

DRILLING/REAMING

COMMON SPEEDS (RPM)

Stock Material	Aluminum		Plain Carbon Steel		Stainless Steel	
Cutter Diameter (in)	Drilling	Reaming	Drilling	Reaming	Drilling	Reaming
0.125 [1/8]	2500	2500	2500	2500	1680	2500
0.250 [1/4]	2500	2500	1910	2500	840	2500
0.375 [3/8]	2500	2500	1270	1870	560	1490
0.500 [1/2]	2500	2500	950	1400	420	1120
0.625 [5/8]	1700	1700	760	1120	340	890
0.750 [3/4]	1770	1770	640	940	280	750
0.875 [7/8]	1520	1520	550	800	240	640
1.000	1330	1330	480	700	210	560