

O FLUTE ROUTER BIT

FEED&SPEED CHART

Depth of cut: 1xCutting diameter

CUTTING DIA (INCH)	MATERIAL	RPM	CHIPLOAD	FEED RATE	STEP DOWN (INCH)	STEP OVER (INCH)
1/8	MDF/Softwood	18,000	0.006	108	0.125	0.025
	Plastic/Acrylic	18,000	0.004	72	0.125	0.025
	Aluminum	18,000	0.002	36	0.125	0.025
1/4	MDF/Softwood	18,000	0.01	180	0.25	0.1
	Plastic/Acrylic	18,000	0.008	144	0.25	0.1
	Aluminum	18,000	0.004	72	0.25	0.1

- **Adjusting Feed and Speed for Bit Diameter:** The feed rate in the table above are based a cutting depth that is equal to or less than the bit's diameter.

1 x cutting diameter, Use recommended feed rate

2 x cutting diameter, Reduce feed rate by 30%

3 x cutting diameter, Reduce feed rate by 50%

- **Simple machining calculations:**

Feed rate=RPM x # of flutes x chipload

- Due to the extremely small diameters involved, bits are not guaranteed against breakage.
- Please exercise caution to the accurate calculations of all feed and speed rates
- Always start test the bits with a lower feed rate
- Make overhang of bits as short as possible in condition on non-interference