

# REAMERS: RECOMMENDATIONS OF USING



Material to Machine	Speed SFM		Feed inches/rev.							
	Carbide	Cobalt	Diameter in mm							
			2	6	10	15	20	25	30	40
Steels < 81 Rc (B)	82-132	49-72	.0059	.0059	.0098	.0098	.0118	.0138	.0146	.0177
Steels < 24 Rc (C)	66-82	39-56	.0039	.0047	.0071	.0071	.0098	.0118	.0139	.0157
Steels 24-32 Rc	39-59	23-33	.0031	.0039	.0071	.0059	.0087	.0098	.0118	.0138
Steels 32-41 Rc	33-49	16-23	.0031	.0035	.0059	.0079	.0098	.0106	.0118	.0138
Stainless Steel	23-39	10-16	.0028	.0039	.0047	.0059	.0079	.0098	.0098	.0118
Inconel/Waspaloy	20-33	7-10	.0028	.0039	.0047	.0059	.0079	.0098	.0098	.0118
Cast Iron ≤180 HB (Grey)	99-132	20-49	.0039	.0047	.0079	.0079	.0098	.0118	.0118	.0118
Cast Iron > 180 HB	26-49	13-16	.0028	.0039	.0059	.0071	.0079	.0079	.0098	.0098
Copper	82-99	39-66	.0047	.0071	.0079	.0098	.0118	.0118	.0138	.0157
Brass	115-132	66-99	.0079	.0087	.0118	.0138	.0157	.0157	.0177	.0197
Bronze	66-82	39-56	.0059	.0071	.0087	.0138	.0146	.0146	.0177	.0197
Aluminum	132-197	82-115	.0059	.0071	.0098	.0118	.0138	.0138	.0157	.0177