

$$\text{RPM} = \frac{4 \times \text{CS}}{\text{DIA}}$$

RPM = Revolutions per minute

CS = Cutting speed. See other side of chart

DIA = Drill press - Diameter of drill

DIA = Milling machine
Diameter of cutter

OR

DIA = Lathe - Diameter of workpiece

GOP 1-07

CUTTING SPEED - FPM

Material	High Speed Steel Tool	Carbide Tool
Aluminum	200-600	1000-2000
Brass	100-300	300-700
Bronze	70-90	200-400
Cast iron	70-100	250-350
Copper	60-150	150-500
Steel low carbon	80-150	300-550
Steel high carbon	50-60	150-250
Tool steel	40-60	100-250
Stainless steel	30-80	100-300