

Cutting Speeds: Feet Per Minute & (Metres Per Minute)

Material	HSS Cutters		Carbide Cutters	
	FPM	MPM	FPM	MPM
Aluminum	200-300	60-90	1200-1800	360-550
Brass	150-300	45-90	900-1800	275-550
Bronze	200-250	60-75	1200-1500	360-460
Stainless steel	40-60	20-Dec	50-250	15-75
Machine steel	100-150	30-45	300-600	90-180
Tool Steel	40-60	15-20	50-250	15-75
Cast Iron	80-100	22-30	80-350	25-105

Milling Feeds

Tool Ø	0...	.1...	.2...	.3...	.5...	.6...	.7...	.8...	.9...	1 +
inch/tooth	0.0005	0.001	0.002	0.003	0.005	0.006	0.007	0.008	0.009	0.01

Tool Ø	0...	1...	2...	3...	5...	6...	7...	8...	9...	10 +
mm/tooth	0.01	0.02	0.05	0.08	0.12	0.15	0.17	0.2	0.22	0.25

Drilling Feeds

Tool Ø	.1...	.2...	.3...	.5...	.6...	.7...	.8...	.9...	1 +
inch/rev	0.001	0.002	0.003	0.005	0.006	0.007	0.008	0.009	0.01

Tool Ø	1 ...	2 ...	3 ...	5 ...	6 ...	7 ...	8 ...	9 ...	10 +
mm/rev	0.01	0.02	0.03	0.05	0.06	0.07	0.08	0.09	0.1