



## REAMING SPEEDS AND FEED RATES (HSS)

MATERIAL	BRINELL	SFM*	FEED RATE (in/rev)
Aluminum	99-101	150-160	0.005-0.012
Aluminum Bronze	170-187	40-45	0.005-0.012
Bakelite	-	50-60	0.005-0.012
Brass	192-202	150-160	0.005-0.012
Bronze, Common	166-183	150-160	0.005-0.012
Bronze, Phosphor, 1/2 hard	187-202	130-140	0.005-0.012
Cast Iron - soft	126	100-110	0.005-0.010
Cast Iron - medium soft	196	50-60	0.005-0.010
Cast Iron - hard	293-302	30-35	0.005-0.010
Cast Iron - chilled	402	8-10	0.002-0.004
Cast Steel	286-302	70-75	0.004-0.008
Celluloid	-	75-80	0.005-0.012
Copper	80-85	45-55	0.005-0.012
Drop Forgings (steel)	170-196	40-45	0.004-0.008
Duralumin	90-104	150-160	0.005-0.012
Everdur	179-207	40-45	0.005-0.012
Machinery Steel	170-196	67-75	0.004-0.008
Magnet Steel - soft	241-302	20-25	0.004-0.008
Magnet Steel - hard	321-512	10	0.002-0.004
Manganese Steel (7%-13%)	187-217	10	0.004-0.008
Steel - carbon	175-225	35-70	0.004-0.008
Steel - alloy	112-126	35-40	0.004-0.008
Stainless Steel - AISI 302	135-275	15-30	0.004-0.008
Stainless Steel - AISI 403	135-325	20-50	0.004-0.008
Stainless Steel - AISI 416	135-325	30-60	0.004-0.008
Stainless Steel - AISI 430	135-325	30-50	0.004-0.008
Stainless Steel - AISI 443	135-325	15-30	0.004-0.008

\*Cutting speeds in surface feet per minute (SFM or FPM) for reaming with HSS Reamer.