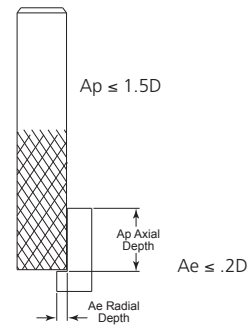
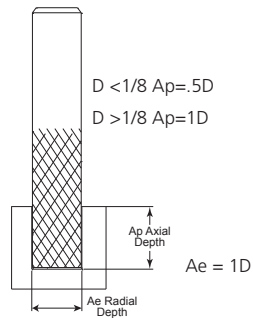


Diamond Grind Routers

230 / 231 / 231B / 231D / 231F Series Recommended Cutting Data - Inch



Slotting 300 (SFM)		
Tool Diameter	RPM	IPM
1/32	36000	29
3/64	24000	24
1/16	18000	27
3/32	12000	24
1/8	9100	22
3/16	6100	18
1/4	4500	16
5/16	3600	14

Slotting 600 (SFM)		
Tool Diameter	RPM	IPM
1/32	73000	58
3/64	48000	48
1/16	36000	54
3/32	24000	48
1/8	18000	45
3/16	12000	36
1/4	9000	32
5/16	7000	28

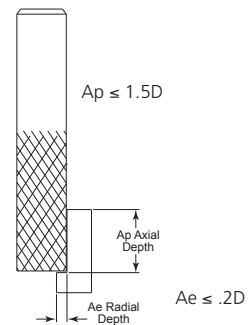
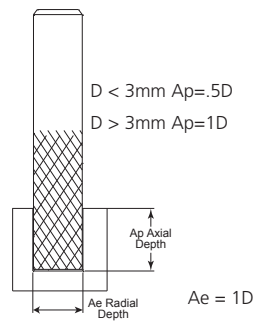
Side Milling 400 (SFM)		
Tool Diameter	RPM	IPM
1/32	48000	39
3/64	32000	32
1/16	24000	36
3/32	16000	32
1/8	12000	30
3/16	8100	24
1/4	6100	21
5/16	4800	19

Side Milling 900 (SFM)		
Tool Diameter	RPM	IPM
1/32	90000	72
3/64	73000	73
1/16	55000	83
3/32	36000	72
1/8	27000	68
3/16	18000	54
1/4	13000	46
5/16	11000	44

** Tool must have end grind in order 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



Slotting 90 (m/min)		
Tool Diameter	RPM	mm/min
0.8	35000	141
1	28000	226
1.2	23000	306
1.5	18000	376
1.6	17000	388
2	14000	423
2.4	11000	447
3	9400	480
5	5600	395
6	4700	423
8	3500	353

Slotting 182 (m/min)		
Tool Diameter	RPM	mm/min
0.8	72000	289
1	57000	463
1.2	48000	627
1.5	38000	771
1.6	36000	795
2	28000	868
2.4	24000	916
3	19000	984
5	11000	810
6	9600	868
8	7200	723

Side Milling 120(m/min)		
Tool Diameter	RPM	mm/min
0.8	47000	190
1	38000	305
1.2	31000	413
1.5	25000	508
1.6	23000	524
2	19000	572
2.4	15000	604
3	12000	648
5	7600	534
6	6300	572
8	4700	477

Side Milling 240 (m/min)		
Tool Diameter	RPM	mm/min
0.8	95000	381
1	76000	610
1.2	63000	826
1.5	50000	1017
1.6	47000	1049
2	38000	1145
2.4	31000	1208
3	25000	1297
5	15000	1068
6	12000	1145
8	9500	954

** Tool must have end grind in order 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.