



Diameter		Impact Torque		Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Aluminium
		<12mm Thick Steel	<1/2" Thick Steel	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	45m/Min
Metric	8mm	Nm Torque	Ft Lb Torque	RPM Range					
	10mm	200	160	940	540	410	1020	550	1365
	12mm	220	175	900	510	380	1005	530	1290
	14mm	280	185	875	490	370	995	520	1200
	16mm	320	220	690	360	305	700	500	1100
	18mm	340	260	640	335	225	660	340	920
	20mm	360	270	535	290	210	550	305	800
	22mm	380	285	490	230	195	510	250	745
	24mm	400	300	460	210	180	470	235	690
	26mm	520	385	360	150	140	430	215	490
	32mm	545	405	310	140	135	375	200	400
	32mm	575	430	290	130	125	340	180	355
Inch	1/2"	300	205	875	490	370	520	510	1185
	9/16"	330	235	690	360	305	450	450	1025
	5/8"	335	250	640	335	225	340	340	975
	11/16"	350	265	535	290	210	305	305	860
	3/4"	370	280	490	230	195	250	280	745
	7/8"	425	310	460	210	180	235	235	675
	15/16"	460	380	360	150	140	215	215	540
	1"	530	390	310	140	135	200	200	410
	1-1/16"	575	440	295	130	125	190	385	380

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

BEST PRACTICE ADVICE

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

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

QUICK GUIDE

- For fastest performance use on Impact Wrenches & Impact Drivers
- Excellent life and performance when used with Rotary Pistol Drills or Pillar Drills
- Suitable for stainless and harder materials if used at low RPM
- Use appropriate lubrication and correct RPM to achieve long tool life

MORE INFO

