



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	70 (65-75)	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.15	-	-	-	-
	12															
	13	50 (45-55)	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.15	-	-	-	-
	14															
M	21	35 (30-40)	0.03	0.04	0.04	0.05	0.06	0.07	0.08	0.10	0.12	0.13	-	-	-	-
	22															
K	31	90 (80-100)	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.13	0.17	0.20	-	-	-	-
	32															
	33	60 (50-70)	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.13	0.17	0.20	-	-	-	-
	34															
S	41	35 (33-40)	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.10	0.12	0.13	-	-	-	-
	42															
	51	18 (15-20)	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.09	0.11	0.12	-	-	-	-
	52															
N	71	160 (150-170)	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.16	0.20	0.24	-	-	-	-
	72															
	73	120 (110-130)	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.16	0.20	0.24	-	-	-	-
	74															

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_n - feed rate (mm/rev)

ø - drill diameter (mm)

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

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

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.