



Countersinks			
Material Guide	SFM		FEED PER TOOTH (FPT)
	HSS	Carbide	
INCONEL ALLOY HASTELLOY WROUGHT	15 - 20	25 - 35	.0010 - .0020
HASTELLOY (CAST)	5 - 7	7 - 15	.0010 - .0020
MAGNESIUM MAGNESIUM ALLOY	125 - 250	250 - 400	.0010 - .0020
HIGH NICKEL STEEL	30 - 50	50 - 75	.0010 - .0020
STAINLESS STEEL (FREE MACHINING)	30 - 80	80 - 125	.0010 - .0020
STAINLESS STEEL (WORK HARDENING)	15 - 50	50 - 75	.0010 - .0020
STEEL - MILD	70 - 100	80 - 170	.0010 - .0020
STEEL - TOOL	50 - 60	60 - 100	.0010 - .0020
STEEL - FORGINGS	40 - 50	50 - 80	.0010 - .0020
STEEL - ALLOYS 300 - 400 BRINELL	20 - 30	30 - 50	.0010 - .0020
STEEL - HIGH TENSILE 35 - 45 HRC	25 - 40	35 - 60	.0010 - .0020
STEEL - HIGH TENSILE 45 - 50 HRC	15 - 25	25 - 40	.0010 - .0020
STEEL - HIGH TENSILE 50 - 55 HRC	7 - 15	15 - 20	.0010 - .0020
IRON - CAST SOFT	75 - 125	125 - 225	.0010 - .0020
IRON - CAST MEDIUM HARD	50 - 100	100 - 175	.0010 - .0020
IRON MALLEABLE	80 - 90	90 - 150	.0010 - .0020
ALUMINUM ALUMINUM ALLOYS	150 - 250	300 - 500	.0010 - .0020
BRASS/BRONZE	75 - 125	150 - 250	.0010 - .0020
PLASTIC BAKELITE	100 - 250	250 - 400	.0010 - .0020