



Series 21, 22 Fractional			Vc (SFM)		Diameter (D ₁) (inch)				
	Ae x D ₁	Ap x D ₁			1/8	1/4	3/8	1/2	3/4
HARDWOODS	Slot 	1 ≤ 1	1550	RPM	47368	23684	15789	11842	7895
			(1240-1860)	Fz	0.0008	0.0015	0.0025	0.0030	0.0045
				Feed (IPM)	76	71	79	71	71
	Profile 	≤ 0.5 ≤ 1.5	1550	RPM	47368	23684	15789	11842	7895
			(1240-1860)	Fz	0.0008	0.0015	0.0025	0.0030	0.0045
				Feed (IPM)	76	71	79	71	71
SOFTWOODS	Slot 	1 ≤ 1	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0010	0.0020	0.0030	0.0035	0.0055
				Feed (IPM)	119	119	119	104	109
	Profile 	≤ 0.5 ≤ 1.5	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0010	0.0020	0.0030	0.0035	0.0055
				Feed (IPM)	119	119	119	104	109
PLYWOODS	Slot 	1 ≤ 1	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0013	0.0025	0.0040	0.0050	0.0075
				Feed (IPM)	155	149	159	149	149
	Profile 	≤ 0.5 ≤ 1.5	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0013	0.0025	0.0040	0.0050	0.0075
				Feed (IPM)	155	149	159	149	149
N ALUMINUM ALLOYS	Slot 	1 ≤ 1	1150	RPM	35144	17572	11715	8786	5857
			(920-1380)	Fz	0.0006	0.0015	0.0020	0.0025	0.0040
				Feed (IPM)	42	53	47	44	47
	Profile 	≤ 0.5 ≤ 1.5	1150	RPM	35144	17572	11715	8786	5857
			(920-1380)	Fz	0.0006	0.0015	0.0020	0.0025	0.0040
				Feed (IPM)	42	53	47	44	47
PLASTICS	Slot 	1 ≤ 1	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0008	0.0017	0.0025	0.0035	0.0050
				Feed (IPM)	95	101	99	104	99
	Profile 	≤ 0.5 ≤ 1.5	1950	RPM	59592	29796	19864	14898	9932
			(1560-2340)	Fz	0.0008	0.0017	0.0025	0.0035	0.0050
				Feed (IPM)	95	101	99	104	99

rpm = sfm x 3.82 / D₁
ipm = (inch / flute) x 2 x rpm