		Cutting Tool	Feed Rate (inch/min)	Plunge Rate (inch/min)	Stepover (inch)	Stepdown - Slotting (inch)	Stepdown - Pocketing (inch)	Router Speed (RPM)	Makita Speed Dial Setting
	-				V-bits				
	Jee	90, 60 Degree V-bit - V-Carving	88	30	0.07	0.42	0.92	22000	4
	ar S	30, 90, 60 Degree V-bit - Fine Detail/Engraving	44	15	0.07	0.42	0.92	22000	4
	Carving/Detailing - Regular Speed			Tapere	d Ball End Mi	ills			
	- &	1/4" - D1/16" Tapered Ball End Mill - Coarse	125	62	0.009	N/A	1	28500	6
	. 8	1/4" - D1/16" Tapered Ball End Mill - Fine	150	50	0.003	N/A	1	28500	6
	ta Eiii	1/8" - D0.5mm Tapered Ball End Mill - Coarse	79	39	0.006	N/A	0.5	28500	6
) Oe	1/8" - D0.5mm Tapered Ball End Mill - Fine	143	72	0.0016	N/A	0.5	28500	6
	ing			Ba	III End Mills				
	<u> </u>	1/4" Ball End Mill - Finishing	110	55	0.012	0.16	1	22000	4
		1/8" Ball End Mill - Finishing	81	41	0.006	0.21	1	27000	5
		•							
					End Mills				
		1/4" Single Flute Flat End Mill UC	64	32	0.11	0.11	0.24	17000	3
		1/4" Flat End Mill UC	65	33	0.11	0.11	0.24	12000	2
	ing	1/4" Flat End Mill DC	65	33	0.11	0.11	0.24	12000	2
	Ħ	1/4" Ball End Mill	65	33	0.11	0.11	0.24	12000	2
	Ë	1/8" Single Flute Flat End Mill UC	41	21	0.06	0.17	0.37	22000	4
	Reduced Speed - Finishing, or mild cutting	1/8" Flat End Mill UC	64	32	0.06	0.11	0.24	17000	3
	, g	1/8" Flat End Mill DC	64	32	0.06	0.11	0.24	17000	3
	shir	1/8" Ball End Mill	64	32	0.06	0.11	0.24	17000	3
	Ë	1/16" Flat End Mill UC	34	17	0.08	0.11	0.24	17000	3
		1/16" Flat End Mill DC	34	17	0.03	0.10	0.23	17000	3
	bee								
	S D	1/16" Corncob End Mill	34	17	0.03	0.10	0.23	17000	3
	3	22mm Surfacing Bit	61	31	0.35	0.016	0.04	17000	3
	Rec				d Groove Bit				
		1/2" Round Groove Bit	34	17	0.22	0.13	0.28	17000	3
		3/4" Round Groove Bit	34	17	0.34	0.09	0.19	17000	3
		1" Round Groove Bit	34	17	0.45	0.06	0.14	17000	3
· ·									
					End Mills				
		1/4" Single Flute Flat End Mill UC	85	43	0.11	0.16	0.36	17000	3
		1/4" Flat End Mill UC	86	43	0.11	0.16	0.36	12000	2
		1/4" Flat End Mill DC	86	43	0.11	0.16	0.36	12000	2
		1/4" Ball End Mill	86	43	0.11	0.16	0.36	12000	2
		1/8" Single Flute Flat End Mill UC	55	28	0.06	0.25	0.55	22000	4
	20	1/8" Flat End Mill UC	85	43	0.06	0.16	0.36	17000	3
	Regular Speed	1/8" Flat End Mill DC	85	43	0.06	0.16	0.36	17000	3
	a S	1/8" Ball End Mill	85	43	0.06	0.16	0.36	17000	3
	lnge	1/16" Flat End Mill UC	43	21	0.03	0.16	0.37	17000	3
	ž	1/16" Flat End Mill DC	43	21	0.03	0.16	0.37	17000	3
		1/16" Corncob End Mill	43	21	0.03	0.16	0.37	17000	3
		22mm Surfacing Bit	81	41	0.35	0.02	0.06	17000	3
•				Rour	d Groove Bit	s			
		1/2" Round Groove Bit	41	20	0.22	0.35	0.78	17000	3
		3/4" Round Groove Bit	51	26	0.34	0.19	0.42	17000	3
		1" Round Groove Bit	51	26	0.45	0.14	0.31	17000	3
The same of the sa					End Mills				
		1/4" Single Flute Flat End Mill UC	106	53	0.11	0.22	0.48	17000	3
		1/4" Flat End Mill UC	108	54	0.11	0.21	0.48	12000	2
	ting	1/4" Flat End Mill DC	108	54	0.11	0.21	0.48	12000	2
