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
Non-Ferrous Materials							
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
Cast Iron							
Malleable	50-100	150-250	.005	.007	.011	.015	.030
Ductile	25-40	100-175	.004	.006	.009	.012	.018
Steels							
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
Stainless Steels							
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
High Temp Alloys							
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
Titanium	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
Non-Ferrous Materials											
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
Cast Iron											
Malleable	.002	.003	.006	.010	.011	.013	.014	.016	.018	.019	.020
Ductile	.002	.003	.006	.010	.011	.013	.014	.015	.017	.018	.019
Steels											
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
Stainless Steels	.001	.002	.005	.009	.010	.012	.013	.015	.016	.017	.018
High Temp Alloys											
Soft	.002	.003	.005	.009	.010	.011	.013	.014	.016	.017	.018
Hard	.001	.003	.005	.008	.009	.010	.012	.013	.014	.015	.016
Titanium	.001	.003	.005	.010	.011	.013	.014	.015	.016	.017	.018