



# ACE

technical reference

## Table of Cutting Speeds

Feet Per Minute	40'	50'	60'	70'	80'	90'	100'
Diam. In Inches							
1/64	9778	12223	14668	17112	19557	22001	24446
1/32	4889	6112	7334	8556	9778	11001	12223
3/64	3259	4074	4889	5704	6519	7334	8149
1/16	2445	3056	3667	4278	4889	5500	6112
5/64	1956	2445	2934	3422	3911	4400	4889
3/32	1630	2037	2445	2852	3259	3667	4074
7/64	1397	1746	2095	2445	2794	3143	3492
1/8	1222	1528	1833	2139	2445	2750	3056
9/64	1086	1358	1630	1901	2173	2445	2716
5/32	978	1222	1467	1711	1956	2200	2445
11/64	889	1111	1333	1556	1778	2000	2222
3/16	815	1019	1222	1426	1630	1833	2037
13/64	752	940	1128	1316	1504	1692	1880
7/32	698	873	1048	1222	1397	1572	1746
15/64	652	815	978	1141	1304	1467	1630
1/4	611	764	917	1070	1222	1375	1528
9/32	543	679	815	951	1086	1222	1358
5/16	489	611	733	856	978	1100	1222
11/32	444	556	667	778	889	1000	1111
3/8	407	509	611	713	815	917	1019
13/32	376	470	564	658	752	846	940
7/16	349	437	524	611	698	786	873
15/32	326	407	489	570	652	733	815
1/2	306	382	458	535	611	688	764
9/16	272	340	407	475	543	611	679
5/8	244	306	367	428	489	550	611
11/16	222	278	333	389	444	500	556
3/4	204	255	306	357	407	458	509
13/16	188	235	282	329	376	423	470
7/8	175	218	262	306	349	393	437
15/16	163	204	244	285	326	367	407
1	153	191	229	267	306	344	382
1-1/8	136	170	204	238	272	306	340
1-1/4	122	153	183	214	244	275	306
1-3/8	111	139	167	194	222	250	278
1-1/2	102	127	153	178	204	229	255
1-5/8	94	118	141	165	188	212	235
1-3/4	87	109	131	153	175	196	218
1-7/8	81	102	122	143	163	183	204
2	76	95	115	134	153	172	191
2-1/4	68	85	102	119	136	153	170
2-1/2	61	76	92	107	122	138	153
2-3/4	56	69	83	97	111	125	139
3	51	64	76	89	102	115	127
3-1/2	44	55	65	76	87	98	109

For speeds higher than tabulated, multiply all values by 10 or 100.  
 For speeds lower than tabulated, divide all values by 10.