

## Series 4100 Cross Cut Routers

Standard Flute Length and Extended Flute Length Designs

Router Size	Diameter (inch)	Feed (inch/min)	Speed (k-rpm)	Plunge Feed (inch/min)	Z-Axis Offset (inches)
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 Precision Tools Applications Engineer for recommendations.

Note: This information is based on **60K RPM** Spindle Capability. Please use maximum spindle speed if listed RPM is unattainable

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