

DRILL SPEED GUIDE

HIGH SPEED STEEL



HSS Drill RPM

(mm)	(inch)	Stainless Steel	Mild Steel	Cast Iron	Aluminium
1.5	1/16	3000	6000	6000	18000
3	1/8	1500	3000	3000	9000
5	3/16	1000	2000	2200	6000
6	1/4	800	1500	1600	4500
8	5/16	600	1300	1300	3500
10	3/8	500	1000	1100	3000
11	7/16	450	900	900	2500
13	1/2	400	800	850	2250
14	9/16	350	700	750	2000
16	5/8	300	650	670	1800
17	11/16	270	600	620	1600
19	3/4	250	550	560	1500
21	13/16	230	500	500	1400
22	7/8	210	470	470	1300
25	1	190	420	440	1100
28	1 1/8	170	370	380	1000
32	1 1/4	150	340	340	900
35	1 3/8	140	300	300	800
38	1 1/2	130	280	275	750
41	1 5/8	120	260	250	700
44	1 3/4	110	240	235	650
47	1 7/8	100	220	220	600
50	2	90	210	190	570

The information in this table is intended as a guide only. Figures will vary with the grades of material and style of drill bit. It is best to start with a moderate speed, making adjustments as you observe the cutting action and condition of the drill bit.