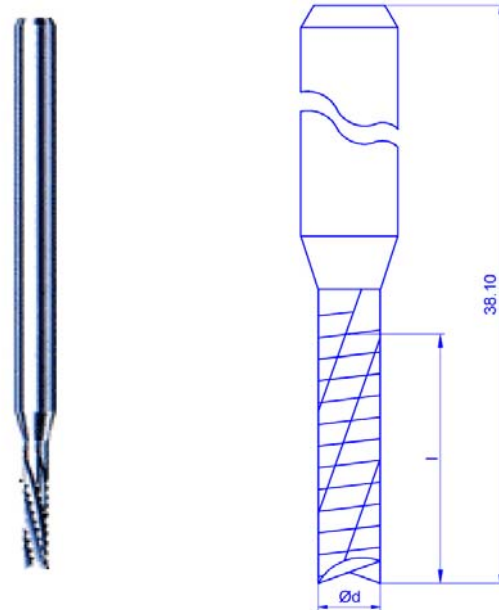




Mega Part Numbers
13-111160 to 13-111166
High Performance Chip Breaker Routers
Sizes 0.8mm – 3.0mm
 Common Shank Dia 1/8" (3.175mm)

D	L
0.80	5.00
1.00	5.00
1.20	5.00
1.50	6.00
2.00	7.50
2.50	8.50
3.00	8.50



All dimensions are in mm

ROUTING DATA PARAMETER RECOMMENDATIONS FOR FR4				
Diameter mm	Spindle Speed Rpm	X-Y Table Feed M/min	Z-FEED RATED (M/min)	
			Without pre- drilling	With Drilling
0.80	70000	0.3 – 0.4	0.2	0.4
1.00	70000	0.4 – 0.6	0.2	0.4
1.20	58000	0.5 – 0.7	0.4	0.8
1.50	46000	0.6 – 0.8	0.5	1.0
2.00	35000	1.0 – 1.4	0.5	1.2
2.50	28000	1.0 – 1.4	0.5	1.4
3.00	23000	1.0 – 1.3	0.4	1.4

The tabulated parameters provide guidelines which act as starting points for optimising speeds and feeds at the user's end

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