTTER SIZE RANGE	12 - 100mm TCT
MAX CUTTER CAPACITY	100mm TCT
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 ADHESION	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	Gravity Oil Fed
WARRANTY	2 Year (When registered)

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

MARKET LEADING PERFORMANCE

VERSADRIVE©
PATENT PROTECTED

VersaDrive V125T Magnet Drill

Supplied with two quick change adapters

UK Built

The HMT VersaDrive V125T is the first UK Built portable drilling machine range designed for the 21st century. Designed to meet a need in the market for a high-performance, low-maintenance, industrial quality portable drilling unit and to deliver constant performance in the most challenging drilling environments and fabrication conditions.

Combining light weight and portability with a high power all-day broaching capability up to 125mm diameter is combined with a forward reverse, variable speed motor that will tap holes up to M32 diameter. Fully rated for reaming, countersinking, and tapping. Advanced British electromagnets provide enhanced magnet hold for exceptional safety and stability.

In addition to standard through-hole tapping, the V125T can also be used with the VersaDrive blind hole tapping system up to M30 diameter.

Supplied with handles, heavy duty metal sliding guard system, morse taper broaching arbor, VersaDrive adapter, site case and gravity fed coolant system.

Technical Specifications

CUTTER SIZE RANGE	12 - 125mm TCT
MAX CUTTER CAPACITY	125mm TCT
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 ADHESION	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	Gravity Oil Fed
WARRANTY	2 Year (When registered)

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

MARKET LEADING PERFORMANCE

HOLEMAKER-TECHNOLOGY.COM
HMT

OverReach Fixed System

The HMT OverReach system is a range of magnetic base units that are designed to reach over obstructions such as plates or rivet heads to position a drilling unit where it would have not been previously possible. The powerful electromagnet can be positioned further away from the hole and a magnet drill can be placed on the fixed projecting steel plate to give more positioning options.

Technical Specifications

CUTTER CAPACITY	30mm
PLATE THICKNESS	10mm
PLATE AREA	212 x 115mm
MAGNET POWER	1100kgs
MAX WEIGHT SUPPORTED	12kg
USE WITH	V35, MAX30, MAX40V Magnet Drills
MINIMUM BASE MATERIAL REQUIRED	10mm thick, clean, flat, paint & rust free

Reach over obstructions

CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

861010	HMT OverReach Magnet Base Clamp Fixed V Plate, 110 Volt

UK Built

OverReach Swivel System

The HMT OverReach Swivel system extends the reach of the fixed base unit. An adjustable arm mounted to the magnetic base allows magnet drills to be positioned up to 300mm from the fixed unit giving greater flexibility and overcoming otherwise impractical or impossible drilling challenges.

Technical Specifications

CUTTER CAPACITY	30mm
PLATE THICKNESS	20mm
PLATE AREA	400 x 140mm
TRAVEL	300mm
MAGNET POWER	1100kgs
MAX WEIGHT SUPPORTED	12kg
USE WITH	V35, MAX30, MAX40V Magnet Drills
MINIMUM BASE MATERIAL REQUIRED	10mm thick, clean, flat, paint & rust free

Reach over obstructions

CAUTION: Electro-magnets of any machine used with the OverReach should be contained on the plate area at all times in use & must not over-hang

861020	HMT OverReach Magnet Base Clamp with Slide Plate, 110 Volt

UK Built

HOLEMAKER-TECHNOLOGY.COM
HMT

RTQ40 Magnet Drill

Integrated lubricant system and feed hose

Technical Specifications

CUTTER SIZE RANGE	12-40mm
MAX CUTTER CAPACITY	40mm
TWIST DRILL CAPACITY	13mm
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	19.05mm 3/4" Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	1 Year

Part No	Contents
803084-110	HMT RTQ40 Low Profile Magnetic Drill 110V
803084-230	HMT RTQ40 Low Profile Magnetic Drill 230V

The new HMT RTQ40 is a low profile Magnet drill for tight access applications, being designed to fit into any space greater than 180mm. Suitable for use with any standard broaching cutters while optimised to work with the high-performance CarbideMax 40 cutters.

- Ratchet drive can be mounted on either side of the machine.
- Powerful motor and magnet gives excellent stability.
- Quick-change 19.05mm 3/4" arbor for all standard broaching cutters

Each machine comes in a plastic case with hex keys, safety strap, ratchet, and removable coolant system

IDEAL FOR TIGHT ACCESS APPLICATIONS

HMT MAX40V Magnet Drill

Metal guard system supplied as part of a comprehensive kit package

The MAX40V offers a 145mm stroke and comfortably accommodates cutters up to 110mm for deep broaching. It also accepts the VersaDrive Rapid-Lock Weldon Adapter with VersaDrive tooling, opening up 1,000s of time saving solutions from the whole VersaDrive system.

Technical Specifications

CUTTER SIZE RANGE	12 - 40mm TCT
MAX CUTTER CAPACITY	110mm TCT
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	16mm
COUNTERSINKING	25mm
REAMING	12mm
LENGTH	264mm
WIDTH (Inc Handles)	180mm
HEIGHT (Min-Max)	360 - 440mm
STROKE	145mm
WEIGHT	10.5 kg
MAGNET (L X W)	160 x 80mm
MAGNETIC ADHESION	1500 kgs
MOTOR POWER	1150w
SPEED RPM (No Load)	600 RPM
SPINDLE	19.05 mm (¾") Weldon
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

Part No	Contents
803046-110	HMT MAX40V Magnetic Drill - 110V
803046-230	HMT MAX40V Magnetic Drill - 230V

MARKET LEADING PERFORMANCE

MAX200 Magnet Drill

Compatible with the largest CarbideMax XL broach cutters

The Ultimate Magnetic Drill for the largest possible broaching, drilling and Countersinking tasks. Fantastic power and magnetic adhesion make this Mag Drill a world beater for heavy duty engineering tasks.

- Designed for heavy portable engineering works
- Huge Power 3800 Watt Motor
- High precision Twin column slideway system
- Up to 200mm Broach Capacity

Each machine comes in a metal, heavy duty, wheeled case with MT4 broaching arbor, hex keys, safety strap and internal coolant system.

Technical Specifications

CUTTER SIZE RANGE	12-200mm
MAX CUTTER LENGTH	200mm
TWIST DRILL RANGE	12-50mm
TAPPING RANGE	N/A
COUNTERSINKING	80mm
REAMING	39mm
LENGTH	480mm
WIDTH INC HANDLES	260mm
HEIGHT	660-840mm
STROKE	280mm
WEIGHT	53kg
MAGNET SIZE (L x W)	330x110mm
MAGNETIC FORCE	3900kg
MOTOR POWER	3800W
SPEED RPM (No Load)	1) 70-150 2)170-410 RPM
SPINDLE	MT4
ARBOR	Weldon XL 32mm 1 1/4"
COOLANT SYSTEM	Gravity Oil Fed
WARRANTY	2 Year (When registered)

Part No	Contents
803095-0001	HMT MAX200 Magnet Drill Kit - 110v
803095-0002	HMT MAX200 Magnet Drill Kit - 230v

HUGE POWER AND MAGNET HOLD TO MAKE LIGHT WORK OF HEAVY ENGINEERING TASKS

CARBIDEMAX®

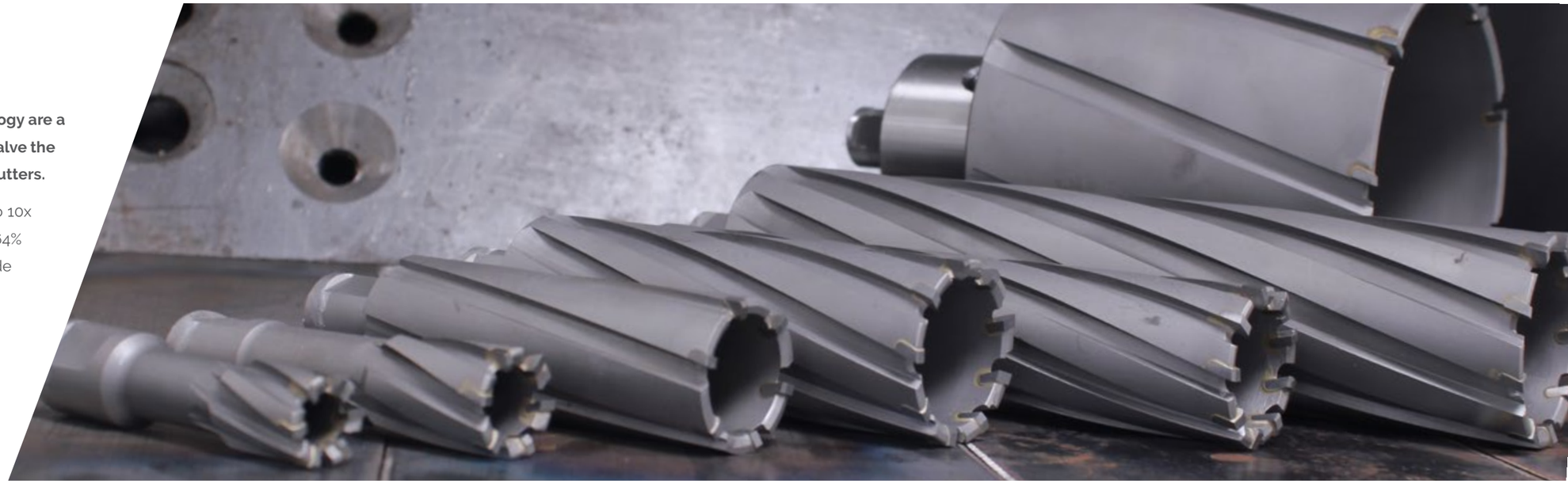
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax TCT Broach cutters by Holemaker Technology are a new generation of broach cutter proven to more than halve the cost of hole broaching compared with traditional HSS cutters.

CarbideMax TCT cutters also offer a life expectancy up to 10x that of standard HSS cutters and cutting speeds up to 64% faster thanks to their individually brazed Tungsten Carbide cutting teeth and elaborate tool geometry.

