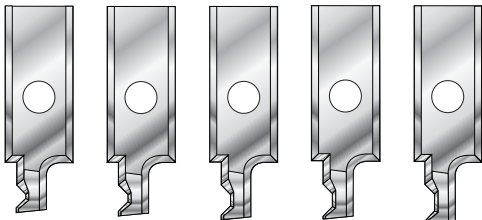


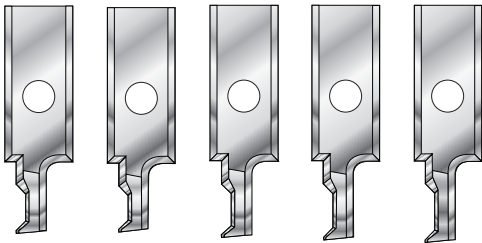


RC-1075 RC-1076 67127 5004

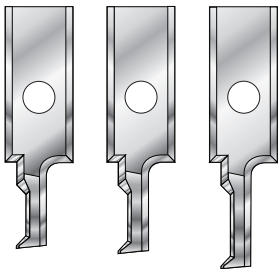
Knives shown 1:1



RCK-428 RCK-429 RCK-430 RCK-431 RCK-433



RCK-432 RCK-435 RCK-436 RCK-434 RCK-437



RCK-438 RCK-439 RCK-440

For Cutting

- Plastics & Plexiglas®

inch/min

CUTTING & QUAD CHAMFERING

| Material thickness up to | 0.079" | 0.118" | 0.181" | 0.220" |
|--------------------------|--------|--------|--------|--------|
| Rotation speed RPM | | | | |
| 6000 | 59 | 52 | 47 | 43 |
| 7000 | 69 | 61 | 55 | 50 |
| 8000 | 79 | 69 | 63 | 57 |
| 9000 | 89 | 78 | 71 | 64 |
| 10000 | 98 | 87 | 79 | 71 |
| 11000 | 108 | 95 | 87 | 78 |
| 12000 | 118 | 104 | 94 | 85 |
| 13000 | 128 | 113 | 102 | 92 |
| 14000 | 138 | 121 | 110 | 99 |
| 15000 | 148 | 130 | 118 | 106 |
| 16000 | 157 | 139 | 126 | 113 |
| 17000 | 167 | 147 | 134 | 120 |
| 18000 | 177 | 156 | 142 | 128 |
| 19000 | 187 | 165 | 150 | 135 |
| 20000 | 197 | 173 | 157 | 142 |
| 21000 | 207 | 182 | 165 | 149 |
| 22000 | 217 | 191 | 173 | 156 |
| 23000 | 226 | 199 | 181 | 163 |
| 24000 | 236 | 208 | 189 | 170 |
| 25000 | 246 | 217 | 197 | 177 |
| 26000 | 256 | 225 | 205 | 184 |
| 27000 | 266 | 234 | 213 | 191 |
| 28000 | 276 | 243 | 220 | 198 |

CHAMFERING ONLY

| | 0.236" | 0.283" | 0.315" |
|--------------------|--------|--------|--------|
| Rotation speed RPM | | | |
| 6000 | 59 | 52 | 47 |
| 7000 | 69 | 61 | 55 |
| 8000 | 79 | 69 | 63 |
| 9000 | 89 | 78 | 71 |
| 10000 | 98 | 87 | 79 |
| 11000 | 108 | 95 | 87 |
| 12000 | 118 | 104 | 94 |
| 13000 | 128 | 113 | 102 |
| 14000 | 138 | 121 | 110 |
| 15000 | 148 | 130 | 118 |
| 16000 | 157 | 139 | 126 |
| 17000 | 167 | 147 | 134 |
| 18000 | 177 | 156 | 142 |
| 19000 | 187 | 165 | 150 |
| 20000 | 197 | 173 | 157 |
| 21000 | 207 | 182 | 165 |
| 22000 | 217 | 191 | 173 |
| 23000 | 226 | 199 | 181 |
| 24000 | 236 | 208 | 189 |
| 25000 | 246 | 217 | 197 |
| 26000 | 256 | 225 | 205 |
| 27000 | 266 | 234 | 213 |
| 28000 | 276 | 243 | 220 |

