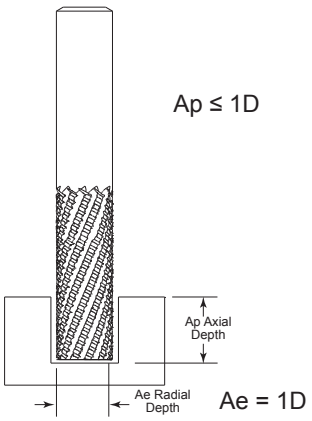
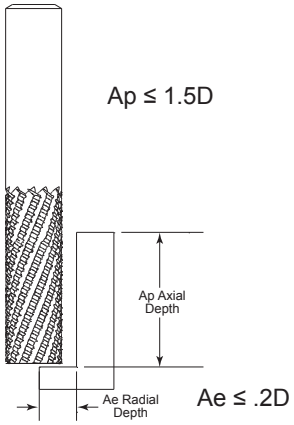
Routers
Series 239

Recommended Cutting Data - Inch





Finishing Slotting 300 (SFM)		
Tool Diameter	RPM	IPM
1/8	9000	10
3/16	6000	12
1/4	5000	15
5/16	4000	18
3/8	3000	20
1/2	2000	25

Roughing Slotting 600 (SFM)		
Tool Diameter	RPM	IPM
1/8	18000	20
3/16	12000	25
1/4	9000	30
5/16	7000	35
3/8	6000	40
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%

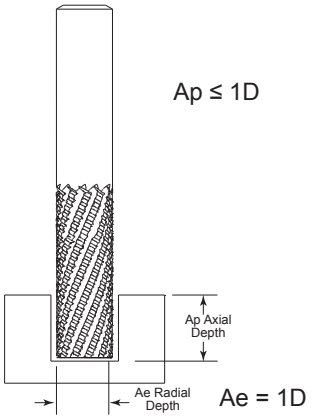
Finishing Side Milling 400 (SFM)		
Tool Diameter	RPM	IPM
1/8	12000	20
3/16	8000	25
1/4	6000	30
5/16	5000	35
3/8	4000	40
1/2	3000	50

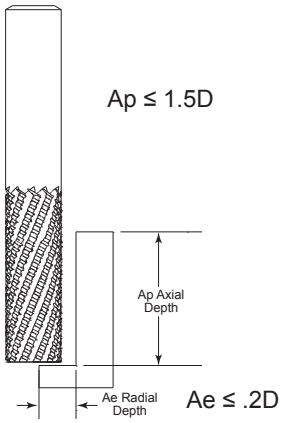
Roughing Side Milling 800 (SFM)		
Tool Diameter	RPM	IPM
1/8	24000	40
3/16	16000	50
1/4	12000	60
5/16	10000	70
3/8	8000	80
1/2	6000	100

** 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.

Recommended Cutting Data - Metric





Finishing Slotting 90 (m/min)		
Tool Diameter	RPM	mm/ min
3	9000	254
5	6000	304
6	5000	381
8	4000	457
10	3000	508
12	2000	635

Roughing Slotting 180 (m/min)		
Tool Diameter	RPM	mm/ min
3	18000	508
5	12000	635
6	9000	762
8	7000	889
10	6000	1016
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)		
Tool Diameter	RPM	mm/ min
3	12000	508
5	8000	635
6	6000	762
8	5000	889
10	4000	1016
12	3000	1270

Roughing Side Milling 240 (m/min)		
Tool Diameter	RPM	mm/ min
3	24000	1016
5	16000	1270
6	12000	1524
8	10000	1778
10	8000	2032
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.