This specialist construction also results in quieter, easier drilling, with smooth, accurate holes and chatter free performance throughout the cut.

The CarbideMax range - stronger and faster for longer, the ultimate value for money.



THE RANGE

WORLD'S LARGEST STOCKS

HMT hold the world's largest range of available TCT products.

The CarbideMax range also features an expansive selection of sizes, unique products and HMT exclusive lengths.

Sizes available:

Diameter (Ø) :	***12mm - 150mm***
Cutting Length (L) :	***40mm - 200mm***

EXTREME DRILLING DEPTH

For the most extreme drilling depths the CarbideMax range offers 150mm & 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.

XL - ULTRA LARGE DIAMETER

With the requirement for ultra large diameter broaching fast increasing, the CarbideMax-XL™ range offers cutters from 60mm right up to 200mm diameter with 110mm cutting depth as standard. These high quality TCT cutters have a reinforced 32mm diameter shank to withstand the high levels of torque generated.

Sizes available

Ø	12-80mm	12-65mm	12-50mm	14-60mm	18-50mm	18-50mm	65-150mm	16-120mm
L	40mm	55mm	80mm	110mm	150mm	200mm	55mm	110mm

A NEW GENERATION OF LONG-LIFE CUTTER

UP TO 10X LONGER LIFE

Tungsten Carbide is one of the hardest materials available for use in cutting tools. The HMT CarbideMax range uses Premium Grade Sandvik Tungsten Carbide teeth meaning that cutters are capable of drilling through the toughest steels whilst maintaining their strength & cutting surface for up to 10x longer than traditional HSS cutters.

UP TO 64% FASTER CUTS

The elaborate geometry of CarbideMax broach cutters means the teeth of the cutter do all the work. This reduces strain on the tool body and means that a strong but thin flexible alloy can be used for its construction. Thinner walls means CarbideMax tools need to remove less material from the work piece resulting in a faster cut and quieter, easier drilling.

ULTIMATE VALUE FOR MONEY

With lifespans up to 10x greater than standard HSS cutters and speeds up to 64% faster, HMT CarbideMax broach cutters will cut more holes, more quickly, for longer. Over the lifetime of the tool this means incredible value for money, greater job site efficiencies and fewer stops as fewer tools are reordered and replaced.

Features & Benefits

- *Up to 10x the life of standard HSS cutters*
- *Up to 64% faster than HSS cutters*
- *Premium Sandvik Tungsten Carbide teeth*
- *Fits all standard 19.05mm Weldon shanks*
- *Works well in Stainless Steel & Cast Iron*
- *Elaborate tool geometry for a smooth cut*
- *More than halves the cost of hole broaching*
- *Reduced thickness tool made from flexible alloy steel results in fewer breakages*

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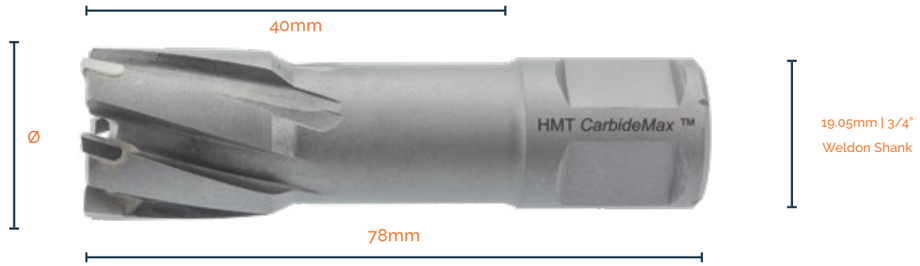
CarbideMax 40 - TCT Broach Cutters



Part No	Diameter mm	Shank Size
108030-0120	12mm	19.05mm / 3/4"
108030-0130	13mm	19.05mm / 3/4"
108030-0140	14mm	19.05mm / 3/4"
108030-0150	15mm	19.05mm / 3/4"
108030-0160	16mm	19.05mm / 3/4"
108030-0170	17mm	19.05mm / 3/4"
108030-0180	18mm	19.05mm / 3/4"
108030-0190	19mm	19.05mm / 3/4"
108030-0200	20mm	19.05mm / 3/4"
108030-0210	21mm	19.05mm / 3/4"
108030-0220	22mm	19.05mm / 3/4"
108030-0230	23mm	19.05mm / 3/4"
108030-0240	24mm	19.05mm / 3/4"
108030-0250	25mm	19.05mm / 3/4"
108030-0260	26mm	19.05mm / 3/4"
108030-0270	27mm	19.05mm / 3/4"
108030-0280	28mm	19.05mm / 3/4"
108030-0290	29mm	19.05mm / 3/4"
108030-0300	30mm	19.05mm / 3/4"
108030-0310	31mm	19.05mm / 3/4"
108030-0320	32mm	19.05mm / 3/4"
108030-0330	33mm	19.05mm / 3/4"

Part No	Diameter mm	Shank Size
108030-0340	34mm	19.05mm / 3/4"
108030-0350	35mm	19.05mm / 3/4"
108030-0360	36mm	19.05mm / 3/4"
108030-0370	37mm	19.05mm / 3/4"
108030-0380	38mm	19.05mm / 3/4"
108030-0390	39mm	19.05mm / 3/4"
108030-0400	40mm	19.05mm / 3/4"
108030-0410	41mm	19.05mm / 3/4"
108030-0420	42mm	19.05mm / 3/4"
108030-0430	43mm	19.05mm / 3/4"
108030-0440	44mm	19.05mm / 3/4"
108030-0450	45mm	19.05mm / 3/4"
108030-0460	46mm	19.05mm / 3/4"
108030-0470	47mm	19.05mm / 3/4"
108030-0480	48mm	19.05mm / 3/4"
108030-0490	49mm	19.05mm / 3/4"
108030-0500	50mm	19.05mm / 3/4"
108030-0550	55mm	19.05mm / 3/4"
108030-0600	60mm	19.05mm / 3/4"
108030-0650	65mm	19.05mm / 3/4"
108030-0700	70mm	19.05mm / 3/4"
108030-0750	75mm	19.05mm / 3/4"
108030-0800	80mm	19.05mm / 3/4"

CarbideMax 40 Pilot Pins

12-17mm Cutters

Part No	Dia Ø	Length	Unit of sale
108030P-0170	6.34	90	Pack 2
108030P-0170-P10	6.34	90	Pack 10

18-80mm Cutters

Part No	Dia Ø	Length	Unit of sale
108030P-0600	7.98	90	Pack 2
108030P-0600-P10	7.98	90	Pack 10

CarbideMax 40 TCT Sets

Part No	Set Contains
108030-SET	14, 18, 22mm + 2 Pilot Pins
108030-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

Find a stockist at www.holemaker-technology.com

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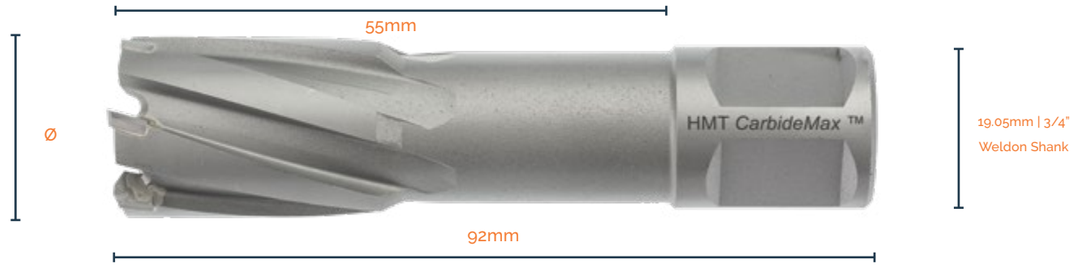
CarbideMax 55 - TCT Broach Cutters



Part No	Diameter mm	Shank Size
108020-0120	12mm	19.05mm / 3/4"
108020-0130	13mm	19.05mm / 3/4"
108020-0140	14mm	19.05mm / 3/4"
108020-0150	15mm	19.05mm / 3/4"
108020-0160	16mm	19.05mm / 3/4"
108020-0170	17mm	19.05mm / 3/4"
108020-0175	17.5mm	19.05mm / 3/4"
108020-0180	18mm	19.05mm / 3/4"
108020-0190	19mm	19.05mm / 3/4"
108020-0200	20mm	19.05mm / 3/4"
108020-0210	21mm	19.05mm / 3/4"
108020-0220	22mm	19.05mm / 3/4"
108020-0230	23mm	19.05mm / 3/4"
108020-0240	24mm	19.05mm / 3/4"
108020-0250	25mm	19.05mm / 3/4"
108020-0260	26mm	19.05mm / 3/4"
108020-0265	26.5mm	19.05mm / 3/4"
108020-0270	27mm	19.05mm / 3/4"
108020-0280	28mm	19.05mm / 3/4"
108020-0290	29mm	19.05mm / 3/4"
108020-0300	30mm	19.05mm / 3/4"
108020-0310	31mm	19.05mm / 3/4"
108020-0320	32mm	19.05mm / 3/4"
108020-0330	33mm	19.05mm / 3/4"
108020-0340	34mm	19.05mm / 3/4"
108020-0350	35mm	19.05mm / 3/4"

Part No	Diameter mm	Shank Size
108020-0360	36mm	19.05mm / 3/4"
108020-0370	37mm	19.05mm / 3/4"
108020-0380	38mm	19.05mm / 3/4"
108020-0390	39mm	19.05mm / 3/4"
108020-0400	40mm	19.05mm / 3/4"
108020-0410	41mm	19.05mm / 3/4"
108020-0420	42mm	19.05mm / 3/4"
108020-0430	43mm	19.05mm / 3/4"
108020-0440	44mm	19.05mm / 3/4"
108020-0450	45mm	19.05mm / 3/4"
108020-0460	46mm	19.05mm / 3/4"
108020-0470	47mm	19.05mm / 3/4"
108020-0480	48mm	19.05mm / 3/4"
108020-0490	49mm	19.05mm / 3/4"
108020-0500	50mm	19.05mm / 3/4"
108020-0510	51mm	19.05mm / 3/4"
108020-0520	52mm	19.05mm / 3/4"
108020-0530	53mm	19.05mm / 3/4"
108020-0540	54mm	19.05mm / 3/4"
108020-0550	55mm	19.05mm / 3/4"
108020-0560	56mm	19.05mm / 3/4"
108020-0570	57mm	19.05mm / 3/4"
108020-0580	58mm	19.05mm / 3/4"
108020-0590	59mm	19.05mm / 3/4"
108020-0600	60mm	19.05mm / 3/4"

