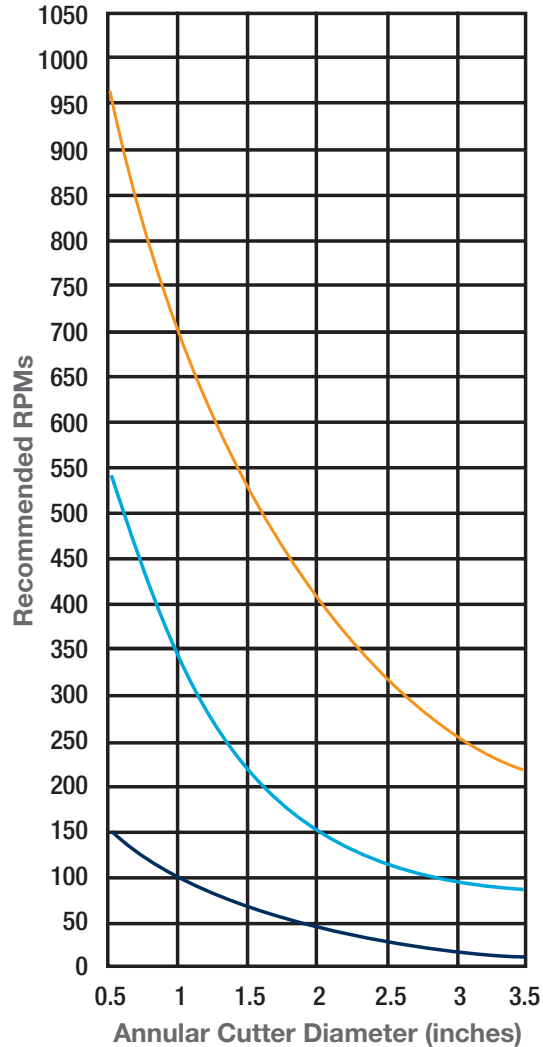


High Speed Steel Annular Cutter Recommended Speed

*Recommended Feed Rate:
.002 - .004 inches per revolution*



Aluminum 200 ft./min. **Mild Steel (Carbon)** 80 ft./min. **Stainless Steel** 30 ft./min.

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Tungsten Carbide-Tipped Cutters Annular Cutter Recommended Speed

| Cutter Size | Stainless Steel & Alloy Steel | Mild Steel | Iron Plate |
|---------------------|-------------------------------|------------|------------|
| Diameter | RPM | RPM | RPM |
| 1/2" - 5/8" | 500 - 800 | 600 - 1000 | 800 - 1200 |
| 11/16" - 13/16" | 400 - 640 | 480 - 800 | 640 - 960 |
| 7/8" - 15/16" | 330 - 530 | 400 - 660 | 530 - 800 |
| 1" - 13/16" | 270 - 420 | 320 - 530 | 420 - 640 |
| 1 1/4" - 1 3/8" | 230 - 370 | 270 - 460 | 360 - 550 |
| 1 7/16" - 1 9/16" | 200 - 320 | 240 - 400 | 320 - 480 |
| 1 5/8" - 1 3/4" | 180 - 280 | 210 - 350 | 280 - 420 |
| 1 13/16" - 2" | 160 - 260 | 190 - 320 | 260 - 380 |
| 2 1/16" - 2 3/16" | 145 - 230 | 170 - 290 | 230 - 350 |
| 2 1/4" - 2 3/8" | 135 - 210 | 160 - 270 | 210 - 320 |
| 2 7/16" - 2 9/16" | 120 - 200 | 150 - 250 | 200 - 300 |
| 2 5/8" - 2 3/4" | 115 - 180 | 140 - 230 | 180 - 270 |
| 2 13/16" - 2 15/16" | 110 - 170 | 130 - 210 | 170 - 260 |
| 3" - 3 1/8" | 100 - 160 | 120 - 200 | 160 - 240 |
| 3 3/16" - 3 3/8" | 95 - 150 | 115 - 190 | 150 - 230 |
| 3 7/16" - 3 9/16" | 90 - 140 | 110 - 180 | 140 - 210 |
| 3 5/8" - 3 3/4" | 85 - 135 | 105 - 170 | 135 - 200 |
| 3 13/16" - 3 15/16" | 80 - 130 | 95 - 160 | 130 - 195 |
| 4" - 4 5/16" | 70 - 120 | 90 - 145 | 120 - 170 |
| 4 3/8" - 4 3/4" | 70 - 110 | 80 - 135 | 110 - 160 |
| 4 13/16" - 5 1/8" | 65 - 100 | 75 - 125 | 100 - 150 |

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