	cut	1/4" Ball End Mill	108	54	0.11	0.21	0.48	12000	2
	<u>š</u>	1/8" Single Flute Flat End Mill UC	69	35	0.06	0.33	0.73	22000	4
	ress	1/8" Flat End Mill UC	106	53	0.06	0.22	0.48	17000	3
	988	1/8" Flat End Mill DC	106	53	0.06	0.22	0.48	17000	3
	9	1/8" Ball End Mill	106	53	0.06	0.22	0.48	17000	3
	ing	1/16" Flat End Mill UC	53	27	0.03	0.22	0.49	17000	3
	lgno								
	- 8	1/16" Flat End Mill DC	53	27	0.03	0.22	0.49	17000	3
	e d	1/16" Corncob End Mill	53	27	0.03	0.22	0.49	17000	3
	9	22mm Surfacing Bit	102	51	0.35	0.03	0.08	17000	3
	ᄷ			Rour	d Groove Bits	5			
	Full Sp	1/01/0				0.55	0.15	45000	_
	Full Speed - Roughing or aggressive cutting	1/2" Round Groove Bit	51	26	0.22	0.28	0.63	17000	3
	Full St	1/2" Round Groove Bit 3/4" Round Groove Bit 1" Round Groove Bit	51 51 51			0.28 0.19 0.14	0.63 0.42 0.31	17000 17000 17000	3 3 3

		Cutting Tool	Feed Rate (inch/min)	Plunge Rate (inch/min)	Stepover (inch)	Stepdown - Slotting (inch)	Stepdown - Pocketing (inch)	Router Speed (RPM)	Makita Speed Dial Setting
	_				V-bits				
	Carving/Detailing - Regular Speed	90, 60 Degree V-bit - V-Carving	68	23	0.07	0.25	0.56	17000	3
	S.	30, 90, 60 Degree V-bit - Fine Detail/Engraving	44	15	0.07	0.39	0.86	22000	4
	E E			Tapere	d Ball End Mi	ills			
	Reg	1/4" - D1/16" Tapered Ball End Mill - Roughing	125	62	0.009	N/A	1	28500	5
	- 8	1/4" - D1/16" Tapered Ball End Mill - Finishing	150	75	0.003	N/A	1	28500	5
		1/8" - D0.5mm Tapered Ball End Mill - Roughing	51	25	0.006	N/A	0.5	28500	5
	Det	1/8" - D0.5mm Tapered Ball End Mill - Finishing	143	72	0.0016	N/A	0.5	28500	5
	ng/			Ba	II End Mills				
	a Z	1/4" Ball End Mill - Finishing	110	55	0.012	0.075	1.0	22000	4
	Ü	1/8" Ball End Mill - Finishing	81	41	0.006	0.1	1.0	27000	5
						· · · · · · · · · · · · · · · · · · ·			
					End Mills				
		1/4" Single Flute Flat End Mill UC	64	32	0.11	0.11	0.24	17000	3
		1/4" Flat End Mill UC	65	33	0.11	0.11	0.24	12000	2
	ti g	1/4" Flat End Mill DC	65	33	0.11	0.11	0.24	12000	2
	C E	1/4" Ball End Mill	65	33	0.11	0.11	0.24	12000	2
	Reduced Speed - Finishing, or mild cutting	1/8" Single Flute Flat End Mill UC	41	21	0.06	0.17	0.37	22000	4
	or n	1/8" Flat End Mill UC	64	32	0.06	0.11	0.24	17000	3
	ng, c	1/8" Flat End Mill DC	64	32	0.06	0.11	0.24	17000	3
	ishii	1/8" Ball End Mill	64	32	0.06	0.11	0.24	17000	3
	듄	1/16" Flat End Mill UC	34	17	0.03	0.10	0.24	17000	3
	- pa	1/16" Flat End Mill DC	34	17	0.03	0.10	0.24	17000	3
) be	1/16" Corncob End Mill	34	17	0.03	0.10	0.24	17000	3
	8	22mm Surfacing Bit	61	31	0.35	0.016	0.04	17000	3
	onpa				d Groove Bits		0.0 1	27000	
	2	1/2" Round Groove Bit	31	15	0.22	0.07	0.15	17000	3
		3/4" Round Groove Bit	34	17	0.34	0.04	0.09	17000	3
		1" Round Groove Bit	31	15	0.45	0.03	0.07	17000	3
					End Mills				
		1/4" Single Flute Flat End Mill UC	85	43	0.11	0.07	0.17	17000	3
		1/4" Flat End Mill UC	86	43	0.11	0.07	0.17	12000	2
		1/4" Flat End Mill DC	86	43	0.11	0.07	0.17	12000	2