CarbideMax 55 Pilot Pins

12-17mm Cutters

Part No	Dia Ø	Length	Unit of sale
108020P-0170	6.34	103	Pack 2
108020P-0170-P10	6.34	103	Pack 10

17.5-60mm Cutters

Part No	Dia Ø	Length	Unit of sale
108020P-0600	7.98	103	Pack 2
108020P-0600-P10	7.98	103	Pack 10

CarbideMax 55 TCT Sets

Part No	Set Contains
108020-SET	14, 18, 22mm + 2 Pilot Pins
108020-5SET	12, 14, 18, 22, 26mm + 2 Pilot Pins

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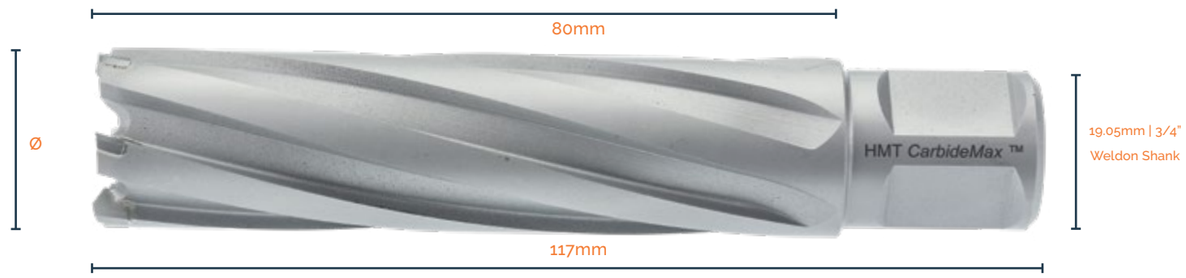
CarbideMax 80 - TCT Broach Cutters



Part No	Diameter mm	Shank Size
108010-0120	12mm	19.05mm / 3/4"
108010-0140	14mm	19.05mm / 3/4"
108010-0160	16mm	19.05mm / 3/4"
108010-0180	18mm	19.05mm / 3/4"
108010-0200	20mm	19.05mm / 3/4"
108010-0220	22mm	19.05mm / 3/4"
108010-0240	24mm	19.05mm / 3/4"
108010-0260	26mm	19.05mm / 3/4"
108010-0280	28mm	19.05mm / 3/4"
108010-0300	30mm	19.05mm / 3/4"
108010-0320	32mm	19.05mm / 3/4"
108010-0330	33mm	19.05mm / 3/4"
108010-0340	34mm	19.05mm / 3/4"
108010-0350	35mm	19.05mm / 3/4"
108010-0360	36mm	19.05mm / 3/4"
108010-0380	38mm	19.05mm / 3/4"
108010-0390	39mm	19.05mm / 3/4"
108010-0400	40mm	19.05mm / 3/4"
108010-0420	42mm	19.05mm / 3/4"
108010-0450	45mm	19.05mm / 3/4"
108010-0500	50mm	19.05mm / 3/4"

CarbideMax 80 Pilot Pins

12-17mm Cutters

Part No	Dia Ø	Length	Unit of sale
108010P-0170	6.34	130	Pack 2

18-60mm Cutters

Part No	Dia Ø	Length	Unit of sale
108010P-0600	7.98	130	Pack 2

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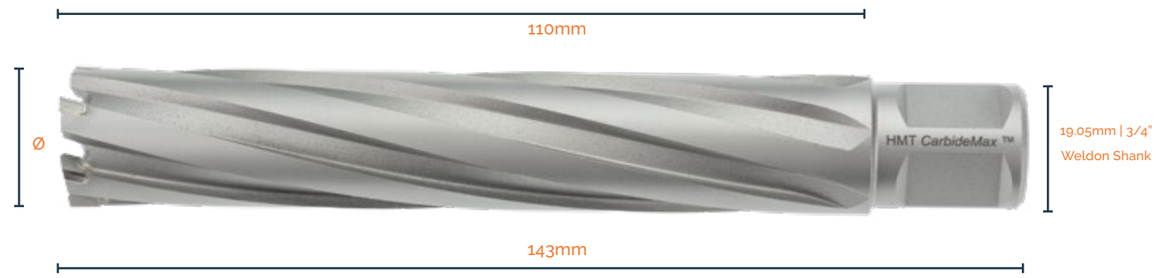
CarbideMax 110 - TCT Broach Cutters



Part No	Diameter mm	Shank Size
108040-0140	14mm	19.05mm / 3/4"
108040-0160	16mm	19.05mm / 3/4"
108040-0180	18mm	19.05mm / 3/4"
108040-0190	19mm	19.05mm / 3/4"
108040-0200	20mm	19.05mm / 3/4"
108040-0210	21mm	19.05mm / 3/4"
108040-0220	22mm	19.05mm / 3/4"
108040-0230	23mm	19.05mm / 3/4"
108040-0240	24mm	19.05mm / 3/4"
108040-0250	25mm	19.05mm / 3/4"
108040-0260	26mm	19.05mm / 3/4"
108040-0270	27mm	19.05mm / 3/4"
108040-0280	28mm	19.05mm / 3/4"
108040-0290	29mm	19.05mm / 3/4"
108040-0300	30mm	19.05mm / 3/4"
108040-0320	32mm	19.05mm / 3/4"
108040-0330	33mm	19.05mm / 3/4"
108040-0340	34mm	19.05mm / 3/4"
108040-0350	35mm	19.05mm / 3/4"
108040-0360	36mm	19.05mm / 3/4"
108040-0380	38mm	19.05mm / 3/4"
108040-0390	39mm	19.05mm / 3/4"
108040-0400	40mm	19.05mm / 3/4"
108040-0410	41mm	19.05mm / 3/4"
108040-0420	42mm	19.05mm / 3/4"
108040-0430	43mm	19.05mm / 3/4"
108040-0440	44mm	19.05mm / 3/4"
108040-0450	45mm	19.05mm / 3/4"
108040-0460	46mm	19.05mm / 3/4"
108040-0470	47mm	19.05mm / 3/4"
108040-0480	48mm	19.05mm / 3/4"
108040-0490	49mm	19.05mm / 3/4"
108040-0500	50mm	19.05mm / 3/4"
108040-0510	51mm	19.05mm / 3/4"
108040-0520	52mm	19.05mm / 3/4"
108040-0540	54mm	19.05mm / 3/4"
108040-0550	55mm	19.05mm / 3/4"
108040-0560	56mm	19.05mm / 3/4"
108040-0570	57mm	19.05mm / 3/4"
108040-0580	58mm	19.05mm / 3/4"
108040-0590	59mm	19.05mm / 3/4"
108040-0600	60mm	19.05mm / 3/4"

CarbideMax 110 Pilot Pins

14-17mm Cutters

Part No	Dia Ø	Length	Unit of sale
108040P-0171	6.34	155	Pack 2

18-60mm Cutters

Part No	Dia Ø	Length	Unit of sale
108040P-0600	7.98	155	Pack 2

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax 150 - TCT Broach Cutters

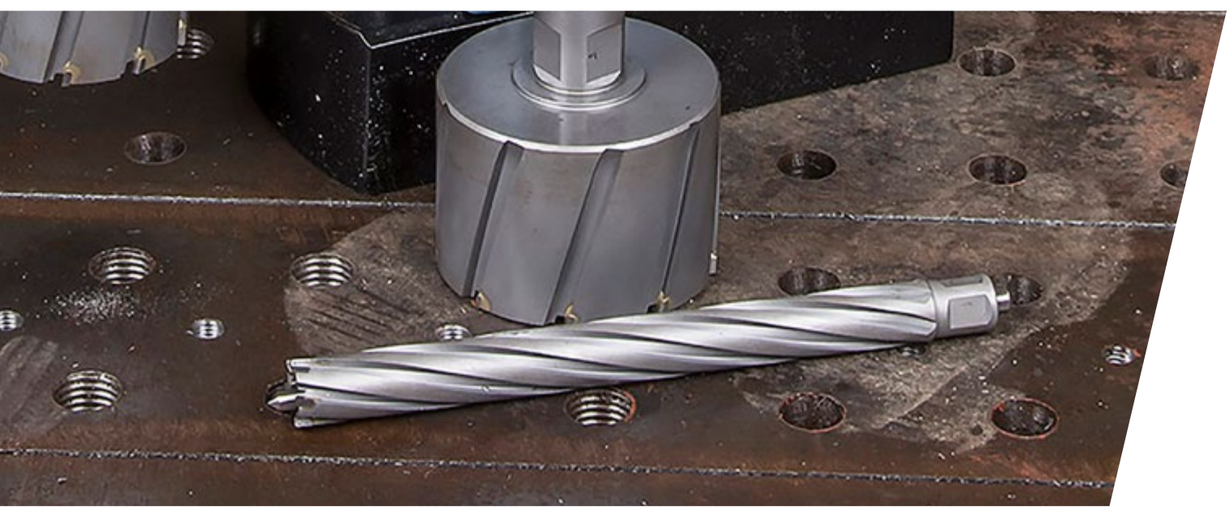
Part No	Diameter mm	Shank Size
108045-0180	18mm	19.05mm / 3/4"
108045-0200	20mm	19.05mm / 3/4"
108045-0220	22mm	19.05mm / 3/4"
108045-0240	24mm	19.05mm / 3/4"
108045-0260	26mm	19.05mm / 3/4"
108045-0280	28mm	19.05mm / 3/4"
108045-0300	30mm	19.05mm / 3/4"
108045-0320	32mm	19.05mm / 3/4"
108045-0330	33mm	19.05mm / 3/4"
108045-0360	36mm	19.05mm / 3/4"
108045-0390	39mm	19.05mm / 3/4"
108045-0500	50mm	19.05mm / 3/4"

