COUNTERSINK

FULLERTON

SPEEDS / FEEDS

Approximate suggested speeds for:

MATERIAL	FEET PER TOOTH (FPT)	CARBIDE SPEED (SFM)
Aluminum Aluminum Alloys	.001/.002	300-500
Brass / Bronze	.001/.002	150-250
Iron - Cast Soft	.001/.002	125-225
Iron - Cast Medium Hard	.001/.002	100-175
Iron Malleable	.001/.002	90-150
Magnesium Magnesium Alloys	.001/.002	250-400
High Nickel Steel	.001/.002	50-75
Plastic Bakelite	.001/.002	250-400
Steel - Mild	.001/.002	80-170
Steel - Tool	.001/.002	60-100
Steel - Forgings	.001/.002	50-80
Steel - Alloys 300-400 Brinell	.001/.002	30-50
Steel - High Tensile 35-45 RC	.001/.002	35-60
Steel - High Tensile 45-50 RC	.001/.002	25-40
Steel - High Tensile 50-55 RC	.001/.002	15-20
Stainless Steel (Free Machining)	.001/.002	80-125
Stainless Steel (Work Hardening)	.001/.002	50-75
Inconell Alloy Hastelloy Wrought	.001/.002	25-35
Hastelloy (Cast)	.001/.002	7-15

Formulas

RPM = SFM X 3.82 ÷ CUTTER O.D. (FINISHED DIAMETER)

IPR = FPT X NUMBER OF TEETH

IPM = IPR X RPM

THESE ARE STARTING FEEDS AND SPEEDS, CUTTING FLUID IS REQUIRED!