Bi-Metal Hole Saw Recommended Cutting Speeds (in RPMs)

Size Inches	Mild Steel	Cast Iron	Tool and Stainless Steel	Brass	Aluminum
9/16	580	400	300	790	900
5/8	550	365	275	730	825
11/16	500	330	250	665	750
3/4	460	300	230	600	690
13/16	425	280	210	560	635
7/8	390	260	195	520	585
15/16	370	245	185	495	555
1	350	235	175	470	525
1-1/16	325	215	160	435	480
1-1/8	300	200	150	400	450
1-3/16	285	190	145	380	425
1-1/4	275	180	140	360	410
1-5/16	260	175	135	345	390
1-3/8	250	165	125	330	375
1-7/16	240	160	120	315	360
1-1/2	230	150	115	300	345
1-9/16	220	145	110	290	330
1-5/8	210	140	105	280	315
1-11/16	205	135	100	270	305
1-3/4	195	130	95	260	295
1-13/16	190	125	95	250	285
1-7/8	180	120	90	240	270
2	170	115	85	230	255
2-1/16	165	110	80	220	245
2-1/8	160	105	80	210	240
2-1/4	150	100	75	200	225
2-5/16	145	100	75	195	225
2-3/8	140	95	70	190	220
2-1/2	135	90	65	180	205
2-9/16	130	85	65	175	200
2-5/8	130	85	65	170	195
2-3/4	125	80	60	160	185
2-7/8	120	80	60	160	180
3	115	75	55	150	170
3-1/8	110	70	55	140	165
3-1/4	105	70	50	140	155
3-3/8	100	65	50	130	150
3-1/2	95	65	45	130	145
3-5/8	95	60	45	120	140
3-3/4	90	60	45	120	135
3-7/8	90	60	45	120	135
4	85	55	40	110	130
4-1/8	80	55	40	110	120
4-1/4	80	55	40	110	120
4-3/8	80	50	40	100	120
4-1/2	75	50	35	100	105
4-3/4	75	50	35	95	95
5	65	45	30	90	90
5-1/2	60	40	25	85	85
5-3/4	55	35	25	75	75
6	55	35	25	75	75

Hole Saw Use and Care Information

Lubricants Use a good cutting oil for faster, more efficient cutting in ferrous metals. Do not use cutting oil when cutting cast iron. Paraffin or beeswax is frequently used when cutting aluminum.

Workpiece position Do not enter the workpiece at an angle. It is important to have all the saw teeth in contact with the material to avoid tooth damage.

Feeds Hole saws require a level, even pressure to saw efficiently. Excessive pressure will contribute to premature wear, dulling of the teeth and tooth breakage. When cutting thick material, the saw should be removed from the cut at intervals to allow for chip clearances.