

## Routing Feed & Speed Chart for

### Series 2300 Chipbreaker Routers

Standard Flute Length and Extended Flute Length Designs

(Note: Chart is based on 60K RPM Spindle Capability. Please use maximum spindle speed if listed RPM is unattainable)

Size	Diameter	Table Feed Rate	Speed	Plunge Feed	Z-Axis Offset
	(inch)	(Inches/min)	(k-rpm)	(inches/min)	(inches)
0.80mm	0.0315	15	60	20	-0.020
0.90mm	0.0354	15	55	20	-0.020
1.00mm	0.0394	20	55	20	-0.020
1.10mm	0.0433	25	50	25	-0.020
1.20mm	0.0472	30	47	25	-0.025
1.27mm	0.0500	35	46	25	-0.025
1.30mm	0.0512	35	45	25	-0.025
1.40mm	0.0551	35	40	25	-0.025
1.50mm	0.0591	35	38	25	-0.030
1/16"	0.0625	40	36	25	-0.030
1.60mm	0.0630	40	36	25	-0.030
1.70mm	0.0669	40	34	25	-0.030
1.80mm	0.0709	40	34	25	-0.035
1.90mm	0.0748	40	30	25	-0.035
2.00mm	0.0787	40	27	25	-0.035
2.10mm	0.0827	40	27	25	-0.040
2.20mm	0.0866	40	25	25	-0.040
2.30mm	0.0906	40	25	25	-0.040
3/32"	0.0938	40	24	25	-0.045
2.40mm	0.0945	40	24	25	-0.045
2.50mm	0.0984	40	22	25	-0.050
2.55mm	0.1004	40	22	25	-0.050
3.00mm	0.1181	40	20	25	-0.055
3.10mm	0.1220	40	20	25	-0.060
3.175mm	0.1250	40	20	25	-0.060

In some cases, there may be an opportunity to increase Table Feed Rates based on the application's robustness. Variables such as machine technology and condition, stack height, and material type may allow higher throughput. Conversely, if the application is not robust due to critical dimensions, internal cuts, or similar, Table Feed Rate should be reduced. Consult your regional Tycom Applications Engineer for recommendations.