

HIGH SPEED STEEL DRILLS - FRACTIONAL

Recommended Cutting Speeds in R.P.M.

CUTTING SPEEDS	Feet per Minute			
	10	40	100	150
CUTTING SPEEDS	Meters per Minute			
	3	12	30	45
Size	Revolutions per Minute			
1/16	611	2445	6112	9168
5/64	489	1955	4888	7332
3/32	408	1630	4075	6113
7/64	349	1397	3492	5238
1/8	306	1222	3056	4584
9/64	272	1086	2716	4074
5/32	244	978	2444	3666
11/64	222	889	2222	3333
3/16	204	815	2038	3057
13/64	188	752	1880	2820
7/32	175	698	1746	2619
15/64	163	652	1629	2444
1/4	153	611	1528	2292
5/16	122	489	1222	1833
3/8	102	407	1018	1527
7/16	87	349	873	1309
1/2	76	306	764	1146
9/16	68	272	679	1019
5/8	61	244	611	916
3/4	51	204	509	764
7/8	44	174	436	654
1	38	153	382	573
1-1/8	34	136	339	509
1-1/4	31	122	306	459
1-3/8	28	111	278	417
1-1/2	25	102	254	381
1-3/4	22	87	218	327
2	19	76	191	286
2-1/4	17	68	169	253
2-1/2	15	61	153	229
2-3/4	14	56	139	209
3	13	51	127	191
3-1/4	12	47	117	176
3-1/2	11	44	109	164
3-3/4	10	41	102	153
4	9.5	38	95	143