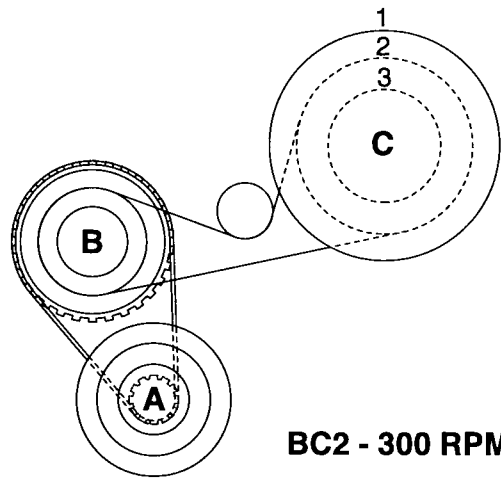
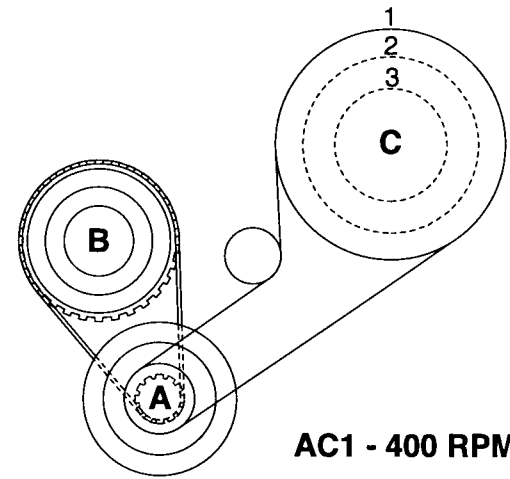


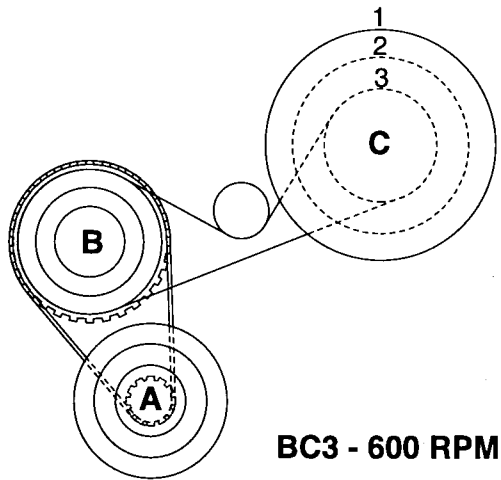
BC1 - 130 RPM



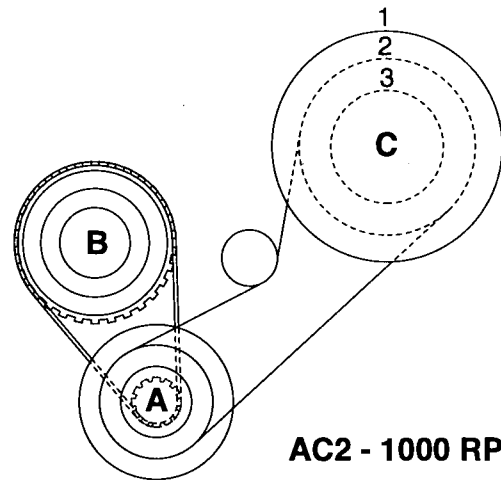
BC2 - 300 RPM



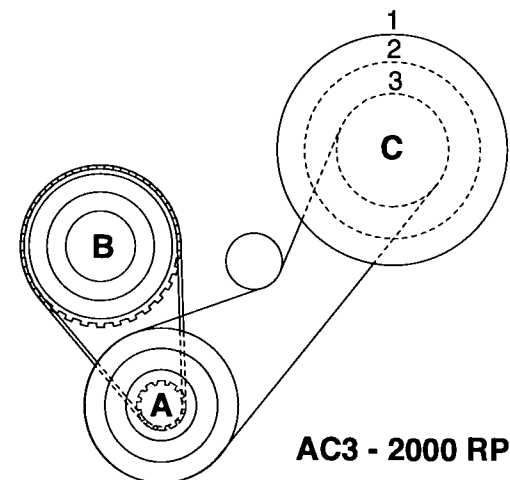
AC1 - 400 RPM



BC3 - 600 RPM



AC2 - 1000 RPM



AC3 - 2000 RPM

Calculating R.P.M.'s

Part Diameter S.F.P.M. →	Cast Iron, Brass, Stainless			Steel			Aluminum		
	40	50	60	70	80	90	100	110	120
0.016"	9779	12224	14669	17114	19558	22003	24448	26893	29338
0.031"	4890	6112	7334	8557	9779	11002	12224	13446	14669
0.062"	2445	3056	3667	4278	4889	5500	6112	6723	7333
0.125"	1222	1528	1833	2139	2445	2750	3056	3361	3667
0.187"	815	1019	1222	1426	1630	1833	2037	2241	2445
0.250"	611	764	917	1070	1222	1375	1528	1681	1833
0.312"	489	611	733	856	978	1100	1222	1345	1467
0.375"	407	509	611	713	815	917	1019	1120	1222
0.437"	349	437	524	611	698	786	876	960	1048
0.500"	306	382	458	535	611	688	764	840	917
0.625"	244	306	367	428	489	550	611	672	733
0.75"	204	255	306	357	407	458	509	560	611
0.875"	175	218	262	306	349	393	473	480	524
1.0"	153	191	229	267	306	344	382	420	458
1.125"	136	170	204	238	272	306	340	373	407
1.25"	122	153	183	214	244	275	306	336	367
1.375"	111	139	167	194	222	250	278	306	333
1.5"	102	127	153	178	204	229	255	280	306
1.625"	91	118	141	165	188	212	235	259	282
1.75"	87	109	131	153	175	196	218	246	262
1.875"	82	102	122	143	163	183	204	224	244
2.0"	76	96	115	134	153	172	191	210	229
2.25"	68	85	102	119	136	153	170	187	204
2.5"	61	76	92	107	122	138	153	168	183
2.75"	56	70	83	97	111	125	139	153	167
3.0"	51	64	76	89	102	115	127	140	153
3.25"	47	55	71	82	94	106	118	129	141
3.5"	44	59	66	76	87	98	109	126	131
3.75"	41	51	61	71	81	92	102	112	122
4.0"	38	48	57	67	76	86	96	105	115
4.5"	34	42	51	59	68	76	85	93	102
5.0"	31	38	46	54	61	69	76	84	92
5.5"	28	35	41	49	56	63	70	76	83
6.0"	26	32	38	45	51	57	64	70	76
6.5"	24	29	35	42	47	53	59	65	71
7.0"	22	27	33	38	44	49	55	60	66
7.5"	20	26	31	36	41	46	51	56	61
8.0"	19	24	29	33	38	43	48	53	57

Example: 1" diameter steel using 80 surface feet per minute should be run at 306 r.p.m. To calculate r.p.m.s for diameters not listed here; multiply the surface feet per minute by the diameter of the stock and divide by 4.