		1/4" Ball End Mill	86	43	0.11	0.07	0.17	12000	2
		1/8" Single Flute Flat End Mill UC	55	28	0.06	0.12	0.26	22000	4
	_	1/8" Flat End Mill UC	85	43	0.06	0.07	0.17	17000	3
	996	1/8" Flat End Mill DC	85	43	0.06	0.07	0.17	17000	3
	Regular Speed	1/8" Ball End Mill	85	43	0.06	0.07	0.17	17000	3
	E E	1/16" Flat End Mill UC	43	21	0.03	0.07	0.17	17000	3
	Reg	1/16" Flat End Mill DC	43	21	0.03	0.07	0.17	17000	3
Au		1/16" Corncob End Mill	43	21	0.03	0.07	0.17	17000	3
		22mm Surfacing Bit	81	41	0.35	0.012	0.028	17000	3
					d Groove Bit				
		1/2" Round Groove Bit	41	20	0.22	0.17	0.37	17000	3
		3/4" Round Groove Bit	51	26	0.34	0.09	0.19	17000	3
		1" Round Groove Bit	51	26	0.45	0.07	0.15	17000	3
					End Mills				
		1/4" Single Flute Flat End Mill UC	106	53	0.11	0.10	0.22	17000	3
		1/4" Flat End Mill UC	108	54	0.11	0.10	0.22	12000	2
	ting	1/4" Flat End Mill DC	108	54	0.11	0.10	0.22	12000	2
	cut	1/4" Ball End Mill	108	54	0.11	0.10	0.22	12000	2
	sive	1/8" Single Flute Flat End Mill UC	69	35	0.06	0.15	0.34	22000	4
	res	1/8" Flat End Mill UC	106	53	0.06	0.10	0.22	17000	3
	988	1/8" Flat End Mill DC	106	53	0.06	0.10	0.22	17000	3
	3 or	1/8" Ball End Mill	106	53	0.06	0.10	0.22	17000	3
	hin	1/16" Flat End Mill UC	53	27	0.03	0.10	0.23	17000	3
	gno	1/16" Flat End Mill DC	53	27	0.03	0.10	0.23	17000	3
	<u>~</u>	1/16" Corncob End Mill	53	27	0.03	0.10	0.23	17000	3
		22mm Surfacing Bit	102	51	0.35	0.016	0.04	17000	3
	a a				d Groove Bits				
	II Spee								
	Full Speed - Roughing or aggressive cutting	1/2" Round Groove Bit	51				0,29	17000	3
	Full Spee	1/2" Round Groove Bit 3/4" Round Groove Bit	51 51	26	0.22	0.13	0.29 0.19	17000 17000	3
	Full Spee	1/2" Round Groove Bit 3/4" Round Groove Bit 1" Round Groove Bit	51 51 51				0.29 0.19 0.15	17000 17000 17000	3 3 3

		Cutting Tool	Feed Rate (inch/min)	Plunge Rate (inch/min)	Stepover (inch)	Stepdown - Slotting (inch)	Stepdown - Pocketing (inch)	Router Speed (RPM)	Makita Speed Dial Setting
					V-bits				
	Dec 9	90, 60 Degree V-bit - V-Carving	68	23	0.07	0.03	0.06	17000	3
	Sp.	30, 90, 60 Degree V-bit - Fine Detail/Engraving	44	15	0.07	0.04	0.09	22000	4
	Carving/Detailing - Regular Speed				d Ball End Mi	ills			
	Reg	1/4" - D1/16" Tapered Ball End Mill - Roughing	28	14	0.009	N/A	0.016	10000	1
	- 26	1/4" - D1/16" Tapered Ball End Mill - Finishing	39	20	0.003	N/A	0.016	10000	1
	EZ .	1/8" - D0.5mm Tapered Ball End Mill - Roughing	79	39	0.006	N/A	0.01	10000	1
6	Ģ	1/8" - D0.5mm Tapered Ball End Mill - Finishing	118	59	0.0016	N/A	0.01	10000	1
	ing			Ва	II End Mills				
	a S	1/4" Ball End Mill - Finishing	66	33	0.005	0.055	1	22000	4
	0	1/8" Ball End Mill - Finishing	41	20	0.005	0.09	1	27000	5
	₩				End Mills				
	Reduced Speed - Finishing, or mild cutting	1/4" Single Flute Flat End Mill UC	63	31	0.11	0.024	0.05	12000	2
	d cu	1/4" Flat End Mill UC	91	46	0.11	0.016	0.04	10000	1
	충틸	1/4" Ball End Mill	91	46	0.11	0.016	0.04	10000	1
