



Nyheter 2025

HOLEMAKER TECHNOLOGY
HMT



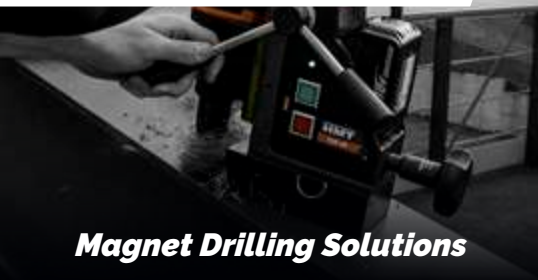
VERSADRIIVE[®]
PATENT PROTECTED

- *Plug & Play Modular Tooling System*
- *Impact Rated - Work 15x Faster*
- *Anti-Kickback for Safer Drilling*



- *NEW 18v Cordless Tools*
- *Over 200 NEW Products for 2025*
- *Portable drilling solutions to speed up Installation & Maintenance*

STEELBOR[™]



Magnet Drilling Solutions

STAKIT[®]



Protect, organise, transport

Tap blind holes without breaking the tap.

The VersaDrive® clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-power, reversible Morse Taper magnetic drill, insert a VersaDrive® Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.



- Quick change system accepts all VersaDrive® Taps
- Adapters pre-set to appropriate clutch settings
- Collar design prevents accidental tool release

- Options for tapping blind holes from M8 - M24
- Optimised for use with VersaDrive® Spiral Flute Taps
- Collar finished in rust resistant Manganese Phosphate



Art.nr.:	Infesting	Dimensjoner	Dimensjoner ("UNC)	d1 (mm)	D (mm)	L (mm)	Listepris
132002-0812	MT2	M8 - M12	5/16" - 1/2"	29	47	186	6 242,00
132002-1216	MT2	M12 - M16	1/2" - 5/8"	29	61	194	7 364,00
132002-1620	MT2	M16 - M20	5/8" - 3/4"	29	61	194	6 847,00
132003-2024	MT3	M20 - M24	3/4" - 1"	29	61	220	7 872,00
Sets							
132000-SET2	MT2 Clutched Adapter (M8 - M12) + MT2 Clutched Adapter (M12 - M16) + MT2 Clutched Adapter (M16 - M20) + M8 - M20 VersaDrive® Spiral Flute Taps						23 213,00
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) + MT2 Clutched Adapter (1/2" - 5/8" UNC) + MT3 Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps						27 689,00



FOR TECHNICAL DATA & USER ADVICE SEE P.124

Impact Tap blind holes without breaking the tap.

The VersaDrive® clutched tapping system is a unique method of effectively threading blind holes without risking damage to your taps.

Fit the adapter to a high-torque Impact Wrench, insert a VersaDrive® Spiral Flute ImpactaTap and start tapping. When the tap makes contact with the bottom of the hole, the clutch will engage and prevent the tap from breaking. Then safely back out your tap for a perfectly tapped blind hole.



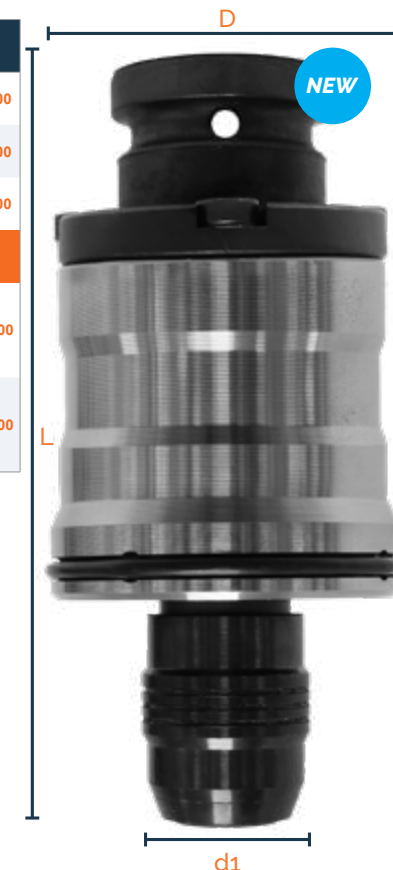
- Quick change system accepts all VersaDrive® Taps
- Adapters pre-set to appropriate clutch settings
- Collar design prevents accidental tool release
- Collar finished in rust resistant Manganese Phosphate

- Options for tapping blind holes from M8 - M24
- Optimised for use with VersaDrive® Spiral Flute Taps
- Supplied with retention pin & securing ring

Part No	Drive size	For hole sizes (Metric Coarse)	For hole sizes ("UNC)	d1 (mm)	D (mm)	L (mm)	RSP
131012-0812	1/2"	M8 - M12	5/16" - 1/2"	29	47	101	5 100,00
131012-1216	1/2"	M12 - M16	1/2" - 5/8"	29	61	116	5 473,00
131034-2024	3/4"	M20 - M24	3/4" - 1"	29	61	125	5 799,00
Sets							
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) + 1/2" Impact Wrench Clutched Adapter (M12 - M16) + 3/4" Impact Wrench Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps						20 922,00
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) + 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) + 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps						20 922,00



FOR TECHNICAL DATA & USER ADVICE SEE P.124

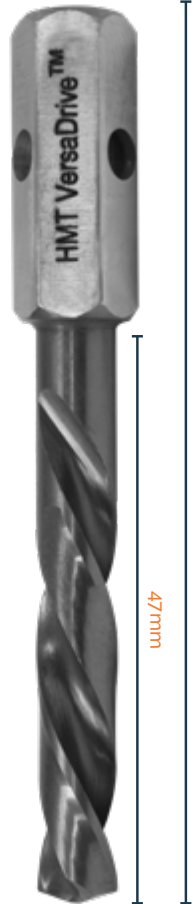


Premium specification drill bits with left-handed spiral flute. 8% Cobalt with advanced TiAlN coating to reduce friction and heat generation. Can be used both on Rotary and Impact settings.

To be used for drilling the pilot holes in broken bolts and seized studs ready for VersaDrive® Bolt extractors. Designed to run in reverse to help loosen the seized item at the same time as creating the pilot hole.



- Premium 8% Cobalt with advanced TiAlN coating
- For use on hardened bolts & studs
- Loosen seized or sheared bolts and studs
- Impact Rated for high speed operation
- Drill pilot holes ready for ImpactaBite bolt extractors to be inserted
- VersaDrive patented shank & adapters provide multiple modular solutions
- Use on impact to prevent dangerous kickback caused by handheld rotary tools



Part No.	Pilot Drill No.	Use with bolt sizes	Use with bolt sizes	Listepris
209011-030	3	M5 - M6	7/32 - 9/32"	464,00
209011-040	4	M8 - M10	5/16 - 3/8"	556,00
209011-050	5	M12 - M14	1/2 - 9/16"	619,00
209011-060	6	M16 - M20	5/8 - 3/4"	734,00
209011-070	7	M22 - M26	7/8 - 1-1/8"	948,00

Pilot Drill & Bolt Extractor Combination Set				
Part No.	Pcs.	Contents	Suitable for	Listepris
2040EX-SET1	8 pcs	ImpactaBite Left Hand Pilot Drill Bits #3, #4, #5, #6 ImpactaBite Bolt Extractors #3, #4, #5, #6	Extract bolts M5 - M20 & 7/32 - 7/8"	4 174,00



FOR TECHNICAL DATA & USER ADVICE SEE P.114

Extract broken bolts and seized studs with the new VersaDrive® impact rated bolt extractor. A vast improvement to using traditional hand operated easy-outs.

