



Holding the Cutting Edge  
for over 100 Years

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### Reaming Feeds and Speeds

Material	Brinell	Surface Feet Per Minute *
Aluminum	99-101	150-160
Aluminum Bronze	170-187	40-45
Bakelite	-	50-60
Brass	192-202	150-160
Bronze, Common	166-183	150-160
Bronze, Phosphor, ½ Hard	187-202	130-140
Cast Iron – Soft	126	100-110
Cast Iron – Medium Soft	196	50-60
Cast Iron – Hard	293-302	30-35
Cast Iron – Chilled	402	8-10
Cast Steel	286-302	70-75
Celluloid	-	75-80
Copper	80-85	45-55
Drop Forgings (Steel)	170-196	40-45
Duralumin	90-104	150-160
Everdur	179-207	40-45
Machinery Steel	170-196	67-75
Magnet Steel – Soft	241-302	20-25
Magnet Steel – Hard	321-512	10
Manganese Steel – 7% - 13%	187-217	10
Steel – Carbon	175-225	35-70
Steel – Alloy	112-126	35-40
Stainless Steel – AISI 302	135-275	15-30
Stainless Steel – AISI 403	135-325	20-50
Stainless Steel – AISI 416	135-325	30-60
Stainless Steel – AISI 430	135-325	30-50
Stainless Steel – AISI 443	135-325	15-30

\* Cutting Speeds in Surface Feet Per Minute for reaming with a High Speed Steel reamer.