

# ANNULAR CUTTERS : SPECIFICATIONS

## RAIL CUTTERS



### Normal/Standard/260 Grade HP Rail Grade • Head Hardened

The cutters are designed to produce high quality accurate holes in the toughest rail grades in use.

Suitable for all rail drilling machines that have a 3/4" (19.05mm) arbor bore.

#### METRIC SIZES:

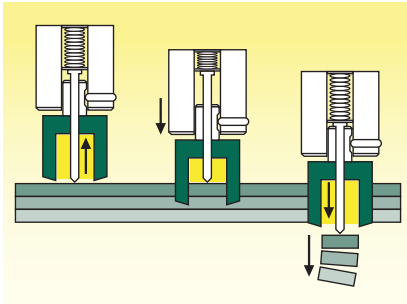
- Cutting diameters are 21mm to 40mm
- Standard depth of cut (DOC) is 25mm, and 35mm & 50mm DOC on request

#### IMPERIAL SIZES:

- Cutting diameters are 7/8" to 1.1/2"
- Standard depth of cut (DOC) is 1", and 1.3/8" & 2" DOC on request

Full details available on request.

## STACK CUTTERS



A clear breakthrough is essential when drilling stacked plates. The Powerbor® Stack Cutter has specially designed cutting edges and flutes to provide better chip clearance and offers high cutting performance.

- Purpose designed for drilling a combination of stacked plates
- More cutting edges for greater cutting efficiency
- Smoother surface of cut with multiple edges

Full details available on request.



## ANNULAR CUTTER SPEED RECOMMENDATIONS

CUTTER DIAMETER	HIGH TENSILE STEEL	MILD STEEL
MM	RPM	RPM
12	239	637
14	205	546
16	179	477
18	159	424
20	143	382
22	130	347
24	119	318
26	110	294
28	102	273
30	95	255
32	90	239
34	84	225
36	80	212
38	75	201
40	72	191
42	68	182
44	65	174
46	62	166
48	60	159
50	57	153
52	55	147
54	53	141
56	51	136
58	49	132
60	48	127
62	46	123
64	45	119
66	43	116
68	42	112
70	41	109
72	40	106
74	39	103
76	38	101
78	37	98
80	36	95
82	35	93
84	34	91
86	33	89
88	33	87
90	32	85
92	31	83
94	30	81
96	30	80
98	29	78
100	29	76

CUTTER DIAMETER	HIGH TENSILE STEEL	MILD STEEL
INCH	RPM	RPM
7/16	262	698
1/2	229	611
9/16	204	543
5/8	183	489
11/16	167	444
3/4	153	407
13/16	141	376
7/8	131	349
15/16	122	326
1	115	306
1.1/16	108	288
1.1/8	102	272
1.3/16	96	257
1.1/4	92	244
1.5/16	87	233
1.3/8	83	222
1.7/16	80	213
1.1/2	76	204
1.9/16	73	196
1.5/8	71	188
1.11/16	68	181
1.3/4	65	175
1.13/16	63	169
1.7/8	61	163
1.15/16	59	158
2	57	153
2.1/16	56	148
2.1/8	54	144
2.3/16	52	140
2.1/4	51	136
2.5/16	50	132
2.3/8	48	129
2.7/16	47	125
2.1/2	46	122
2.9/16	45	119
2.5/8	44	116
2.11/16	43	114
2.3/4	42	111
2.13/16	41	109
2.7/8	40	106
2.15/16	39	104
3	38	102
3.1/16	37	100
3.1/8	37	98
3.3/16	36	96
3.1/4	35	94
3.5/16	35	92
3.3/8	34	91
3.7/16	33	89
3.1/2	33	87
3.9/16	32	86
3.5/8	32	84
3.11/16	31	83
3.3/4	31	81
3.13/16	30	80
3.7/8	30	79
3.15/16	29	78
4	29	76

### PERIPHERAL SPEED

MILD STEEL: 24m/min - 80ft/min

HIGH TENSILE STEEL: 9m/min - 30ft/min