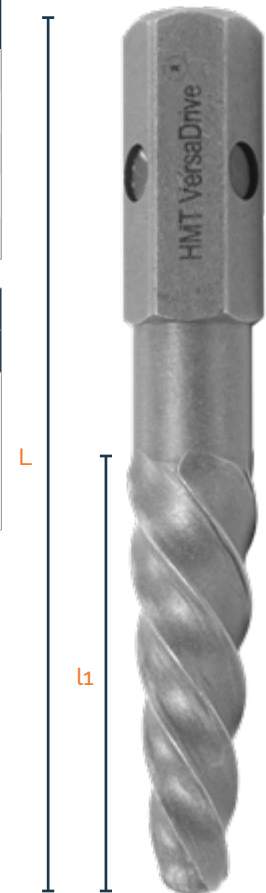
ImpactaBite uses the impact feature to break the grip caused by corroded or damaged threads. Use once the pilot holes have been created with ImpactaBite Left Hand Drill Bits.



- Extract seized or sheared bolts and studs
- Impact Rated for high speed operation
- Solid one piece steel design for heavy duty applications
- Heavy-duty hex shank design for secure non-slip operation
- VersaDrive patented shank & adapters provide multiple modular solutions
- Use on impact to prevent dangerous kickback caused by handheld rotary tools

Part No.	Bolt Extractor No.	Use with bolt sizes	Use with bolt sizes	l1 (mm)	L (mm)	Listepris
403010-030	3	M5 - M6	7/32 - 9/32"	25	65	413,00
403010-040	4	M8 - M10	9/32 - 3/8"	35	74	489,00
403010-050	5	M12 - M14	3/8 - 5/8"	39	77	569,00
403010-060	6	M16 - M20	5/8 - 7/8"	46	84	722,00
403010-070	7	M22 - M26	7/8 - 1-1/8"	49	90	987,00

STAKIT® Pilot Drill & Bolt Extractor ETOP2 12pc Set				
Part No.	Pcs.	Contents	Suitable for	Listepris
2040EX-SET2	12 pcs	ImpactaBite Left Hand Pilot Drill Bits #3, #4, #5, #6, #7 ImpactaBite Bolt Extractors #3, #4, #5, #6, #7 VersaDrive® Rapid-Lock 1/2" Impact Wrench Adapter VersaDrive® Rapid-Lock Magnet Drill Adapter VersaDrive® STAKIT® ETOP2 Half Top Case	Extract bolts M5 - M26 & 7/32 - 1-1/8"	7 182,00



FOR TECHNICAL DATA & USER ADVICE SEE P.114

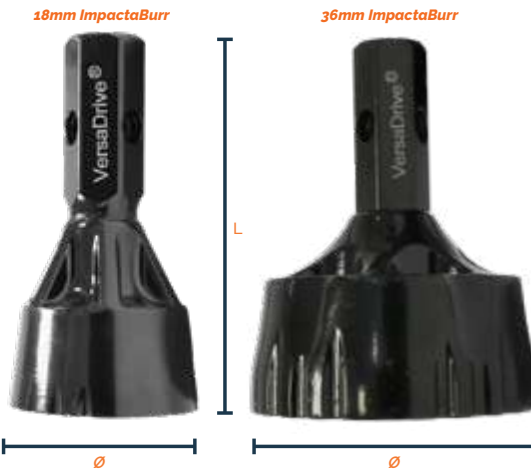
VersaDrive® ImpactaBurr TCT Chamfer Tool

The ImpactaBurr chamfer tool has tungsten carbide inserts designed to chamfer the outside edge of tube and round bar.

This removes dangerous burrs and also prepares the facing edge ready to receive an external thread or fastener.

- Quick and effective deburring and chamfering
- Impact rated to reduce dangerous kickback
- Compatible with the VersaDrive® adapter range
- 60° angle
- Impact & Rotary rated

Part No	For use with	Ø	L	Listepris
115200-0190	4 - 18mm Bar	29mm	57mm	598,00
115200-0360	19 - 36mm Bar	46mm	61mm	725,00



VersaDrive® ImpactaDie Kit

M6 - M12 Threads // 1/4 - 1/2" UNC Threads

The ImpactaDie Impact Die threading kit is a complete solution for creating and repairing external threads on metal bar.

Faster, more efficient and less fatiguing than traditional hand threading practices, the ImpactaDie system can be used to quickly and accurately cut new or repair damaged external threads using an Impact Wrench or Magnetic Drill.

Along with all necessary dies and guides for threading at sizes M6 - M12 (¼ - ½"), the kit contains the unique VersaDrive® ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading. Supplied in a VersaDrive® STAKIT® compatible ETOP2 half top case.

*requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents	Listepris
115810-SET	ImpactaDie Holder, Guide Collar, Flush Collar, M6/8/10/12 Guides, M6/8/10/12 Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case	7 077,00
115820-SET	ImpactaDie Holder, Guide Collar, Flush Collar, 1/4, 5/16, 3/8, 1/2" Guides, 1/4, 5/16, 3/8, 1/2" UNC Hex Die Nuts, ImpactaBurr Chamfer Tool, ETOP2 Case	7 077,00



FOR TECHNICAL DATA & USER ADVICE SEE P.115

Create external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- Guide collar ensures straight & true threading
- Create external threads from M6 - M12
- Create external threads up to 50mm long
- Impact chipbreaker action for effective swarf evacuation
- VersaDrive® patented shank & modular adapters provide unbeatable jobsite flexibility



- Use with Impact Wrenches (prevents dangerous kickback)
- Clean out existing external threads
- Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods



ImpactaDie Holder

43mm



Flush Collar (for repairing threads)



Guide Collar (for creating threads)



ImpactaDie Hex Die Nut



ImpactaDie Guide

VersaDrive® ImpactaDie Holder (body only)		
Part No	Suitable for	Listepris
115100-01	M6 - M12 Threads 1/4-20 - 1/2-13 UNC	1 895,00

VersaDrive® ImpactaDie Collars		
Part No	Product	Listepris
115100-02	Guide Collar for creating M6 - M12 & 1/4-20 - 1/2-13 UNC Threads	939,00
115100-03	Flush Collar for repairing M6 - M12 & 1/4-20 - 1/2-13 UNC Threads	819,00

ImpactaDie Hex 24mm Die Nut		
Part No	To create or repair threads sized	Listepris
302810-0060	M6 x 1.0	611,00
302810-0080	M8 x 1.25	706,00
302810-0100	M10 x 1.5	845,00
302810-0120	M12 x 1.75	1 058,00
302820-0010	1/4-20 UNC	617,00
302820-0020	5/16-18 UNC	717,00
302820-0030	3/8-16 UNC	859,00
302820-0040	1/2-13 UNC	1 077,00

ImpactaDie Guides		
Part No	For thread sizes	Listepris
115110-0060	M6	305,00
115110-0080	M8	323,00
115110-0100	M10	357,00
115110-0120	M12	382,00
115120-0010	1/4"	305,00
115120-0020	5/16"	323,00
115120-0030	3/8"	357,00
115120-0040	1/2"	382,00



Total assembled length of holder + guide collar + guide = 121mm

FOR TECHNICAL DATA & USER ADVICE SEE P.115

VersaDrive® ImpactaDie XL Kits

M16 - M24 Threads // M16-M25 Metric Fine Threads

Create or repair large diameter external threads on metal bar or conduit with VersaDrive® ImpactaDie XL kits.

Offering fast, easy impact-thread cutting in a variety of sizes from M16 - M25 & 5/8" - 1", the ImpactaDie XL system speeds up the challenging and traditionally time-consuming process of creating large external threads.

