

Milling Spindle Speeds (RPM)

Cutter Diameter	Aluminum		Plain Carbon Steel		SS 304	
	HSS	Carbide	HSS	Carbide	HSS	Carbide
0.125	1732	3000	2139	3000	1528	3000
0.188	3000	3000	1426	3000	1019	3000
0.250	2597	3000	1070	3000	764	3000
0.313	2078	3000	856	3000	611	3000
0.375	1732	3000	713	2954	509	2546
0.438	1484	3000	611	2532	437	2183
0.500	1299	3000	535	2215	382	1910
0.563	1154	3000	475	1969	340	1698
0.625	1039	3000	428	1772	306	1528
0.688	945	2806	389	1611	278	1389
0.750	866	2572	357	1477	255	1273
0.813	799	2374	329	1363	235	1175
0.875	742	2205	306	1266	218	1091
0.938	693	2058	285	1182	204	1019
1.000	649	1929	267	1108	191	955

Drilling/Reaming Spindle Speeds (RPM)

Cutter Diameter	Aluminum		Plain Carbon Steel		Stainless Steel FM	
	Drilling	Reaming	Drilling	Reaming	Drilling	Reaming
0.125	3000	3000	3000	2819	2139	2292
0.188	2363	2506	2445	1879	1426	1528
0.250	1772	1879	1833	1409	1070	1146
0.313	1418	1503	1467	1128	856	917
0.375	1182	1253	1222	940	713	764
0.438	1013	1074	1048	805	611	655
0.500	886	940	917	705	535	573
0.563	788	835	815	626	475	509
0.625	709	752	733	564	428	458
0.688	644	683	667	513	389	417
0.750	591	626	611	470	357	382
0.813	545	578	564	434	329	353
0.875	506	537	524	403	306	327
0.938	473	501	489	376	285	306
1.000	443	470	458	352	267	286