

CNC Insert Nova System for Cabinet Doors

Feed / Speed Rates & Chip Load

Tool No.	Feed rate Inch/Min	Speed rate RPM	Max RPM	Chip load Inch/Rev
RC-2480	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2481	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2482	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2483	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2484	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2485	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2486	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2490	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2494	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2496	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2498	120" - 280"	24,000	28,000	0.005" - 0.011"
RC-2499	120" - 280"	24,000	28,000	0.005" - 0.011"

Simple Machining Calculations:

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

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

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

To find **Chip Load**: $\text{IPM} / (\text{RPM} \times \# \text{ of Flutes})$

Depth of Cut: 1 x D Use recommended feed rate
 2 x D Reduce feed rate by 25%
 3 x D Reduce feed rate by 50%