



Recommended cutting speed for M2Al HSS
MULTI-STEP™ Drill Bits

Diameter		Aluminum	Copper	Mild Steel	Stainless Steel	Non-Metallic
mm	Inch					
3.2	1/8"	4012	3511	2006	1505	4514
4.8	3/16"	2676	2342	1338	1004	3011
6.4	1/4"	2006	1755	1003	752	2257
7.9	5/16"	1604	1404	802	602	1805
9.5	3/8"	1338	1171	669	502	1505
11.1	7/16"	1147	1003	573	430	1290
12.7	1/2"	1003	878	502	376	1128
14.3	9/16"	892	781	446	335	1004
15.9	5/8"	802	702	401	301	902
17.5	11/16"	730	638	365	274	821
19.1	3/4"	669	585	334	251	752
20.6	13/16"	617	540	309	231	694
22.2	7/8"	573	502	287	215	645
23.8	15/16"	535	468	268	201	602
25.4	1"	502	439	251	188	564
27.0	1-1/16"	472	413	236	177	531
28.6	1-1/8"	446	390	223	167	502
30.2	1-3/16"	422	370	211	158	475
31.8	1-1/4"	401	351	201	150	451
33.3	1-5/16"	382	334	191	143	430
34.9	1-3/8"	365	319	182	137	410

*Choose RPM based on LARGEST step diameter.