



Recommended cutting speed for Walter SST™ and SST+™  
HSS+Co Twist Drill Bits

SFM*		100	70	40	200
mm	Inch	Mild Steel 500N/mm <sup>2</sup>	Steel 900N/mm <sup>2</sup>	Stainless Steel	Aluminum
1.6	1/16"	6112	4278	2445	12224
3.2	1/8"	3056	2139	1222	6112
4.8	3/16"	2037	1426	815	4075
6.4	1/4"	1528	1070	611	3056
7.9	5/16"	1222	856	489	2445
9.5	3/8"	1019	713	407	2037
11.1	7/16"	873	611	349	1746
12.7	1/2"	764	535	306	1528
14.3	9/16"	679	475	272	1358
15.9	5/8"	611	428	244	1222
17.5	11/16"	556	389	222	1111
19.1	3/4"	509	357	204	1019
20.6	13/16"	470	329	188	940
22.2	7/8"	437	306	175	873
23.8	15/16"	407	285	163	815
25.4	1"	382	267	153	764
27.0	1-1/16"	360	252	144	719
28.6	1-1/8"	340	238	136	679
30.2	1-3/16"	322	225	129	643
31.8	1-1/4"	306	214	122	611
33.3	1-5/16"	291	204	116	582
34.9	1-3/8"	278	194	111	556
36.5	1-7/16"	266	186	106	531
38.1	1-1/2"	255	178	102	509

\*SFM = Surface Feet per Minute

$$\text{Optimal RPM} = \frac{\text{SFM} \times 3.82}{\text{Diameter (in.)}}$$