



### Carbide Reamers - SFM & I.P.R (Inch Per Rev)

MATERIAL	SFM	FEED (IPR)	MATERIAL	SFM	FEED (IPR)
INCONEL	20 - 60	.0010 - .0050	TOOL STEEL	30 - 90	.0040 - .0060
RENE	20 - 60	.0020 - .0060	CAST IRON - SOFT	80 - 200	.0060 - .0150
TITANIUM	30 - 90	.0020 - .0080	CAST IRON - MEDIUM	60 - 150	.0060 - .0120
WASPOLOY	20 - 60	.0020 - .0060	CAST IRON - HARD	40 - 90	.0040 - .0100
STAINLESS STEEL - 300 SERIES	20 - 80	.0040 - .0080	ALUMINUM / ALUMINUM ALLOYS	100 - 250	.0050 - .0150
STAINLESS STEEL - 400 SERIES	30 - 120	.0050 - .0100	ALUMINUM - HIGH SILICON	80 - 200	.0030 - .0120
MAGNESIUM	100 - 250	.0050 - .0150	BRASS	100 - 250	.0050 - .0150
MONEL	40 - 120	.0040 - .0120	BRONZE	90 - 175	.0030 - .0120
STEEL - CAST & FORGED	40 - 100	.0030 - .0100	COPPER / COPPER ALLOYS	90 - 220	.0050 - .0150
STEEL - HEAT TREATED (35-40 RC)	40 - 70	.0040 - .0080	EPOXY FIBER	100 - 250	.0050 - .0150
STEEL - HEAT TREATED (40-45 RC)	30 - 50	.0020 - .0060	PLASTIC	100 - 300	.0050 - .0150
STEEL - HEAT TREATED (45+ RC)	15 - 40	.0010 - .0040	RESIN - FIBER GLASS	100 - 300	.0050 - .0150
STEEL - MEDIUM CARBON	50 - 100	.0050 - .0100	MASONITE	60 - 150	.0050 - .0150
MOLD STEEL	40 - 120	.0040 - .0060	PHENOLIC	60 - 100	.0050 - .0150