CarbideMax 150 Pilot Pins

1 Piece: 18-50mm Cutters

Part No	Dia Ø	Length	Unit of sale
108045P-0600	7.98	205	Pack 2

Ideal for drilling matching holes through box or H section in a single pass



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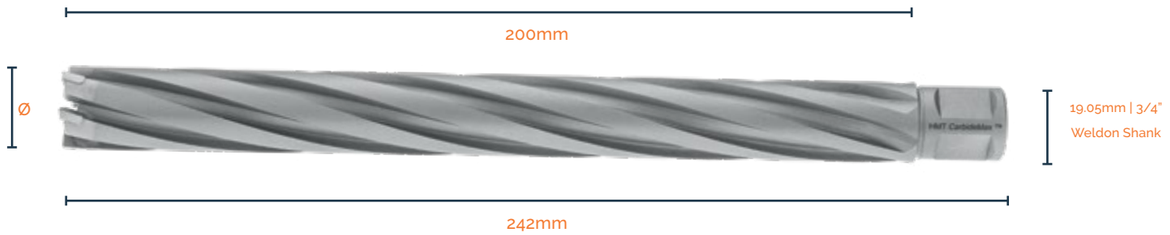
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax 200 - TCT Broach Cutters



Part No	Diameter mm	Shank Size
108050-0180	18mm	19.05mm / 3/4"
108050-0200	20mm	19.05mm / 3/4"
108050-0220	22mm	19.05mm / 3/4"
108050-0240	24mm	19.05mm / 3/4"
108050-0260	26mm	19.05mm / 3/4"
108050-0300	30mm	19.05mm / 3/4"
108050-0320	32mm	19.05mm / 3/4"
108050-0330	33mm	19.05mm / 3/4"
108050-0360	36mm	19.05mm / 3/4"
108050-0390	39mm	19.05mm / 3/4"
108050-0420	42mm	19.05mm / 3/4"
108050-0450	45mm	19.05mm / 3/4"
108050-0500	50mm	19.05mm / 3/4"

CarbideMax 200 Pilot Pins

2 Piece: 18-50mm Cutters

Used when 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.

Part No	Dia Ø	Length	Unit of sale
108050P-0600-2P	7.98	255	Pack 2

Ideal for drilling matching holes through box or H section in a single pass

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax XL55 - TCT Broach Cutters

Part No	D Ø mm	Shank Size
108020-0610	61mm	32mm / 1 1/4"
108020-0620	62mm	32mm / 1 1/4"
108020-0630	63mm	32mm / 1 1/4"
108020-0640	64mm	32mm / 1 1/4"
108020-0650	65mm	32mm / 1 1/4"
108020-0660	66mm	32mm / 1 1/4"
108020-0670	67mm	32mm / 1 1/4"
108020-0680	68mm	32mm / 1 1/4"
108020-0690	69mm	32mm / 1 1/4"
108020-0700	70mm	32mm / 1 1/4"
108020-0725	72.5mm	32mm / 1 1/4"
108020-0750	75mm	32mm / 1 1/4"
108020-0800	80mm	32mm / 1 1/4"
108020-0850	85mm	32mm / 1 1/4"

Part No	D Ø mm	Shank Size
108020-0900	90mm	32mm / 1 1/4"
108020-0950	95mm	32mm / 1 1/4"
108020-1000	100mm	32mm / 1 1/4"
108020-1050	105mm	32mm / 1 1/4"
108020-1100	110mm	32mm / 1 1/4"
108020-1150	115mm	32mm / 1 1/4"
108020-1200	120mm	32mm / 1 1/4"
108020-1250	125mm	32mm / 1 1/4"
108020-1270	127mm	32mm / 1 1/4"
108020-1300	130mm	32mm / 1 1/4"
108020-1350	135mm	32mm / 1 1/4"
108020-1400	140mm	32mm / 1 1/4"
108020-1450	145mm	32mm / 1 1/4"
108020-1500	150mm	32mm / 1 1/4"

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL55 cutters to 19.05mm standard Magnet Drill fitting; includes pilot for 55mm Depth Cutters

Part No	Details
103091-1932-55	19.05 Male to 32mm Female Weldon Adapter + Pilot for 55mm cutters

32mm Weldon Shank Morse Taper Arbor and Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4"
103013-0324	MT4	32mm / 1 1/4"
108020P-1500	CarbideMax55 Pilot Pin, 61-150mm, Pk 2	

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax XL110 - TCT Broach Cutters

Part No	D Ø mm	Shank Size
108040-0610	61mm	32mm / 1 1/4"
108040-0620	62mm	32mm / 1 1/4"
108040-0630	63mm	32mm / 1 1/4"
108040-0640	64mm	32mm / 1 1/4"
108040-0650	65mm	32mm / 1 1/4"
108040-0660	66mm	32mm / 1 1/4"
108040-0670	67mm	32mm / 1 1/4"
108040-0680	68mm	32mm / 1 1/4"
108040-0690	69mm	32mm / 1 1/4"
108040-0700	70mm	32mm / 1 1/4"
108040-0730	73mm	32mm / 1 1/4"
108040-0750	75mm	32mm / 1 1/4"
108040-0800	80mm	32mm / 1 1/4"
108040-0850	85mm	32mm / 1 1/4"
108040-0900	90mm	32mm / 1 1/4"
108040-0950	95mm	32mm / 1 1/4"
108040-1000	100mm	32mm / 1 1/4"
108040-1050	105mm	32mm / 1 1/4"

Part No	D Ø mm	Shank Size
108040-1100	110mm	32mm / 1 1/4"
108040-1150	115mm	32mm / 1 1/4"
108040-1200	120mm	32mm / 1 1/4"
108040-1250	125mm	32mm / 1 1/4"
108040-1300	130mm	32mm / 1 1/4"
108040-1350	135mm	32mm / 1 1/4"
108040-1400	140mm	32mm / 1 1/4"
108040-1500	150mm	32mm / 1 1/4"

NEW: 160-200mm TCT Cutters

Part No	D Ø mm	Shank Size
108040-1600	160mm	32mm / 1 1/4"
108040-1700	170mm	32mm / 1 1/4"
108040-1800	180mm	32mm / 1 1/4"
108040-1900	190mm	32mm / 1 1/4"
108040-2000	200mm	32mm / 1 1/4"

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL110 cutters to 19.05mm standard Magnet Drill fitting; includes pilot for 110mm Depth Cutters

Part No	Details
103091-1932-110	19.05 Male to 32mm Female Weldon Adapter + Pilot for 110mm cutters

32mm Weldon Shank Morse Taper Arbor and Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4"
103013-0324	MT4	32mm / 1 1/4"
108040P-1500-2P	CarbideMax 110 2 Piece Pilot Pin 61-200mm, Pk2	

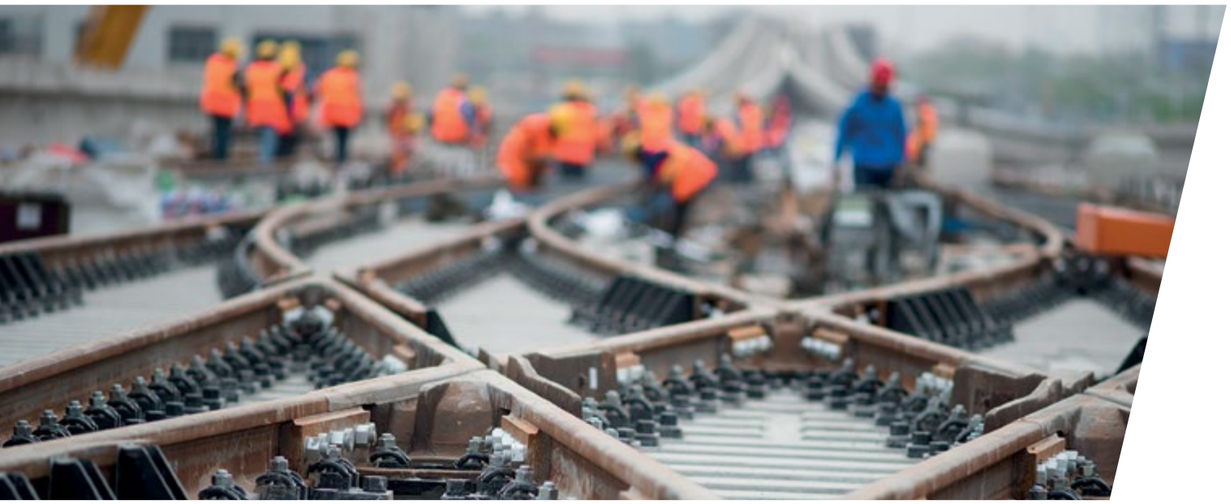
CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax 30 Rail Broach Cutters

Part No	Diameter mm	Shank Size
106030-0180	**18mm**	19.05mm / 3/4”
106030-0200	**20mm**	19.05mm / 3/4”
106030-0220	**22mm**	19.05mm / 3/4”
106030-0240	**24mm**	19.05mm / 3/4”
106030-0260	**26mm**	19.05mm / 3/4”
106030-0280	**28mm**	19.05mm / 3/4”
106030-0300	**30mm**	19.05mm / 3/4”
106030-0320	**32mm**	19.05mm / 3/4”
106030-0360	**36mm**	19.05mm / 3/4”

CarbideMax 30 Rail Pilot Pin 18 -36mm Cutters

Part No	Dia Ø	Length	Unit of sale
106030P-0360	**7.98**	77	Pack 2



CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

CarbideMax 55 Rail Broach Cutters

Part No	Diameter mm	Shank Size
106020-0180	**18mm**	19.05mm / 3/4”
106020-0200	**20mm**	19.05mm / 3/4”
106020-0220	**22mm**	19.05mm / 3/4”
106020-0240	**24mm**	19.05mm / 3/4”
106020-0260	**26mm**	19.05mm / 3/4”
106020-0280	**28mm**	19.05mm / 3/4”
106020-0300	**30mm**	19.05mm / 3/4”
106020-0320	**32mm**	19.05mm / 3/4”
106020-0330	**33mm**	19.05mm / 3/4”
106020-0360	**36mm**	19.05mm / 3/4”

CarbideMax 55 Rail Pilot Pin 18 - 36mm Cutters

Part No	Dia Ø	Length	Unit of sale
108020P-0600	**7.98**	103	Pack 2

CARBIDEMAX® ULTRA
TUNGSTEN CARBIDE TECHNOLOGY

HMT have developed a generation of ULTRA cutting tools for drilling very hard materials.

