

Aluminum						
Diameter Ø	HSS			Carbide		
SFM	300	500	600	800	1000	1500
0.25 in	4500	7500	9000	12000	15000	23000
0.5 in	2500	4000	4500	6000	7500	12000
1 in	1000	2000	2500	3000	4000	6000
2 in	600	1000	1000	1500	2000	3000
3 in	400	600	800	1000	1500	2000
4 in	300	500	600	800	1000	1500
Steel						
Diameter Ø	HSS			Carbide		
SFM	50	80	100	200	500	800
0.25 in	800	1200	1500	3000	7500	12000
0.5 in	400	600	800	1500	4000	6000
1 in	200	300	400	800	2000	3000
2 in	100	200	200	400	1000	1500
3 in	100	100	100	300	600	1000
4 in	50	100	100	200	500	800
Stainless						
Diameter Ø	HSS			Carbide		
SFM	30	40	50	150	200	300
0.25 in	500	600	800	2500	3000	4500
0.5 in	200	300	400	1000	1500	2500
1 in	100	200	200	600	800	1000
2 in	60	80	100	300	400	600
3 in	40	50	60	200	250	400
4 in	30	40	50	150	200	300
Titanium						
Diameter Ø	HSS			Carbide		
SFM	20	25	30	100	150	200
0.25 in	300	400	500	1500	2500	3000
0.5 in	200	200	200	800	1000	1500
1 in	100	100	100	400	600	800
2 in	50	50	100	200	300	400
3 in	50	50	50	100	200	300
4 in	50	50	50	100	100	200
Brass/Bronze						
Diameter Ø	HSS			Carbide		
SFM	300	500	600	800	1000	1200
0.25 in	4500	7500	9000	12000	15000	18000
0.5 in	2500	4000	4500	6000	7500	9000
1 in	1000	2000	2500	3000	4000	4500
2 in	600	1000	1000	1500	2000	2500
3 in	400	600	800	1000	1500	1500
4 in	300	500	600	800	1000	1000