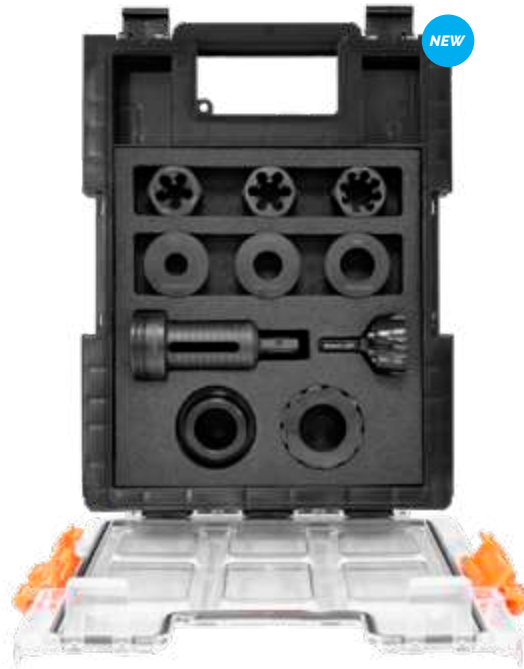
Kits include the VersaDrive® ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a VersaDrive® **STAKIT®** compatible ETOP2 half top case.

*requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents	Listepris
115810-XL-SET1 (Metric Coarse)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24 Guides, M16/20/24 Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case	12 208,00
115810-XL-SET2 (Metric fine for electrical conduit)	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/25 Guides, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case	12 273,00
115820-XL-SET (UNC)	ImpactaDie Holder, Guide Collar, Flush Collar, 5/8, 3/4, 7/8, 1" Guides, 5/8, 3/4, 7/8, 1" UNC Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case	14 413,00



NEW

VersaDrive® ImpactaDie XL Complete Kit

M16-M24 Metric Coarse & M16-M25 Metric Fine Threads

The VersaDrive® ImpactaDie XL complete kit is the ultimate solution for creating and repairing large diameter external threads in both Metric Coarse and Metric Fine sizes.

Comprising dies and guides in both Metric Coarse M16 - M24 and Metric Fine M16 - M25, this kit offers fast, easy thread cutting for fixings on standard metal bar as well as electrical conduit.

Whatever the job and whatever the challenges, the ImpactaDie XL complete kit will ensure you have the tools needed to quickly and easily tackle the issue whether it be unexpected last minute modifications, every-day workshop use or emergency on-site repairs.

The VersaDrive® ImpactaDie XL system can be used with high-torque impact wrenches and high-power magnetic drills.

The complete kit also includes the unique VersaDrive® ImpactaBurr chamfer tool which can be used to prepare a new bar ready for threading and comes supplied in a VersaDrive® **STAKIT®** compatible ETOP2 half top case.

*requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter)

L x W x H (mm) - 270 x 370 x 95

Part No	Set contents	Listepris
115810-XL-SET3	ImpactaDie Holder, Guide Collar, Flush Collar, M16/20/24/25 Guides, M16/20/24 Metric Coarse Hex Die Nuts, M16/20/25 Metric Fine Hex Die Nuts, ImpactaBurr 36mm Chamfer Tool, ETOP2 Case	16 796,00



NEW

Create XL external threads quickly and easily with this unique patent-pending impact die system.

Ideal for both creating/extending new threads, repairing existing damaged/deformed threads or cleaning old threads clogged with surface coatings, rust or other unwanted material that can prevent threads mating and turning properly.

Patent Pending GB 2319619.9

- Guide collar ensures straight & true threading
- Create external threads from M16 - M25
- Create external threads up to 75mm long
- Impact chipbreaker action for effective swarf evacuation
- VersaDrive® patented shank & modular adapters provide unbeatable jobsite flexibility
- Use with Impact Wrenches (prevents dangerous kickback)
- Clean out existing external threads
- Impact-rated due to dual hardening process - allows up to 15X faster speed than traditional methods



ImpactaDie XL Holder

59.5mm

Flush Collar
(for repairing threads)

Guide Collar
(for creating threads)

ImpactaDie XL Hex Die Nut

ImpactaDie XL Guide

VersaDrive® ImpactaDie XL Holder (body only)		
Part No	Suitable for	Listepris
115300-01	M16 - M25 Threads 5/8" - 1" UNC	2 392,00

VersaDrive® ImpactaDie XL Collars		
Part No	Product	Listepris
115300-02	Guide Collar for creating M16 - M25 & 5/8" - 1" UNC Threads	1 186,00
115300-03	Flush Collar for repairing M16 - M25 & 5/8" - 1" UNC Threads	1 034,00

ImpactaDie XL Hex 36mm Die Nut		
Part No	To create or repair threads sized	Listepris
303810-0160	M16 x 2.0	
303810-0200	M20 x 2.5	
303810-0240	M24 x 3.0	
303815-0160	M16 x 1.5 Metric Fine	
303815-0200	M20 x 1.5 Metric Fine	
303815-0250	M25 x 1.5 Metric Fine	
302830-0050	5/8" UNC	
302830-0060	3/4" UNC	
302830-0070	7/8" UNC	
302830-0080	1" UNC	

ImpactaDie XL Guides		
Part No	For thread sizes	Listepris
115310-0160	M16	834,00
115310-0200	M20	908,00
115310-0240	M24	1 039,00
115310-0250	M25	1 098,00
115320-0050	5/8"	834,00
115320-0060	3/4"	908,00
115320-0070	7/8"	1 039,00
115320-0080	1"	1 098,00

Also available with VersaDrive® MAX shank on request (115400-01)



Total assembled length of XL holder + XL guide collar + XL guide = 146,5mm

VersaDrive® Spiral Flute Tap Sets - Metric



Part No	Set contents	Listepris
309010-SET1	M6, M8, M10, M12, M16	6 782,00
309010-SET2	M12, M16, M20, M24	8 774,00

VersaDrive® Spiral Flute Tap Sets - Inch



Part No	Set contents	Listepris
309020-SET1	1/4, 5/16, 3/8, 1/2, 5/8" UNC	6 780,00
309020-SET2	1/2, 3/4, 1" UNC	8 774,00

VersaDrive® Impact Wrench Clutched Adapter Set - Metric Coarse



Part No	Set contents	Listepris
131000-SET1	1/2" Impact Wrench Clutched Adapter (M8 - M12) + 1/2" Impact Wrench Clutched Adapter (M12 - M16) + 3/4" Impact Wrench Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps	20 922,00

VersaDrive® Impact Wrench Clutched Adapter Set - Inch UNC



Part No	Set contents	Listepris
131000-INSET1	1/2" Impact Wrench Clutched Adapter (5/16" - 1/2" UNC) + 1/2" Impact Wrench Clutched Adapter (1/2" - 5/8" UNC) + 3/4" Impact Wrench Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps	20 922,00

VersaDrive® Morse Taper Clutched Adapter Set - Metric Coarse



Part No	Set contents	Listepris
132000-SET1	MT2 Clutched Adapter (M8 - M12) + MT2 Clutched Adapter (M12 - M16) + MT3 Clutched Adapter (M20 - M24) + M8 - M24 VersaDrive® Spiral Flute Taps	23 213,00

VersaDrive® Morse Taper Clutched Adapter Set - Inch UNC



Part No	Set contents	Listepris
132000-INSET2	MT2 Clutched Adapter (5/16" - 1/2" UNC) + MT2 Clutched Adapter (1/2" - 5/8" UNC) + MT3 Clutched Adapter (3/4" - 1" UNC) + 5/16 - 1" UNC VersaDrive® Spiral Flute Taps	27 689,00

VersaDrive® Spiral Flute Taps are designed for tapping blind holes.

They can be adapted for use in a reversible Magnet Drill, Impact Wrench, cordless pistol drill or even used with any standard Hand Tap wrench.

Recommended for use with the NEW VersaDrive® Clutched Adapters on p.22 & p.23.



