COREHOG®

Speeds & Feeds

Product Table: Diamond Cut Routers - Burr End Style

Material	SFM	IPT by Cutter Diameter				Depth of Cut	
		.250	.313	.375	.500	Radial	Axial
Carbon, Carbon Graphite, Unfilled Plastics	1600-3200	.0033	.0043	.0053	.0073	N/A	1x Dia
Composites	Dia<.375":1200-2800 Dia≥.375": 1600-3200	.0014	.0029	.0043	.006	N/A	1x Dia
Fiberglass Filled Plastics	Dia<.375":1200-2800 Dia≥.375":1600-3200	.0014	.0029	.0043	.006	N/A	1x Dia
Green Ceramic, Green Carbide	800-1600	.0023	.0033	.0043	.006	N/A	1x Dia

Product Notes:

For 2x diameter axial depth of cut reduce feed rate by 25%. For 3x diameter axial depth of cut reduce feed rate by 50%.

Radial depth of cut not posted as deburring is typically done in one pass.

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **833-584-3448** or **corehogtech@harveyperformance.com**.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.