



Recommended cutting speed for M2Al HSS Countersinks (82°)

Diameter		Aluminum	Copper	Mild Steel	Stainless Steel	Non-Metallic
mm	Inch					
6.4	1/4"	1505	1404	752	602	1755
7.9	5/16"	1203	1123	602	481	1404
9.5	3/8"	1004	937	502	401	1171
11.1	7/16"	861	803	430	344	1004
12.7	1/2"	752	702	376	301	878
14.3	9/16"	669	624	335	268	781
15.9	5/8"	602	562	301	241	702
17.5	11/16"	547	511	274	219	638
19.1	3/4"	502	468	251	201	585
20.6	13/16"	463	432	231	185	540
22.2	7/8"	430	401	215	172	502
23.8	15/16"	401	375	201	161	468
25.4	1"	376	351	188	150	439
27.0	1-1/16"	354	331	177	142	413
28.6	1-1/8"	334	312	167	134	390
30.2	1-3/16"	317	296	158	127	370
31.8	1-1/4"	301	281	150	120	351
33.3	1-5/16"	287	267	143	115	334
34.9	1-3/8"	274	255	137	109	319
36.5	1-7/16"	262	244	131	105	305
38.1	1-1/2"	251	234	125	100	293
39.7	1-9/16"	241	225	120	96	281
41.3	1-5/8"	231	216	116	93	270
42.9	1-11/16"	223	208	111	89	260
44.5	1-3/4"	215	201	107	86	251
46.0	1-13/16"	208	194	104	83	242
47.6	1-7/8"	201	187	100	80	234
49.2	1-15/16"	194	181	97	78	227
50.8	2"	188	176	94	75	219