The specialist ULTRA coating is proven to significantly increase tool life working with extremely hard materials and wear plates such as Hardox.

Ultra Cutters can also be used to increase service life in other challenging materials such as Armor plates, Inconel, Stainless Steel etc.

CarbideMax Ultra Tools are produced from premium grade materials and coated using a range of state of the art, high-temperature surface coatings.

ULTRA coated Carbide Tools are capable of providing a service life increase in excess of 9X longer than uncoated TCT tools.

It should be understood that drilling holes in these very hard materials is a specialist task and good results are dependent on the right setup - including high torque/slow speed, geared Magnet Drills, like the VersaDrive Series, ample BioCut Blue lubricant.

Using the incorrect Magnet drill or a poorly maintained Magnet drill with unstable drilling operation, poor magnet hold and excessive pressure or inadequate lubrication is likely to result in rapid tool failure.

Wear Plate Uses

Wear plates and abrasion resistant steels are typically up to 5x harder than standard S275 Structural grade steel and are used in industries needing very hard or wear resistant steel plates, for instance aggregate & waste processing and conveying, Mining & excavation industries etc.

They are also used for fabricating & protecting earth moving excavation parts like digger buckets.

Machining Wear Plates

The extreme hardness and wear resistance of the these materials makes machining them extremely challenging, especially when the application requires the use of portable tools like Magnetic Drills.

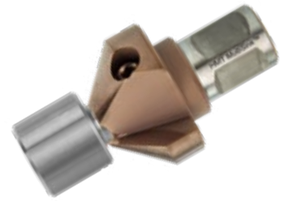
It should be understood that even with high tech tooling, successfully machining Wear plates is challenging with little or no margin for error. It requires experienced operators, quality, premium Magnetic Drills suitable for these applications, and the specially developed BioCut Blue cutting fluid when broaching or Speedlube Aerosol spray when countersinking.

Commonly found brands and types of wear plate include:

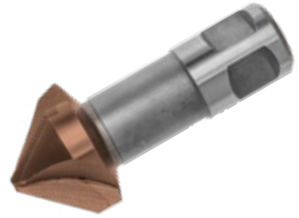
HARDOX - CREUSABRO - ABRO - RAEX - STRENX - BISALLOY

HARDOX & WEAR PLATE TOOLING

CarbideMax ULTRA TCT Broach Cutter
108070
Page 72



CarbideMax ULTRA Coated MultiSink
601056
Page 73



CarbideMax ULTRA 90° Countersink 32mm
601036
Page 74

BEST PRACTICE ADVICE FOR DRILLING WEAR PLATE STEEL:

Broaching Wear Plate Steel

- *Cautious & Gentle feed pressure should be used at all times, especially during the start of the cut and exiting the material*
- *Generous application of Biocut Blue cutting fluid should be used during the cut & applied frequently during the cut*
- *Backing off the cutter & applying more BioCut Blue is necessary for increasing tool life*
- *Swarf removal from the cutter is also required for longer tool life*

16-18mm diameter	*450-250 RPM (No Load)*
20-26mm diameter	*360-250 RPM (No Load)*

Countersinking Wear Plate Steel

- *For best results the Countersink must be piloted*
- *Do not allow the countersink to vibrate over swarf while cutting as this will cause chatter, ultimately causing the cutting edges to chip & blunt*
- *Regular Speedlube application & regular swarf removal on countersinking is essential*
- *A hand brush works better than mag stick to clean cutter and material surface*

32mm diameter	*60-125 RPM (No Load)*
40mm diameter	*60-110 RPM (No Load)*
55mm diameter	*60-80 RPM (No Load)*

When using a geared drilling machine, use low gears to provide maximum torque
When using a Mag Drill with Electronic Torque Control, i.e.. V85T – V125T, speed should be lowered

ULTRA Coated TCT Broach Cutters

CarbideMax Ultra cutters are specifically designed for the toughest broaching jobs on the planet, including Hardox steel.

Our ULTRA TCT Broach 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.

- *Increased wear resistance in the hardest materials*
- *Elaborate tool geometry for faster, quieter cutting*
- *Chatter free performance when used correctly*
- *Up to 55mm depth of cut*
- *Standard 19.05mm Weldon shank*
- *Use with high torque/slow speed, geared magnet drills*
- *ULTRA coated for optimum performance and lifespan*

HARDOX BROACHING TOOL

WELDON SHANK

ULTRA

19.05mm 3/4"
Weldon Shank

Ultra Coated CarbideMax 55 TCT Cutters *Additional Sizes are available to order*

Part No	Diameter mm	Shank Size
108070-0160	**16mm**	19.05mm / 3/4"
108070-0180	**18mm**	19.05mm / 3/4"
108070-0200	**20mm**	19.05mm / 3/4"
108070-0220	**22mm**	19.05mm / 3/4"
108070-0240	**24mm**	19.05mm / 3/4"
108070-0260	**26mm**	19.05mm / 3/4"

CarbideMax ULTRA 55 Pilot Pins

Part No	D Ø	Length	Cutter Size	Qty
108020P-0170	**6.34**	103	12-17mm	Pack 2
108020P-0600	**7.98**	103	18-60mm	Pack 2

ULTRA Coated Broach Cutter Set

Part No	Set Contains
108070-SET	ULTRA Broach cutters 12, 14, 18, 22 & 26mm

ULTRA Coated MultiSink

Ultra coated Multisink for increased wear resistance whilst countersinking the toughest materials like Hardox, Inconel and Armor plate.

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

- *Innovative Combination Countersinking Tool.*
- *Save Time Completing Countersunk Holes.*
- *Suitable for holes of 16mm and above*
- *For holes smaller than 16mm, see the 32mm Ultra countersink*

COMBINATION COUNTERSINKING TOOL FOR HARDOX

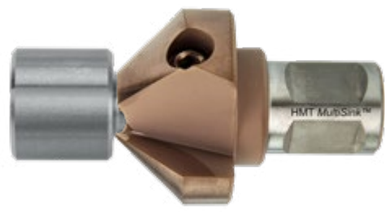
WELDON SHANK

ULTRA

19.05mm 3/4"
Weldon Shank

Ultra Coated MultiSink

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



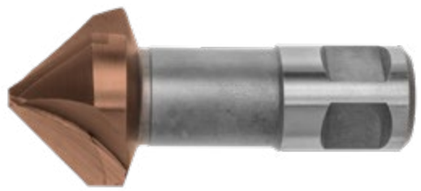
MultiSink Pilot

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

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

HMT Weldon Shank TCT Countersink ULTRA Coated, 32mm 90°

NEW



Premium countersink with 3X heavy duty tungsten carbide inserts for maximum life in challenging materials. Plus ULTRA high-temperature surface coating to optimise cutting performance.
Standard 19.05mm Weldon shank for use in all standard magnet drills. Use with a 101013 Morse taper arbor to use in a pillar drill press or radial drill

Part No	Size
601036-0320	32mm ULTRA Countersink

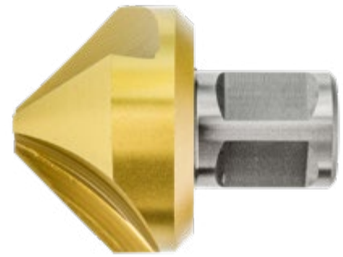
HMT Weldon Shank TCT Countersink, 32mm 90°

NEW

Premium countersink with 3X heavy duty tungsten carbide inserts for maximum life in challenging materials
Standard 19.05mm Weldon shank for use in all standard magnet drills. Use with a 101013 Morse taper arbor to use in a pillar drill press or radial drill

Part No	Size
601035-0320	32mm TCT Countersink

GoldMax HSS Weldon Countersink - 90°



Specially coated for increased tool life,
Standard 19.05mm Weldon shank for use in all standard magnet drills.

Part No	Size
601025-0300	30mm
601025-0400	40mm
601025-0550	55mm

VersaDrive MultiSink® System

The MultiSink is a worldwide unique new Combination Countersink Tool 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.

Size Available: 40 & 55mm

Refer to P44 for more information.

HMT 90° Carbide Indexable Countersink 76mm

NEW

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

HMT Magnet Drill Countersink - 50mm, 60°

NEW

High Speed Steel material with precision ground flutes.
Standard 19.05mm Weldon shank for use in all standard magnet drills.

Part No	Size
601040-0500	50mm

VersaDrive Countersink 90°

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

Sizes Available: 6.3 - 31mm

Refer to P36 for more information.

VersaDrive Combination DrillSink Tool

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.

Sizes Available: 6.8 - 14mm Drill size with 12.4 - 25mm Countersinks

Refer to P34 for more information.

Weldon Shank Twist Drill Bits

HSS-XE twist drill bits with integrated magnet 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 or tapping size holes has been a long and time consuming job in the past, fitting the Silvermax Magnet Twist Drills into a magnet drill can suddenly make the job far quicker and safer than struggling with a pistol drill and jobber drills.

