

DIMENSION 200

RECOMMENDED FEED AND DEPTH PER PASS VALUES

This card lists the **recommended** Feed Rate (in inches per minute) and Depth Per Pass values used with a 1/4" and 1/8" cutter for various materials and thicknesses. Noting variations in workpiece size, configuration, rigidity of setup, material hardness, spindle speed (in revolutions per minute), and desired surface finish, you may find with experience that faster speeds are possible. You may also decide to change the recommended Depth Per Pass amounts.

Pass	Tool	Depth Per Pass	Feed Rate (in/min)	Plunge (in/min)
1/4" acrylic, 1/8" tool, multipass				
Basic	1/8" carbide	.126	45	10
Finish	1/8" carbide		40	10
1/4" acrylic, 1/4" tool, single pass				
Basic	1/4" carbide	.250	30	15
1/8" acrylic, 1/8" tool, single pass				
Basic	1/8" carbide	.125	40	15
1/2" PVC, 1/4" tool, multipass				
Basic	1/4" carbide	.251	54	15
Finish	1/4" carbide		54	15
1/2" hardwood, 1/4" "O" flute, multipass				
Basic	1/4" carbide "O" flute	.210	54	20
Finish	1/4" carbide		54	20

RECOMMENDED FEED AND DEPTH PER PASS VALUES

Pass	Tool	Depth Per Pass	Feed Rate (in/min)	Plunge (in/min)
1/8" aluminum*, 1/8" tool, single pass				
Basic	1/8" carbide	.135	15	5
1/4" aluminum*, 1/8" tool, multipass				
Basic	1/8" carbide	.131	15	5
Finish	1/8" carbide		20	5
1/4" aluminum*, 1/4" tool, single pass				
Basic	1/4" carbide	.260	10	5
1/4" aluminum*, 1/4" tool, multipass				
Basic	1/4" carbide	.100	30	5
Finish	1/4" carbide		15	5
1/8" brass*, 1/8 tool, single pass				
Basic	1/8" carbide	.135	10	4
1/4" brass*, 1/4 tool, multipass				
Basic	1/4" carbide	.087	20	5
Finish	1/4" carbide		15	4

* All metals require use of the Mist Coolant System.