



"Performance, Value, Integrity"

Router Feed Rate and Spindle Speed Estimator

Spindle RPM Suggestion	Router Diameter - English	0.04	0.063	0.078	0.093	0.1	0.125	0.152
	Router Diameter - Metric	1.016	1.6002	1.9812	2.3622	2.54	3.175	3.8608
	RPM Low	20,000	17,000	16,000	15,000	14,000	13,000	12,000
	RPM High	28,000	25,000	22,000	20,000	18,000	17,000	16,000
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Router Feed Rate	Substrate Thickness	Feed Rate Inches/Second						
	0.040 substrate (1mm thk)	0.75	1	1.25	1.5	1.5	1.5	1.75
	0.062 substrate (1.6mm thk)	0.5	0.75	1	1.25	1.25	1.25	1.5
	0.125 substrate (3.175mm thk)	Not Suitable		0.75	0.625	0.5	0.5	0.5
	0.25 substrate (6.35mm thk)	Not Suitable			0.25	0.25	0.25	0.25

Note:

These Speeds and Feeds are Suggested. Based on PCB material types they may need to change. The bit "tooth" pattern may also change and can impact feed rates, bits may be Fluted, Toothed, UpCut, Down Cut and include finishes that will also impact their performance and Life. If in doubt please contact Getech or your local Distributor.

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