

**PCD\* CNC T-Slot Router Bit Speed and Feed Chart**


<b>Tool No.</b>	<b>Diameter</b> Inch/mm	<b>No. Teeth</b>	<b>Chip Load Per Tooth</b> Inch (mm)/min	<b>RPM</b>	<b>Feed Rate</b> Inch (mm)/min
<b>DRB-300-RH</b>	1-3/8" (35mm)	2	.008" (0.20mm)	14,500	230" (5,800mm)

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**: RPM x # of flutes x chip load
- To find **Chip Load** =  $\frac{\text{Feed Rate}}{\text{RPM} \times \# \text{ of Flutes}}$