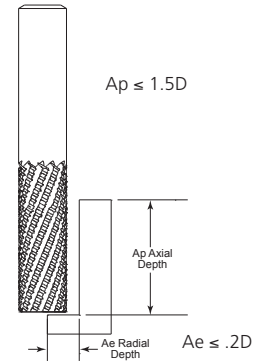
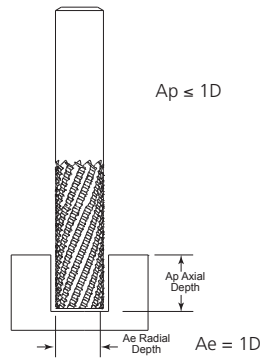


Diamond Coated Routers

239 Series Recommended Cutting Data - Inch



Finishing Slotting 300 (SFM)			Roughing Slotting 600 (SFM)		
Tool Diameter	RPM	IPM	Tool Diameter	RPM	IPM
1/8	9000	10	1/8	18000	20
3/16	6000	12	3/16	12000	25
1/4	5000	15	1/4	9000	30
5/16	4000	18	5/16	7000	35
3/8	3000	20	3/8	6000	40
1/2	2000	25	1/2	5000	50

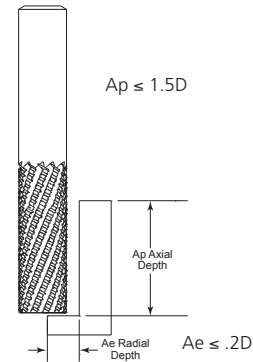
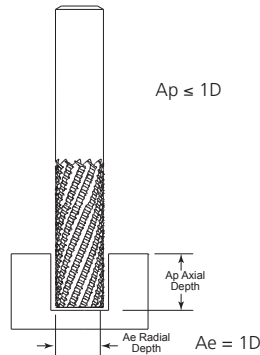
Feed adjustment to part thickness	
≤ 0.5D	x 150%
0.5D - 1D	x 120%
1D - 2D	x 80%
3D-4D	x 50%

Finishing Side Milling 400 (SFM)			Roughing Side Milling 800 (SFM)		
Tool Diameter	RPM	IPM	Tool Diameter	RPM	IPM
1/8	12000	20	1/8	24000	40
3/16	8000	25	3/16	16000	50
1/4	6000	30	1/4	12000	60
5/16	5000	35	5/16	10000	70
3/8	4000	40	3/8	8000	80
1/2	3000	50	1/2	6000	100

** Tool must have end grind to slot.

Note: The parameters in this table are for common material thickness of 1/4". You must use the Radial Depth (Ae) of 20% or less for Side Milling. For best surface finish conventional mill is recommended. Higher feed rates are possible but surface finish may change.

239 Series Recommended Cutting Data - Metric



Finishing Slotting 90 (m/min)			Roughing Slotting 180 (m/min)		
Tool Diameter	RPM	mm/min	Tool Diameter	RPM	mm/min
3	9000	254	3	18000	508
5	6000	304	5	12000	635
6	5000	381	6	9000	762
8	4000	457	8	7000	889
10	3000	508	10	6000	1016
12	2000	635	12	5000	1270

Feed adjustment to part thickness	
≤ 0.5D	x 150%
0.5D - 1D	x 120%
1D - 2D	x 80%
3D-4D	x 50%

Finishing Side Milling 120 (m/min)			Roughing Side Milling 240 (m/min)		
Tool Diameter	RPM	mm/min	Tool Diameter	RPM	mm/min
3	12000	508	3	24000	1016
5	8000	635	5	16000	1270
6	6000	762	6	12000	1524
8	5000	889	8	10000	1778
10	4000	1016	10	8000	2032
12	3000	1270	12	6000	2540

** Tool must have end grind to slot.

Note: The parameters in this table are for common material thickness of 6mm. You must use the Radial Depth (Ae) of 20% or less for Side Milling. For best surface finish conventional mill is recommended. Higher feed rates are possible but surface finish may change.

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.