

Polycrystalline Diamond (PCD) CNC Double Edge Folding 'V' Groove Router Bit Speed and Feed Chart

Tool No. DRB-450			Surface Cutting Speed		Chip Load Per Tooth		RPM		Feed Rate	
Material	Diameter Inch/mm	No. Teeth	From	To	From	To	From	To	From	To
			Inch (mm)/min	Inch (mm)/min	Inch (mm)/min	Inch (mm)/min	Inch (mm)/min	Inch (mm)/min	Inch (mm)/min	Inch (mm)/min
Aluminum, Bronze, Copper	1/2" (12.7mm)	2	24" (600mm)	32" (8000mm)	.006" (0.15mm)	.001" (0.25mm)	15,000	20,000	178" (4,514mm)	395" (10,031mm)

Maximum RPM: 20,000

Correction factor for chip load:

0.8 = MDF with or without Coating

1.1 = Chipboard with or without Coating

0.7 = Veneer across grain

Simple Machining Calculations:

To find **RPM:** SFM x 3.82 / diameter of tool

To find **SFM:** 0.262 x diameter of tool x RPM

To find **Feed Rate:** RPM x # of flutes x chip load