

SPOILBOARD SURFACING ROUTER BIT

FEED&SPEED CHART

WINGS	SHNAK DIAMETER	RPM	MDF/LAMINATE	SOFTWOOD	HARDWOOD	STEP DOWN (MM)
3	1/2	18,000	150	130	100	2
	8mm	18,000	150	130	100	2
	12mm	18,000	300	250	200	2
4	1/2	18,000	200	180	150	2
	8mm	18,000	200	180	150	2
2+2	1/4	18,000	200	150	100	2
	8mm	18,000	300	250	200	2
	12	18,000	400	300	250	2

- **Adjusting Feed and Speed for Bit Diameter:** The feed rate in the table above are based a cutting depth that is equal to or less than the chart above

1 x suggest step down, Use recommended feed rate

2 x suggest step down, Reduce feed rate by 30%

3 x suggest step down, Reduce feed rate by 50%

- **Simple machining calculations:**

Feed rate=RPM x # of flutes x chipload

- Due to the extremely small diameters involved, bits are not guaranteed against breakage.
- Please excercise caution to the accurate calculations of all feed and speed rates
- Always start test the bits with a lower feed rate
- Make overhang of bits as short as possible in condition on non-interference