



Routing Feed & Speed Chart for

Series 4100 Cross Cut 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 |
|---------|---------------|---------------------|----------------|---------------------|-----------------|
| | <i>(inch)</i> | <i>(Inches/min)</i> | <i>(k-rpm)</i> | <i>(inches/min)</i> | <i>(inches)</i> |
| 0.80mm | 0.0315 | 20 | 60 | 20 | -0.020 |
| 0.90mm | 0.0354 | 25 | 60 | 20 | -0.020 |
| 1.00mm | 0.0394 | 30 | 58 | 20 | -0.020 |
| 1.10mm | 0.0433 | 30 | 53 | 25 | -0.020 |
| 1.20mm | 0.0472 | 35 | 49 | 25 | -0.025 |
| 1.27mm | 0.0500 | 35 | 46 | 25 | -0.025 |
| 1.30mm | 0.0512 | 40 | 45 | 25 | -0.025 |
| 1.40mm | 0.0551 | 40 | 42 | 25 | -0.025 |
| 1.50mm | 0.0591 | 40 | 39 | 25 | -0.030 |
| 1/16" | 0.0625 | 40 | 37 | 25 | -0.030 |
| 1.60mm | 0.0630 | 40 | 36 | 25 | -0.030 |
| 1.70mm | 0.0669 | 45 | 34 | 25 | -0.030 |
| 1.80mm | 0.0709 | 45 | 32 | 25 | -0.035 |
| 1.90mm | 0.0748 | 45 | 31 | 25 | -0.035 |
| 2.00mm | 0.0787 | 45 | 29 | 25 | -0.035 |
| 2.10mm | 0.0827 | 45 | 28 | 25 | -0.040 |
| 2.20mm | 0.0866 | 45 | 26 | 25 | -0.040 |
| 2.30mm | 0.0906 | 50 | 25 | 25 | -0.040 |
| 3/32" | 0.0938 | 50 | 24 | 25 | -0.045 |
| 2.40mm | 0.0945 | 50 | 24 | 25 | -0.045 |
| 2.50mm | 0.0984 | 50 | 23 | 25 | -0.050 |
| 2.55mm | 0.1004 | 50 | 23 | 25 | -0.050 |
| 3.00mm | 0.1181 | 50 | 19 | 25 | -0.055 |
| 3.10mm | 0.1220 | 50 | 19 | 25 | -0.060 |
| 3.175mm | 0.1250 | 50 | 18 | 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 Kyocera Tycom Applications Engineer for recommendations.