

| | | Cutting speeds m/min. | | | | | | | | | | | | | | | |
|---------------|----|-----------------------|-----|-----|------|------|------|------|------|------|------|------|------|------|-------|-------|-------|
| | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 15 | 20 | 25 | 30 | 40 | 50 | 60 |
| | | Tool r.p.m. | | | | | | | | | | | | | | | |
| Ø of the tool | 1 | 318 | 637 | 955 | 1273 | 1592 | 1910 | 2546 | 3183 | 3820 | 4775 | 6366 | 7958 | 9549 | 12732 | 15915 | 19099 |
| | 2 | 159 | 318 | 477 | 637 | 796 | 955 | 1273 | 1592 | 1910 | 2387 | 3183 | 3979 | 4775 | 6366 | 7958 | 9549 |
| | 3 | 106 | 212 | 318 | 424 | 531 | 637 | 849 | 1061 | 1273 | 1592 | 2122 | 2653 | 3183 | 4244 | 5305 | 6366 |
| | 4 | 80 | 159 | 239 | 318 | 398 | 477 | 637 | 796 | 955 | 1194 | 1592 | 1989 | 2387 | 3183 | 3979 | 4775 |
| | 5 | 64 | 127 | 191 | 255 | 318 | 382 | 509 | 637 | 764 | 955 | 1273 | 1592 | 1910 | 2546 | 3183 | 3820 |
| | 6 | 53 | 106 | 159 | 212 | 265 | 318 | 424 | 531 | 637 | 796 | 1061 | 1326 | 1592 | 2122 | 2653 | 3183 |
| | 8 | 40 | 80 | 119 | 159 | 199 | 239 | 318 | 398 | 477 | 597 | 796 | 995 | 1194 | 1592 | 1989 | 2387 |
| | 10 | 32 | 64 | 95 | 127 | 159 | 191 | 255 | 318 | 382 | 477 | 637 | 796 | 955 | 1273 | 1592 | 1910 |
| | 12 | 27 | 53 | 80 | 106 | 133 | 159 | 212 | 265 | 318 | 398 | 531 | 663 | 796 | 1061 | 1326 | 1592 |
| | 14 | 23 | 45 | 68 | 91 | 114 | 136 | 182 | 227 | 273 | 341 | 455 | 568 | 682 | 909 | 1137 | 1364 |
| | 16 | 20 | 40 | 60 | 80 | 99 | 119 | 159 | 199 | 239 | 298 | 398 | 497 | 597 | 796 | 995 | 1194 |
| | 18 | 18 | 35 | 53 | 71 | 88 | 106 | 141 | 177 | 212 | 265 | 354 | 442 | 531 | 707 | 884 | 1061 |
| | 20 | 16 | 32 | 48 | 64 | 80 | 95 | 127 | 159 | 191 | 239 | 318 | 398 | 477 | 637 | 796 | 955 |
| | 25 | 13 | 25 | 38 | 51 | 64 | 76 | 102 | 127 | 153 | 191 | 255 | 318 | 382 | 509 | 637 | 764 |
| | 30 | 11 | 21 | 32 | 42 | 53 | 64 | 85 | 106 | 127 | 159 | 212 | 265 | 318 | 424 | 531 | 637 |
| | 35 | 9 | 18 | 27 | 36 | 45 | 55 | 73 | 91 | 109 | 136 | 182 | 227 | 273 | 364 | 455 | 546 |
| | 40 | 8 | 16 | 24 | 32 | 40 | 48 | 64 | 80 | 95 | 119 | 159 | 199 | 239 | 318 | 398 | 477 |
| | 45 | 7 | 14 | 21 | 28 | 35 | 42 | 57 | 71 | 85 | 106 | 141 | 177 | 212 | 283 | 354 | 424 |
| | 50 | 6 | 13 | 19 | 25 | 32 | 38 | 51 | 64 | 76 | 95 | 127 | 159 | 191 | 255 | 318 | 382 |