

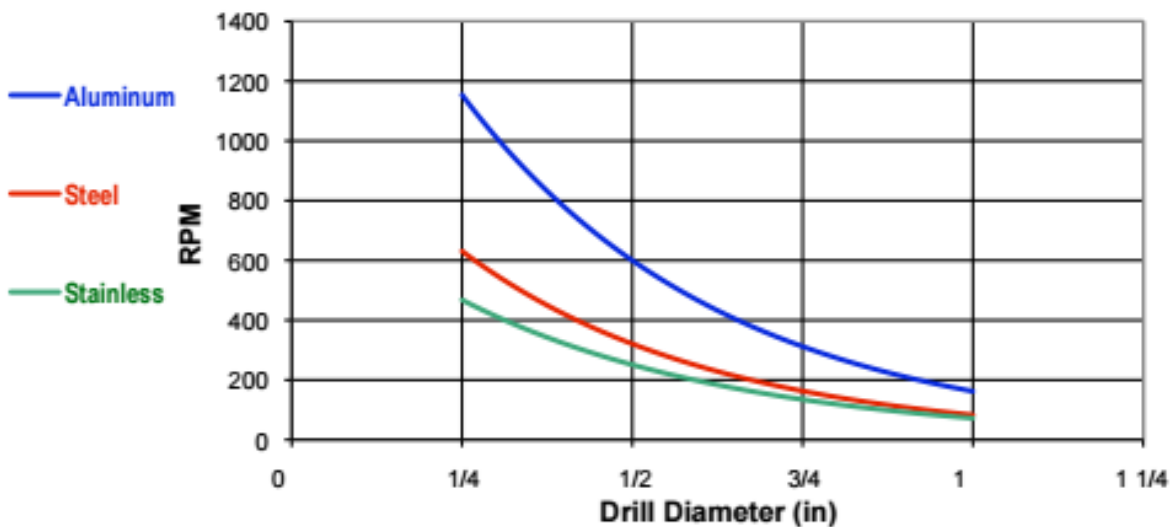
Citrus Circuits Machine Shop Reference Information

Recommended RPM for Drilling Operations

Drill Diameter
(inches):



	Aluminum	Steel	Stainless
1/4	1200	750	500
3/8	900	500	375
1/2	600	250	250
5/8	360	200	150
3/4	300	150	120
1	180	100	85



All holes 1/2" or greater should be drilled in 1/8" increments, starting with 3/8"



Run center drill at speed according to the largest diameter of the center drill



Countersink bits are run at 300 RPM max



Counterbore bits are run at 200 RPM max

Reamer bits are run at ~100 RPM