

# Drill Speed Recommendation Chart (Cont'd.)

For Various Materials Using High-Speed Steel (HSS) Drills\*

DRILL SIZES – INCHES (mm)									
3/16 (5)		1/4 (6)		5/16 (8)		3/8 (10)		1/2 (13)	
0.188		0.250		0.313		0.375		0.500	
MIN. RPM	MAX. RPM	MIN. RPM	MAX. RPM	MIN. RPM	MAX. RPM	MIN. RPM	MAX. RPM	MIN. RPM	MAX. RPM
304	507	229	381	183	305	152	254	114	190
304	507	229	381	183	305	152	254	114	190
304	507	229	381	183	305	152	254	114	190
406	609	305	458	244	366	203	305	152	229
609	812	458	611	366	488	305	407	229	305
609	812	458	611	366	488	305	407	229	305
812	1,015	611	763	488	610	407	509	305	381
812	1,015	611	763	488	610	407	509	305	381
1,015	1,219	763	916	610	732	509	611	381	458
1,422	1,625	1,069	1,222	854	976	713	814	534	611
1,422	2,031	1,069	1,527	854	1,220	713	1,018	534	763
609	2,031	458	1,527	366	1,220	305	1,018	229	763
1,625	1,828	1,222	1,375	976	1,098	814	916	611	687
1,625	2,234	1,222	1,680	976	1,342	814	1,120	611	840
2,031	3,047	1,527	2,291	1,220	1,830	1,018	1,527	763	1,145
2,031	3,047	1,527	2,291	1,220	1,830	1,018	1,527	763	1,145
2,031	3,047	1,527	2,291	1,220	1,830	1,018	1,527	763	1,145
4,063	6,095	3,055	4,583	2,440	3,661	2,037	3,055	1,527	2,291
4,063	6,095	3,055	4,583	2,440	3,661	2,037	3,055	1,527	2,291
5,079	8,127	3,819	6,111	3,050	4,881	2,546	4,074	1,909	3,055
6,095	8,127	4,583	6,111	3,661	4,881	3,055	4,074	2,291	3,055
6,095	8,127	4,583	6,111	3,661	4,881	3,055	4,074	2,291	3,055
RPM RANGES									
2,401	3,001	3,601	4,201	5,001	6,001	7,001	8,001	9,001	10,001
3,000	3,600	4,200	5,000	6,000	7,000	8,000	9,000	10,000	25,000

DRILLS & SPECIALTY TOOLS

\*Chart is based on High-Speed Steel (HSS) drills and drill bits. For other drill materials and coatings, follow drill bit manufacturer's recommendations.