

TRAY & CORE BOX ROUTER BIT

FEED&SPEED CHART

BOWL	RPM	CHIPLOAD	FEED RATE (INCH/MIN)	STEP DOWN (INCH)	STEP OVER (INCH)
MDF/Laminate	18,000	0.005	180	0.125	0.2
Softwood	18,000	0.004	150	0.125	0.2
Hardwood	18,000	0.003	120	0.125	0.2
CORE BOX	RPM	CHIPLOAD	FEED RATE (INCH/MIN)	STEP DOWN (INCH)	STEP OVER (INCH)
MDF/Laminate	18,000	0.005	180	0.125	0.2
Softwood	18,000	0.004	150	0.125	0.2
Hardwood	18,000	0.002	72	0.125	0.2

- 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 chart above.

1 x suggestion cutting depth, Use recommended feed rate

2 x suggestion cutting depth, Reduce feed rate by 30%

3 x suggestion cutting depth, 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