

FEEDS & SPEEDS GUIDE

ALUMINIUM

<u>GRADE OF ALUMINIUM</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
5005		3mm	501106009	1	2.0 – 2.5 m/min	18 000 RPM
		4mm	501106009	2	2.0 – 2.5 m/min	18 000 RPM
		5mm	501106009	3	1.8 – 2.0 m/min	18 000 RPM
		6mm	501108001	4	2.0 – 2.5 m/min	18 000 RPM
5051		3mm	501106009	1	2.0 – 2.5 m/min	18 000 RPM
		4mm	501106009	2	2.0 – 2.5 m/min	18 000 RPM
		5mm	501106009	3	1.8 – 2.0 m/min	18 000 RPM
		6mm	501108001	4	2.0 – 2.5 m/min	18 000 RPM
5083	Fine Work	2mm	501103004	2	1.8 m/min	18 000 RPM
	(Detailed)	3mm	501103004	3	1.8 m/min	18 000 RPM
		4mm	501103004	4	1.8 m/min	18 000 RPM
		5mm	501103004	5	1.8 m/min	18 000 RPM
		6mm	501103004	6	1.8 m/min	18 000 RPM
6061	Fine Work	2mm	501103004	2	1.8 m/min	18 000 RPM
	(Detailed)	3mm	501103004	3	1.8 m/min	18 000 RPM
		4mm	501103004	4	1.8 m/min	18 000 RPM
		5mm	501103004	5	1.8 m/min	18 000 RPM
		6mm	501103004	6	1.8 m/min	18 000 RPM

ALUMINIUM (Continued)

<u>GRADE OF ALUMINIUM</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
5083	Large Work	2mm	501106009	1	6.0 m/min	18 000 RPM
		3mm	501106009	1	5.5m/min	18 000 RPM
		4mm	501106009	1	5.0m/min	18 000 RPM
		5mm	501106009	1	4.5m/min	18 000 RPM
		6mm	501106009	1	4.0m/min	18 000 RPM
		8mm	501106009	2	5.0m/min	18 000 RPM
		10mm	501106009	2	4.0m/min	18 000 RPM
		12mm	501108002	2	4.0m/min	18 000 RPM
		16mm	501108002	3	4.5m/min	18 000 RPM
		20mm	501110002	4	3.0m/min	18 000 RPM
		25mm	501110002	5	3.0m/min	18 000 RPM
6061	Large Work	2mm	501106009	1	6.0 m/min	18 000 RPM
		3mm	501106009	1	5.5m/min	18 000 RPM
		4mm	501106009	1	5.0m/min	18 000 RPM
		5mm	501106009	1	4.5m/min	18 000 RPM
		6mm	501106009	1	4.0m/min	18 000 RPM
		8mm	501106009	2	5.0m/min	18 000 RPM
		10mm	501106009	2	4.0m/min	18 000 RPM
		12mm	501108002	2	4.0m/min	18 000 RPM
		16mm	501108002	3	4.5m/min	18 000 RPM
		20mm	501110002	4	3.0m/min	18 000 RPM
		25mm	501110002	5	3.0m/min	18 000 RPM

WOODWORKING

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
PINE	Rough Cutting	5mm	783110002	1	15.0m/min	18 000 RPM
		10mm	783110002	1	15.0m/min	18 000 RPM
		12mm	783110002	1	15.0m/min	18 000 RPM
		20mm	783110002	1	15.0m/min	18 000 RPM
		25mm	783110002	2	15.0m/min	18 000 RPM
		30mm	783110002	2	15.0m/min	18 000 RPM
		35mm	783110002	2	15.0m/min	18 000 RPM
	Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM
		12mm	812110001	1	12.0m/min	18 000 RPM
		20mm	812110001	1	12.0m/min	18 000 RPM
		25mm	812110001	2	12.0m/min	18 000 RPM
		30mm	812110002	2	12.0m/min	18 000 RPM
		35mm	812110002	2	12.0m/min	18 000 RPM
	Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM
		10mm	812110001	1	8.0m/min	18 000 RPM
		12mm	812110001	1	8.0m/min	18 000 RPM
		20mm	812110001	1	8.0m/min	18 000 RPM
		25mm	812110001	2	8.0m/min	18 000 RPM
		30mm	812110002	2	8.0m/min	18 000 RPM
		35mm	812110002	2	8.0m/min	18 000 RPM

