

		1/16	3/32	1/8	5/32	3/16	7/32	1/4	9/32	5/16	11/32	3/8	7/16	1/2	9/16	5/8	11/16	3/4	7/8	1
		0.063	0.094	0.125	0.156	0.188	0.219	0.250	0.281	0.313	0.344	0.375	0.438	0.500	0.563	0.625	0.688	0.750	0.875	1.000
		1.58mm	2.38mm	3.17mm	3.96mm	4.76mm	5.55mm	6.35mm	7.13mm	7.95mm	8.73mm	9.52mm	11.12mm	12.7mm	14.3mm	15.8mm	17.47mm	19.05mm	22.22mm	25.4mm
Aluminum	RPM	10,000	8000	6000	5000	4000	3500	3000	2700	2400	2200	2000	1750	1500	1350	1200	1100	1000	875	750
	HP	0.01	0.04	0.07	0.09	0.10	0.15	0.20	0.24	0.28	0.33	0.38	0.53	0.67	0.83	1	1.18	1.37	1.84	2.30
	Feed	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.008	0.009	0.009	0.01	0.012	0.013	0.014	0.015	0.016	0.017	0.018
	Thrust	6	16	25	38	50	65	80	90	100	113	125	163	200	230	260	298	335	389	450
Brass	RPM	10,000	8000	6000	5000	4000	3200	2400	2100	1800	1650	1500	1350	1200	1050	900	825	750	675	600
	HP	0.01	0.03	0.05	0.08	0.10	0.14	0.18	0.23	0.28	0.31	0.35	0.45	0.55	0.68	0.80	1	1.18	1.5	1.80
	Feed	0.001	0.0015	0.002	0.0025	0.003	0.0035	0.004	0.0045	0.005	0.0055	0.006	0.007	0.008	0.009	0.01	0.015	0.012	0.013	0.014
	Thrust	10	17	25	35	45	58	70	85	100	118	135	175	215	255	295	345	395	460	525
Cast Iron	RPM	6000	4500	3000	2500	2000	1725	1450	1300	1150	1063	975	850	725	663	600	550	500	438	375
	HP	0.01	0.03	0.04	0.08	0.11	0.15	0.18	0.23	0.28	0.33	0.38	0.48	0.57	0.69	0.80	0.95	1.1	1.43	1.75
	Feed	0.001	0.0015	0.002	0.003	0.004	0.0045	0.005	0.0055	0.006	0.0065	0.007	0.0075	0.008	0.0085	0.009	0.0095	0.010	0.011	0.012
	Thrust	15	28	40	70	100	125	150	175	200	230	260	305	350	415	480	515	550	675	800
Low Carbon Steel	RPM	4300	3225	2150	1800	1450	1275	1100	1000	900	813	750	650	550	500	450	405	360	318	275
	HP	0.01	0.03	0.05	0.08	0.12	0.16	0.20	0.25	0.30	0.33	0.35	0.52	0.68	0.87	1.05	1.28	1.50	1.8	2.10
	Feed	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.0075	0.008	0.0085	0.009	0.011	0.012	0.013	0.014	0.015	0.016	0.017	0.018
	Thrust	30	55	80	113	145	188	230	285	340	390	440	570	700	875	1050	1175	1300	1650	2000
Stainless Steel	RPM	3200	2375	1550	1288	1025	900	775	698	620	565	510	455	400	355	310	305	260	215	170
	HP	0.01	0.03	0.05	0.09	0.12	0.17	0.21	0.3	0.40	0.44	0.48	0.67	0.85	1.15	1.45	2.58	2.05	2.58	3.1
	Feed	0.001	0.0015	0.002	0.0025	0.003	0.0035	0.004	0.0045	0.005	0.005	0.005	0.006	0.007	0.008	0.009	0.0095	0.010	0.0105	0.011
	Thrust	40	70	100	140	180	235	290	358	425	445	465	623	780	940	1100	1300	1500	1700	1900
Plastic / Wood	RPM	7000	5500	4000	3350	2700	2350	2000	1800	1600	1500	1400	1200	1000	900	800	750	700	625	550
	HP	0.01	0.04	0.07	0.09	0.10	0.11	0.12	0.13	0.14	0.15	0.16	0.18	0.20	0.25	0.30	0.38	0.45	0.58	0.70
	Feed	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.02	0.02
	Thrust	10	15	20	30	40	50	60	65	70	80	90	118	145	160	175	188	200	265	330
Fiberglass	RPM	18000	12000	9000	7346	6095	5232	4584	4078	3661	3331	3056	2616	2292	2035	1833	1665	1528	1309	1146
	HP																			
	Feed																			
	Thrust																			

Inconel = 1/4 of Stainless Steel RPM | Bronze Add 1/3 HP of Brass Numbers | Copper Use Brass Numbers