

HSSCo8 NC SPOTTING DRILLS SPEED CHART

Work Material	Carbon Steels		Alloy Steels		Alloy Steels, Tool Steels, Hardened Steels		Carbon Steels		Carbon Steels	
	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR
1/8 5/32	2460	0.002	2110	0.002	1080	0.002	940	0.002	7040	0.005
11/64 3/16	1850	0.002	1580	0.002	800	0.002	700	0.002	5280	0.006
13/64 15/64	1510	0.003	1300	0.003	670	0.003	580	0.003	4400	0.006
1/4 5/16	1170	0.003	1030	0.003	540	0.003	460	0.003	3520	0.007
21/64 25/64	880	0.004	790	0.004	400	0.004	350	0.004	2640	0.008
13/32 15/32	700	0.004	630	0.004	320	0.004	290	0.004	2110	0.009
31/64 5/8	590	0.005	530	0.005	260	0.005	240	0.005	1760	0.011
41/64 47/64	460	0.007	400	0.007	200	0.007	180	0.007	1320	0.012
3/4 1	350	0.009	320	0.009	150	0.009	140	0.009	1060	0.017