

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

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

SFM* Surface feet per minute

IPR** Inches per revolution

Simple Machining Calculations:

To find **RPM**: $SFM \times 3.82 / \text{diameter of tool}$

To find **SFM**: $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate**: $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

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%