



## Hole saw bi-metal

320



### Execution

- ▶ Variable tooth splitting for less vibration
- ▶ Less heat production
- ▶ Long life
- ▶ High precision of concentric running
- ▶ Smoother cutting
- ▶ Cutting depth up to max. 38 mm
- ▶ Up to Ø 30 mm R 1/4" thread
- ▶ Up to Ø 32 mm R 3/8" thread
- ▶ R = pipe thread

### For use in



- ▶ For iron, steel, nonferrous heavy metal, light alloy, cast iron, plastics, wood, plywood, plaster board

### Application

- ▶ In all rotary and percussion drilling machines
- ▶ In machines for mechanical processing
- ▶ Pillar drilling machines or lathes
- ▶ Only for rotary use

### Packaging



■ 157 ■ 168

### Comments

- ▶ 1 = Recommended speed - Wrought Steel
- ▶ 2 = Recommended speed - Cast iron
- ▶ 3 = Recommended speed - Stainless Steel
- ▶ 4 = Recommended speed - Copper Brass
- ▶ 5 = Recommended speed - Aluminium



D Ø mm	D Ø "	1 1/min	2 2/min	3 3/min	4 4/min	5 5/min	12345	EAN 4016707	12345	€
98,0	3 7/8	90	60	45	120	135	1	110436	320 000 098	17,71
102,0	4	85	55	40	110	130	1	110443	320 000 102	18,55
105,0	4 1/8	80	55	40	110	120	1	110450	320 000 105	19,18
108,0	4 1/4	80	55	40	110	120	1	110467	320 000 108	19,85
111,0	4 3/8	80	50	40	100	120	1	110474	320 000 111	20,58
114,0	4 1/2	75	50	35	100	105	1	110481	320 000 114	21,28
121,0	4 3/4	75	50	35	95	95	1	110498	320 000 121	22,89
127,0	5	65	45	30	90	90	1	110504	320 000 127	24,26
140,0	5 1/2	60	40	25	85	85	1	110511	320 000 140	27,30
146,0	5 3/4	55	35	25	75	75	1	110528	320 000 146	28,84
152,0	6	55	35	25	75	75	1	110535	320 000 152	30,31



### Locating shank for bi-metal hole saw

No	SW 2mm	d Ø mm	LS	12345	EAN 4016707	12345	€
1		6,3	LS 14-30	1	110580	320 300 006	4,52
2	9,50		LS 14-30	1	110597	320 300 095	4,97
3	11,00		LS 14-30	1	110603	320 300 011	5,04
SDS-plus 4			LS 14-30	1	110696	320 255 001	6,27
5	9,50		LS 32-152	1	110627	320 400 095	9,24
6	11,00		LS 32-152	1	110610	320 301 011	9,70
7	11,00		LS 32-152	1	110634	320 400 011	9,70
8	16,00		LS 32-152	1	110641	320 400 016	12,57
SDS-plus 9			LS 32-152	1	110702	320 255 002	13,55



### Centre drill bit for bi-metal hole saw

L1 mm	d Ø mm	Chuck	12345	EAN 4016707	12345	€
75	6,3	Chuck 2*3*4*5*6*7*9	1	110658	320 100 080	2,24
105	6,3	Chuck 1*8	1	110665	320 100 115	2,24



### Locating shank for bi-metal hole saw

L1 mm	SW mm	Chuck	12345	EAN 4016707	12345	€
300	11,00	Chuck 3*6*7	1	110689	320 500 100	6,97

## HSS hole saw bi-metal

### Product information

- ▶ Designed for long lifetime and high cutting performance
- ▶ Always use the recommended operating speed, speed to be increased slowly if easier cutting can be noticed. Excessive speed can reduce lifetime of saw
- ▶ Always use a cutting-oil (except cast iron and wood) to help clear chips and to lubricate the saw for longer life
- ▶ Material chips to be removed regularly in the cutting region
- ▶ Start the hole-sawing with steady feed pressure and then make sure that the hole saw is really cutting the material
- ▶ The centre drill must exceed the saw teeth by approximate 3 - 4 mm
- ▶ Make sure that the hole saw always is in vertical position to the work piece surface



1



Locating shank, round

14 - 30

2 3



Locating shank, AF

14 - 30

5 6 7 8



Quick-rel. locating shank

32 - 152



Hole saw System  
320 Bi-Metall



Centre drill bit

### Item numbers for locating shanks of various hole saw manufacturers

KEIL	American SAW	MILFORD	Milwaukee	RULE	SANDVIK	STARRETT	MORSE
320 300 006	4 L	45136	49-56 6950	5514	3834-0630	A 4	M 24 K
320 300 095	5 L	45319				A 1	M 34
320 300 011	1 L	45313	49-56 7000	5518	3834-1130	A 11	M 44
320 400 016	3 L	45315	49-56 7130	5573	3834-16152	A 3	M 55 P
320 400 011	2 L	45314		5545	3834-11152		M 45 P