WOODWORKING (Continued)

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
MDF	Rough Cutting	5mm	783110002	1	15.0m/min	18 000 RPM
		10mm	783110002	1	15.0m/min	18 000 RPM
		12mm	783110002	1	15.0m/min	18 000 RPM
		20mm	783110002	1	15.0m/min	18 000 RPM
		25mm	783110002	2	15.0m/min	18 000 RPM
		30mm	783110002	2	15.0m/min	18 000 RPM
		35mm	783110002	2	15.0m/min	18 000 RPM
	Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM
		12mm	812110001	1	12.0m/min	18 000 RPM
		20mm	812110001	1	12.0m/min	18 000 RPM
		25mm	812110001	2	12.0m/min	18 000 RPM
		30mm	812110002	2	12.0m/min	18 000 RPM
		35mm	812110002	2	12.0m/min	18 000 RPM
	Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM
		10mm	812110001	1	8.0m/min	18 000 RPM
		12mm	812110001	1	8.0m/min	18 000 RPM
		20mm	812110001	1	8.0m/min	18 000 RPM
		25mm	812110001	2	8.0m/min	18 000 RPM
		30mm	812110002	2	8.0m/min	18 000 RPM
		35mm	812110002	2	8.0m/min	18 000 RPM

WOODWORKING (Continued)

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>	
PARTICLE BOARD	Rough Cutting	5mm	783110002	1	15.0m/min	18 000 RPM	
		10mm	783110002	1	15.0m/min	18 000 RPM	
		12mm	783110002	1	15.0m/min	18 000 RPM	
		20mm	783110002	1	15.0m/min	18 000 RPM	
		25mm	783110002	2	15.0m/min	18 000 RPM	
		30mm	783110002	2	15.0m/min	18 000 RPM	
		35mm	783110002	2	15.0m/min	18 000 RPM	
		Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM	
		12mm	812110001	1	12.0m/min	18 000 RPM	
	20mm	812110001	1	12.0m/min	18 000 RPM		
	25mm	812110001	2	12.0m/min	18 000 RPM		
	30mm	812110002	2	12.0m/min	18 000 RPM		
	35mm	812110002	2	12.0m/min	18 000 RPM		
	Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM	
10mm		812110001	1	8.0m/min	18 000 RPM		
12mm		812110001	1	8.0m/min	18 000 RPM		
20mm		812110001	1	8.0m/min	18 000 RPM		
25mm		812110001	2	8.0m/min	18 000 RPM		
30mm		812110002	2	8.0m/min	18 000 RPM		
35mm		812110002	2	8.0m/min	18 000 RPM		

WOODWORKING (Continued)

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>	
MR PARTICLE BOARD	Rough Cutting	5mm	783110002	1	15.0m/min	18 000 RPM	
		10mm	783110002	1	15.0m/min	18 000 RPM	
		12mm	783110002	1	15.0m/min	18 000 RPM	
		20mm	783110002	1	15.0m/min	18 000 RPM	
		25mm	783110002	2	15.0m/min	18 000 RPM	
		30mm	783110002	2	15.0m/min	18 000 RPM	
		35mm	783110002	2	15.0m/min	18 000 RPM	
		Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM	
		12mm	812110001	1	12.0m/min	18 000 RPM	
	20mm	812110001	1	12.0m/min	18 000 RPM		
	25mm	812110001	2	12.0m/min	18 000 RPM		
	30mm	812110002	2	12.0m/min	18 000 RPM		
	35mm	812110002	2	12.0m/min	18 000 RPM		
Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM		
	10mm	812110001	1	8.0m/min	18 000 RPM		
	12mm	812110001	1	8.0m/min	18 000 RPM		
	20mm	812110001	1	8.0m/min	18 000 RPM		
	25mm	812110001	2	8.0m/min	18 000 RPM		
	30mm	812110002	2	8.0m/min	18 000 RPM		
	35mm	812110002	2	8.0m/min	18 000 RPM		

