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› CCLIFE 18-Piece HSS Bi-metal Hole Saw Set (Model 2725) Instruction Manual

CCLIFE 2725

CCLIFE 18-Piece HSS Bi-metal Hole Saw Set Instruction Manual

Model: 2725

1. INTRODUCTION

This manual provides essential instructions for the safe and effective use of your CCLIFE 18-Piece HSS Bi-metal Hole Saw Set. This set is designed for creating precise holes in various materials, including stainless steel, metal, wood, PVC panels, and plastic. Please read this manual thoroughly before operation and retain it for future reference.

2. PRODUCT COMPONENTS

The CCLIFE 18-Piece HSS Bi-metal Hole Saw Set includes the following components:

- 13 x Bi-metal Hole Saws: Ø16-19-22-25-32-35-37-44-51-64-68-76mm
- 2 x Mandrels
- 3 x HSS Drill Bits
- 1 x Hex Key
- 1 x Adapter



Figure 2.1: Overview of the CCLIFE 18-Piece HSS Bi-metal Hole Saw Set in its storage case.



Figure 2.2: Individual components including mandrels, HSS drill bits, hex key, and the range of saw blades with their respective diameters.

3. SETUP AND ASSEMBLY

Proper assembly is crucial for safe and effective operation. Follow these steps to assemble your hole saw:

1. **Select Components:** Choose the appropriate hole saw blade and mandrel for your desired hole size and material.
2. **Attach Drill Bit:** Insert the pilot drill bit into the mandrel. Secure it firmly with the locking screw using the hex key.
3. **Attach Saw Blade:** Thread the selected hole saw blade onto the mandrel. Ensure it is tightened securely to prevent wobbling during operation.
4. **Insert into Drill:** Insert the assembled hole saw into the chuck of your power drill (bench drill or pistol drill). Tighten the drill chuck firmly to prevent slippage.

How to Assemble?

HIGH-QUALITY AND PRECISE
MULTI-PURPOSE USE



Figure 3.1: Step-by-step assembly of the hole saw, illustrating the connection of the mandrel, saw blade, drill bit, and locking screw. Compatible drill types are also shown.

Replacing the Pilot Drill Bit

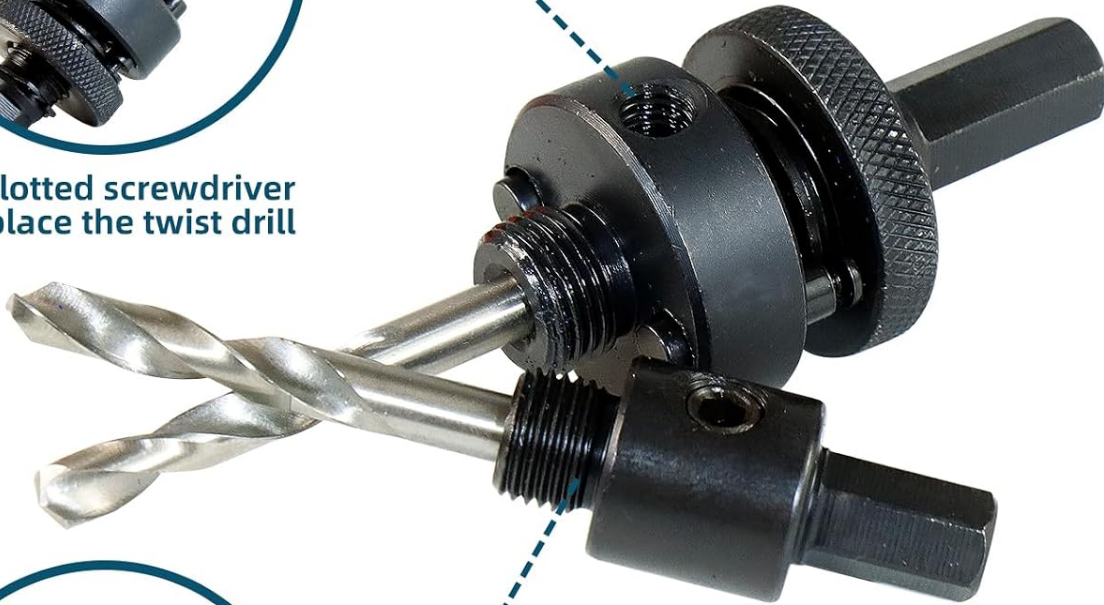
To replace a worn or damaged pilot drill bit:

1. Loosen the locking screw on the mandrel using a slotted screwdriver or the hex key.
2. Remove the old pilot drill bit.
3. Insert the new pilot drill bit and tighten the locking screw firmly.

2-PC REPALCEABLE PILOT DRILL BIT



Use slotted screwdriver
to replace the twist drill



The hole for chip removal

**High Speed Steel
Material 7/16" & 3/8"**

Figure 3.2: Illustration of how to replace the pilot drill bit within the mandrel assembly.

4. OPERATING INSTRUCTIONS

General Operation

The CCLIFE HSS Bi-metal Hole Saws are designed for high cutting performance and efficient chip removal. The 4-slot design and sharp serration contribute to clean and professional cuts.

