

PCD* CNC T-Slot Router Bit Speed and Feed Chart



Tool No.	Diameter Inch/mm	No. Teeth	Chip Load Per Tooth Inch (mm)/min	RPM	Feed Rate Inch (mm)/min
DRB-300-RH	1-3/8" (35mm)	2	.008" (0.20mm)	14,500	230" (5,800mm)

Multipliers for different materials:

0.8% = MDF with or without Coating

1.1% = Chipboard with or without Coating

0.7% = Cross grain veneer

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

To find **Chip Load** =
$$\frac{\text{Feed Rate}}{\text{RPM} \times \# \text{ of Flutes}}$$