



Material Group	vc (m/min)	fn (mm/rev)					
		ø4.3 -6.3	ø7.0 -10.0	ø10.4 -15.0	ø16.5 -23.0	ø25.0 -31.0	
<b>P</b>	11	28 (25-30)	0.08 (0.06-0.10)	0.10 (0.08-0.12)	0.15 (0.13-0.17)	0.18 (0.16-0.20)	0.23 (0.22-0.25)
	12						
	13	18 (15-20)	0.06 (0.04-0.08)	0.08 (0.06-0.10)	0.12 (0.10-0.14)	0.15 (0.13-0.17)	0.18 (0.16-0.20)
	14						
<b>H</b>	15	8 (5-10)	0.05 (0.04-0.06)	0.06 (0.04-0.08)	0.10 (0.08-0.12)	0.12 (0.10-0.14)	0.14 (0.12-0.16)
	16						
<b>M</b>	21	7 (6-8)	0.05 (0.04-0.06)	0.06 (0.04-0.08)	0.10 (0.08-0.12)	0.12 (0.10-0.14)	0.14 (0.12-0.16)
	22						
	23						
<b>K</b>	31	20 (15-25)	0.08 (0.06-0.10)	0.10 (0.08-0.12)	0.15 (0.13-0.17)	0.18 (0.16-0.20)	0.23 (0.22-0.25)
	32						
	33	10 (8-12)	0.06 (0.04-0.08)	0.08 (0.06-0.10)	0.12 (0.10-0.14)	0.15 (0.13-0.17)	0.18 (0.16-0.20)
	34						
<b>S</b>	41	11 (10-12)	0.08 (0.06-0.10)	0.10 (0.08-0.12)	0.15 (0.13-0.17)	0.18 (0.16-0.20)	0.23 (0.22-0.25)
	42						
	51	10 (8-12)	0.06 (0.04-0.08)	0.08 (0.06-0.10)	0.12 (0.10-0.14)	0.15 (0.13-0.17)	0.18 (0.16-0.20)
	52						
<b>N</b>	61	23 (20-25)	0.05 (0.04-0.06)	0.06 (0.04-0.08)	0.10 (0.08-0.12)	0.12 (0.10-0.14)	0.14 (0.12-0.16)
	62						
	63						
	71	28 (25-30)	0.10 (0.08-0.12)	0.12 (0.10-0.14)	0.16 (0.14-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)
	72						
	73	20 (18-22)	0.08 (0.06-0.10)	0.10 (0.08-0.12)	0.15 (0.13-0.17)	0.18 (0.16-0.20)	0.23 (0.22-0.25)
<b>O</b>	81	25 (20-30)	0.05 (0.04-0.06)	0.06 (0.04-0.08)	0.10 (0.08-0.12)	0.12 (0.10-0.14)	0.14 (0.12-0.16)
	82						

vc - cutting speed (m/min)

n - RPM (rev/min)

fn - feed rate (mm/rev)

ø - drill diameter (mm)

$$\text{To calculate RPM from cutting speed: } n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$$

$$\text{To calculate cutting speed from RPM: } v_c = \frac{n \cdot \pi \cdot \phi}{1000}$$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.