- *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*
- *Sizes from 5 - 12mm*
- *Fits any standard 19.05mm arbor*

USE WITH ANY STANDARD MAG DRILL

WELDON SHANK

Part No	Diameter mm	Shank Size	Tap Size (Metric Coarse)
201070-0050	**5.0mm**	19.05mm / 3/4"	M6
201070-0060	**6.0mm**	19.05mm / 3/4"	-
201070-0068	**6.8mm**	19.05mm / 3/4"	M8
201070-0070	**7.0mm**	19.05mm / 3/4"	-
201070-0080	**8.0mm**	19.05mm / 3/4"	-
201070-0085	**8.5mm**	19.05mm / 3/4"	M10
201070-0090	**9.0mm**	19.05mm / 3/4"	-
201070-0100	**10.0mm**	19.05mm / 3/4"	-
201070-0102	**10.2mm**	19.05mm / 3/4"	M12
201070-0110	**11.0mm**	19.05mm / 3/4"	-
201070-0120	**12.0mm**	19.05mm / 3/4"	-

Weldon Drill Bit Sets

Part No	Contents
201070-SET	4 piece Set contains: 6, 8, 10, 12mm Weldon Drill Bits
201070-TSET	4 piece Set contains: 5.0, 6.8, 8.5, 10.2mm Weldon Drill Bits Tap Sizes

ImpactaMag Reamers

The ImpactaMag™ HSS reamer is a unique double-use reamer for enlarging and aligning holes in metals and hard materials.

Specially designed cutting geometry allows the tool to be used in an Impact wrench or a Magnet drill. When used in an Impact wrench it is secured into a special adapter meaning the tool is easier to control, apply correct feed rate, and withdraw from the finished hole, enhancing tool life. This reamer will also fit into a standard Weldon magnet drill arbor.

- *Ideal for steel erection & bridge work*
- *Ideal for modifying & enlarging holes*
- *Secured directly to the Impact Wrench*
- *Can be used with any standard Magnet Drill*
- *Available in intermediate sizes*
- *Unique 6 flute design for faster, smoother cut*
- *Prepare holes ready for installation of TCB & friction grip bolts*

MODIFY OR ENLARGE HOLES

IMPACT RATED

Part No	Max Diameter mm (D)	Shank Size	d1 mm	L mm	l1 mm	l2 mm	Minimum torque to Ream 15mm steel
501020-0140	**14mm**	19.05mm / 3/4"	7	140	52	50	340 Nm
501020-0180	**18mm**	19.05mm / 3/4"	9	165	61	53	360 Nm
501020-0200	**20mm**	19.05mm / 3/4"	11	178	62	65	380 Nm
501020-0220	**22mm**	19.05mm / 3/4"	13	178	62	65	400 Nm
501020-0240	**24mm**	19.05mm / 3/4"	15	178	63	63	520 Nm
501020-0260	**26mm**	19.05mm / 3/4"	16	178	67	60	520 Nm
501020-0280	**28mm**	19.05mm / 3/4"	19	178	67	60	600 Nm
501020-0300	**30mm**	19.05mm / 3/4"	21	178	64	63	650 Nm
501020-0320	**32mm**	19.05mm / 3/4"	22.5	178	64	63	650 Nm
501020-0330	**33mm**	19.05mm / 3/4"	23	200	70	57	650 Nm
501020-0360	**36mm**	19.05mm / 3/4"	26	200	71	57	800 Nm
501020-0390	**39mm**	19.05mm / 3/4"	29	200	70	56	1000 Nm

ImpactaMag® Reamer Sets

Part No	Set Contains
501020-3SET	14, 18, 22mm ImpactaMag Reamers
501020-SET-WO	14, 18, 22, 26, 32mm ImpactaMag Reamers

• Sets do not include adapter

ImpactaMag® Impact Adapter

Part No	Square Drive Size	Shank Size
00200-12A-19	**1/2"**	19.05mm / 3/4"
00200-34A-19	**3/4"**	19.05mm / 3/4"

• Supplied with retention pin & ring.

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"

Standard Weldon Shank Extension Arbor

- Select appropriate pilot pin from box below
- 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"

Morse Taper Sleeve

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

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
103616-E44	MT4 outside, MT4 inside
103616E-E43	MT4 outside, MT3 inside

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"

Replacement Grub Screws

Part No	Thread Size	Head 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

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

Magnet Drill Chuck & Adapter

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

32mm to 19.05mm Weldon Shank Adapter & Pilot

Adapts 32mm Shank XL55 cutters to 19.05mm standard Magnet Drill fitting; includes pilot for 55mm Depth Cutters

Part No	Details
103091-1932-55	19.05 Male to 32mm Female Weldon Adapter + Pilot for 55mm cutters
103091-1932-110	19.05 Male to 32mm Female Weldon Adapter + Pilot for 110mm cutters

32mm Weldon Shank Morse Taper Arbor & Pilot

Spring loaded for cutter slug ejection

Part No	Arbor Size	Shank Size
103013-0323	MT3	32mm / 1 1/4"
103013-0324	MT4	32mm / 1 1/4"

Magnetic Swarf Lifter

Part No	Total Length	Magnet Length
103011-0001	400mm	180mm

Quick Change Morse Taper Magnet Drill Arbor

Morse Taper Arbor with a smooth action, rotating collar and push-release action to allow rapid tool or adapter loading and unloading without the need for fiddly, time consuming grub screws or Allen keys. Takes 19.05mm (3/4") Magnet Drill Weldon fitting.

Part No	Description
103016-0192	MT2 Quick change arbor
103016-0193	MT3 Quick change arbor

GoldMax Tungsten Carbide Burrs

GoldMax TCT Burr - Flame

Standard 6mm Shank

Part No	Head Dimension	Total Length
402050-0060	6 x 16mm	60mm
402050-0120	12 x 25mm	70mm

GoldMax TCT Burr - Cylinder

Standard 6mm Shank

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

GoldMax TCT Burr - Ball Nose

Standard 6mm Shank

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

GoldMax TCT Burr - Ball

Standard 6mm Shank

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

GoldMax TCT Burr - Tree

Standard 6mm Shank

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

GoldMax TCT Burr - 4 Piece Set

4 Piece set contains Flame, Cylinder, Ball Nose and Tree Burrs in 12mm head diameter

Part No	Head Dimension
4020-SET1	12mm

Metal Cutting Lubricants

SpeedLube™ Lubricant Spray

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 and heat dissipation. Easy one-handed application provides fast, efficient lubricant coverage and minimises the amount of applications needed during the drilling process. Unique 360° valve which enables Speedlube to be sprayed from all angles.

Part No	Aerosol Size	Unit of Sale
701010-0002	500ml	Each
701010-0002-P12	500ml	Pack 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

AeroPaste™ Lubricant Spray

AeroPaste™ is an aerosol applied paste-type, metalworking lubricant for hole broaching, tapping, reaming & drilling applications. Ideal for overhead or positional application, the high viscosity of AeroPaste allows it to cling directly to the cutting tool or steel it is applied to, without fluid run-off.
Ideal for use in environmentally sensitive areas such as above water. Using AeroPaste minimises repainting or galvanising issues caused by conventional soluble lubricants and reduces mess and slipping hazards.

Part No	Aerosol Size	Unit of Sale
701010-0001	500ml	Each
701010-0001-P12	500ml	Pack of 12

BioCut Paste - Drilling & Tapping Paste

BioCut Drilling & BioCut 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, taps, countersinks, reamers and broach cutters. 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

CARBIDEMAX®
TUNGSTEN CARBIDE TECHNOLOGY

TCT Broach Cutter - Data Sheet

Cutter Diameter	Structural Steel <500Nm (S275, S355) 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	Cast Iron-Grey	Aluminium
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
12-19 mm	1265-850	850-580	530-350	925-615	2200-1560
20-25 mm	840-650	550-410	345-255	610-440	1480-1140
26-32 mm	545-460	410-315	250-200	430-335	1125-890
33-39 mm	460-395	315-265	195-170	330-280	885-730
40-46 mm	405-340	265-250	165-140	280-235	720-620
47-53 mm	335-300	250-195	135-120	235-205	615-545
54-60 mm	295-265	195-180	120-105	200-180	540-475
61-70 mm	260-230	180-140	105-90	180-160	475-415
71-80 mm	230-200	140-130	90-70	160-145	410-365
81-90 mm	195-180	130-115	70-65	140-125	350-325
91-100 mm	180-160	115-100	60-55	125-110	320-280
101-112 mm	160-140	100-90	55-50	110-100	280-250
113-124 mm	140-120	90-85	50-48	100-90	250-235
125-136 mm	120-110	85-75	48-45	90-80	230-205
137-150 mm	110-100	70-65	45-40	80-75	205-190

Best Practice Advice

GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Centre punch or pilot drill the surface for accurate hole start.	7	Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.
2	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.	8	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
3	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.	9	For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf.
4	Avoid lateral movement or tilting which can cause damage to the cutter.	10	When drilling multiple layers of steel CarbideMax Stack Laminate cutters are designed with a special tooth geometry to avoid stuck slugs.
5	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	11	Selecting the correct machine will often result in better life from the consumables and a quicker completion of the task.
6	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.		

Quick Guide

1	*Adjust RPM to match the material hardness*
2	*Slowly and cautiously begin cutting before increasing pressure*
3	*For best results and swarf clearance always select a cutter longer than the material thickness*
4	*For hard materials and wear plates like Hardox use Ultra coated cutters. See page 76*

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TCT HoleCutter - Data Sheet

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)	Fibreglass	Composite	Plastics	Wood
Diameter Ø	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	780-705	1350-850	900-640	1495-1010
18-25MM	850-625	580-420	350-250	1575-1125	600-455	700-520	850-625	620-450	990-895
26-31MM	620-500	415-325	240-195	1080-885	435-345	500-405	620-500	440-345	895-850
32-39MM	480-410	320-275	195-160	875-740	330-285	400-330	480-410	345-280	850-740
40-46MM	390-340	270-220	160-145	730-620	285-240	315-275	390-340	175-235	740-610
47-53MM	335-300	220-180	140-120	615-545	235-215	275-245	335-300	235-215	600-505
54-60MM	295-260	180-165	115-100	525-485	210-180	240-215	295-260	210-185	500-460
61-70MM	260-225	165-155	100-90	475-415	180-160	205-185	260-225	180-160	455-400
71-80MM	220-195	155-140	90-75	410-365	155-140	180-160	220-195	155-140	395-360

Best Practice Advice

GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Centre punch or pilot drill the surface for accurate hole start	6	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
2	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	7	When using a Magnet Drill regularly check that the slides, handles, arbors and movable parts have not vibrated loose over time.
3	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut	8	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Avoid lateral movement or tilting which can cause damage to the tool	9	For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf.
5	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	10	For thicker materials, predrill 6.35mm pilot drill first and use then sprung pilot drill or pilot pin as a guide.

