

Feed & Speed Charts for Solid Carbide Spirals

Feed Rate = RPM x Number of Flutes x Chip Load

RPM = Feed Rate / (Number of Flutes x Chip Load)

Chip Load = Feed Rate (Inches Per Minute) / (RPM x Number of Flutes)

Feed Rate Chart Using Solid Carbide Routers in Wood

**Based on 1/2" Diameter Tool, Cutting 3/4" Stock at 18,000 RPM*

All Figures Are Shown As IPM (Inches Per Minute)

Note: For smaller diameters than reference in the charts - Reduce feed rate

For larger diameters - Increase feed rate

Information below should be used as a guideline - results may vary

P/N Begins With:	Wood Composites	Hardwoods	Softwoods
RIV-110	400	325	275
RIV-120	400	350	300
RIV-150	400	300	275
RIV-160	400	325	300
RIV-205	425	350	325
RIV-215	425	375	325
RIV-225	400	375	325
RIV-235	425	400	350
RIV-250	600	400	450
RIV-265	650	450	500
RIV-275	700	500	550
RIV-300	650	450	500
RIV-390	575	600	625
RIV-400	600	625	650
RIV-410	550	550	475
RIV-420	550	575	500
RIV-430	550	575	600
RIV-440	550	600	625
RIV-450	550	550	475
RIV-460	550	575	500
RIV-495	1000	800	850
RIV-500	1000	800	850

Feed Rate Chart Using Solid Carbide Routers In Plastics

**Based on 1/4" Diameter Tool, Cutting 1/4" Stock at 18,000 RPM*
Information below should be used as a guideline - results may vary

P/N Begins With:	Soft Plastics	Hard Plastics
RIV-130	250	225
RIV-140	275	250
RIV-170	275	250
RIV-180	300	275
RIV-540	350	300
RIV-550	300	275
RIV-560	225	200
RIV-570	250	200
RIV-590	250	225
RIV-610	275	250