

SPEEDS AND FEEDS FOR BORING TOOLS

DEPTH OF CUT

MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE	FEED INCHES PER REVOLUTION	DEPTH OF CUT		
				INSERT BARS SERIES 16THRU 18 PAGE 45 THRU 48	SOLID CARBIDE BARS OUR SERIES 10 PAGE 2	TIN COATED SOLID CARBIDE BARS OUR SERIES 11 PAGE 3
PLASTIC	TEFLON	500-600	.003 - .006	.007	.012	.016
	NYLON	700-800	.001 - .003	.007	.012	.016
	PHENOLIC	700-800	.001 - .003	.007	.012	.016
	GLASS FILLED	700-800	.001 - .003	.005	.012	.016
MAGNESIUM	AZ,AM,EZ,ZE,HK	750-1500	.005 - .012	.008	.012	.016
ALUMINUM	2021 THRU 6061	700-1400	.005 - .012	.008	.014	.018
COPPER	101-707	600-800	.003 - .005	.008	.014	.016
	834-978	600-800	.003 - .005	.008	.014	.016
BRASS		350-400	.001 - .003	.006	.011	.012
BRONZE		300-400	.001 - .002	.006	.011	.012
CAST IRON	GRAY	250-350	.004 - .010	.007	.007	.009
	DUCTILE	250-350	.004 - .010	.007	.007	.009
	MALLEABLE	250-350	.004 - .010	.007	.007	.009
STEEL	1005-1029	100-300	.003 - .007	.007	.014	.016
	1030-1055	100-300	.003 - .007	.007	.014	.016
	1060-1095	150-400	.003 - .005	.007	.014	.016
	10L45-10L50	300-500	.004 - .006	.007	.014	.016
	12L13-12L15	300-500	.003 - .005	.007	.014	.016
	41L30-41L50	200-400	.003 - .005	.007	.014	.016
	4140-4150	150-400	.003 - .005	.007	.014	.016
	4140 (35 HRC)	90-125	.001 - .004	.004	.007	.008
	8617-8622	100-300	.002 - .004	.007	.006	.007
	M1-M6	150-250	.003 - .008	.006	.005	.006
	H10-H19	150-250	.003 - .007	.006	.005	.006
	D2-D7	150-250	.004 - .010	.006	.005	.006
	A2-A9, 01-07	150-250	.003 - .008	.006	.005	.006
	W1, W2	150-250	.003 - .008	.006	.006	.007
M-50, 52100	300-400	.004 - .010	.007	.006	.007	
TITANIUM	TI-9AI-6V	90-250	.001 - .003	.005	.008	.011
STAINLESS	201-385	100-250	.001 - .004	.005	.008	.012
	405-446	100-250	.001 - .004	.005	.008	.012
	15-5PH,16-6PH,14-4PH	300-400	.002 - .004	.005	.008	.012
NICKEL	NICKEL 200-230	100-250	.002 - .005	.004	.007	.009
MONEL		80-120	.001 - .003	.004	.007	.009
INCONEL		80-120	.001 - .003	.004	.007	.009
WASPALOY		80-120	.001 - .003	.004	.007	.009
HASTELLOY		80-120	.001 - .003	.004	.007	.009

NOTE: ALL SPEEDS AND FEEDS LISTED HERE ARE PROVIDED FOR REFERENCE ONLY.

$$\frac{RPM = SFM \times 12}{(1) \times \text{DIAMETER}}$$