Quick Guide

1	*Optimum life and performance when used with rotary pistol drills*
2	*Good results from SDS Drills when used in Rotary-Only mode*
3	*For best results pre-drill the pilot hole*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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ImpactaStep Cutter - Data Sheet

Impact Torque Nm

Reamer Diameter	Impact Torque <12mm Thick Steel	Impact Torque <25mm Thick Steel
Diameter Ø	Nm Torque	
8MM	200	380
10MM	220	400
12MM	280	420
1/2”	300	445
14MM	320	480
9/16”	330	490
5/8”	335	505
16MM	340	510
11/16”	350	525
18MM	360	540
3/4”	370	550
20MM	380	570
22MM	400	600
7/8”	425	630
15/16”	460	695
24MM	520	780
1”	530	805
26MM	545	840
1-1/16”	575	875

Impact Torque <1/2" Thick Steel	Impact Torque <1" Thick Steel
Ft Lb Torque	
160	290
175	300
185	305
205	310
220	330
235	355
250	375
260	390
265	400
270	410
280	420
285	425
300	435
310	440
380	575
385	600
390	620
405	640
440	660

Revolutions per minute (Rotary)

Reamer Diameter	Structural Steel <500Nm 32m/Min	Structural Steel <1000Nm 18m/Min	Stainless Steel INOX 12m/Min	Brass 32m/Min	Cast Iron (Grey) 16m/Min	Aluminium 45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2”	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16”	690	360	305	450	450	1025
5/8”	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16”	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4”	490	230	195	250	280	745
20MM	490	230	195	510	250	745
22MM	460	210	180	470	235	690
7/8”	460	210	180	235	235	675
15/16”	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1”	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16”	295	130	125	190	385	380

Best Practice Advice

GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	When drilling into box section ensure the tip of the tool 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.
7	Flame cut, laser cut or punched holes may not be possible to ream with Impact Wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive Reamer.		

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Excellent life and performance when used with rotary pistol drills or drill presses*
3	*Suitable for stainless and harder materials if used at low RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Step Drill - Data Sheet

Metric

Impact Torque Nm

Step Drill Diameter	Impact Torque
Diameter Ø	Nm Torque
3-12 mm	200-280
14-22 mm	330-400
24-30 mm	400-485
32-40 mm	610-750

Revolutions per minute (Rotary)

Step Drill 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
3-12 mm	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
14-22 mm	597-430	390-270	200-145	600-440	245-180	380-275
24-30 mm	420-330	260-215	140-110	420-330	175-135	275-180
32-40 mm	260-230	160-145	85-75	260-230	95-85	150-140

Inch

Impact Torque Ft Lbs

Step Drill Diameter	Impact Torque
Diameter Ø	Ft Lbs Torque
3/16-1/2”	270-380
3/16-7/8”	440-540
1/4-1-3/8”	540-660

Revolutions per minute (Rotary)

Step Drill 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
3/16-1/2”	3100-1200	2000-740	1000-380	3100-1200	1300-450	1800-650
3/16-7/8”	597-430	390-270	200-145	600-440	245-180	380-275
1/4-1-3/8”	420-330	260-215	140-110	420-330	175-135	275-180

Best Practice Advice

GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	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.

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Excellent life and performance when used with rotary pistol drills or drill presses*
3	*Suitable for stainless and harder materials if used at low RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Drill Bit - Data Sheet

Revolutions per minute (Rotary)

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
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
3- 4MM	3400-2550	1700-1250	850-700	3400-2550	2000-1300	4300-2000	5200-3500
5 - 9MM	2100-1140	1020-575	760-420	2050-1130	1200-600	1750-1040	3400-1550
10-15MM	1030-660	520-350	385-225	1020-660	550-340	1025-620	1500-950
16-20MM	640-490	335-230	220-195	640-510	330-250	600-470	975-745
21-25MM	460-330	220-140	190-150	500-410	240-200	460-350	730-500
26-32MM	310-250	140-110	150-120	320-275	200-175	335-320	400-315

Impact wrench / Impact Driver Required Nm Torque										
6mm	6.8mm	7mm	8mm	8.5mm	9mm	10mm	11mm	12mm	13mm	14mm
140 Nm	170 Nm	195 Nm	240 Nm	270 Nm	360 Nm	375 Nm	405 Nm	420 Nm	435 Nm	440 Nm

Best Practice Advice

GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Apply firm, steady feed pressure throughout the cut	5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Avoid lateral movement or tilting which can cause damage to the tool	6	VersaDrive Drill Bits up to 10mm diameter can be driven by an Impact wrench (in rotary mode only)

Quick Guide

1	*Drill Bit - Optimum life and performance when used with rotary pistol drills*
2	*Drill Bit - Up to 10mm can be used on impact wrench & impact drivers for fast cutting performance*
3	*Drill Bit - Suitable for harder materials such as stainless steel when used at reduced RPM*
4	*Turbo Tip - For fastest performance use on impact wrenches & impact drivers*
5	*Turbo Tip - For optimum life and accuracy use with pistol drills and magnet drills*
6	*Turbo Tip - Suitable for use on standard construction grade steels such as Structural or Stainless Steel.*
7	*Use appropriate lubrication and correct RPM to achieve long tool life*

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ImpactaTaps - Data Sheet

Impact Torque Nm

Thread Diameter	Impact Tapping Torque 6mm Steel	12mm Steel	25mm Steel	Impact Tapping Torque 1/4" Steel	1/2" Steel	1" Steel
Diameter Ø	Nm Torque			Ft Lbs Torque		
M3	105	160	N/A	80	120	N/A
M4	120	180	N/A	90	135	N/A
M5	135	200	N/A	100	150	N/A
M6	140	240	400	105	180	N/A
1/4"	145	255	410	105	180	295
5/16"	145	265	420	110	205	320
M8	150	280	430	115	210	330
3/8"	165	290	440	125	220	355
M10	170	300	480	125	220	360
M12	185	320	512	135	235	400
1/2"	190	330	525	135	235	375
M14	190	340	544	140	250	400
5/8"	195	355	555	145	365	425
M16	200	360	576	150	265	425
3/4"	245	385	615	230	295	470
M20	315	400	640	235	300	470
7/8"	N/A	515	775	N/A	370	710
M24	N/A	600	960	N/A	440	720
1"	N/A	695	1050	N/A	445	735
M27	N/A	740	1184	N/A	545	875
M30	N/A	800	1200	N/A	590	885

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165
M27	105	90	75	330	145
M30	95	80	60	310	130

Best Practice Advice

*GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	ImpactaTaps are recommended for through hole applications only.	7	Regularly apply 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, 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 thread by hand before driving it through at the correct torque

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Laser cut holes & Stainless Steel require higher torque*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

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Combi Drill Taps - Data Sheet

Impact Torque Nm

Thread Diameter	Impact Tapping Torque 6mm Steel	12mm Steel	25mm Steel
Diameter Ø	Nm Torque		
M3	105	160	N/A
M4	120	180	N/A
M5	135	200	N/A
M6	140	240	N/A
1/4"	145	255	N/A
5/16"	145	265	N/A
M8	150	280	N/A
3/8"	160	290	N/A
M10	170	300	N/A
M12	185	320	512
1/2"	190	330	520
M14	195	340	544
5/8"	195	355	555
M16	200	360	576
3/4"	245	380	610
M20	315	400	640
7/8"	N/A	515	715
M24	N/A	600	960
1"	N/A	675	1050

Impact Tapping Torque 1/4" Steel	1/2" Steel	1" Steel
Ft Lbs Torque		
75	120	N/A
90	130	N/A
95	145	N/A
100	180	N/A
105	175	295
105	205	330
110	205	N/A
115	220	355
125	220	N/A
135	235	380
140	235	375
140	300	405
145	365	425
150	265	425
185	295	470
230	295	475
N/A	370	710
N/A	420	720
N/A	445	735

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165

Best Practice Advice

*GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Impact Taps 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 correct NM torque power for impact wrench applications	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 - misaligned taps will greatly increase the risk of breakage.	11	301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench
6	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	12	301130- Heavy Duty Drill Taps are designed for use with Magnet 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

Quick Guide - Drill Taps (301125)

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Up to M10 (3/8") can also be used on cordless drills*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

Heavy Duty Drill Taps (301130)

1	*Correct RPM is critical for good performance on larger drill taps*
2	*Ideal for use in drill presses and magnet drills*
3	*For impact wrench use, pilot drilling is recommended*

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Impact Reamers - Data Sheet

Impact Torque Nm

Reamer Diameter	Impact Torque <12mm Thick Steel	<25mm Thick Steel
Diameter Ø	Nm Torque	
8MM	200	380
10MM	220	400
12MM	280	420
1/2"	300	445
14MM	320	480
9/16"	330	490
5/8"	335	505
16MM	340	510
11/16"	350	525
18MM	360	540
3/4"	370	550
20MM	380	570
21MM	390	580
22MM	400	600
7/8"	425	630
15/16"	460	695
24MM	520	780
1"	530	805
26MM	545	840
1-1/16"	575	875
28MM	600	900
30MM	650	975
32MM	680	1020
33MM	695	1035
36MM	740	1090
39MM	900	1150

Impact Torque <1/2" Thick Steel	<1" Thick Steel
Ft Lb Torque	
160	290
175	300
185	305
205	310
220	330
235	355
250	375
260	390
265	400
270	410
280	420
285	425
290	430
300	435
310	440
380	575
385	600
390	620
405	640
440	660
480	750
520	785
545	820
560	840
600	870
720	920

