

SIERRATASAS

DRILLING TESTING REPORT

PRODUCT INFORMATION:		DATE: 2015-9-24	
DESCRIPTION: BI-METAL HOLE SAW - M3		CUTTING MATERIAL: 5 mm/A3 steel	
Claves: PT1055 A PT1089		TESTING EQUIPMENT: Beach Drill	
SIZE: 51 mm	OPERATION SPEED: 260 RPM		

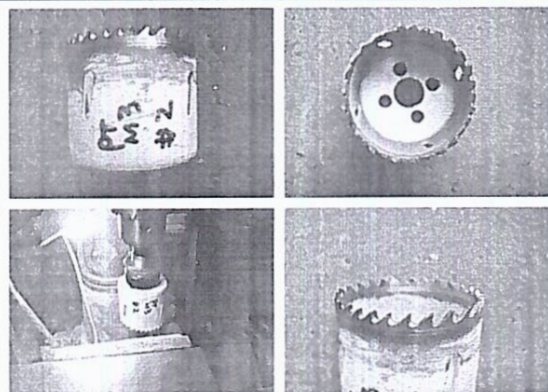
PT M3 #2	Hole No.	1	2	3	4	5	6	7	8	9	10	11	12	13	14
	Time(s)	33.7	36.9	35.3	41.3	44.5	37.3	35.4	26	32.2	31.4	35.5	27.7	39.1	36.2
	Hole Dia.(mm)	51.2	51.3	51.1	51.2	51.3									
	Hole No.	15	16	17	18	19	20	21	22	23	24	25	26	27	28
	Time(s)	53.7	46.5	44.5	41.7	36.7	42.1	40.2	49	38.3	33.4	36.3	37.3	34.2	33.4
	Hole Dia.(mm)														
	Hole No.	29	30	31	32	33	34	35	36	37	38	39	40	41	42
	Time(s)	27.7	33	33.7	26.8	26.5	23.9	23.3	30.8	33	23.5	24.1	27	25.1	36.1
	Hole Dia.(mm)														
	Hole No.	43	44	45	46	47	48	49	50	51	52	53	54	55	56
	Time(s)	39.8	34.8	30.5	36.8	31.5	32.9	32.5	33.6	23.9	27	21.4	19.8	24.7	23.7
	Hole Dia.(mm)														
	Hole No.	57	58	59	60	61	62	63	64	65	66	67	68	69	70
	Time(s)	21.1	25.7	20	24.8	23.1	17.7	20.9	22.8	20.3	19.9	20.4	16.2	19.3	28.4
	Hole Dia.(mm)														
	Hole No.	71	72	73	74	75	76	77	78	79	80	81	82	83	84
	Time(s)	23.2	22.3	20.5	18	22.6	19.6	18.3	16.6	29	31.4	37.1	19	17.9	20.3
	Hole Dia.(mm)														
	Hole No.	85	86	87	88	89	90	91	92	93	94	95	96	97	98
	Time(s)	21.2	15.7	18.8	16.9	15.6	19.1	17.5	17.2	17.5	19.1	16.8	17.3	16.3	17
Hole Dia.(mm)															
Hole No.	99	100	101	102	103	104	105	106	107	108	109	110	111	112	
Time(s)	15.4	15.8	16.3	17.2	15.1	19.3	15.2	18.4	15.9	17.9	19.7	17.2	20.8	17.4	
Hole Dia.(mm)															
Hole No.	113	114	115	116	117	118	119	120	121	122	123	124	125	126	
Time(s)	16.2	17.5	16.8	16.3	15.8	16.1	13.9	13.6	19.7	16.5	21.3	18.9	16.4	20.3	
Hole Dia.(mm)															
Hole No.	127	128	129	130	131	132	133	134	135	136	137	138	139	140	
Time(s)	18.6	15.2	15	15.6	20.8	18.8	21.2	21.3	23.2	26.5	27.6	31.5	26.2	26.4	
Hole Dia.(mm)															
Hole No.	141	142	143	144	145	146	147	148	149	150	151	152	153	154	
Time(s)	28	28.7	27.5	27.3	24.8	28.6	21.5	26.9	24.9	24.1	24.2	21.3	19.8	20.6	
Hole Dia.(mm)															
Hole No.	155	156	157	158	159	160	161	162	163	164	165	166	167	168	
Time(s)	18.8	24.5	23.5	20.4	24.4	24.2	24.6	32.7	22.8	23.1	28.4	25.3	19.7	28.7	
Hole Dia.(mm)															
Hole No.	169	170	171	172	173	174	175	176	177	178	179	180	181	182	
Time(s)	24	19.2	20.7	21.1	21.3	18.5	22.3	27.4	22.5	19.3	19.5	21.5	18.6	16.4	

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Hole Dia.(mm)														
Hole No.	183	184	185	186	187	188	189	190	191	192	193	194	195	196
Time(s)	17.2	15.8	18.4	23.1	19.8	16.7	18.9	22	17.7	16.4	15.3	15.3	21	18.7
Hole Dia.(mm)														
Hole No.	197	198	199	200	201	202	203	204	205	206	207	208	209	210
Time(s)	18.3	21.5	22.1	24.2	17.2	16.9	20.1	24.8	21.6	19.4	22.1	20.1	18.8	26.3
Hole Dia.(mm)														
Hole No.	211	212	213	214	215	216	217	218	219	220	221	222	223	224
Time(s)	20.2	19.5	19.1	21	20.1	17.3	19.3	22	20.2	22.7	19.1	19.2	20.6	21.4
Hole Dia.(mm)														
Hole No.	225	226	227	228	229	230	231	232	233	234	235	236	237	238
Time(s)	20.9	18.4	22.7	24.5	21.3	23.1	22.9	18.1	22.4	21.1	18.4	22.4	19.9	22.6
Hole Dia.(mm)														
Hole No.	239	240	241	242	243	244	245	246	247	248	249	250	251	252
Time(s)	27.7	21.6	15	16.6	17.1	18.5	18.3	19.3	20.6	26.5	23.8	22.4		
Hole Dia.(mm)								51.4	51.5	51.4	51.3	51.4		



COMMENTS

After 250 holes cutting, the hole saw still can be used. The teeth part were not grinded too much.

SIGNATURE/DATE