

Router Bit Operation Parameter Chart

| Diameter | | Spindle Speed | Feed / Table Speed | |
|----------|--------|---------------|--------------------|------|
| mm | inch | KRPM | MPM | IPM |
| 0.8 | 0.0315 | 40 | 0.64 | 25.2 |
| 0.9 | 0.0354 | 36 | 0.65 | 25.6 |
| 1.0 | 0.0394 | 32 | 0.64 | 25.2 |
| 1.1 | 0.0433 | 32 | 0.70 | 27.6 |
| 1.2 | 0.0472 | 32 | 0.77 | 30.3 |
| 1.3 | 0.0512 | 31 | 1.01 | 39.8 |
| 1.4 | 0.0551 | 31 | 1.09 | 42.9 |
| 1.5 | 0.0591 | 30 | 1.13 | 44.5 |
| 1.6 | 0.0630 | 30 | 1.20 | 47.2 |
| 1.7 | 0.0669 | 29 | 1.48 | 58.3 |
| 1.8 | 0.0709 | 29 | 1.57 | 61.8 |
| 1.9 | 0.0748 | 29 | 1.65 | 65.0 |
| 2.0 | 0.0787 | 28 | 2.02 | 79.5 |
| 2.1 | 0.0827 | 27 | 2.04 | 80.3 |
| 2.2 | 0.0866 | 25 | 1.98 | 78.0 |
| 2.3 | 0.0906 | 24 | 1.99 | 78.3 |
| 2.4 | 0.0945 | 23 | 1.99 | 78.3 |
| 2.5 | 0.0984 | 22 | 1.98 | 78.0 |
| 2.6 | 0.1024 | 21 | 1.97 | 77.6 |
| 2.7 | 0.1063 | 21 | 2.04 | 80.3 |
| 2.8 | 0.1102 | 20 | 2.02 | 79.5 |
| 2.9 | 0.1142 | 19 | 1.98 | 78.0 |
| 3.0 | 0.1181 | 19 | 2.05 | 80.7 |
| 3.1 | 0.1220 | 18 | 2.01 | 79.1 |
| 3.175 | 0.1250 | 18 | 2.06 | 81.1 |

