

## Greenlee 825-2

# Greenlee 825-2 Bi-Metal Hole Saw Instruction Manual

Model: 825-2

## 1. PRODUCT OVERVIEW

The Greenlee 825-2 Bi-Metal Hole Saw is engineered for cutting through a variety of materials including steel, tin, aluminum, fiberglass, wood, and plastic. Its robust design ensures efficient and clean cuts for professional and demanding applications.



Image: Greenlee 825-2 Bi-Metal Hole Saw. This image displays the grey-colored hole saw with its sharp, bi-metal teeth and the Greenlee brand and model number (825-2) clearly visible on its side. A slot for material ejection is also visible.

### Key Features:

- **Versatile Cutting:** Capable of cutting steel, tin, aluminum, fiberglass, wood, and plastic.
- **Deep Cutting Depth:** Features a 1-5/8-inch (41.3 mm) cutting depth, suitable for cutting through 2-inch by 4-inch wood studs.
- **Durable Bi-Metal Blade:** Constructed from high-grade tool steel for extended life and superior performance.
- **Steam Oxide Finish:** Prevents gumming up and slows cutting, ensuring cooler operation and longer tool life.
- **Extra-Thick Back Plate:** Minimizes vibration for smoother, easier, and less fatiguing cutting.
- **Arbor Compatibility:** Designed for use with Greenlee standard and quick change arbors.

## 2. SAFETY INFORMATION

Always prioritize safety when operating power tools. Failure to follow these safety guidelines may result in serious injury or property damage.

- **Eye Protection:** Always wear ANSI-approved safety glasses or goggles to protect against flying debris.
- **Hand Protection:** Wear appropriate work gloves to protect hands from sharp edges and vibrations.
- **Hearing Protection:** Use ear protection, especially during prolonged use, to prevent hearing damage.
- **Secure Workpiece:** Ensure the material being cut is securely clamped or held to prevent movement during operation.
- **Proper Attire:** Avoid loose clothing, jewelry, or long hair that could get caught in rotating parts.
- **Tool Condition:** Before each use, inspect the hole saw for any damage, dull teeth, or cracks. Do not use damaged tools.
- **Correct Speed:** Use the appropriate drill speed for the material being cut. Refer to your drill's manual for recommended speeds.
- **Clear Work Area:** Keep your work area clean and well-lit. Remove any obstacles or clutter.
- **Disconnect Power:** Always disconnect the power tool from the power source before changing accessories, making adjustments, or performing maintenance.

### 3. SETUP

Proper setup is crucial for safe and effective operation of your Greenlee 825-2 Bi-Metal Hole Saw.

1. **Select the Correct Arbor:** This hole saw is designed for use with Greenlee standard and quick change arbors. Ensure the arbor matches the hole saw's size and your drill's chuck capacity.
2. **Install Pilot Drill:** Insert a 1/4 inch diameter x 4-1/4 inch L pilot drill into the arbor. Secure it firmly according to your arbor's instructions.
3. **Attach Hole Saw to Arbor:** Thread the hole saw onto the arbor until it is hand-tight. For some arbors, a wrench may be required for final tightening. Ensure the hole saw is seated flush against the arbor's flange.
4. **Secure Arbor in Drill Chuck:** Insert the arbor's shank (1/2 inch Round, 3/8 inch Round, or 7/16 inch Hex) into your drill's chuck. Tighten the chuck securely to prevent slippage during operation.
5. **Verify Stability:** Before starting, gently spin the drill by hand to ensure the hole saw and arbor are properly aligned and stable.

### 4. OPERATING INSTRUCTIONS

Follow these steps for optimal performance and safety when using your Greenlee 825-2 Bi-Metal Hole Saw.