- Ground flutes create the perfect tapped hole
- Safer tapping with minimal kickback
- Create internal threaded holes with speed and precision
- Quickly clean out & repair damaged or fouled internal threads
- Impact-rated due to dual hardening process
- Use on Impact to prevent dangerous kickback caused by handheld rotary tools
- Industrial grade Titanium Nitride coating reduces heat buildup and burn-out
- Heavy-duty hex shank design for secure non-slip operation
- Allows up to 15X faster speed than traditional methods

Metric Coarse	M Thread Size & Pitch	L (mm)	L ₁ (mm)	THS**	THS***	Listepris
309010-0060	M6 x 1.00	58	20	5.0	-	871,00
309010-0080	M8 x 1.25	60	22	6.8	-	1 043,00
309010-0100	M10 x 1.50	70	24	8.5	-	1 396,00
309010-0120	M12 x 1.75	80	29	10.2	-	1 746,00
309010-0160	M16 x 2.00	90	32	14.0	-	2 087,00
309010-0200	M20 x 2.50	100	37	17.5	-	2 716,00
309010-0240	M24 x 3.00	110	45	21.0	-	3 206,00
309010-0300	M30 x 3.50	130	48	26.5	-	3 798,00
Inch	M Thread Size & Pitch	L (")	L ₁ (")	THS**	THS***	Listepris
309020-0010	1/4 x 20 UNC	2-3/8	63/64	5.1	#7	960,00
309020-0020	5/16 x 18 UNC	2-3/8	63/64	6.6	#F	1 145,00
309020-0030	3/8 x 16 UNC	2-3/4	1	8	5/16	1 537,00
309020-0040	1/2 x 13 UNC	3-1/8	1-3/64	10.8	27/64	1 918,00
309020-0050	5/8 x 11 UNC	3-1/2	1-5/64	13.5	17/32	2 297,00
309020-0060	3/4 x 10 UNC	3-31/32	1-9/64	16.5	21/32	2 988,00
309020-0065	7/8 x 9 UNC	4-1/8	1-13/16	19.5	49/64	3 252,00
309020-0070	1 x 8 UNC	4-3/8	2	22.25	7/8	3 527,00
309020-0110	1-1/4 x 7 UNC	5	2	28	1-7/64	7 686,00



** Tap Hole Size (mm) *** Tap Hole Size (")
FOR TECHNICAL DATA & USER ADVICE SEE P.124

VersaDrive® MAX Reamer ETOP2 Kits - Metric



Part No	Reamers	Set contents	Listepris
501050-3SET	3pcs	18, 22, 26mm + 3/4" Impact Adapter	10 536,00
501050-4SET	4pcs	18, 22, 24, 26mm + 3/4" Impact Adapter	12 950,00

VersaDrive® MAX Reamer ETOP2 Kits - Inch



Part No	Reamers	Set contents	Listepris
501051-SET1	3pcs	11/16, 13/16, 15/16" + 3/4" Impact Adapter	11 094,00
501051-SET2	4pcs	11/16, 13/16, 15/16", 1-1/16" + 3/4" Impact Adapter	13 605,00

VersaDrive® MAX Impact Reamer STAKIT® Kit - 5pc



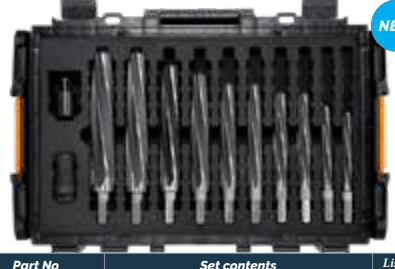
Part No	Set contents	Listepris
STC-EMID-MAX02	22, 26, 30, 32, 36mm VersaDrive® MAX Reamers, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	24 749,00
STC-EMID-INMAX02	1 3/16, 1-1/8, 1-1/4, 1-1/2, 1-5/8" VersaDrive® MAX Impact Reamers, 3/4" VersaDrive® MAX Impact Wrench Adapter, 3/4" Weldon Shank Magnet Drill Adapter	25 538,00

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Metric



Part No	Set contents	Listepris
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm VersaDrive® MAX Reamers, M24, M27, M30, M33, M36 VersaDrive® MAX Impact Taps, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	37 081,00

VersaDrive® MAX Impact Reamer STAKIT® Kit - 10pc



Part No	Set contents	Listepris
STC-EMID-MAX01	14, 18, 20, 22, 24, 26, 30, 32, 36, 39mm VersaDrive® MAX Reamers, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	36 290,00
STC-EMID-INMAX01	1 1/4, 1 1/2, 1 3/4, 1 7/8, 2, 2 1/8, 2 1/4, 2 1/2, 2 3/4, 2 7/8, 3, 3 1/8, 3 1/4, 3 1/2, 3 3/4, 3 7/8, 4, 4 1/8, 4 1/4, 4 1/2, 4 3/4, 4 7/8, 5, 5 1/8, 5 1/4, 5 1/2, 5 3/4, 5 7/8, 6, 6 1/8, 6 1/4, 6 1/2, 6 3/4, 6 7/8, 7, 7 1/8, 7 1/4, 7 1/2, 7 3/4, 7 7/8, 8, 8 1/8, 8 1/4, 8 1/2, 8 3/4, 8 7/8, 9, 9 1/8, 9 1/4, 9 1/2, 9 3/4, 9 7/8, 10, 10 1/8, 10 1/4, 10 1/2, 10 3/4, 10 7/8, 11, 11 1/8, 11 1/4, 11 1/2, 11 3/4, 11 7/8, 12, 12 1/8, 12 1/4, 12 1/2, 12 3/4, 12 7/8, 13, 13 1/8, 13 1/4, 13 1/2, 13 3/4, 13 7/8, 14, 14 1/8, 14 1/4, 14 1/2, 14 3/4, 14 7/8, 15, 15 1/8, 15 1/4, 15 1/2, 15 3/4, 15 7/8, 16, 16 1/8, 16 1/4, 16 1/2, 16 3/4, 16 7/8, 17, 17 1/8, 17 1/4, 17 1/2, 17 3/4, 17 7/8, 18, 18 1/8, 18 1/4, 18 1/2, 18 3/4, 18 7/8, 19, 19 1/8, 19 1/4, 19 1/2, 19 3/4, 19 7/8, 20, 20 1/8, 20 1/4, 20 1/2, 20 3/4, 20 7/8, 21, 21 1/8, 21 1/4, 21 1/2, 21 3/4, 21 7/8, 22, 22 1/8, 22 1/4, 22 1/2, 22 3/4, 22 7/8, 23, 23 1/8, 23 1/4, 23 1/2, 23 3/4, 23 7/8, 24, 24 1/8, 24 1/4, 24 1/2, 24 3/4, 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VersaDrive® MAX Broach & Tap Set - 10pc Metric



NEW

Part No	Set contents	Listepris
STC-EMID-MAX03	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, M24, M27, M30, M33, M36 VersaDrive® MAX ImpactaTaps, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	29 529,00

VersaDrive® MAX Broach & Tap Set - 10pc Inch



NEW

Part No	Set contents	Listepris
STC-EMID-INMAX03	1, 1-1/4, 1-1/2, 1-3/4, 1-1/2" CarbideMax 55 TCT Broach Cutters, 1-1/2, 1-1/4, 1-3/4, 1-1/2" VersaDrive® MAX ImpactaTaps, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	31 066,00

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Metric



NEW

Part No	Set contents	Listepris
STC-EMID-MAX04	21, 24, 26.5, 30, 32mm CarbideMax 55 TCT Broach Cutters, 14, 18, 22, 26, 32mm VersaDrive® MAX Reamers, M24, M27, M30, M33, M36 VersaDrive® MAX ImpactaTaps, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	37 081,00

VersaDrive® MAX Broach, Tap & Ream Set - 15pc Inch



NEW

Part No	Set contents	Listepris
STC-EMID-INMAX04	1, 1-1/4, 1-1/2, 1-3/4, 1-1/2" CarbideMax 55 TCT Broach Cutters, 1/2, 1-1/4, 1-1/2, 1-3/4, 1-1/2" VersaDrive® MAX Reamers, 1-1/2, 1-1/4, 1-3/4, 1-1/2" VersaDrive® MAX ImpactaTaps, 3/4" VersaDrive® MAX Impact Wrench Adapter, 19.05mm VersaDrive® MAX Magnet Drill Adapter	38 799,00

VersaDrive® MAX taps are heavy duty, impact rated taps for use in challenging industrial applications.

