

HIGH SPEED STEEL DRILLS - METRIC

Recommended Cutting Speeds in R.P.M.

| CUTTING SPEEDS | Feet per Minute | | | |
|----------------|------------------------|------|------|-------|
| | 10 | 40 | 100 | 150 |
| CUTTING SPEEDS | Meters per Minute | | | |
| | 3 | 12 | 30 | 45 |
| Size | Revolutions per Minute | | | |
| 1.0 | 970 | 3878 | 9695 | 14542 |
| 1.5 | 647 | 2589 | 6474 | 9711 |
| 2.0 | 485 | 1941 | 4853 | 7280 |
| 2.5 | 388 | 1552 | 3882 | 5823 |
| 3.0 | 323 | 1294 | 3234 | 4851 |
| 3.5 | 277 | 1108 | 2772 | 4158 |
| 4.0 | 243 | 970 | 2425 | 3638 |
| 5.0 | 194 | 776 | 1941 | 2911 |
| 6.0 | 162 | 647 | 1617 | 2426 |
| 7.0 | 139 | 554 | 1386 | 2079 |
| 8.0 | 121 | 485 | 1213 | 1819 |
| 9.0 | 108 | 431 | 1078 | 1617 |
| 10.0 | 97 | 388 | 970 | 1455 |
| 11.0 | 88 | 353 | 882 | 1323 |
| 12.0 | 81 | 323 | 809 | 1213 |
| 14.0 | 69 | 277 | 693 | 1039 |
| 16.0 | 61 | 243 | 607 | 910 |
| 18.0 | 54 | 216 | 539 | 808 |
| 20.0 | 49 | 194 | 485 | 728 |
| 22.0 | 44 | 176 | 441 | 662 |
| 26.0 | 37 | 149 | 373 | 560 |
| 30.0 | 32 | 129 | 324 | 485 |
| 34.0 | 29 | 114 | 285 | 428 |
| 38.0 | 26 | 102 | 255 | 383 |
| 42.0 | 23 | 93 | 231 | 347 |
| 46.0 | 21 | 85 | 211 | 317 |
| 50.0 | 19 | 78 | 194 | 291 |
| 56.0 | 17 | 70 | 173 | 260 |
| 62.0 | 16 | 62 | 156 | 234 |
| 68.0 | 14 | 56 | 141 | 211 |
| 74.0 | 13 | 52 | 130 | 195 |
| 80.0 | 12 | 49 | 121 | 182 |
| 90.0 | 11 | 44 | 109 | 163 |
| 95.0 | 10 | 41 | 102 | 153 |
| 100.0 | 9.7 | 39 | 97 | 145 |