



**INDUSTRIAL**

## Solid Carbide Glass Reinforced Plastic Cutting Router Bits Speed and Feed Chart

### Chip Load Per Tooth IPR\*\*

Material	51521/51531 1/8"	51525/51535 1/4"
Fiberglass & Composites	0.002" - 0.004"	0.002" - 0.004"

**Operating RPM:** 10,000

**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%