

## HSS & Carbide Reamers Speeds & Feeds

Workpiece Material	Speeds (SFM)		(Feed Per Tooth) by Reamer Diameter (Inches)				
	HSS	Carbide	1/8	1/4	1/2	3/4	1
<b>Non-Ferrous Materials</b>							
Aluminum	125-325	450-1000	.004	.006	.010	.020	.040
Brass/Bronze	125-200	225-400	.004	.005	.007	.015	.030
Copper/Copper Alloys	50-75	100-175	.004	.006	.010	.010	.015
Plastics	75-100	550-900	.002	.005	.008	.015	.030
<b>Cast Iron</b>							
Malleable	50-100	150-250	.005	.007	.011	.015	.030
Ductile	25-40	100-175	.004	.006	.009	.012	.018
<b>Steels</b>							
Low Carbon Steels	50-80	250-300	.006	.010	.014	.020	.040
Medium Alloy Steels 200, 250, 300	30-50	125-225	.004	.006	.009	.011	.016
High Strength Steels	10-25	50-100	.002	.004	.006	.008	.016
<b>Stainless Steels</b>							
PH Series	15-25	60-90	.003	.004	.006	.010	.015
Austenitic 200,302, 303, 304, 304(L), 316(L)	20-30	150-225	.004	.006	.008	.012	.018
Martensitic 403, 410, 416, 420, 440	15-25	60-110	.004	.006	.008	.012	.018
<b>High Temp Alloys</b>							
Nickel Based Inconel 601, 625, 718, Waspalloy, Hastelloy	10-20	45-70	.002	.004	.006	.008	.016
Cobalt Based Stellite, Haynes 25	10-15	30-50	.002	.004	.006	.008	.016
Iron Based Incolloy 800-802, Haynes 556	15-25	50-75	.002	.004	.006	.008	.016
<b>Titanium</b>	35-100	45-90	.003	.005	.006	.009	.018

**NOTES:** Speeds and Feeds listed are estimated and will vary by application.



## Total Stock Allowance by Reamer Diameter

Workpiece Material	0.015	0.032	0.063	0.125	0.250	0.375	0.500	0.625	0.750	0.875	1.00-2.00
<b>Non-Ferrous Materials</b>											
Aluminum	.001	.003	.006	.011	.012	.015	.016	.018	.020	.021	.022
Brass/Bronze	.001	.003	.006	.011	.012	.013	.015	.016	.018	.019	.020
Copper/Copper Alloys	.001	.003	.006	.011	.012	.014	.015	.017	.019	.020	.021
<b>Cast Iron</b>											
Malleable	.002	.003	.006	.010	.011	.013	.014	.016	.018	.019	.020
Ductile	.002	.003	.006	.010	.011	.013	.014	.015	.017	.018	.019
<b>Steels</b>											
Low Carbon Steels	.001	.003	.006	.010	.011	.013	.014	.016	.017	.018	.019
Medium Alloy Steels 200, 250, 300	.001	.003	.005	.009	.010	.012	.013	.015	.017	.018	.019
High Strength Steels	.001	.002	.004	.007	.008	.010	.011	.013	.014	.015	.016
<b>Stainless Steels</b>	.001	.002	.005	.009	.010	.012	.013	.015	.016	.017	.018
<b>High Temp Alloys</b>											
Soft	.002	.003	.005	.009	.010	.011	.013	.014	.016	.017	.018
Hard	.001	.003	.005	.008	.009	.010	.012	.013	.014	.015	.016
<b>Titanium</b>	.001	.003	.005	.010	.011	.013	.014	.015	.016	.017	.018

