

SPEED & FEED GUIDE

Optimum Performance



Series 265

537

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
				P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	.3 x D	220	6723	17	3362	17	2241	20	1681	21
1.25 x D	.2 x D	264	8068			24	4034	24	2689	29	2017	30	1614	29	1345	27
1.5 x D	.08 x D	317	9681			48	4841	48	3227	56	2420	59	1936	57	1614	52
1.5 x D	.05 x D	380	11618			76	5809	64	3873	74	2904	77	2324	74	1936	68
Alloy Steel 4140, 8620	1 x D	.3 x D	180		5501	14	2750	19	1834	17	1375	17	1100	17	917	15
	1.25 x D	.2 x D	225		6876	21	3438	29	2292	25	1719	26	1375	25	1146	23
	1.5 x D	.08 x D	270		8251	41	4126	57	2750	48	2063	51	1650	49	1375	44
	1.5 x D	.05 x D	297		9076	59	4538	68	3025	57	2269	60	1815	58	1513	53
Tool Steel A2, A3, D2, H11, H13	.5 x D	.3 x D	160		4890	12	2445	17	1630	15	1222	15	978	15	815	14
	1.0 x D	.2 x D	200		6112	18	3056	26	2037	22	1528	23	1222	22	1019	20
	1.5 x D	.08 x D	240		7334	37	3667	51	2445	43	1834	45	1467	43	1222	40
	1.5 x D	.05 x D	264		8068	52	4034	61	2689	51	2017	54	1614	52	1345	47
M	SS 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	.3 x D	140	4278	11	2139	9	1426	13	1070	13	856	13	713	12
		1.25 x D	.2 x D	185	5654	17	2827	14	1885	20	1413	21	1131	21	942	19
		1.5 x D	.08 x D	230	7039	35	3519	28	2346	41	1760	43	1408	41	1173	38
		1.5 x D	.05 x D	276	8446	55	4223	42	2815	53	2112	56	1689	54	1408	49
	Precipitation SS 15-5, 16-6, 17-4, 17-6	.5 x D	.3 x D	115	3514	9	1757	7	1171	8	879	9	703	8	586	8
		1.25 x D	.2 x D	180	5501	17	2750	14	1834	15	1375	15	1100	15	917	14
		1.5 x D	.08 x D	250	7640	38	3820	31	2547	33	1910	35	1528	33	1273	31
		1.5 x D	.05 x D	300	9168	60	4584	46	3056	55	2292	58	1834	55	1528	51
S	High Temp Alloys Inconel 718, Hastalloy, A286, Waspalloy, CoCr	.25 x D	.3 x D	70	2139	5	1070	4	713	5	535	5	428	5	357	5
		1 x D	.2 x D	80	2445	7	1222	6	815	7	611	7	489	7	407	6
		1.25 x D	.08 x D	125	3820	19	1910	15	1273	17	955	17	764	17	637	15
		1.5 x D	.05 x D	160	4890	32	2445	24	1630	29	1222	31	978	30	815	27