

## Solid Carbide Aluminum Cutting Spiral 'O' Flute Router Bits Speed and Feed Chart

Diameter	Spindle Speed SFM*	Feed Per Tooth
1/16" (0.0625)	600-800	0.002" - 0.004"
2mm	600-800	0.002" - 0.004"
3/32" (0.0938)	600-800	0.002" - 0.004"
3mm	600-800	0.002" - 0.004"
1/8" (0.125)	600-800	0.002" - 0.004"
5/32" (0.1563)	600-800	0.002" - 0.004"
4mm	600-800	0.002" - 0.004"
3/16" (0.1875)	600-800	0.003" - 0.006"
5mm	600-800	0.003" - 0.006"
6mm	600-800	0.003" - 0.006"
1/4" (0.250)	600-800	0.003" - 0.006"
9/32" (0.2813)	600-800	0.003" - 0.006"
5/16" (0.3125)	600-800	0.003" - 0.006"
8mm	600-800	0.003" - 0.006"
21/64" (0.3281)	600-800	0.004" - 0.008"
11/32" (0.3438)	600-800	0.004" - 0.008"
9mm	600-800	0.004" - 0.008"
3/8" (0.375)	600-800	0.004" - 0.008"
10mm	600-800	0.004" - 0.008"
12mm	600-800	0.004" - 0.008"
1/2" (0.250)	600-800	0.004" - 0.008"

**Operating RPM:** 18,000

**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%