


Double Edge 'V' Grooving Router Bits with Flat Bottom for ACM Materials Speed and Feed Chart

Material	Spindle Speed SFM**	Chip Load Per Tooth				
		Depth of Cut				
		< 1/8" (< 3mm)	1/8"-3/16" (3mm-5mm)	3/16"-5/16" (5mm-8mm)	5/16"-9/16" (8mm-14mm)	9/16"-23/32" (14mm-18mm)
Aluminum	656 - 1,312	0.0004" - 0.001"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.005"	0.005" - 0.006"
Brass	492 - 984	0.0003" - 0.0008"	0.0008" - 0.0016"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.004"
Bronze	328 - 492	0.0003" - 0.0008"	0.0008" - 0.0016"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.004"
Plastics-Bakelite	164 - 328	0.001" - 0.0016"	0.002" - 0.003"	0.003" - 0.005"	0.005" - 0.008"	0.008" - 0.010"
Plastics-PVC	328 - 656	0.001" - 0.002"	0.002" - 0.004"	0.004" - 0.007"	0.006" - 0.008"	0.008" - 0.011"
Thermoplastics, Acetate, Plexiglass, Nylon	984 - 1,640	0.0004" - 0.0014"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.006"	0.006" - 0.007"
Wood	984 - 1,312	0.0005" - 0.0014"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.005"	0.005" - 0.006"
*Stainless Steel, Steel, DuraPlate®	164 - 295	0.0003" - 0.0005"	0.0004" - 0.001"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.004"

 *Use Only Item No. 's 45762 and 45778.

SFM** Surface feet per minute

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

Depth of Cut: 1 x D Use recommended chip load
 2 x D Reduce chip load by 25%
 3 x D Reduce chip load by 50%