



Material Group	vc (m/min)	fn (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	140 (130-150)	0.05	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
	12															
	13	125 (115-135)	0.05	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
	14															
K	31	240 (230-250)	0.15	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
	32															
	33	150 (140-160)	0.15	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
	34															

- ▶ For 8xD drills reduce feed rate by 15%
- ▶ For diameters below 3.0mm reduce cutting speed by 40%
- ▶ For recommended coolant pressure refer to p.191

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_n - feed rate (mm/rev)

ϕ - drill diameter (mm)

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

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

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.