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Tube Removal Tools

Recommended Cutting Speeds RPM for Tube Cutters, Tube Facers, Grooving Tools and Tube End Prep Tools

Tube OD	Inconel 10 SFM	Hastalloy 20 SFM	300 Series Stainless 30 SFM	Monel 40 SFM	400 Series Stainless 50 SFM	Titanium 60 SFM	Carbon Steels 80 SFM	Copper 90 SFM	Copper- Nickel 100 SFM	Red Brass 200 SFM	Admiralty Brass 225 SFM	Aluminum 250 SFM
1/4"	153	306	458	611	764	917	1222	1376	1528	3056	3438	3818
5/16"	122	244	367	489	611	733	978	1100	1222	2445	2750	3055
3/8"	102	204	306	408	509	611	815	916	1018	2037	2292	2545
7/16"	87	175	262	349	437	524	699	786	874	1746	1964	2182
1/2"	76	153	229	306	382	459	611	688	764	1528	1719	1909
9/16"	68	137	204	272	340	407	543	611	679	1358	1528	1697
5/8"	61	122	184	245	306	367	489	552	612	1222	1375	1527
11/16"	55	112	167	222	278	333	444	500	555	1111	1250	1388
3/4"	51	102	153	203	254	306	408	458	508	1019	1146	1273
13/16"	47	95	142	190	237	284	379	427	474	940	1058	1175
7/8"	44	87	131	175	219	262	349	392	438	873	982	1091
1"	38	76	115	153	191	229	306	344	382	764	859	955
1-1/8"	34	68	102	136	170	204	272	306	340	679	764	848
1-1/4"	31	61	92	123	153	183	245	274	306	611	688	764
1-3/8"	28	56	83	111	139	167	222	250	278	556	625	694
1-1/2"	25	51	76	102	127	153	204	230	254	509	573	636
1-3/4"	22	44	66	88	109	131	175	196	218	437	491	545
2"	19	38	57	76	96	115	153	172	191	382	430	477
2-1/2"	15	31	46	61	76	92	122	137	153	305	344	382
3"	13	25	38	51	64	76	102	115	127	255	286	318
4"	10	19	29	38	48	57	76	86	95	191	215	239

Revolutions Per Minute

A slower rpm is recommended when an optimum rpm is needed to maximize cutter blade life.