

Polycrystalline Diamond (PCD) CNC Lamello P-System Router Bit

Tool No.	Diameter Inch/mm	Flute	Chip Load Per Tooth Inch (mm)/min	RPM	Feed Rate Inch (mm)/min
DRB-LAM98	0.386" (9.8mm)	2	0.013" (0.33mm)	18,000	230" (5,842mm)

Multipliers for different materials:

0.8% = MDF with or without Coating

1.1% = Chipboard with or without Coating

0.7% = Cross grain veneer

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 IPM**: RPM x # of flutes x chip load (When calculating feed rate IPM use only 1 flute)

To find **Chip Load** = $\frac{\text{Feed Rate IPM}}{\text{RPM} \times \# \text{ of Flutes}}$