

Solid Carbide ZrN Coated CNC Honeycomb Hogger Router Bits Speed and Feed Chart

Material	Spindle Speed		Chip Load Per Tooth IPR**		
	SFM*		#46306	#46305	#46309
	1/4" (0.250) - 1/2" (0.500)		1/4" (0.250)	3/8" (0.375)	1/2" (0.500)
Aluminum Honeycomb	800 - 1,200		0.006" - 0.009"	0.007" - 0.010"	0.006" - 0.009"
Aramid Honeycomb	1,200 - 1,600		0.003" - 0.006"	0.005" - 0.008"	0.009" - 0.013"
Carbon Laminates (Nomex, Kevlar)	1,100 - 1,400		0.003" - 0.006"	0.005" - 0.008"	0.003" - 0.006"
Tedlar	1,400 - 1,600		0.001" - 0.004"	0.002" - 0.005"	0.001" - 0.0004"

Operating RPM: 18,000

SFM* Surface feet per minute

IPR** Inches per revolution

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%