

PRODUCT BULLETIN

ANNULAR CUTTER

SPEED CHART

9-Series Carbide Tipped Annular Cutters

Materials have an optimum range for machinability depending on the diameter of hole. See below for the recommended RPM rates when cutting different materials with 9-series carbide-tipped annular cutters from CS Unitec. The chart is intended as only a starting point. Adjustments may be required depending upon application.



Standard Fractional (inches)		Metric (mm)		Stainless Steel & Alloy Steel	Mild Steel	Iron Plate	Copper Plate & Brass Plate	Plastic & FRP
From	To	From	To	RPM				
9/16"	5/8"	14	16	500-800	600-1000	800-1200	1000-1400	1200-1600
11/16"	13/16"	17	20	400-640	480-800	640-960	800-1110	960-1280
13/16"	15/16"	21	24	330-530	400-660	530-800	660-930	800-1060
1"	1-3/16"	25	30	270-420	320-530	420-640	530-740	640-850
1-1/4"	1-3/8"	31	35	230-370	270-460	360-550	460-640	550-730
1-7/16"	1-9/16"	36	40	200-320	240-400	320-480	400-560	480-640
1-5/8"	1-3/4"	41	45	180-280	210-350	280-420	350-500	420-570
1-13/16"	2"	46	50	160-260	190-320	260-380	320-450	380-510
2"	2-3/16"	51	55	145-230	170-290	230-350	290-410	350-460
2-3/16"	2-3/8"	56	60	135-210	160-270	210-320	270-370	320-420
2-3/8"	2-9/16"	61	65	120-200	150-250	200-300	250-340	300-390
2-5/8"	2-3/4"	66	70	115-180	140-230	180-270	230-320	270-360
2-13/16"	2-15/16"	71	75	110-170	130-210	170-260	210-300	260-340
3"	3-1/8"	76	80	100-160	120-200	160-240	200-280	240-320
3-1/4"	3-3/8"	81	85	95-150	115-190	150-230	190-260	230-300
3-3/8"	3-9/16"	86	90	90-140	110-180	140-210	180-250	210-280
3-9/16"	3-3/4"	91	95	85-135	105-170	135-200	170-240	200-270
3-3/4"	3-15/16"	96	100	80-130	95-160	130-195	160-220	190-260
4"	4-5/16"	101	110	70-120	90-145	120-170	150-200	170-230
4-3/8"	4-3/4"	111	120	70-110	80-135	110-160	130-190	160-210
4-3/4"	5-1/8"	121	130	65-100	75-125	100-150	120-170	150-200