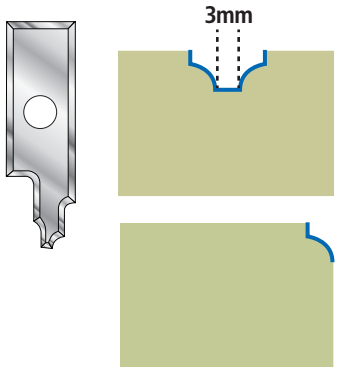
IN-GROOVE™
CNC INSERT ENGRAVING SYSTEM

1 Flute Bead Groove & Corner Round & Point Round Over

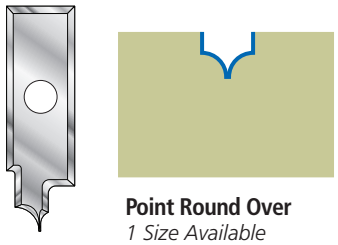
RPM & Feed Rate Chart



RC-1075 RC-1076 67127 5004



Bead Groove & Corner Round
3 Sizes Available



Point Round Over
1 Size Available

inch/min

Cutting depth up to	1/8"	3/16"	1/4"	5/16"
Rotation speed RPM				
6000	59	52	47	43
7000	69	61	55	50
8000	79	69	63	57
9000	89	78	71	64
10000	98	87	79	71
11000	108	95	87	78
12000	118	104	94	85
13000	128	113	102	92
14000	138	121	110	99
15000	148	130	118	106
16000	157	139	126	113
17000	167	147	134	120
18000	177	156	142	128
19000	187	165	150	135
20000	197	173	157	142
21000	207	182	165	149
22000	217	191	173	156
23000	226	199	181	163
24000	236	208	189	170
25000	246	217	197	177
26000	256	225	205	184
27000	266	234	213	191
28000	276	243	220	198

mm/min

Cutting depth up to	3.2mm	4.76mm	6.35mm	7.93mm
Rotation speed RPM				
6000	1500	1320	1200	1080
7000	1750	1540	1400	1260
8000	2000	1760	1600	1440
9000	2250	1980	1800	1620
10000	2500	2200	2000	1800
11000	2750	2420	2200	1980
12000	3000	2640	2400	2160
13000	3250	2860	2600	2340
14000	3500	3080	2800	2520
15000	3750	3300	3000	2700
16000	4000	3520	3200	2880
17000	4250	3740	3400	3060
18000	4500	3960	3600	3240
19000	4750	4180	3800	3420
20000	5000	4400	4000	3600
21000	5250	4620	4200	3780
22000	5500	4840	4400	3960
23000	5750	5060	4600	4140
24000	6000	5280	4800	4320
25000	6250	5500	5000	4500
26000	6500	5720	5200	4680
27000	6750	5940	5400	4860
28000	7000	6160	5600	5040

For Cutting

- Acrylic Stone
- Carbon Fiber
- Corian
- Hard Wood
- HDPE
- King Starboard®/ Marine Building Material
- Laminated Materials
- MDF
- PCB Board
- Phenolic
- Plastics & Plexiglas®
- Poly (Methyl Methacrylate) (PMMA)
- Soft Wood
- Solid Surface
- Veneers

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:** IPM / (RPM x # of Flutes)

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