

Drilling Speed Table	
Material	Cutting Speed/ SFPM
<i>Low-Carbon Steel</i>	60 – 100
<i>Aluminum Alloys</i>	100 – 300
<i>Cast Iron</i>	60 – 200
<i>Alloy Steel</i>	40 – 90
<i>Brass and Bronze</i>	50 - 200
Drilling Feed Table	
Drill Size Dia.	IPR
<b>Under (1/8)</b>	0.001 to 0.002
<b>(1/8) to (1/4)</b>	0.002 to 0.004
<b>(1/4) to (1/2)</b>	0.004 to 0.007
<b>(1/2) to 1"</b>	0.007 to 0.015
<b>Over 1"</b>	0.015