



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	20 (25-25)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
	12															
M	21	8 (6-10)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
	22															
K	31	8 (6-10)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
	32															
S	41	5 (4-6)	0.08	0.020	0.025	0.031	0.038	0.045	0.060	0.075	0.090	0.100	0.110	0.120	0.130	0.140
	42															
N	71	40 (40-45)	0.020	0.038	0.063	0.070	0.076	0.120	0.160	0.180	0.200	0.225	0.250	0.275	0.300	0.325
	72															
O	81	18 (15-20)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
	82															

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_n - feed rate (mm/rev)

ø - drill diameter (mm)

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

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

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.