

Work Material	Gray Cast Iron (≤350MPa)				Ductile Cast Iron (≤450MPa)			
	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)
1.0	40	12700	0.02 (0.010—0.030)	255	30	9500	0.015 (0.009—0.028)	140
1.5	40	8400	0.055 (0.032—0.080)	460	30	6300	0.05 (0.027—0.076)	315
2.0	50	7900	0.07 (0.040—0.100)	550	50	7900	0.065 (0.034—0.095)	515
2.5	50	6300	0.09 (0.055—0.125)	565	50	6300	0.08 (0.045—0.120)	505
2.95	90	9500	0.10 (0.060—0.130)	950	50	5300	0.09 (0.050—0.120)	475

Work Material	Aluminium Alloy (Si<5%)				Heat ResistantAlloy			
					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)
1.0	50	15900	0.05 (0.030—0.075)	795	10	3100	0.02 (0.016—0.027)	60
1.5	70	14800	0.085 (0.053—0.120)	1255	10	2100	0.03 (0.025—0.040)	60
2.0	80	12700	0.105 (0.060—0.150)	1335	15	2300	0.04 (0.032—0.050)	90
2.5	90	11400	0.135 (0.075—0.200)	1540	15	1900	0.05 (0.040—0.060)	95
2.95	100	10600	0.23 (0.100—0.350)	2435	20	2100	0.07 (0.050—0.090)	145