

TABLE 4-4. Rotational speeds and feeds for high-speed twist drills

Diameter of drill (in.)	MATERIAL AND CUTTING SPEED (FT PER MINUTE)										Feed per revolution (in.)
	Aluminum	Brass & Bronze	Cast iron	Mild steel 0.2-0.3 carbon (LOW)	Steel 0.4-0.5 carbon (MED)	Tool steel 1.2 carbon and drop forgings	Conn. rod molybdenum steel	3.5 nickel steel	Stainless steel and monel metal	Malleable iron	
	300	200	100	110	80	60	55	80	60	65	
	Revolutions per minute										
1/16.....	18,336	12,224	8,112	8,724	4,883	3,888	3,404	3,978	3,068	5,192	0.0015
1/8.....	9,168	6,112	3,056	3,362	2,444	1,834	1,702	1,988	1,528	2,596	0.002-0.003
3/16.....	6,108	4,072	2,036	2,242	1,630	1,222	1,120	1,324	1,018	1,734	0.004
1/4.....	4,584	3,056	1,528	1,681	1,222	917	851	984	784	1,298	0.005
5/16.....	3,888	2,444	1,222	1,344	978	733	672	794	611	1,036	0.006
3/8.....	3,064	2,036	1,018	1,121	818	611	560	662	509	867	0.008
7/16.....	2,622	1,748	874	921	699	524	481	568	437	742	0.007
1/2.....	2,292	1,528	764	840	611	458	420	497	382	648	0.008
9/16.....	2,037	1,368	678	747	543	407	373	441	340	577	0.008
5/8.....	1,836	1,224	612	673	489	367	337	398	308	520	0.009
11/16.....	1,688	1,110	556	611	444	333	300	360	273	472	0.009
3/4.....	1,524	1,018	508	558	408	308	279	330	254	433	0.010
13/16.....	1,422	948	474	521	379	286	261	308	237	403	0.010
7/8.....	1,314	876	438	482	349	262	241	288	219	371	0.011
15/16.....	1,221	814	407	448	328	244	224	268	204	348	0.012
1.....	1,148	764	382	420	308	229	210	258	191	326	0.013
1 1/16.....	1,077	718	359	396	287	216	197	233	180	306	0.013
1 1/8.....	1,020	680	340	374	272	204	187	221	170	288	0.014
1 3/16.....	968	644	322	354	258	193	177	209	161	274	0.014
1 1/4.....	918	612	306	337	246	183	168	199	153	260	0.015
1 5/16.....	873	582	291	320	233	175	160	189	148	248	0.015
1 3/8.....	834	556	278	308	222	167	153	180	139	236	0.015
1 7/16.....	795	530	266	292	212	159	148	172	133	226	0.016
1 1/2.....	762	508	254	279	204	153	140	166	127	216	0.016
1 9/16.....	732	486	244	268	196	146	134	160	122	207	0.016
1 5/8.....	702	468	234	267	188	141	129	152	117	201	0.016
1 11/16.....	678	452	226	249	181	138	124	147	113	192	0.016
1 3/4.....	654	436	218	240	175	131	120	142	109	186	0.016
1 13/16.....	630	420	210	231	168	126	118	137	106	179	0.016
1 7/8.....	612	408	204	224	163	122	112	133	102	173	0.016
1 15/16.....	591	394	197	216	158	118	108	128	99	168	0.016
2.....	573	382	191	210	153	116	105	124	96	162	0.016

1. Rotational speed value for carbide twist drills are 200 to 300 percent higher than H.S.S.

# Manual Lathe Speeds And Feeds Chart

**George F. Schrader, Ahmad K.  
Elshennawy**



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