Based on the bestselling ImpactaTaps, they are double hardened with a unique cutting geometry that makes them suitable for use with impact wrenches.



- Thread new holes effectively with high-torque impact wrenches
- Ideal for cleaning and rethreading pre-threaded holes
- Used in commercial vehicle and transportation repair applications

- Can also be used with heavy duty, reversible magnetic drills
- Swarf chipbreaker action for effective use on through holes
- 6 flute design for a faster, smoother cut

Metric	M Thread Size & Pitch	L (mm)	lt (mm)	Listepris	
NEW Size	308610-0240	M24 x 3.0	135	45	4 176,00
	308610-0270	M27 x 3.0	136	48	4 549,00
	308610-0300	M30 x 3.5	138	48	5 010,00
	308610-0330	M33 x 3.5	151	51	5 870,00
	308610-0360	M36 x 4.0	162	57	6 545,00
	308610-0390	M39 x 4.0	170	60	8 088,00
	308610-0420	M42 x 4.5	170	60	8 837,00
Inch	M Thread Size & Pitch	L (")	lt (")	Listepris	
	308650-0105	1-1/8 x 7 UNC	4-9/16	1-7/8	4 968,00
	308650-0110	1-1/4 x 7 UNC	5	2	5 910,00
	308650-0120	1-3/8 x 6 UNC	5-3/8	2-1/4	7 109,00
	308650-0130	1-1/2 x 6 UNC	5-5/8	2-3/8	7 981,00
	308650-0140	1-3/4 x 5 UNC	6-1/4	2-5/8	8 583,00

FURTHER SIZES AVAILABLE ON REQUEST





The V18-900 Install SiteKit is a portable powerhouse of compact, lightweight and easily transportable drilling and fastening solutions.

The new cordless 18v V18-900 Impact Wrench has a 1/2" drive, 900Nm of torque and is rated for metal drilling, threading and reaming as well as for performing standard bolt fastening and unfastening operations.

Working seamlessly with the V18-900, the accompanying VersaDrive® installation kit gives a bestselling selection of cutting tools to overcome the most frequently encountered drilling and hole modification challenges. Drill new holes with VersaDrive® TurboTips and TCT HoleCutters, enlarge existing holes with the unique ImpactaStep Cutter and align connection holes with VersaDrive® Impact Reamers before threading quickly and easily with VersaDrive® ImpactaTaps.

The wheeled sitecart gives additional storage and helps transport everything around site.

Contents:

1 x VersaDrive® V18-900 1/2" Impact Wrench (p.75)
(Supplied in **STAKIT**® Mid case, with 2 x 4.0Ah batteries + compact charger & VersaDrive® Rapid-Lock Impact Wrench Adapter)

1 x **STAKIT**® Site Installation Kit (p.107)
(supplied in **STAKIT**® Mid Case)

1 x **STAKIT**® SiteCart Compact (p.106)



Part No	Product	Listepris
STC-KIT-V189INS-2B	STAKIT ® V18-900 Install SiteKit	
STC-KIT-V189INS-2BEU	STAKIT ® V18-900 Install SiteKit EU Plug	37 074,00

The VersaDrive® V18-900 is a powerful and compact brushless impact wrench, rated for metal drilling, threading, and hole enlargement work alongside standard bolt tightening & loosening.

Quickly and safely create and modify connection holes in heavy metal components. Optimised for use with the VersaDrive® range of cutting tools.

- Compatible with the Makita LXT 18V battery platform
- Supplied with VersaDrive® Rapid-Lock adapter
- 3 Impact settings plus Nutbuster mode



- Powerful & efficient brushless motor
- Rapid airflow cooling system
- Twin LED spotlights for bright, shadow-free illumination

TECHNICAL SPECIFICATIONS

ANVIL/DRIVE SIZE	½"
NO LOAD SPEED (RPM)	1500 / 2000 / 2500
IMPACT MODES	3
IMPACT TORQUE	400 / 630 / 900Nm
IMPACT RATE (BPM)	1600 / 2200 / 2700
DRILLING/FASTENING TORQUE	900 Nm
NUT BUSTING MODES	1
NUT BUSTING TORQUE	1180 Nm
WEIGHT (w/o battery)	1.9kg
WEIGHT (with 4Ah battery)	2.5kg
WIDTH	170mm
HEIGHT (w/o battery)	225mm
HEIGHT (with battery)	272mm
VOLTAGE	18v
WARRANTY	1yr
BATTERY COMPATIBILITY	HMT 18v Battery & MAKITA LXT

Part No	Contents	Listepris
808010-010	VersaDrive® 1/2" Impact Wrench Body only Inc. VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter	3 680,00
808010-025EU	VersaDrive® 1/2" Impact Wrench 4.0Ah Kit (EU Plug for charger) Inc. Body + 2 x 4.0Ah Batteries + Compact Charger + VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter	10 433,00
808010-020EU	VersaDrive® 1/2" Impact Wrench 9.0Ah Kit (EU Plug for charger) Inc. Body + 2 x 9.0Ah Batteries + Compact Charger + VersaDrive® 1/2" Rapid-Lock Impact Wrench Adapter	16 209,00
809010-040	18v 4.0Ah Battery	2 241,00
809010-090	18v 9.0Ah Battery	4 169,00
809020-020EU	18v Compact Battery Charger EU Plug (170 x 130 x 86mm)	1 118,00



All versions supplied with VersaDrive® Rapid-Lock adapter
Kits also supplied with **STAKIT**® EMID-100 case, 2 batteries and charger





The RTV36 Install SiteKit offers compact, lightweight, and easily transportable drilling solutions, perfect for sites without power or with tight access.

The new RTV36 runs on an 18V, Makita LXT compatible battery platform that provides variable speed broaching up to 36mm, drilling up to 13mm and countersinking up to 32mm.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

- 1 x HMT RTV36 Cordless Low Profile Mag Drill (p.77)
(Supplied in **STAKIT®** Base 200 case, with 2 x 9.0Ah batteries + compact charger)
- 1 x **STAKIT®** Site Installation Kit (p.107)
(supplied in **STAKIT®** Mid Case)
- 1 x **STAKIT®** SiteCart Compact (p.106)



Part No	Product	Listepris
STC-KIT-RTV36INS-2B	STAKIT® RTV36 Install Sitekit	
STC-KIT-RTV36INS-2BEU	STAKIT® RTV36 Install Sitekit EU Plug	69 125,00

The HMT RTV36 offers the flexibility of a cordless machine coupled with the accessibility benefits of a low profile machine.

Fitting into any gap greater than 178mm, the 18v battery powered RTV36 gives high-powered broaching and drilling solutions for jobsites with restricted access requirements or without generators or electrical connections.