	S o %	1/8" Single Flute Flat End Mill UC	31	16	0.06	0.047	0.10	12000	2
	red hing	1/8" Flat End Mill UC	63	31	0.06	0.02	0.05	12000	2
	inis	1/8" Ball End Mill	63	31	0.06	0.024	0.05	12000	2
	ш	1/16" Flat End Mill UC	44	22	0.03	0.016	0.035	17000	3
					End Mills				
	_	1/4" Single Flute Flat End Mill UC	72	36	0.11	0.04	0.09	12000	2
	Regular Speed	1/4" Flat End Mill UC	104	52	0.11	0.03	0.06	10000	1
	R. P.	1/4" Ball End Mill	104	52	0.11	0.03	0.06	10000	1
	grila	1/8" Single Flute Flat End Mill UC	36	18	0.06	0.08	0.18	12000	2
	Reg	1/8" Flat End Mill UC	72	36	0.06	0.04	0.09	12000	2
		1/8" Ball End Mill	72	36	0.06	0.04	0.09	12000	2
		1/16" Flat End Mill UC	51	26	0.03	0.03	0.06	17000	3
	Full Speed - Roughing or aggressive cutting	A (All Circula Flore Flore For IACILLIC	00		End Mills	0.07	0.40	40000	
		1/4" Single Flute Flat End Mill UC	90	45	0.11	0.06	0.12	12000	2
	toug	1/4" Flat End Mill UC	130	65	0.11	0.04	0.08	10000	1
	d-R sive	1/4" Ball End Mill	130	65	0.11	0.04	0.08	10000	1
	pee	1/8" Single Flute Flat End Mill UC	45	22	0.06	0.11	0.23	12000	2
	38e	1/8" Flat End Mill UC	90	45	0.06	0.06	0.12	12000	2
	교하	1/8" Ball End Mill	90	45	0.06	0.06	0.12	12000	2
		1/16" Flat End Mill UC	64	32	0.03	0.04	0.09	17000	3

		Cutting Tool	Feed Rate (inch/min)	Plunge Rate (inch/min)	Stepover (inch)	Stepdown - Slotting (inch)	Stepdown - Pocketing (inch)	Router Speed (RPM)	Makita Speed Dial Setting
	ing				V-bits				
	taili	30, 90, 60 Degree V-bit - Fine Detail/Engraving	53	18	0.06	0.008	0.020	17000	3
	Carving/Detailing			Ba	II End Mills				
	Ş İğ	1/4" Ball End Mill - Finishing	44	22	0.012	0.016	1	22000	4
	Ö	1/8" Ball End Mill - Finishing	27	14	0.006	0.028	1	27000	5
	8				End Mills				
	t ii	1/4" Single Flute Flat End Mill UC	35	17	0.11	0.012	0.024	17000	3
	bee ild c	1/4" Flat End Mill UC	49	24	0.11	0.008	0.016	12000	2
	ed S	1/4" Ball End Mill	49	24	0.11	0.008	0.016	12000	2
	duc ng, c	1/8" Single Flute Flat End Mill UC	17	9	0.06	0.016	0.035	17000	3
	Reduced Speed - Finishing, or mild cutting	1/8" Flat End Mill UC	35	17	0.06	0.008	0.02	17000	3
		1/8" Ball End Mill	35	17	0.06	0.008	0.02	17000	3
				<u> </u>	End Mills				
		1/4" Single Flute Flat End Mill UC	43	21	0.11	0.016	0.035	17000	3
	beed	1/4" Flat End Mill UC	60	30	0.11	0.012	0.024	12000	2
	arS	1/4" Ball End Mill	60	30	0.11	0.012	0.024	12000	2
	Regular Speed	1/8" Single Flute Flat End Mill UC	21	11	0.06	0.024	0.051	17000	3
	~	1/8" Flat End Mill UC	43	21	0.06	0.012	0.028	17000	3
		1/8" Ball End Mill	43	21	0.06	0.012	0.028	17000	3
	b0			E	End Mills				
	ting:	1/4" Single Flute Flat End Mill UC	53	27	0.11	0.018	0.039	17000	3
	Soug	1/4" Flat End Mill UC	75	38	0.11	0.012	0.028	12000	2
	Full Speed - Roughing or aggressive cutting	1/4" Ball End Mill	75	38	0.11	0.012	0.028	12000	2
	Spee	1/8" Single Flute Flat End Mill UC	26	13	0.06	0.028	0.059	17000	3
	ull to	1/8" Flat End Mill UC	53	27	0.06	0.014	0.031	17000	3
		1/8" Ball End Mill	53	27	0.06	0.014	0.031	17000	3