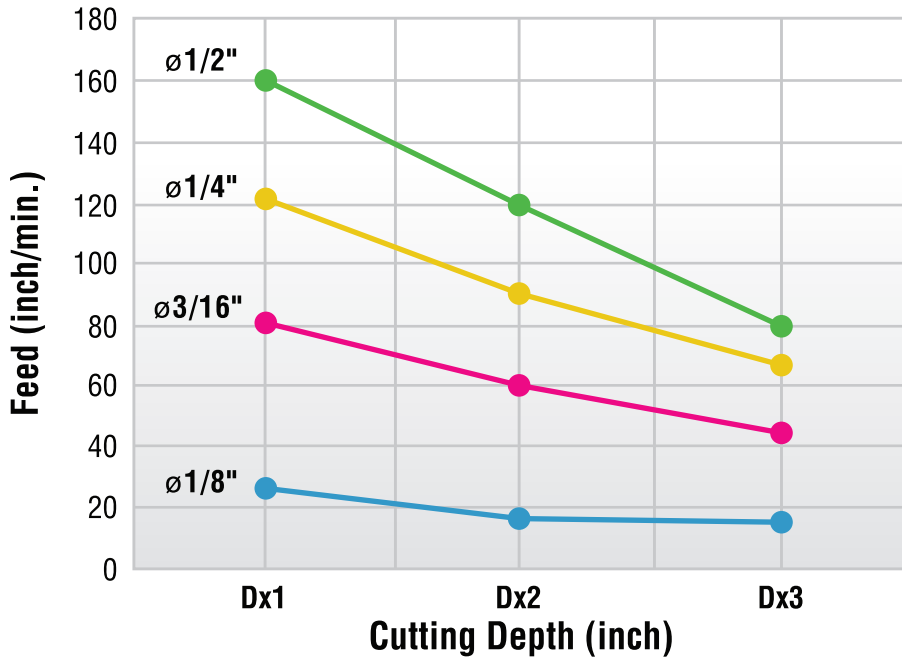


SPEED & FEED CHART

Solid Carbide Spiral 'O' Flute, Aluminum Cutting Router Bits



MATERIAL	CHIP LOAD		
	1/8" (.125")	3/16" (.1875")	1/4" (.250")
Aluminum, Low Silicone (≤8% silicone)	.002"-.004"	.003"-.005"	.003"-.006"
Aluminum, High Silicone (8%+ silicone)	.002"-.004"	.003"-.005"	.003"-.006"

Adjustments for "Depth of Cut"

- 1 Xs Diameter: Recommended chip load
- 2 Xs Diameter: Reduce chip load by 25%
- 3 Xs Diameter: Reduce chip load by 50%

Math For Routers:

- To find Chip Load = Feed Rate / RPM of spindle X # of cutting edges
- To find Feed Rate = RPM X # of cutting edges X chip load
- To find RPM = Feed Rate / (Chip Load X # of cutting edges)



Your **source** for industrial cutting tools!