

Material Group	Cutting speed v_c (m/min)	Tool diameter (mm)		
	Solid carbide Start/max	Feed per revolution f (mm/U)		
		Ø 14.0–19.0	Ø 20.0–32.0	Ø 33.0–42.0
P1	125–165	0.10-0.22	0.10-0.24	0.10-0.26
P2	105–135	0.10-0.22	0.10-0.24	0.10-0.26
P3	85–110	0.08-0.18	0.08-0.22	0.08-0.24
M1	20–40	0.08-0.16	0.08-0.18	0.08-0.22
M2	20–30	0.08-0.16	0.08-0.18	0.08-0.22
K1	115–135	0.10-0.22	0.10-0.24	0.10-0.26
K2	85–105	0.10-0.20	0.10-0.22	0.10-0.24
S	20–30	0.06-0.16	0.10-0.18	0.10-0.20

The cutting data indicated are starting values and must be adjusted to the prevailing conditions.
The minimum value should not be less than 30 % of the start value.

Recommended allowance for reaming

Tool diameter	Pre-drilling diameter – Reduction (mm)		
	min	Start	max
4.00–10.00	0.10	0.15	0.25
10.00–15.00	0.15	0.20	0.30
15.00–20.00	0.15	0.25	0.35
20.00–42.00	0.20	0.30	0.40