mm/min

CUTTING & QUAD CHAMFERING

| Material thickness (mm) | 0-2 | 2-3 | 3-4.6 | 4.6-5.6 |
|-------------------------|------|------|-------|---------|
| Rotation speed RPM | | | | |
| 6000 | 1500 | 1320 | 1200 | 1080 |
| 7000 | 1750 | 1540 | 1400 | 1260 |
| 8000 | 2000 | 1760 | 1600 | 1440 |
| 9000 | 2250 | 1980 | 1800 | 1620 |
| 10000 | 2500 | 2200 | 2000 | 1800 |
| 11000 | 2750 | 2420 | 2200 | 1980 |
| 12000 | 3000 | 2640 | 2400 | 2160 |
| 13000 | 3250 | 2860 | 2600 | 2340 |
| 14000 | 3500 | 3080 | 2800 | 2520 |
| 15000 | 3750 | 3300 | 3000 | 2700 |
| 16000 | 4000 | 3520 | 3200 | 2880 |
| 17000 | 4250 | 3740 | 3400 | 3060 |
| 18000 | 4500 | 3960 | 3600 | 3240 |
| 19000 | 4750 | 4180 | 3800 | 3420 |
| 20000 | 5000 | 4400 | 4000 | 3600 |
| 21000 | 5250 | 4620 | 4200 | 3780 |
| 22000 | 5500 | 4840 | 4400 | 3960 |
| 23000 | 5750 | 5060 | 4600 | 4140 |
| 24000 | 6000 | 5280 | 4800 | 4320 |
| 25000 | 6250 | 5500 | 5000 | 4500 |
| 26000 | 6500 | 5720 | 5200 | 4680 |
| 27000 | 6750 | 5940 | 5400 | 4860 |
| 28000 | 7000 | 6160 | 5600 | 5040 |

CHAMFERING ONLY

| | 5.6-6 | 6-7.2 | 7.2-8 |
|--------------------|-------|-------|-------|
| Rotation speed RPM | | | |
| 6000 | 1500 | 1320 | 1200 |
| 7000 | 1750 | 1540 | 1400 |
| 8000 | 2000 | 1760 | 1600 |
| 9000 | 2250 | 1980 | 1800 |
| 10000 | 2500 | 2200 | 2000 |
| 11000 | 2750 | 2420 | 2200 |
| 12000 | 3000 | 2640 | 2400 |
| 13000 | 3250 | 2860 | 2600 |
| 14000 | 3500 | 3080 | 2800 |
| 15000 | 3750 | 3300 | 3000 |
| 16000 | 4000 | 3520 | 3200 |
| 17000 | 4250 | 3740 | 3400 |
| 18000 | 4500 | 3960 | 3600 |
| 19000 | 4750 | 4180 | 3800 |
| 20000 | 5000 | 4400 | 4000 |
| 21000 | 5250 | 4620 | 4200 |
| 22000 | 5500 | 4840 | 4400 |
| 23000 | 5750 | 5060 | 4600 |
| 24000 | 6000 | 5280 | 4800 |
| 25000 | 6250 | 5500 | 5000 |
| 26000 | 6500 | 5720 | 5200 |
| 27000 | 6750 | 5940 | 5400 |
| 28000 | 7000 | 6160 | 5600 |

Simple Machining Calculations:

To find **RPM**: (SFM x 3.82) / diameter of tool

To find **SFM**: 0.262 x diameter of tool x RPM

To find **Feed Rate**: RPM x # of flutes x chip load

To find **Chip Load**: IPM / (RPM x # of Flutes)