



**Recommended Cutting Speeds (RPM's)
for Various Materials and Diameters**

<u>Diameter Inches</u>	<u>Stainless Tool Steel</u>	<u>Cast Iron</u>	<u>Mild Steel</u>	<u>Brass</u>	<u>Aluminum</u>
9/16	300	400	580	790	900
5/8	275	365	550	730	825
11/16	250	330	500	665	750
3/4	230	300	460	600	690
13/16	210	280	425	560	635
7/8	195	260	390	520	585
15/16	185	245	370	495	555
1	175	235	350	470	525
1-1/16	160	215	325	435	480
1-1/8	150	200	300	400	450
1-3/16	145	190	285	380	425
1-1/4	140	180	275	360	410
1-5/16	135	175	260	345	390
1-3/8	125	165	250	330	375
1-7/16	120	160	240	315	360
1-1/2	115	150	230	300	345
1-9/16	110	145	220	290	330
1-5/8	105	140	210	280	315
1-11/16	100	135	205	270	305
1-3/4	95	130	195	260	295
1-13/16	95	125	190	250	285
1-7/8	90	120	180	240	270
2	85	115	170	230	255
2-1/16	80	110	165	220	245
2-1/8	80	105	160	210	240
2-1/4	75	100	150	200	225
2-5/16	75	100	145	195	225
2-3/8	70	95	140	190	220
2-1/2	65	90	135	180	205
2-9/16	65	85	130	175	200
2-5/8	65	85	130	170	195
2-3/4	60	80	125	160	185
2-7/8	60	80	125	160	180
3	55	75	115	150	170
3-1/8	55	70	110	140	165
3-1/4	50	70	105	140	155
3-3/8	50	65	100	130	150
3-1/2	45	65	95	130	145
3-5/8	45	60	95	120	140
3-3/4	45	60	90	120	135
3-7/8	45	60	90	120	135
4	40	55	85	110	130
4-1/8	40	55	80	110	120
4-1/4	40	55	80	110	120
4-3/8	40	50	80	100	120
4-1/2	35	50	75	100	105
4-3/4	35	50	75	95	95
5	30	45	65	90	90
5-1/2	25	40	60	85	85
6	25	35	55	75	75

ALWAYS WEAR SAFETY ITEMS TO AVOID RISK OF INJURY

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