Product Details

Φ16MM-76MM



4 SLOT DESIGN



Stamped Markings



AHARP SERRATION

Figure 4.1: Key features of the hole saw blade, including the 4-slot design for chip removal and sharp serrations.



Figure 4.2: Detailed view of the hole saw's construction, highlighting the progressive tooth strip, HSS Bi-metal composition with 8% Cobalt for durability, and the slot design for easy core plug removal.

Applicable Materials

This hole saw set is suitable for cutting a variety of materials:

- Hardwood
- Density Board
- Metal (including Stainless Steel)
- Thin PVC Plate
- Plastic



Figure 4.3: Examples of materials that can be cut using the hole saw set.

Recommended RPM (Revolutions Per Minute)

To achieve optimal cutting performance and extend the life of your hole saws, adhere to the recommended RPMs for different materials and hole saw diameters. Always use coolant when drilling, especially in metal.

Table 4.1: Recommended Hole Saw Speed (RPM)

Diameter (mm)	Light Metal	Stainless Steel	Cast Iron	Brass	Aluminum	Wood
16	550	275	365	730	825	3000
19	460	230	300	580	660	3000
22	390	195	260	520	585	3000
25	350	175	235	470	525	2700
32	275	140	180	360	410	2400
35	250	125	165	330	375	2400
37	240	120	160	315	360	2400
44	195	95	130	260	295	2100
51	170	85	115	230	255	2000
57	150	75	100	200	225	2000
64	135	65	90	180	205	1800
68	130	65	85	170	195	1800
76	115	55	75	150	170	1500

Important: Always use coolant when drilling, especially in metal.

5. MAINTENANCE

Regular maintenance ensures the longevity and performance of your hole saw set:

- **Cleaning:** After each use, clean the hole saws, mandrels, and drill bits to remove any debris, chips, or residue. Use a brush or compressed air.
- **Lubrication:** Apply a light coat of oil to metal components, especially after cleaning, to prevent rust.
- **Storage:** Store the set in its original plastic case in a dry environment to protect it from moisture and damage.
- **Inspection:** Periodically inspect saw blades for dullness or damage. Replace worn drill bits and blades as needed to maintain cutting efficiency and safety.

6. TROUBLESHOOTING

If you encounter issues during operation, consider the following:

- **Hole Saw Binding/Sticking:** This can occur if the feed rate is too aggressive, the RPM is incorrect for the material, or if the saw is dull. Reduce pressure, adjust RPM according to the table, and ensure the blade is sharp. Ensure coolant is used for metal.
- **Mandrel Locking Nut Issues:** If the locking nut on the mandrel frequently jams or becomes difficult to loosen, ensure it is clean and free of debris. Apply a small amount of lubricant if necessary. Avoid over-tightening.
- **Poor Cut Quality:** A dull blade, incorrect RPM, or insufficient coolant can lead to rough cuts. Replace the blade if dull, adjust RPM, and ensure proper lubrication/cooling.
- **Excessive Heat/Smoke:** This indicates too much friction, often due to incorrect RPM, lack of coolant, or a dull blade. Stop

immediately, check the blade, adjust RPM, and apply coolant.

7. SPECIFICATIONS

- **Brand:** CCLIFE
- **Model Number:** 2725
- **Material:** HSS Bi-metal (with 8% Cobalt alloy)
- **Hardness:** 63-65°HRC
- **Cutting Depth:** 38mm
- **Hole Saw Diameters:** 16, 19, 22, 25, 32, 35, 37, 44, 51, 64, 68, 76mm
- **Number of Pieces:** 18 (13 hole saws, 2 mandrels, 3 drill bits, 1 hex key, 1 adapter)
- **Product Dimensions:** 34 x 24.5 x 0.1 cm (approximate case dimensions)
- **Item Weight:** 2.3 Kilograms
- **Country of Origin:** China

8. SAFETY INFORMATION

Always prioritize safety when using power tools and accessories:

- **Personal Protective Equipment (PPE):** Always wear safety glasses or goggles to protect your eyes from flying debris. Consider gloves and hearing protection.
- **Secure Workpiece:** Ensure the material you are drilling is securely clamped or held to prevent movement during operation.
- **Correct Speed:** Use the recommended RPM for the material being cut to prevent overheating, binding, and premature wear.
- **Coolant:** Apply appropriate coolant, especially when drilling metal, to reduce heat and extend tool life.
- **Stable Stance:** Maintain a firm grip on the drill and a stable body position.
- **Clear Work Area:** Keep your work area clean and well-lit. Remove any loose objects that could interfere with the drilling process.
- **Inspect Tools:** Before each use, inspect the hole saw, mandrel, and drill bit for any damage or wear. Do not use damaged tools.
- **Unplug When Changing:** Always unplug the power drill or remove the battery pack before changing accessories or performing maintenance.

9. WARRANTY AND SUPPORT

For warranty information or customer support regarding your CCLIFE 18-Piece HSS Bi-metal Hole Saw Set, please consult the retailer or contact CCLIFE customer service directly. Information regarding spare parts availability is not provided in this manual.
Manufacturer: CCLIFE Technic GmbH

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Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question