- Compatible with Makita LXT batteries
- Quick release weldon arbor for keyless use
- Up to 49 x 18mm holes per 9.0Ah battery (10mm plate)



- Ratchet handle can be used on both sides of machine
- 36mm diameter TCT broaching capacity
- Fits into spaces 178mm or greater
- Max 40mm cutting depth

TECHNICAL SPECIFICATIONS

CUTTER SIZE RANGE	12 -36mm
MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	32mm
LENGTH (Inc 4Ah battery)	385mm
WIDTH	140mm
HEIGHT	177mm
WEIGHT	11.3 kg
STROKE	40mm
MAGNETIC FORCE	650 kg
MOTOR POWER	1000 W
TOTAL POWER	1000 W
SPEED RPM (No Load)	270 - 430
SPINDLE WELDON	19.05mm (¾")
ARBOR	Integral ¾" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY CAPACITY	18V 4Ah / 9Ah Li-ion



Part No	Contents	Listepris
805046-010	RTV36 Magnet Drill - Bare Machine	38 308,00
805046-025EU	RTV36 Magnet Drill Kit Inc. 2 x 4Ah Batteries + Charger (EU Plug for charger)	43 318,00
805046-020EU	RTV36 Magnet Drill Kit Inc. 2 x 9Ah Batteries + Charger (EU Plug for charger)	49 978,00
809010-040	18v 4.0Ah Battery	2 241,00
809010-090	18v 9.0Ah Battery	4 169,00
809020-020EU	18v Compact Battery Charger EU Plug (170 x 130 x 86mm)	1 118,00



Kit supplied in **STAKIT®** Base 200 case with 2 batteries, charger, hex keys, restraint strap and ratchet.





The V36 18V Install SiteKit is the ultimate lightweight portable drilling package.

The new Cordless V36 18V magdrill install sitekit offers the ultimate jobsite freedom. Operate away from mains power. Compatible with the Makita LXT battery platform. Broaching capacity to 36mm, drilling to 12mm.

The VersaDrive installation kit gives a bestselling selection of cutting tools for overcoming installation and maintenance challenges. Includes the bestselling sizes of Impact Reamers, ImpactaTaps, TurboTip Impact Drillbits, CarbideMax TCT Holesaws, and 5 modular adapters.

The wheeled sitecart gives additional storage space for further tooling. All items clip together securely for safe and efficient transportation around the work area.

Contents:

- 1x VersaDrive® V36 Cordless Magnet Drill (p.79)
(Supplied in **STAKIT®** Base 200 case, with 2 x 9.0Ah batteries + charger)
- 1x **STAKIT®** Site Installation Kit (p.107)
(supplied in **STAKIT®** Mid Case)
- 1x **STAKIT®** SiteCart Compact (p.106)



Part No	Product	Listpris
STC-KIT-V36INS-2B	STAKIT® V36-18 Install SiteKit - c/w 2x9Ah Batteries & Charger	
STC-KIT-V36INS-2BEU	STAKIT® V36-18 Install SiteKit - c/w 2x9Ah Batteries & Charger EU Plug	60 254,00

Increase your jobsite solutions with this unique cordless magdrill, the most compact & lightweight unit in its class. Market-leading 140mm stroke which is ideal for extra-long broach cutters and VersaDrive® cutting tools.

The 18V battery pack is compatible with the entire range of Makita LXT powertools.

Permanent magnet provides safe & powerful hold, even on thin materials.

- Compatible with Makita LXT batteries
- Up to 49 x 18mm holes per charge (10mm plate + 9.0Ah battery)



- Weighs just 9.8kg for easy handling
- Available with **STAKIT®** kit options or Bare machine

TECHNICAL SPECIFICATIONS

MAX TCT CUTTER CAPACITY	36mm
MAX HSS CUTTER CAPACITY	32mm
MAX CUTTER LENGTH	110mm
TWIST DRILL CAPACITY	1 - 13mm
COUNTERSINKING	10 - 25mm
REAMING	N/A
TAPPING	N/A
LENGTH	325mm
WIDTH (Inc Handles)	184mm
HEIGHT (Min-Max)	275 - 415mm
STROKE	140mm
WEIGHT	9.8 kg
MAGNET (L x W)	157 x 85mm
MAGNETIC FORCE	650 kgs
MOTOR POWER	1000w
TOTAL POWER	1000w
SPEED RPM (No Load)	530
SPINDLE	3/4" Weldon
ARBOR	Integral 3/4" Weldon
COOLANT SYSTEM	Optional Extra
WARRANTY	1yr
BATTERY CAPACITY	18V 4Ah / 9Ah Li-ion



Part No	Contents	Listpris
805036-010	V36-18 Magnet Drill - Bare Machine	28 520,00
805036-025EU	V36-18 Magnet Drill Kit Inc. 2 x 4Ah Batteries + Charger (EU Plug for charger)	37 333,00
805036-020EU	V36-18 Magnet Drill Kit Inc. 2 x 9Ah Batteries + Charger (EU Plug for charger)	40 992,00
809010-040	18v 4.0Ah Battery	2 241,00
809010-090	18v 9.0Ah Battery	4 169,00
809020-010EU	18v Battery Charger EU Plug (190 x 155 x 70mm)	1 118,00



Kit supplied in **STAKIT®** Base 200 case, with Rapid-Lock VersaDrive® adapter, 2 batteries & battery charger





NEW

Create or repair large diameter external threads on metal bar or conduit with the VersaDrive® ImpactaDie system.

Offering fast, easy impact-thread cutting in a variety of sizes from M6 - M25, the ImpactaDie complete kit speeds up the challenging and traditionally time-consuming process of creating both small and large external threads.

Utilize the speed and power of high-torque impact wrenches* or the power and precision of magnetic drills* to reduce labour and fatigue, improve productivity and complete jobs in less time.

The kit includes the VersaDrive® ImpactaBurr Chamfer tool for preparing bar and conduit prior to impact-threading for swift, accurate results.

Supplied in a VersaDrive® **STAKIT** compatible ETOP4 top case.

*requires VersaDrive® Impact Wrench Adapter or VersaDrive® Magnetic Drill Adapter).

Kit Contents:

- ImpactaDie Holder for M6 - M12 threads
- ImpactaDie Holder for M16 - M25 threads
- Guide Collar for M6 - M12 threads
- Guide Collar for M16 - M25 threads
- Flush Collar for M6 - M12 threads
- Flush Collar for M16 - M25 threads
- M6/8/10/12/16/20/24/25 Guides
- M6/8/10/12/16/20/24 Metric Coarse Hex Die Nuts
- M16/20/25 Metric Fine Hex Die Nuts
- ImpactaBurr 19mm Chamfer Tool
- ImpactaBurr 36mm Chamfer Tool
- STAKIT**® ETOP4 Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product	Listepris
115810-CSET	VersaDrive® ImpactaDie Complete Kit (M6 - M25)	18 563,00



The NEW VersaDrive® **STAKIT**® ULTRA Kit has been developed to offer a comprehensive solution to drilling & countersinking the most challenging materials.

With cutting tools from 6 - 26mm diameter and countersinking options up to 40mm, this kit is a must have for operatives in the quarrying/mining, heavy machinery/plant repair and defence sectors.

