



Freebird Interior Common Projects Cutting Data –

The following 3 pages contain cutting data for various cutters specific to 12mm, 18mm and 22mm Finsa Fibrapan Hidrofugo MDF and Finsa 12Twenty range melamine faced MDF

22mm Finsa Fibrapan Hidrofugo MDF:

Shelves for bookcases - simple rectangular profiles

8mm x 22mm Flute 2 Flute Compression Cutter

2 passes

18,000 RPM - 7560 mm/min feed rate

Shaker doors - 35mm cup holes with 35mm drill (can you quote us for one of them too).

35mm TCT Dowel Drill Bit –

6000 RPM - 3000mm/min feed rate

Shaker doors rebate –

25mm TCT Bottom Cleaning Router Cutter –

18000 RPM - 1584 mm/min feed rate

Shaker doors through cut for panels

12mm x 42mm Flute 2 Flute Down Cut

2 passes

18,00 RPM – 9000 mm/min feed rate

Finish off through onion skin with 5mm straight for less of a corner radius –

5mm x 32mm 2 Flute Solid Carbide Straight Router Cutter –

18,000 RPM – 5400 mm/min feed rate

12mm Finsa Fibrapan Hidrofugo MDF:

8mm x 22mm Flute 2 Flute Compression Cutter

1 pass

18,000 RPM - 7560 mm/min feed rate

18mm Finsa Fibrapan Hidrofugo MDF:

Through cutting profiles -

8mm x 22mm Flute 2 Flute Compression Cutter

1 pass

18,000 RPM - 7560 mm/min feed rate

cabineo holes 12mm deep with 15mm drill –

15mm x 27mm Flute TCT Dowel Drill Bit For Blind Holes –

6000 RPM – 3000 mm/min feed rate

4mm & 5mm drill holes –

4mm x 27mm Flute TCT Dowel Drill Bit For Through Holes –

6000 RPM – 1500 mm/min feed rate

5mm x 27mm Flute TCT Dowel Drill Bit For Through Holes –

6000 RPM – 1650 mm/min feed rate

18mm Finsa 12Twenty range melamine faced MDF –

Use the same setting as above for the 22mm Finsa Fibrapan Hidrofugo MDF