Revolutions per minute (Rotary)

Reamer Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	45m/Min
Diameter Ø	RPM Range					
8MM	940	540	410	1020	550	1365
10MM	900	510	380	1005	530	1290
12MM	875	490	370	995	520	1200
1/2"	875	490	370	520	510	1185
14MM	690	360	305	700	500	1100
9/16"	690	360	305	450	450	1025
5/8"	640	335	225	340	340	975
16MM	640	335	225	660	340	920
11/16"	535	290	210	305	305	860
18MM	535	290	210	550	305	800
3/4"	490	230	195	250	280	745
20MM	490	230	195	510	250	745
21MM	480	225	190	500	240	710
22MM	460	210	180	470	235	690
7/8"	460	210	180	235	235	675
15/16"	360	150	140	215	215	540
24MM	360	150	140	430	215	490
1"	310	140	135	200	200	410
26MM	310	140	135	375	200	400
1-1/16"	295	130	125	190	385	380
28MM	295	130	125	340	190	360
30MM	275	120	110	290	180	330
32MM	250	110	100	275	170	305
33MM	240	105	95	270	165	295
36MM	215	95	80	255	150	255
39MM	195	80	65	240	135	220

Best Practice Advice

*GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.	5	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.
2	To maximise tool life do not attempt to increase the existing hole diameter beyond 2-3mm. 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.	6	Flame cut, laser cut or punched holes may not be possible to ream with impact wrench. In this situation ream with a slow speed Magnet Drill with an ImpactaMag or VersaDrive reamer.
3	Avoid lateral movement or tilting which can cause damage to the tool	7	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	8	Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.

Quick Guide

1	*For fastest performance use on impact wrenches & impact drivers*
2	*Check the minimum torque requirement*
3	*Reamer should be rotating before starting the cut*
4	*Use steady feed pressure throughout the cut*

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DrillSink - Data Sheet

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

Refer to Page 86 for Pilot Hole Drilling Speeds

Best Practice Advice

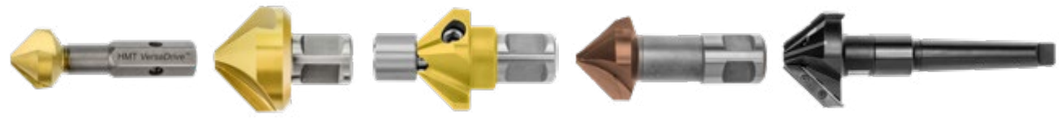
GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	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	6	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
2	Apply firm, steady feed pressure throughout the cut	7	Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
3	Avoid lateral movement or tilting which can cause damage to the tool	8	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)
4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	9	Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant	10	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage

Quick Guide

1	*Optimum life and performance when used with rotary pistol drills or drill presses*
2	*Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
3	*Suitable for harder materials such as stainless steel when used at reduced RPM*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*

Countersink - Data Sheet



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 (1/4")	765	505	265	1250	500	850
10.4 mm	460	300	145	765	315	530
12.4 mm (1/2")	385	255	110	635	265	480
16.5 mm	295	185	80	485	210	345
20.5 mm (13/16")	230	155	50	385	165	280
25 mm (1")	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

1	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage	6	Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
2	Apply firm, steady feed pressure throughout the cut	7	Use at highest available Gear setting (for maximum torque) and use electronic tachometer to set RPM at recommended speed (or slower for difficult applications)
3	Avoid lateral movement or tilting which can cause damage to the tool	8	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)
4	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.	9	Piloted Countersink Bits (like the MultiSink) will significantly increase countersinking performance preventing movement of the countersink whilst drilling.
5	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant		

Quick Guide

1	*Optimum life and performance when used with rotary pistol drills or drill presses*
2	*Up to 16.5mm can be used on impact wrench & impact drivers for fast cutting performance*
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4	*Use appropriate lubrication and correct RPM to achieve long tool life*

NEW PRODUCTS

HMT's relentless focus on product innovation and development continues to deliver new and unique tooling that speeds up metalworking.

This year we are proud to introduce a revolutionary range of new products including the world's first Impact rated combined step cutter and reamer, the ImpactaStep, alongside an expanded collection of specialist countersinks and the HMT exclusive OverReach system.

Further details and catalogue page references can be found for all these products below.

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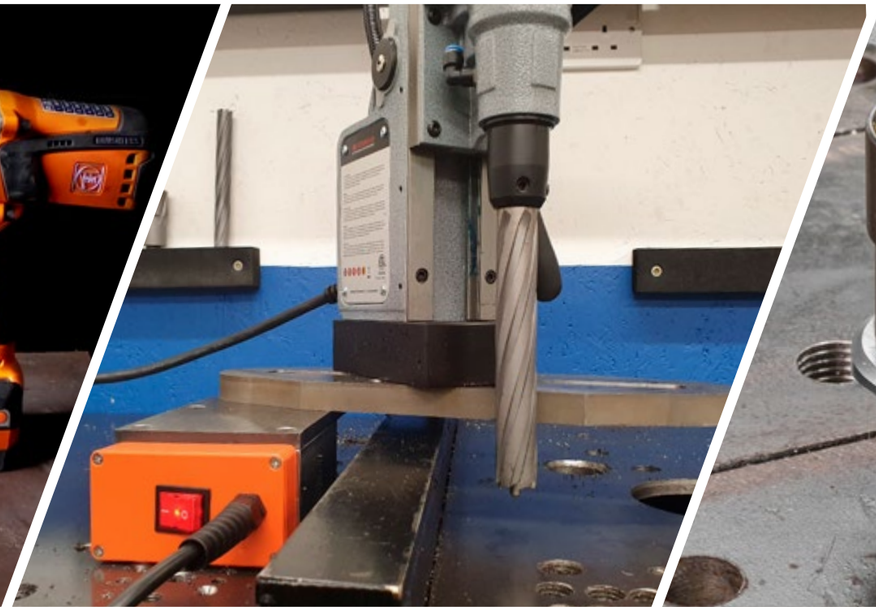
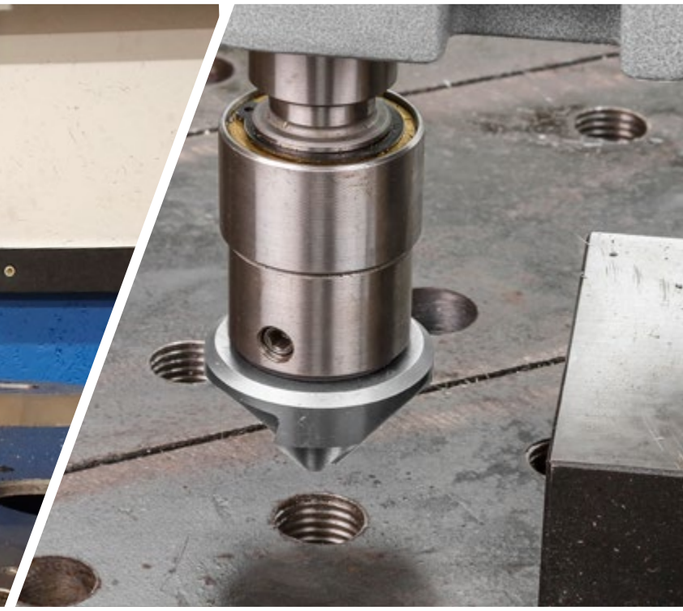
sales@holemaker-technology.com





Rapid Lock Extension 130mm

p13

Extend the working reach of all VersaDrive tools. Rapid-Lock, single handed loading

VersaDrive ImpactaStep

p14

Create & enlarge holes in material up to 12mm thick Use with Impact & Rotary drive tools

OverReach System

p54

Overcome obstacles and continue the job with the innovative OverReach system

Weldon Shank Countersinks

p74

90˚ Countersinks for use with magnet drills without the need for an adapter

VersaDrive Extra Long HoleCutter

p42

Extend your drilling with the Extra Long HoleCutter and its 100mm cutting depth

V35 Magnet Drill

p49

The most versatile compact magnet drill on the market

60˚ Magnet Drill Countersinks

p74

60˚ Countersinks for use with magnet drills without the need for an adapter

Carbide Indexible Insert Countersinks

p74

Heavy duty countersink with Morse Taper shank and replaceable Carbide Indexible inserts.

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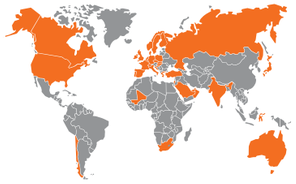
Holemaker Technology are committed to supporting our customers and dealers at every stage of the process. From initial contact through to after sales service and industry leading warranty support, we provide accessible, practical and informative technical expertise, hands on assistance and promotional assets wherever they are required.

With operations now spanning over 40 countries and the network of HMT stockists and end users growing daily, this comprehensive support enables the metalworking industry to do more, more quickly, more safely and more efficiently.

Read below to see the full scope of assets available or get in touch to discuss specific requirements:



DEALERS IN OVER 40 COUNTRIES

With an ever expanding network of stockists and resellers, HMT now operates in over 40 countries around the world. This extensive international presence strengthens stock availability for all customers and helps ensure we can deliver product where it is needed, when it is needed.

PRODUCT SUPPORT

Extensive product support is available online, on the phone and in hard copy. Answers to frequently asked questions, speeds & feeds guidance, best practice advice & additional technical support can all be found through our online product support portal and product pages, catalogue and phone based technical support centre.

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Demonstration kits are available that feature the full range of best selling VersaDrive and CarbideMax products. These kits are an invaluable aid for dealers and sales reps looking to introduce new customers to the range, helping them visualise the products in action and witness the benefits first-hand.

#VERSADRIVE TEST TEAM

VERSADRIVE TEST TEAM (VTT)

The VTT is an exclusive group of metalworking professionals dedicated to advancing the industry & its practices. By sharing their knowledge and expertise, reviewing tools and test driving new products, test team members help others discover new tools and techniques and ensure the latest HMT innovations deliver time saving advances.

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