Kit Contents:

- ULTRA 55 TCT Broach Cutters
- VersaDrive® ULTRA Drill Bits
- Weldon Shank ULTRA TCT Countersink
- ULTRA coated Tungsten Carbide MultiSink
- MultiSink Pilots

Metric Kit:

- 18, 20, 22, 24, 26mm
- 6, 8, 10, 12, 14mm
- 32mm, 90°
- 40mm, 90°
- 18, 20, 22, 24, 26mm

Inch Kit:

- 11/16, 3/4, 13/16, 15/16"
- 1/4, 5/16, 3/8, 1/2, 9/16"
- 1-1/4", 82°
- 1-1/2", 82°
- 11/16, 3/4, 13/16, 15/16"

- 1 x VersaDrive® Heavy Duty Magnet Drill Adapter
- 1 x VersaDrive® **STAKIT**® ETOP4 Full Top Case

L x W x H (mm) - 540 x 390 x 95

Part No	Product	Listepris
STC-ULTRA-KIT	STAKIT ® Ultra Kit - Metric Sizes	€1,407.90
STC-ULTRA-KIT-01	STAKIT ® Ultra Kit - Inch Sizes	

FOR TECHNICAL DATA & USER ADVICE SEE P.128

FOR TECHNICAL DATA & USER ADVICE SEE P.115 ONWARDS



Diameter	Structural Steel <500 Mpa Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa 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
	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

Diameter	Structural Steel <500 Mpa (S275, S355) Based on mm/R Feed of 0.10	Structural Steel <1000 Mpa Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Cast Iron-Grey	Aluminium
	RPM Range				
12-19mm	1265-850	850-580	530-350	925-615	2200-1560
20-25mm	840-650	550-410	345-255	610-440	1480-1140
26-32mm	545-460	410-315	250-200	430-335	1125-890
33-39mm	460-395	315-265	195-170	330-280	885-730
40-46mm	405-340	265-250	165-140	280-235	720-620
47-53mm	335-300	250-195	135-120	235-205	615-545
54-60mm	295-265	195-180	120-105	200-180	540-475
61-70mm	260-230	180-140	105-90	180-160	475-415
71-80mm	230-200	140-130	90-70	160-145	410-365
81-90mm	195-180	130-115	70-65	140-125	350-325
91-100mm	180-160	115-100	60-55	125-110	320-280
101-112mm	160-140	100-90	55-50	110-100	280-250
113-124mm	140-120	90-85	50-48	100-90	250-235
125-136mm	120-110	85-75	48-45	90-80	230-205
137-150mm	110-100	70-65	45-40	80-75	205-190
151 - 174mm	70 - 80	50 - 60	45 - 40	55 - 65	145 - 155
175 - 200mm	60 - 70	40 - 50	25 - 30	45 - 55	120 - 140

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

QUICK GUIDE

- Optimum life & performance when used with Rotary Pistol Drills
- Good results from SDS Drills when used in Rotary-Only mode
- For best results pre-drill the pilot hole
- Use appropriate lubrication and correct RPM to achieve long tool life

MORE INFO



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

QUICK GUIDE

- Adjust RPM to match the material
- Slowly and cautiously begin cutting before increasing pressure
- For best results & swarf clearance always select a cutter longer than the material thickness
- For hard materials & wear plates like Hardox use Ultra coated cutters. See page 68-73

MORE INFO





Left Handed Pilot Drill Bits	Impact Torque	
	Grade 8.8 bolts	Grade 8.8 bolts
	Nm Torque	Ft Lb Torque
#3	160	178
#4	280	207
#5	300	222
#6	580	430
#7	Rotary Only	Rotary Only

Bolt Extractor	Impact Torque	
	Grade 8.8 bolts	Grade 8.8 bolts
	Nm Torque	Ft Lb Torque
#3	140	130
#4	200	145
#5	220	160
#6	430	320
#7	500	380

LEFT HANDED DRILL BITS BEST PRACTICE ADVICE

1. Designed for use in left hand direction (Reverse) only.
2. For best results drilling through hardened bolts and materials, it is recommended to start with a small diameter drill bit and step up to the finished diameter with increasingly larger drill bits
3. Ensure ample application of lubricant (SpeedLube/BioCut Blue) during the drilling process to prevent overheating & work hardening of the fastener.
4. Wherever possible use a scribed or drawn mark to find the exact center of the fastener to be drilled.
5. For best results drill all the way through the bolt/stud before inserting the Screw Extractor
6. Where the application allows, using the Left Hand drills in a reversible Magnet Drill will make the drilling process faster and more stable.
7. For larger diameter drill bit sizes (#6/#7) or when drilling particularly hard materials, using a rotary or magnetic drill may provide better results than an Impact wrench.

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

BOLT EXTRACTOR BEST PRACTICE ADVICE

1. Ensure the correct sized pilot hole is drilled into seized bolt using VersaDrive® Left Hand bits
2. Use a soft-faced hammer to securely tap the extractor into pilot hole
3. Attach VersaDrive® Impact Adapter and use on left hand rotation (Reverse Mode)
4. Where possible ensure ample lubricant is applied to the drilled hole and time allowed for the fastener to cool after drilling and to allow the lubricant to penetrate into the drilled hole and threads.
5. To assist with successful extraction it is important that the pilot hole is drilled square to the centre of the fastener to avoid the extractor running off plane when reversing out, and potentially breaking or coming loose.
6. Whilst the VersaDrive extractors are superior to standard stud extractors readily available, it is recognised that stud/fastener extraction is a very challenging task and a complete success cannot be guaranteed in all circumstances. Using heating methods and/or releasing fluids can often assist with the removal process.

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

QUICK GUIDE

- Drill correct sized pilot hole in seized bolt using VersaDrive® Left Hand bits
- Use a hammer to securely tap the extractor into pilot hole
- Attach VersaDrive® Impact Adapter and use on left hand rotation

MORE INFO



	Die Nut Size	Thread Cutting		Thread Repair / Cleaning		
		Impact Torque Nm	Impact Torque Nm	Ft Lb	Ft Lb	
Metric	M6 x 1.0	130	90	95	65	
	M8 x 1.25	240	160	180	115	
	M10 x 1.5	360	240	270	180	
	M12 x 1.75	400	270	295	195	
	M16 x 2.0	610	410	455	300	
	M20 x 2.5	820	550	605	400	
	M24 x 3.0	1190	790	880	585	
Inch	1/4" UNC	140	95	105	70	
	5/16" UNC	245	165	180	120	
	3/8" UNC	355	235	260	175	
	1/2" UNC	450	300	330	220	
	5/8" UNC	605	405	450	300	
	3/4" UNC	810	540	590	400	
	7/8" UNC	1060	710	785	520	
	1" UNC	1205	805	890	695	
	Conduit Thread Cutting		Conduit Thread Repair / Cleaning		Conduit Thread Repair / Cleaning	
	Impact Torque Nm		Impact Torque Nm		Ft Lb	
	M16 x 1.5	330	220	245	165	
	M20 x 1.5	410	275	305	200	
	M25 x 1.5	520	340	385	245	

BEST PRACTICE ADVICE

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

1. Before cutting the thread, the ImpactaBurr chamfer tool must be used to ensure that the fastener/workpiece has a consistent 60 degree bevel/chamfer.
2. To ensure best results for the life of the Die and avoid the thread cutting unevenly on the fastener/workpiece, ensure the tool is held squarely in alignment with the fastener/workpiece.
3. When cutting a new thread use the Guide collar and Guide to help keep the Die in alignment with the fastener/workpiece.
4. For cleaning/repairing or rethreading applications, the flush collar is intended to allow the die to cut a full length thread.
5. Firm forward pressure is recommended both for starting/cutting the thread and when reversing the tool to remove the Die Threader from the fastener.
6. Ensure regular application of SpeedLube cutting fluid prior to and during the cutting process to minimise heat build up.
7. Take care when handling ImpactaDie and workpiece as threaded components may get very hot.
8. Avoid lateral movement or tilting which can cause damage to the tool.
9. Periodically check Die and ImpactaDie Holder/Collar and remove Swarf as required.
10. When cutting a full thread with the ImpactaDie system it is recommended to use an Impact wrench rather than a rotary drill to avoid potential hand/wrist injury from reaction torque.
11. Ensure the use of appropriate PPE at all times when using cutting tools (Safety Glasses, Gloves etc).
12. Impact wrenches of 3/8, 1/2 or 3/4" square drive are recommended (rather than 1/4" impact drivers).

QUICK GUIDE

- For fastest & safest performance use on Impact Wrenches
- For best results & to avoid kickback, use the ImpactaDie system with an impact wrench rather than a rotary only drill.
- Hardened grades of material may require increased torque
- Use appropriate lubrication and correct torque to achieve long tool life.

