IN-GROOVE™
CNC INSERT ENGRAVING SYSTEM

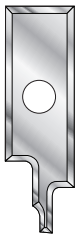
1 Flute Straight & Core Box

RPM & Feed Rate Chart


RC-1075


RC-1076


67127 5004





Straight
4 Sizes Available





Core Box
4 Sizes Available

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)

inch/min

Cutting depth up to	1/8"	3/16"	1/4"	5/16"
Rotation speed RPM				
6000	24	31	35	43
7000	28	36	41	50
8000	31	41	47	57
9000	35	46	53	64
10000	39	51	59	71
11000	43	56	65	78
12000	47	61	71	85
13000	51	67	77	92
14000	55	72	83	99
15000	59	77	89	106
16000	63	82	94	113
17000	67	87	100	120
18000	71	92	106	128
19000	75	97	112	135
20000	79	102	118	142
21000	83	107	124	149
22000	87	113	130	156
23000	91	118	136	163
24000	94	123	142	170
25000	98	128	148	177
26000	102	133	154	184
27000	106	138	159	191
28000	110	143	165	198

mm/min

Cutting depth up to	3.2mm	4.76mm	6.35mm	7.93mm
Rotation speed RPM				
6000	600	780	900	1080
7000	700	910	1050	1260
8000	800	1040	1200	1440
9000	900	1170	1350	1620
10000	1000	1300	1500	1800
11000	1100	1430	1650	1980
12000	1200	1560	1800	2160
13000	1300	1690	1950	2340
14000	1400	1820	2100	2520
15000	1500	1950	2250	2700
16000	1600	2080	2400	2880
17000	1700	2210	2550	3060
18000	1800	2340	2700	3240
19000	1900	2470	2850	3420
20000	2000	2600	3000	3600
21000	2100	2730	3150	3780
22000	2200	2860	3300	3960
23000	2300	2990	3450	4140
24000	2400	3120	3600	4320
25000	2500	3250	3750	4500
26000	2600	3380	3900	4680
27000	2700	3510	4050	4860
28000	2800	3640	4200	5040

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