WOODWORKING (Continued)

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
ROSEWOOD	Rough Cutting	5mm	783110002	1	11.5m/min	18 000 RPM
		10mm	783110002	1	11.5m/min	18 000 RPM
		12mm	783110002	1	11.5m/min	18 000 RPM
		20mm	783110002	2	11.5m/min	18 000 RPM
		25mm	783110002	2	11.5m/min	18 000 RPM
		30mm	783110002	2	11.5m/min	18 000 RPM
		35mm	783110002	3	11.5m/min	18 000 RPM
	Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM
		12mm	812110001	1	12.0m/min	18 000 RPM
		20mm	812110001	1	12.0m/min	18 000 RPM
		25mm	812110001	2	12.0m/min	18 000 RPM
		30mm	812110002	2	12.0m/min	18 000 RPM
		35mm	812110002	2	12.0m/min	18 000 RPM
	Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM
		10mm	812110001	1	8.0m/min	18 000 RPM
		12mm	812110001	1	8.0m/min	18 000 RPM
		20mm	812110001	1	8.0m/min	18 000 RPM
		25mm	812110001	2	8.0m/min	18 000 RPM
		30mm	812110002	2	8.0m/min	18 000 RPM
		35mm	812110002	2	8.0m/min	18 000 RPM

WOODWORKING (Continued)

<u>TYPE OF WOOD</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
MAHOGANY	Rough Cutting	5mm	783110002	1	11.5m/min	18 000 RPM
		10mm	783110002	1	11.5m/min	18 000 RPM
		12mm	783110002	1	11.5m/min	18 000 RPM
		20mm	783110002	2	11.5m/min	18 000 RPM
		25mm	783110002	2	11.5m/min	18 000 RPM
		30mm	783110002	2	11.5m/min	18 000 RPM
		35mm	783110002	3	11.5m/min	18 000 RPM
	Cleanup Pass	5mm	812109501	1	12.0m/min	18 000 RPM
		10mm	812110001	1	12.0m/min	18 000 RPM
		12mm	812110001	1	12.0m/min	18 000 RPM
		20mm	812110001	1	12.0m/min	18 000 RPM
		25mm	812110001	2	12.0m/min	18 000 RPM
		30mm	812110002	2	12.0m/min	18 000 RPM
		35mm	812110002	2	12.0m/min	18 000 RPM
	Clean Cutting	5mm	812109501	1	8.0m/min	18 000 RPM
		10mm	812110001	1	8.0m/min	18 000 RPM
		12mm	812110001	1	8.0m/min	18 000 RPM
		20mm	812110001	1	8.0m/min	18 000 RPM
		25mm	812110001	2	8.0m/min	18 000 RPM
		30mm	812110002	2	8.0m/min	18 000 RPM
		35mm	812110002	2	8.0m/min	18 000 RPM

PLASTICS

<u>TYPE OF PLASTIC</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
PE	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM
	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM
EPVC	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM
	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM
PVC	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM

PLASTICS (Continued)

<u>TYPE OF PLASTIC</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
PVC	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM
HDPE	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM
	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM
UHMWPE	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM
	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM

PLASTICS (Continued)

<u>TYPE OF PLASTIC</u>	<u>WORK TO BE PERFORMED</u>	<u>THICKNESS OF MATERIAL</u>	<u>RECOMMENDED ROUTER TOOL</u>	<u>NUMBER OF PASSES</u>	<u>FEED RATE</u>	<u>SPEED RATE</u>
Acrylic	Fine Work	3mm	501103001	1	1.5m/min	12 000 RPM
		5mm	501103001	2	1.5m/min	12 000 RPM
		10mm	501104002	3	2.5m/min	14 000 RPM
		20mm	501106003	3	2.5m/min	14 000 RPM
	Large Work	3mm	501106001	1	7.5m/min	18 000 RPM
		5mm	501106001	1	6.0m/min	18 000 RPM
		10mm	501108001	1	6.0m/min	18 000 RPM
		20mm	501112001	2	5.0m/min	18 000 RPM