**Polycrystalline Diamond (PCD) CNC Double Edge Folding ‘V’ Groove Router Bit**

**Speed and Feed Chart**

**Simple Machining Calculations:**
- To find **RPM**: \( \text{SFM} \times 3.82 / \text{diameter of tool} \)
- To find **SFM**: \( 0.262 \times \text{diameter of tool} \times \text{RPM} \)
- To find **Feed Rate**: \( \text{RPM} \times \# \text{ of flutes} \times \text{chip load} \)

<table>
<thead>
<tr>
<th>Tool No. DRB-450</th>
<th>Surface Cutting Speed</th>
<th>Chip Load Per Tooth</th>
<th>RPM</th>
<th>Feed Rate</th>
</tr>
</thead>
<tbody>
<tr>
<td>Material</td>
<td>Diameter Inch/mm</td>
<td>No. Teeth</td>
<td>From Inch (mm)/min</td>
<td>To Inch (mm)/min</td>
</tr>
<tr>
<td>Aluminum, Bronze, Copper</td>
<td>1/2” (12.7mm)</td>
<td>2</td>
<td>24” (600mm)</td>
<td>32” (8000mm)</td>
</tr>
</tbody>
</table>

**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