

Wood Router Material Usage and Feed Rates

Based on 18,000 RPM Feed Rate in "Inches" per minute

Tool Description	Soft Woods	Hard Woods	Soft Plywood	Hard Plywood Board	Particle Board	Laminate Particle Plastics	Laminate Plywood Plastics	Soft Ductile Plastics	Hard Brittle Material	Fiber Reinforced Material	Solid Surface	Plastic Laminated	Aluminum
1 FLUTE ROUTERS													
Straight "V" Flute	100-300	100-250	100-250	100-250	100-250								
Straight "O" Flute	100-300							350	300				
Straight "O" Flute (Soft or Hard Plastics)								350	300				
Upcut Spiral	150-300	150-300			150-300								
"O" Flute Upcut Spiral (Soft Plastics)									200		100-180		
Upcut Spiral (Hard Plastics & Aluminum)										100			150
"O" Flute Downcut Spiral (Hard Plastics)								150	150		150-180		
Downcut Spiral	150-300	150-300			150-300								
"O" Flute Downcut Spiral (Hard Plastics)	150-300	150-300			150-300								
Downcut Spiral (Hard Plastics & Aluminum)										150			100
"O" Flute Downcut Spiral (Soft Plastics)								150	150		100-180		
Compression Spiral	100-600	100-600	100-600	100-600	100-500	100-600	100-600						
Mortise (Compression Spiral)	100-600	100-600	100-600	100-600	100-500	100-600	100-600						
2 FLUTE ROUTERS													
Straight Cut (Natural Wood & Hard Plastics)	200-400	200-400	200-400	200-400	200-400								
Straight Cut (Hard Plastics)									250	150			
"O" Flute Straight Cut (Soft Plastics)									250	150	150-200		
"O" Flute Straight Cut (Hard Plastics)									250	150	150-200		
Upcut Spiral	200-450	200-400			200-450			200			150-200		
Upcut Spiral (Hard Plastics & Aluminum)										150	150-200		150
Upcut Spiral (High Impact)	200-450	200-400			200-450								
"O" Flute Upcut Slow Spiral (Soft & Hard Plastics)								275	250		150		
Upcut Spiral Chipbreaker Finisher	400-1500	400-1200	400-1400	400-1200	400-1000								
Upcut Spiral Chipbreaker Finisher (High Impact)	400-1500	400-1200	400-1400	400-1200	400-1000								
Downcut Spiral	200-450	200-400			200-450						150-200		
Downcut Spiral (Hard Plastic & Aluminum)										150	150-200		150
Downcut Slow Spiral (Hard Plastic & Aluminum)								300	275		150		
Downcut Spiral (High Impact)	200-450	200-400			200-450								
Downcut Spiral Chipbreaker Finisher	400-1500	400-1200	400-1400	400-1200	400-1000								
Downcut Spiral Chipbreaker Finisher (High Impact)	400-1500	400-1200	400-1400	400-1200	400-1000								
Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Chipbreaker Finisher Compression	400-1500	400-1200	400-1400	400-1200	400-1000	400-1400	400-1200						
Compression (High Wear)	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						



Material Usage and Feed Rates Continued

Based on 18,000 RPM Feed Rate in "Inches" per minute

Tool Description	Soft Woods	Hard Woods	Soft Plywood	Hard Plywood Board	Particle Board	Laminate Particle Plastics	Laminate Plywood Plastics	Soft Ductile Plastics	Hard Brittle Material	Fiber Reinforced Material	Solid Surface	Plastic Laminated	Aluminum
3 FLUTE ROUTERS													
Upcut Slow Spiral Finisher	200-600	200-500			200-500				300		100-300		
Downcut Slow Spiral Finisher (Soft Plastics)	200-600	200-500			200-500				300		100-300		
Upcut Spiral Chipbreaker Finisher	500-1600	500-1500	700-1800	700-1600	600-1200								
Downcut Spiral Chipbreaker Finisher	500-1600	500-1500	700-1800	700-1600	600-1201								
Upcut Spiral (Hard Plastics)										150			
Upcut Spiral Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Upcut Spiral High Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Upcut Spiral Hogger (High Impact)	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Spiral (Hard Plastics)										150			
Downcut Slow Spiral Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Slow Spiral High Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Spiral Hogger (High Impact)	700-1200	700-1200	700-1500	700-1500	600-1500								
Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Compression (High Wear)	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Mortise Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						

4 FLUTE ROUTERS													
Upcut Spiral (Hard Plastics)										100-300			
Upcut Combination Spiral (High Speed)	1000-1800	1000-1800	1200-3000	1200-2800	1000-2000								
Downcut Spiral (Hard Plastics)										150			
Downcut Combination Spiral (High Speed)	1000-1800	1000-1800	1200-3000	700-2200	1200-2800								
Compression	500-1600	500-1500	700-2400	700-2200	600-1800	700-2400	700-2200						
Combination Compression	1000-1800	1000-1800	1200-3000	1200-2800	1000-2000	1200-3000	1200-2800						
Mortise Compression	800-1600	500-1500	700-2400	700-2200	600-1600	700-2400	700-2200						
SPECIALTY TOOLS													
Diamond Burr Fiberglass Finisher (Hard Plastics)										125			
2 Flute Diamond Burr Fiberglass Finisher (Hard Plastics)										125			
Flush Trim Laminate Bit (Plastic Laminate)										hand feed			
7° Bevel Laminate Bit (Plastic Laminate)										hand feed			