



Speed & Feeds for High Speed Steel Twist Drills

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Work Material

Stainless Steel	Tool Steel	Cast Iron	Malleable Iron	Medium Carbon Steel	Free Culling Steel	Alum. Brass	Wood Plastic
CUTTING SPEED: Meters per minute							
12	18	24	27	30	43	61	91

Single Speed RPM

DRILL DIAMETER (mm)

1.5	2445	3667	4889	5500	6112	8556	12223	18335
2.5	1620	2445	3259	3667	4074	5704	8149	12223
3	1222	1833	2445	2750	3056	4278	6112	9167
4	978	1467	1956	2200	2445	3422	4889	7334
5	815	1222	1630	1833	2037	2852	4074	6112
6	654	982	1309	1473	1637	2292	3274	4911
7	543	815	1086	1222	1358	1901	2716	4074
8	489	733	978	1100	1222	1711	2445	3667
9	448	672	896	1008	1120	1568	2241	3361
10	407	611	815	917	1019	1426	2037	3056
11	349	524	698	786	873	1222	1746	2619
13	306	458	611	688	764	1070	1528	2292
14	272	407	543	611	679	951	1358	2037
16	244	367	489	550	611	856	1222	1833
18	222	333	444	500	556	778	1111	1667
19	204	306	407	458	509	713	1019	1528
20	189	224	378	425	473	662	946	1419
22	175	262	349	393	437	611	873	1310