MORE INFO





Thread Diameter	Impact Tapping Torque			Impact Tapping Torque			Structural Steel	Structural Steel	Stainless Steel	Aluminium	Cast Iron (Grey)
	6mm Steel	12mm Steel	25mm Steel	1/4" Steel	1/2" Steel	1" Steel	<500 Mpa	<1000 Mpa	INOX		
	Nm Torque			Ft Lbs Torque			RPM Range				
M3	105	160	N/A	80	120	N/A	960	809	650	2700	1295
M4	120	180	N/A	90	135	N/A	730	610	490	2060	975
M5	135	200	N/A	100	150	N/A	585	485	385	1750	780
M6	140	240	400	105	180	N/A	485	405	325	1455	650
M8	150	280	430	115	210	330	365	310	245	1095	485
M10	170	300	480	125	220	360	295	245	195	870	390
M12	185	320	512	135	235	400	240	200	162	730	330
M14	190	340	544	140	250	400	210	175	140	625	275
M16	200	360	576	150	265	425	185	155	125	550	243
M20	315	400	640	235	300	470	145	125	100	440	194
M24	N/A	600	960	N/A	440	720	120	100	85	370	165
M27	N/A	740	1184	N/A	545	875	105	90	75	330	145
M30	N/A	800	1200	N/A	590	885	95	80	60	310	130
M33	N/A	N/A	1400	N/A	N/A	1070	84	68	51	265	112
M36	N/A	N/A	1640	N/A	N/A	1260	72	58	44	228	96
M39	N/A	N/A	1860	N/A	N/A	1425	54	44	33	171	72
M42	N/A	N/A	2440	N/A	N/A	1870	40	32	24	126	53

Inch	Impact Tapping Torque			Impact Tapping Torque			Structural Steel	Structural Steel	Stainless Steel	Aluminium	Cast Iron (Grey)
	6mm Steel	12mm Steel	25mm Steel	1/4" Steel	1/2" Steel	1" Steel	<500 Mpa	<1000 Mpa	INOX		
1/4"	145	255	410	105	180	295	485	405	325	1455	650
5/16"	145	265	420	110	205	320	365	310	245	1095	485
3/8"	165	290	440	125	220	355	295	245	195	870	390
1/2"	190	330	525	135	235	375	240	200	162	730	330
5/8"	195	355	555	145	365	425	185	155	125	550	243
3/4"	245	385	615	230	295	470	145	125	100	440	194
7/8"	N/A	515	775	N/A	370	710	130	115	92	410	180
1"	N/A	695	1050	N/A	445	735	120	100	85	370	165
1-1/8"	N/A	N/A	790	N/A	N/A	820	96	78	59	303	128
1-1/4"	N/A	N/A	1300	N/A	N/A	910	90	75	55	300	120
1-3/8"	N/A	N/A	1620	N/A	N/A	1245	78	63	48	246	104
1-1/2"	N/A	N/A	1810	N/A	N/A	1390	50	41	31	158	67
1-3/4"	N/A	N/A	2670	N/A	N/A	2050	40	32	24	126	53

BEST PRACTICE ADVICE

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

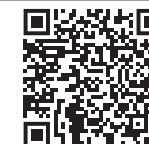
1. ImpactaTaps are recommended for through hole applications only
2. Spiral Flute ImpactaTaps are primarily recommended for blind hole applications using a clutched adapter to prevent the Tap from breaking when it reaches the bottom of the hole (See pages 22 & 23)
3. Pilot drill the exact tapping size hole for best results
4. Select the correct torque for Impact tools using the table opposite. If exact match is not available select the closest torque setting above the recommendation
5. Select the correct RPM when using rotary drive tools using the table opposite.
6. Apply firm, steady feed pressure throughout the cut
7. Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage
8. Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials
9. Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
10. Flame cut/punched/profiled holes will require more torque to tap than drilled holes due to heat build up.
11. **Caution:** Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage
12. Tap the hole in one pass where possible, applying adequate lubrication before you start.
13. 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
14. 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 4
15. 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
16. Follow guidelines to set correct Impact Torque/RPM. Insufficient torque/incorrect RPM can lead to poor life & tool breakage

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

QUICK GUIDE

- For fastest performance use on Impact Wrenches & Impact Drivers
- Check the minimum torque requirement
- Laser cut holes & Stainless Steel require higher torque
- Use appropriate lubrication and correct RPM to achieve long tool life

MORE INFO





Diameter	Impact Torque			Impact Torque			Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Brass	Cast Iron (Grey)	Plastics	Aluminium	
	6mm Thick Steel	12mm Thick Steel	25mm Thick Steel	1/4" Thick Steel	1/2" Thick Steel	1" Thick Steel	32m/Min	18m/Min	12m/Min	32m/Min	16m/Min	30m/Min	45m/Min	
	Nm Torque			Ft Lb Torque			RPM Range							
Metric	6mm	140	170	280	104	126	207	2040	1070	710	1820	1045	1630	2850
	7mm	160	195	300	119	144	222	1780	1020	625	1560	810	1410	2240
	8mm	220	270	380	163	200	281	1580	840	550	1340	725	1220	1765
	9mm	295	360	520	219	267	385	1210	750	420	1130	600	1040	1550
	10mm	320	395	580	237	293	430	1030	520	385	1020	550	990	1480
	11mm	325	405	595	241	300	441	980	500	345	960	490	950	1365
	12mm	350	430	635	259	319	470	860	440	310	825	405	860	1280
	13mm	370	445	675	274	330	500	720	390	260	730	385	745	1160
	14mm	375	455	690	278	337	511	660	350	225	665	340	620	950
	16mm	455	580	880	337	430	652	535	290	200	610	310	510	875
18mm	580	720	1120	430	533	830	490	245	190	580	275	440	800	
20mm	685	845	1245	507	626	922	450	220	175	550	240	350	730	
22mm	720	900	1360	533	667	1007	340	180	160	510	210	330	645	
Inch	3/16"	120	150	220	89	111	163	2270	1135	750	2215	1290	1910	3340
	#7	125	155	240	93	115	178	2250	1100	745	2100	1220	1800	3100
	7/32"	135	160	260	100	119	193	2125	1095	730	1980	1125	1710	3020
	1/4"	150	180	290	111	133	215	1945	1040	680	1715	940	1540	2625
	9/32"	175	220	320	130	163	237	1710	985	595	1410	785	1355	2110
	5/16"	190	245	350	141	181	259	1695	915	570	1355	760	1290	1940
	11/32"	260	330	470	193	244	348	1390	800	515	1435	660	1200	1660
	3/8"	300	375	545	222	278	404	1140	665	400	1095	590	1020	1510
	27/64"	330	410	610	244	304	452	925	480	330	890	465	915	1320
	7/16"	340	420	625	252	311	463	895	455	320	845	430	890	1305
	1/2"	365	440	650	270	326	481	780	410	375	780	400	805	1210
	17/32"	370	445	675	274	330	500	720	390	260	730	385	745	1160
	9/16"	375	455	690	278	337	511	660	350	225	665	340	620	950
5/8"	455	580	880	337	430	652	535	290	200	610	310	510	875	
11/16"	580	720	1120	430	533	830	490	245	190	580	275	440	800	
3/4"	685	845	1245	507	626	922	450	220	175	550	240	350	730	
13/16"	720	900	1360	533	667	1007	340	180	160	510	210	330	645	

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. VersaDrive® TurboTips can be used without piloting at all sizes

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 standard construction grade steels such as Structural or Stainless Steel
- To achieve the best lifespan in Stainless Steel, use with Rotary tools at reduced RPM
- Use appropriate lubrication and correct RPM to achieve long tool life

MORE INFO



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. VersaDrive® Drill Bits up to 10mm diameter can be driven by an Impact Wrench

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

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