

Solid Carbide ZrN Coated CNC Honeycomb Hogger Router Bits

Operating RPM: 18,000

Material	Spindle Speed	Chip Load Per Tooth IPR**			
	SFM*	#40301 / #40304	#46306 / #40305	#46305	#46309
	1/8" (0.125) - 1/2" (0.500)	1/8" (0.125)	1/4" (0.250)	3/8" (0.375)	1/2" (0.500)
Aluminum Honeycomb	800 - 1,200	0.003" - 0.005"	0.006" - 0.009"	0.007" - 0.010"	0.006" - 0.009"
Aramid Honeycomb	1,200 - 1,600	0.002" - 0.004"	0.003" - 0.006"	0.005" - 0.008"	0.009" - 0.013"
Carbon Laminates (Nomex, Kevlar)	1,100 - 1,400	0.002" - 0.004"	0.003" - 0.006"	0.005" - 0.008"	0.003" - 0.006"
Tedlar	1,400 - 1,600	0.001" - 0.003"	0.001" - 0.004"	0.002" - 0.005"	0.001" - 0.0004"

* **SFM** Surface feet per minute

** **IPR** Inches per revolution

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%

Disclaimer: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.