

Bimetal (AV & TA Style)

RPMs • REVOLUCIONES POR MINUTO • TOURS PER MINUTE

Size Inches	Size mm	Mild Steel	Tool / Stainless Steels	Cast Iron	Brass	Aluminum	Size Inches	Size mm	Mild Steel	Tool / Stainless Steels	Cast Iron	Brass	Aluminum
Tamaño Pulgadas	Tamaño mm	Acero Suave	Herramienta / Aceros Inoxidables	Hierro Fundido	Latón	Aluminio	Tamaño Pulgadas	Tamaño mm	Acero Suave	Herramienta / Aceros Inoxidables	Hierro Fundido	Latón	Aluminio
Taille Pouces	Taille mm	Acier Doux	Outil / Acier Inoxydable	Fonte	Laiton	Aluminium	Taille Pouces	Taille mm	Acier Doux	Outil / Acier Inoxydable	Fonte	Laiton	Aluminium
9/16	14	550	300	400	790	900	2 1/8	54	160	80	105	210	240
5/8	16	530	275	365	730	825	2 1/4	57	150	75	100	200	230
1 1/16	17	500	250	330	665	750	2 9/16	59	145	75	100	195	225
3/4	19	460	230	300	600	690	2 3/8	60	140	70	95	190	220
13/16	21	425	210	280	560	630	2 1/2	64	135	70	90	180	205
7/8	22	390	195	260	520	585	2 5/16	65	130	65	85	175	200
15/16	24	370	185	245	495	555	2 3/4	67	130	65	85	170	195
1	25	350	175	235	470	525	2 3/4	70	125	60	80	160	185
1 1/16	27	325	160	215	435	480	2 7/8	73	120	60	80	160	180
1 1/8	29	300	150	200	400	450	3	76	115	55	75	150	170
1 3/16	30	285	145	190	380	425	3 1/8	79	110	55	70	145	165
1 1/4	32	275	140	180	360	410	3 1/4	83	105	50	70	140	155
1 3/8	35	250	125	165	330	375	3 3/8	86	100	50	65	130	150
1 1/2	38	230	115	150	300	345	3 1/2	89	95	45	60	125	145
1 3/4	32	275	140	180	360	410	3 5/8	92	95	45	60	120	140
1 5/16	33	260	135	175	345	390	3 3/4	95	90	45	60	120	135
1 3/8	35	250	125	165	330	375	3 7/8	98	90	45	60	115	130
1 7/16	37	240	120	160	315	360	4	102	85	40	55	115	125
1 1/2	38	230	115	150	300	345	4 1/8	105	85	40	55	110	120
1 9/16	40	220	110	145	290	330	4 1/4	108	80	40	55	110	115
1 5/8	41	210	105	140	280	315	4 3/8	111	80	40	50	100	110
1 11/16	43	205	100	135	270	305	4 1/2	114	75	35	50	100	105
1 3/4	44	195	95	130	260	295	4 3/4	121	70	35	45	90	95
1 13/16	46	190	95	125	250	285	5	127	65	30	40	85	90
1 7/8	48	180	90	120	240	270	5 1/2	140	60	30	35	80	85
2	51	170	85	115	230	255	5 3/4	146	55	25	35	75	80
2 1/16	52	165	80	110	220	245	6	152	55	25	35	75	80

Carbide Tipped (AT Style)

Size Inches	Size mm	Ceramic Tile RPM	Plastic RPM	Formica RPM	Aluminum RPM	Fiber-glass RPM	Computer Flooring RPM	Cast Iron RPM	Particle Board RPM
3/4	19	495	3425	205	1695	245	445	405	3425
7/8	22	425	2935	175	1495	205	465	345	2935
1	25	365	2565	145	1295	185	405	305	2565
1 1/8	29	325	2285	135	1095	165	365	265	2285
1 3/8	35	265	1865	105	895	135	295	215	1865
1 1/2	38	245	1705	95	895	115	265	205	1705
1 3/4	44	205	1465	85	695	105	235	175	1465
2 1/8	54	175	1285	75	595	85	205	145	1285
2 1/4	57	165	1135	65	595	75	175	135	1135
2 1/2	64	145	1025	55	495	65	155	115	1025
2 3/4	70	130	935	50	445	60	145	105	940
3	76	115	855	45	395	55	135	95	855
3 1/4	83	105	785	45	395	55	125	85	785
3 1/2	89	100	705	35	395	45	105	85	705
3 3/4	95	95	685	35	295	45	105	75	685
4	102	90	630	35	295	45	95	65	615
4 1/4	108	85	580	35	295	45	95	60	570
4 1/2	114	85	550	25	295	35	85	55	535
5	127	75	475	25	195	35	85	55	495
5 1/2	140	65	415	25	195	35	75	45	455
6	152	55	355	25	95	25	55	35	415

Carbide Grit (ATCG Style)

MATERIAL TO BE CUT	RPM	COOLANT	DUST PROTECTION
Hardened Tool Steel (Rc 42-65)	SLOW	yes	
Nitride Case & Induction Hardened Steel	SLOW	yes	
High Temp Nickel & Iron Base Superalloys	SLOW	yes	
Hastelloy	SLOW	yes	
Aircraft and Sheet Stainless	SLOW	yes	
Beryllium	SLOW	yes	
Sintered Tungsten, Molybdenum, Iron, Stainless	SLOW	optional	
White & High Alloy Cast Iron	SLOW	yes	
Grey Cast Iron	SLOW	no	
Titanium	SLOW	yes	
Foamed Glass	FAST	no	yes
Syntactic Foam	MED	no	yes
Low Density Ceramics	MED	optional	yes
Green Unfired Ceramics	MED	no	yes
Fiber Reinforced Cement	MED	no	yes
Fiberglass Honeycomb	FAST	no	yes
Polyesters, Epoxies, Melamines, Phenolics	FAST	no	yes
Graphite Composites	FAST	no	yes
Carbon & Graphite	FAST	no	yes
Glass	MED	yes	
Wire Reinforced Rubber	FAST	yes	
Compressed Perlite Fiber Board	MED	no	yes
Cement Lined Steel & Cast Iron Pipe	SLOW	optional	
Soapstone, Mica, Slate, Lava, Coal	SLOW	no	yes