

# HIGH SPEED STEEL DRILLS - METRIC

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			
1.0	970	3878	9695	14542
1.5	647	2589	6474	9711
2.0	485	1941	4853	7280
2.5	388	1552	3882	5823
3.0	323	1294	3234	4851
3.5	277	1108	2772	4158
4.0	243	970	2425	3638
5.0	194	776	1941	2911
6.0	162	647	1617	2426
7.0	139	554	1386	2079
8.0	121	485	1213	1819
9.0	108	431	1078	1617
10.0	97	388	970	1455
11.0	88	353	882	1323
12.0	81	323	809	1213
14.0	69	277	693	1039
16.0	61	243	607	910
18.0	54	216	539	808
20.0	49	194	485	728
22.0	44	176	441	662
26.0	37	149	373	560
30.0	32	129	324	485
34.0	29	114	285	428
38.0	26	102	255	383
42.0	23	93	231	347
46.0	21	85	211	317
50.0	19	78	194	291
56.0	17	70	173	260
62.0	16	62	156	234
68.0	14	56	141	211
74.0	13	52	130	195
80.0	12	49	121	182
90.0	11	44	109	163
95.0	10	41	102	153
100.0	9.7	39	97	145