

RENNIE

Tool Company

Solid Carbide Compression Speeds And Feeds Chart

18,000 RPM			
Feed Rate (mm/min)-			
1 Flute	MDF/Laminate	Plywood	Wood
1/8"	2800	1500	1500
1/4"	3500	1800	1800
3/8"	5600	2800	2800
1/2"	7200	4300	3500
4mm	2800	1600	1600
5mm	3000	1700	1700
6mm	3200	1800	1800
8mm	5000	2400	2400
10mm	6000	3000	2800
12mm	7000	4000	3400

18,000 RPM			
Feed Rate (mm/min)-			
2 Flute			
1/8"	2000	1000	1000
1/4"	5500	2800	2800
3/8"	10000	5000	5000
1/2"	10000	7000	7000
4mm	3000	1500	1500
5mm	4500	2000	2000
6mm	5500	2600	2600
8mm	7500	4500	4500
10mm	10000	5800	5800
12mm	10000	7000	7000