810504, 810505 (Goldex)

Material Group		v_c (m/min)	f_n (mm/rev)												
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	40 (35-45)	0.02	0.06	0.08	0.11	0.11	0.13	0.15	0.18	0.22	0.22	-	-	-	-
	13 14	23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20	-	-	-	-
M	21 22	23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20	-	-	-	-
S	41 42	23 (20-25)	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20	-	-	-	-
N	71 72 73	90 (85-95)	0.02	0.06	0.10	0.11	0.12	0.14	0.16	0.18	0.23	0.23	-	-	-	-

v_c - cutting speed (m/min)
n - RPM (rev/min)
f_n - feed rate (mm/rev)
ø - drill diameter (mm)

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

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.