

**RECOMMENDED SPEEDS
FOR STANDARD MATERIALS WITH H.S.S. DRILLS**

800-350-8665

Material	Recommended Speed (sfm)
Aluminum and its Alloys	200-300
Brass and Bronze (ordinary)	150-300
Bronze (High Tensile)	70-150
Die Castings (Zinc Base)	300-400
Iron-Cast (soft)	75-125
Cast (medium hard)	50-100
Hard Chilled	10-20
Malleable	80-90
Magnesium and its Alloys	250-400
Monel Metal or High-Nickel Steel	30-50
Plastics or Similar Materials	100-300
Steel-	
Mild .2 carbon to .3 carbon	80-100
Steel .4 carbon to .5 carbon	70-80
Tool 1.2 carbon	50-60
Forgings	40-50
Alloy-300 to 400 Brinell	20-30
High Tensile (Heat Treated)	
35 to 40 Rockwell "C"	30-40
40 to 45 Rockwell "C"	25-35
45 to 50 Rockwell "C"	15-25
50 to 55 Rockwell "C"	7-15
Stainless Steel	
Free Matching Grades	30-80
Work Hardening Grades	15-50
Titanium Alloy Sheet	50-60
Titanium Alloys	
Ti-75A (Commercially Pure)	50-60
RS-120	40-60
Ti-150A	40-50
Ti-140A	30-40
RC-130-B	30-40
MST 6A1-4 Va.	20-35
MST 3A1-5 Cr.	10-20