

Carbide Uncoated

MATERIAL GROUP	SURFACE SPEED METRES/MIN	HARDNESS (Bhn)	FEED (mm) REVOLUTION REAMER DIAMETER			
			3mm	6mm	12mm	20mm
Aluminium and Aluminium Alloys - lows	50-80	-	0.100	0.152	0.254	0.355
Brass and Bronze	20-40	-	0.100	0.127	0.177	0.254
Copper and Copper Alloys	20-40	-	0.152	0.203	0.304	0.381
Cast Iron (Soft)	10-25	120-220	0.076	0.100	0.152	0.228
Cast Iron (Hard)	10-15	220-320	0.050	0.076	0.100	0.127
Ductile Iron	15-25	-	0.100	0.152	0.228	0.304
Malleable Iron	20-30	-	0.127	0.177	0.279	0.381
Magnesium and Magnesium Alloys	60-80	-	0.127	0.177	0.254	0.330
Hi-Temperature Alloys	6-12	-	0.050	0.076	0.100	0.152
Monel-High Nickel Steels	9-15	-	0.076	0.100	0.152	0.228
Plastics-Glass Filled	45-55	-	0.050	0.050	0.100	0.228
Plastics	39-45	-	0.050	0.050	0.076	0.127
Low Carbon Steels Annealed	20-26	-	0.152	0.254	0.355	0.508
Medium Carbon Steels	12-20	275-425	0.100	0.152	0.228	0.280
Hardened Steels	6-15	48-52 Rc "C"	0.050	0.076	0.100	0.127
Stainless Steel Soft	16-26	135-275	0.100	0.152	0.203	0.304
Stainless Steel Hard	12-20	275-425	0.076	0.100	0.127	0.127
Titanium (Soft)	15-30	-	0.100	0.152	0.254	0.279
Titanium (Hard)	9-20	-	0.050	0.127	0.203	0.254
Refractory Alloys	15-30	-	0.100	0.127	0.177	0.228

Stock Removal

Stock removal depends on work piece material and finish required. This graph shows starting points for various diameters.

