

## 275 Series Recommended Cutting Data - Inch

Workpiece Material Group	ISO	Vc - SFM Low - High	Tool Diameter (Inch)					
			.039 - .062	.063 - .124	.125 - .188	.189 - .281	.282 - .375	.376 - .472
			Feed (in/rev)					
Low Carbon Steels	P	100 - 140	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Medium Carbon Steels		80 - 120	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Alloy Steels		70 - 110	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Die / Tool Steels		50 - 90	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Free Machining Stainless Steels	M	60 - 100	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Austenitic Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Difficult Stainless Steels		20 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
PH Stainless Steels		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
High Temp Alloys	S	20 - 50	.0005 - .003	.004 - .008	.006 - .012	.008 - .012	.008 - .016	.010 - .018
Titanium Alloys		30 - 60	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024
Gray Cast Irons	K	80 - 120	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Ductile Cast Irons		70 - 110	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Malleable Cast Irons		60 - 100	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminum - ≤ 10% Si	N	250 - 350	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Aluminium - > 10% Si		200 - 300	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Copper / Brass		180 - 250	.005 - .012	.010 - .018	.014 - .026	.016 - .031	.020 - .035	.024 - .041
Hardened Steels 45-50 HRC	H	40 - 70	.003 - .008	.008 - .013	.008 - .016	.011 - .021	.016 - .028	.016 - .031
Hardened Steels 50-55 HRC		30 - 50	.001 - .005	.006 - .012	.008 - .012	.008 - .016	.012 - .020	.012 - .024

Stock Allowance for NC Machine Reamers - Inch	
Reamer Diameter (Inch)	Total Allowance
.039 - .062	.003 - .006
.062 - .125	.005 - .009
.125 - .250	.007 - .012
.250 - .472	.010 - .015

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

## 275 Series Recommended Cutting Data - Metric

Workpiece Material Group	I S O	Vc - M/Min Low - High	Drill Diameter (mm)					
			1.0 - 1.5	1.6 - 3.0	3.1 - 5.0	5.1 - 7.0	7.1 - 9.5	9.6 - 12.0
			Feed (mm/rev)					
Low Carbon Steels	P	30 - 45	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Medium Carbon Steels		25 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Alloy Steels		20 - 35	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Die / Tool Steels		15 - 25	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Free Machining Stainless Steels	M	20 - 30	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Austenitic Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Difficult Stainless Steels		5 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
PH Stainless Steels		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
High Temp Alloys	S	5 - 15	.015 - 0.75	.100 - .205	.105 - .305	.205 - .305	.205 - .405	.255 - .455
Titanium Alloys		10 - 20	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610
Gray Cast Irons	K	25 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Ductile Cast Irons		20 - 35	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Malleable Cast Irons		20 - 30	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminum - ≤ 10% Si	N	75 - 105	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Aluminium - > 10% Si		60 - 90	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Copper / Brass		55 - 75	.125 - .305	.255 - .455	.355 - .660	.405 - .785	.510 - .890	.610 - 1.040
Hardened Steels 45-50 HRC	H	10 - 20	.075 - .205	.205 - .330	.205 - .405	.280 - .535	.405 - .710	.405 - .785
Hardened Steels 50-55 HRC		10 - 15	.025 - .125	.150 - .305	.205 - .305	.205 - .405	.305 - .510	.305 - .610

Stock Allowance for NC Machine Reamers - Metric	
Reamer Diameter (mm)	Total Allowance
1.0 - 1.5	.08 - .15
1.5 - 3.0	.13 - .23
3.0 - 6.0	.18 - .30
6.0 - 12.0	.25 - .38

**If you don't see  
the size you need -  
Contact Customer  
Service for  
assistance.**

**Safety Note**  
Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.

**WARNING:** This product can expose you to chemicals including cobalt which is known to the State of California to cause cancer. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.