

| Fn | Material | | | | Feed Rate (mm/N) | | | | | | | | | | | | | | | |
|----|----------|--------|-------|-------|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|------|------|------|------|
| | HM | HSS HM | HSS | HSS-E | 1mm | 2mm | 3mm | 4mm | 5mm | 6mm | 8mm | 10mm | 12mm | 15mm | 16mm | 20mm | 25mm | 30mm | 40mm | 50mm |
| A | 0.012 | 0.023 | 0.029 | 0.032 | 0.036 | 0.042 | 0.054 | 0.062 | 0.069 | 0.082 | 0.086 | 0.110 | 0.125 | 0.135 | 0.155 | 0.175 | | | | |
| B | 0.014 | 0.028 | 0.037 | 0.041 | 0.046 | 0.053 | 0.067 | 0.080 | 0.090 | 0.103 | 0.108 | 0.135 | 0.153 | 0.165 | 0.188 | 0.208 | | | | |
| C | 0.015 | 0.032 | 0.044 | 0.050 | 0.056 | 0.064 | 0.080 | 0.098 | 0.110 | 0.125 | 0.130 | 0.160 | 0.180 | 0.195 | 0.220 | 0.240 | | | | |
| D | 0.016 | 0.038 | 0.053 | 0.060 | 0.068 | 0.078 | 0.098 | 0.119 | 0.130 | 0.149 | 0.155 | 0.188 | 0.210 | 0.228 | 0.253 | 0.275 | | | | |
| E | 0.017 | 0.043 | 0.062 | 0.071 | 0.080 | 0.092 | 0.115 | 0.140 | 0.150 | 0.173 | 0.180 | 0.215 | 0.240 | 0.260 | 0.285 | 0.310 | | | | |
| F | 0.018 | 0.050 | 0.073 | 0.084 | 0.095 | 0.109 | 0.138 | 0.165 | 0.178 | 0.202 | 0.210 | 0.248 | 0.275 | 0.295 | 0.320 | 0.343 | | | | |
| G | 0.019 | 0.056 | 0.084 | 0.096 | 0.109 | 0.126 | 0.160 | 0.190 | 0.205 | 0.231 | 0.240 | 0.280 | 0.310 | 0.330 | 0.355 | 0.375 | | | | |
| H | 0.020 | 0.066 | 0.102 | 0.116 | 0.130 | 0.150 | 0.190 | 0.228 | 0.243 | 0.271 | 0.280 | 0.320 | 0.355 | 0.375 | 0.398 | 0.418 | | | | |
| I | 0.021 | 0.076 | 0.119 | 0.134 | 0.150 | 0.173 | 0.220 | 0.265 | 0.280 | 0.310 | 0.320 | 0.360 | 0.400 | 0.420 | 0.440 | 0.460 | | | | |
| J | 0.024 | 0.084 | 0.135 | 0.152 | 0.170 | 0.197 | 0.250 | 0.298 | 0.315 | 0.349 | 0.360 | 0.405 | 0.445 | 0.465 | 0.485 | 0.503 | | | | |
| K | 0.026 | 0.092 | 0.150 | 0.170 | 0.190 | 0.220 | 0.280 | 0.330 | 0.350 | 0.388 | 0.400 | 0.450 | 0.490 | 0.510 | 0.530 | 0.545 | | | | |
| L | 0.028 | 0.101 | 0.165 | 0.186 | 0.208 | 0.240 | 0.305 | 0.360 | 0.385 | 0.419 | 0.430 | 0.485 | 0.525 | 0.545 | 0.568 | 0.588 | | | | |
| M | 0.030 | 0.110 | 0.180 | 0.202 | 0.225 | 0.260 | 0.330 | 0.390 | 0.420 | 0.450 | 0.460 | 0.520 | 0.560 | 0.580 | 0.605 | 0.630 | | | | |
| N | 0.032 | 0.119 | 0.195 | 0.218 | 0.242 | 0.280 | 0.355 | 0.420 | 0.455 | 0.481 | 0.490 | 0.555 | 0.595 | 0.615 | 0.642 | 0.672 | | | | |
| S | 0.008 | 0.014 | 0.020 | 0.025 | 0.030 | 0.037 | 0.050 | 0.080 | 0.100 | 0.123 | 0.130 | 0.150 | | | | | | | | |
| T | 0.015 | 0.028 | 0.040 | 0.050 | 0.060 | 0.070 | 0.090 | 0.110 | 0.130 | 0.160 | 0.170 | 0.190 | | | | | | | | |
| U | 0.026 | 0.048 | 0.070 | 0.080 | 0.090 | 0.107 | 0.140 | 0.170 | 0.200 | 0.223 | 0.230 | 0.240 | | | | | | | | |
| V | 0.038 | 0.069 | 0.100 | 0.115 | 0.130 | 0.153 | 0.200 | 0.250 | 0.280 | 0.310 | 0.320 | 0.340 | | | | | | | | |
| W | 0.049 | 0.089 | 0.130 | 0.150 | 0.170 | 0.200 | 0.260 | 0.330 | 0.380 | 0.418 | 0.430 | 0.450 | | | | | | | | |
| X | 0.056 | 0.103 | 0.150 | 0.180 | 0.210 | 0.250 | 0.330 | 0.420 | 0.480 | 0.533 | 0.550 | 0.580 | | | | | | | | |
| Y | 0.068 | 0.124 | 0.180 | 0.220 | 0.260 | 0.317 | 0.430 | 0.550 | 0.700 | 0.700 | 0.700 | 0.740 | | | | | | | | |
| Z | 0.094 | 0.172 | 0.250 | 0.325 | 0.400 | 0.533 | 0.800 | 1.000 | 1.100 | 1.175 | 1.200 | 1.200 | | | | | | | | |

mm/N ± 25 %

$$n = \frac{V_c \times 1000}{\pi \times D}$$

$$V_f = n \times f \times n$$

| Fn | Material | Feed Rate (mm/N) | | | | | | |
|----|----------|------------------|-------|-------|-------|-------|-------|------|
| HM | HSS | 12mm | 15mm | 16mm | 20mm | 25mm | 30mm | 40mm |
| S | 0.100 | 0.123 | 0.130 | 0.150 | 0.170 | 0.190 | 0.220 | |
| T | 0.130 | 0.160 | 0.170 | 0.190 | 0.210 | 0.230 | 0.260 | |
| U | 0.200 | 0.223 | 0.230 | 0.240 | 0.270 | 0.300 | 0.360 | |
| V | 0.280 | 0.310 | 0.320 | 0.340 | 0.400 | 0.440 | 0.510 | |
| W | 0.380 | 0.418 | 0.430 | 0.450 | 0.470 | 0.490 | 0.520 | |

mm/N ± 25 %