

General Purpose Carbide Drills

Speeds & Feeds

	Speed	(Feed Per Tooth) by End Mill Diameter (Inches)				
	SFPM	1/8"	1/4"	1/2"	3/4"	1"
Non Ferrous Materials						
Aluminum	150-400	0.0015	0.003	0.005		
Brass/Bronze	100-300	0.001	0.002	0.003		
Copper/Copper Alloys	150-400	0.002	0.004	0.009		
Plastics	250-600	0.003	0.005	0.012		
Cast Iron						
Malleable	100-300	0.002	0.003	0.006	0.01	0.012
Ductile	70-250	0.0015	0.003	0.005	0.008	0.014
Steels						
Low Carbon Steels	85-150	0.001	0.002	0.004	0.008	0.01
Medium Alloy Steels	65-120	0.001	0.0015	0.003	0.007	0.009
200, 250, 300						
High Strength Steels	30-90	0.0005	0.0015	0.0025	0.004	0.006
Stainless Steels						
PH Series	50-125	0.0005	0.0005	0.002	0.005	0.006
Austenitic	30-90	0.0005	0.0005	0.002	0.005	0.006
200, 302, 303 304(L), 316(L)						
Martensitic	50-125	0.0005	0.0005	0.002	0.005	0.006
403, 410, 416, 420, 440						
High Temp Alloys						
Nickel Base	30-90	0.0005	0.0007	0.001	0.002	0.0025
Inconel 601, 625, 718						
Waspaloy, Hastelloy						
Cobalt Base	30-90	0.0005	0.0007	0.001	0.002	0.0025
Stellite, Haynes 25						
Iron Base	40-100	0.0007	0.001	0.0015	0.0025	0.003
Incoloy 800-802,						
Haynes 556						
Titanium	45-200	0.001	0.003	0.005	0.01	0.011

Notes: Speeds and Feeds listed are estimated and will vary by application.
Reduce Speeds by 20-30% when exceeding 2x length to diameter.