1. **Prepare Workpiece:** Mark the center of the desired hole on your material. Secure the workpiece firmly to a stable surface using clamps or a vise.
2. **Select Drill Speed:** Adjust your drill to the appropriate speed for the material you are cutting. Slower speeds are generally recommended for harder metals, while faster speeds can be used for wood and plastic.
3. **Start the Cut:** Position the pilot drill on your marked center. Begin drilling at a slow speed, applying light, steady pressure. The pilot drill will guide the hole saw.
4. **Engage Hole Saw:** Once the pilot drill has penetrated the material, increase the drill speed to the recommended setting for the material. Continue applying steady, even pressure.
5. **Maintain Pressure:** Avoid excessive force, which can cause the saw to bind or overheat. Let the saw's teeth do the work.
6. **Clear Chips:** For deeper cuts or softer materials, periodically withdraw the saw slightly to clear chips and allow the

saw to cool. The steam oxide finish helps prevent gumming.

- 7. **Complete the Cut:** Continue drilling until the hole saw passes completely through the material.
- 8. **Remove Slug:** After the cut is complete, carefully remove the circular slug from inside the hole saw. Use a screwdriver or punch through the side slots if necessary.

5. MAINTENANCE

Regular maintenance will extend the life and performance of your Greenlee 825-2 Bi-Metal Hole Saw.

- **Cleaning:** After each use, clean the hole saw to remove any debris, chips, or residue. A brush or compressed air can be used. Ensure the teeth are free of obstructions.
- **Inspection:** Periodically inspect the teeth for wear, dullness, or damage. A dull saw will cut slowly and generate excessive heat. Replace the saw if teeth are significantly worn or damaged.
- **Lubrication (for metal cutting):** When cutting metal, use a suitable cutting lubricant to reduce friction, heat, and extend blade life.
- **Storage:** Store the hole saw in a dry place to prevent rust. Keep it in its original packaging or a tool box to protect the teeth from damage.
- **Arbor Care:** Ensure your arbor is also clean and free of debris. Check for any signs of wear or damage on the arbor's threads or shank.

6. TROUBLESHOOTING

Problem	Possible Cause	Solution
Slow cutting or excessive force required	Dull teeth, incorrect speed, insufficient pressure, material buildup	Replace saw, adjust drill speed, apply steady pressure, clear chips
Excessive vibration	Loose arbor, damaged saw, workpiece not secure	Tighten arbor, replace saw, secure workpiece firmly
Saw overheating	Too much pressure, incorrect speed, no lubricant (for metal)	Reduce pressure, adjust speed, use cutting lubricant
Hole is not round or off-center	Pilot drill not centered, workpiece shifted, drill not held steady	Ensure pilot drill is centered, secure workpiece, maintain steady drill position

7. SPECIFICATIONS

Attribute	Detail
Model Number	825-2
Brand	Greenlee
Saw Diameter	2 inches (50.8 mm)
Primary Material Application	Metal
Materials Cut	Steel, Tin, Aluminum, Fiberglass, Wood, Plastic
Tooth Material	Bi-Metal

Attribute	Detail
Teeth per Inch	4/6
Maximum Cutting Depth	1 5/8 inches (41.3 mm)
Shank Sizes	1/2 inch Round, 3/8 inch Round, 7/16 inch Hex
Pilot Drill Size	1/4 inch diameter x 4-1/4 inch L
Color	Grey
Item Weight	4.2 ounces (approx. 119 grams)
Product Dimensions	5.7 x 3.9 x 1 inches
UPC	783310191551
Manufacturer	Greenlee
Included Components	Unit (Hole Saw)

## 8. WARRANTY INFORMATION

The Greenlee 825-2 Bi-Metal Hole Saw comes with a **1-year manufacturer's warranty**. This warranty covers defects in materials and workmanship under normal use. Please retain your proof of purchase for warranty claims. For detailed warranty terms and conditions, please refer to the official Greenlee website or contact their customer support.

## 9. SUPPORT

For further assistance, technical support, or to explore other Greenlee products, please visit the official Greenlee website or their Amazon Brand Store.

**Greenlee Official Website:** [www.greenlee.com](http://www.greenlee.com)

**Greenlee Amazon Brand Store:** [Visit Store](#)

When contacting support, please have your product model number (825-2) and any relevant purchase information ready.

