

Carbide Reamer

Speeds & Feeds

	Speed SFPM	(Feed Per Tooth) by End Mill Diameter (Inches)			
		1/8"	1/4"	1/2"	3/4"
Non Ferrous Materials					
Aluminum	200-250	0.004	0.006	0.01	0.014
Brass/Bronze	70-120	0.004	0.005	0.007	0.01
Copper/Copper Alloys	75-120	0.006	0.008	0.012	0.014
Plastics	130-150	0.002	0.003	0.004	0.005
Cast Iron					
Malleable	45-100	0.005	0.007	0.011	0.015
Ductile	30-45	0.004	0.006	0.009	0.012
Steels					
Low Carbon Steels	65-85	0.006	0.01	0.014	0.02
Meduim Alloy Steels	40-65	0.004	0.006	0.009	0.011
200, 250, 300					
High Strength Steels	20-50	0.002	0.003	0.004	0.005
Stainless Steels					
PH Series	40-65	0.003	0.004	0.005	0.005
Austenitic	55-85	0.004	0.006	0.008	0.012
200, 302, 303 304(L), 316(L)					
Martensitic	40-65	0.003	0.004	0.005	0.005
403, 410,416, 420, 440					
High Temp Alloys					
Nickel Base	20-40	0.002	0.003	0.004	0.006
Inconel 601, 625, 718					
Waspaloy, Hastelloy					
Cobalt Base	20-40	0.002	0.003	0.004	0.006
Stellite, Haynes 25					
Iron Base	25-50	0.003	0.004	0.005	0.005
Incoloy 800-802, Haynes 556					
Titanium	45-90	0.003	0.005	0.006	0.009

Notes: Speeds and Feeds listed are estimated and will vary by application.