

Work Material	Gray Cast Iron ($\leq 350\text{MPa}$)				Ductile Cast Iron ($\leq 450\text{MPa}$)			
	GG30				GGG45			
Drill Dia. (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)
0.5	40	25400	0.01 (0.005—0.015)	250	30	19000	0.01 (0.005—0.015)	190
1.0	50	15900	0.035 (0.020—0.050)	555	40	12700	0.035 (0.020—0.050)	440
1.5	50	10600	0.055 (0.035—0.080)	580	40	8400	0.055 (0.035—0.080)	460
2.0	50	7900	0.07 (0.040—0.100)	550	40	6300	0.07 (0.040—0.100)	440
2.5	60	7600	0.085 (0.050—0.125)	645	50	6300	0.085 (0.050—0.125)	535
2.95	90	9500	0.10 (0.060—0.130)	950	65	6800	0.10 (0.060—0.130)	680

Work Material	Aluminium Alloy ($\text{Si} < 5\%$)				Heat Resistant Alloy			
					Inconel718			
Drill Dia. (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)
0.5	40	25400	0.014 (0.008—0.020)	355	10	6300	0.006 (0.004—0.008)	35
1.0	60	19000	0.05 (0.030—0.075)	950	10	3100	0.02 (0.016—0.027)	60
1.5	80	16900	0.085 (0.053—0.120)	1435	10	2100	0.03 (0.025—0.040)	60
2.0	90	14300	0.105 (0.060—0.150)	1500	15	2300	0.04 (0.032—0.050)	90
2.5	100	12700	0.135 (0.075—0.200)	1710	15	1900	0.05 (0.040—0.060)	95
2.95	120	12700	0.23 (0.100—0.350)	2920	20	2100	0.07 (0.050—0.090)	145