

GERBER PLATINUM FEED SPEED CHART



		DIMENSIONS																					
ETCH CODE	Part Number	Shank Dia.	Cutting Edge Dia. (CED)	Cutting Edge Length (CEL)	Overall Length (OAL)	Substrate	Feed IPM	RPM	Depth per Pass (x CED)	Substrate	Feed IPM	RPM	Depth per Pass (x CED)	Substrate	Feed IPM	RPM	Depth per Pass (x CED)	Substrate	Feed IPM	RPM	Depth per Pass (x CED)		
General Purpose	GP	P80356A	1/8	1/16	1/4	2	Plastics	35-50	18K	1x	Solid & Composite Woods	35-50	18K	1x	Aluminum	20-35	18K	1/2x	Solid Surfaces	35-50	18K	1x	
		P79825A	1/4	1/8	1/2	2		80-120	18K	1.5x		80-120	18K	2.5x		45-70	18K	1x		60-100	18K	2x	
		P80300A	1/4	1/8	1 1/8	2 1/2		40-100	18K	2.5x		Not recommended				Not recommended				Not Recommended			
		P79826A	1/4	3/16	5/8	2		90-150	18K	2.5x		120-180	18K	3x		60-120	18K	1x		60-100	18K	3x	
		P79827A	1/4	3/16	1 1/4	3		60-140	18K	2.5x		100-150	18K	2x		Not recommended				Not Recommended			
		P79828A	1/4	1/4	5/8	2		125-250	18K	3x		125-200	18K	2x		60-150	18K	1x		80-130	18K	2x	
		P79829A	1/4	1/4	7/8	2 1/2		125-200	18K	3x		125-200	18K	2.5x		60-120	18K	1x		80-110	18K	3x	
		P79830A	1/4	1/4	1 1/4	3		125-175	18K	3x		100-150	18K	1.5x		Not recommended				Not Recommended			
		P80301A	3/8	3/8	1 1/8	3		150-300	18K	3x		150-300	18K	2x		80-150	18K	1x		120-150	18K	3x	
Aluminum & Wood	AW	P79820A	1/8	1/16	1/4	1 1/2	Aluminum	20-35	18K	1/2x	Solid & Composite Woods	35-50	18K	1x									
		P79821A	1/8	1/8	1/4	1 1/2		40-65	18K	1x		70-120	18K	1x									
		P79822A	1/4	3/16	3/8	2		70-130	18K	1x		140-210	18K	2x									
		P79823A	1/4	1/4	3/8	2		70-150	18K	1x		140-250	18K	2x									
		P79824A	1/4	1/4	3/4	2 1/2		90-150	18K	1x		140-250	18K	2.5x									
		P80307A	3/8	3/8	3/4	3		100-250	18K	1.5x		150-300	18K	2.5x									
Hard Plastic & Foam	HPF	P80340A	1/4	1/16	1/4	2	Hard Plastics	20-35	18K	1x	Foam	35-60	18K	2x									
		P80341A	1/4	1/8	1/2	2		80-120	18K	1.5x		100-150	18K	3x									
		P80342A	1/4	3/16	5/8	2		90-150	18K	2.5x		100-200	18K	3x									
		P80343A	1/4	1/4	3/4	2 1/2		125-200	18K	3x		100-200	18K	3x									
		P80344A	1/4	1/8	1/4	2		80-120	18K	2x		120-160	18K	2x									
		P80345A	1/4	3/16	3/8	2		90-150	18K	2x		120-160	18K	2x									
		P80346A	1/4	1/4	1/2	2		125-200	18K	2x		125-200	18K	2x									
		P80347A	1/4	3/16	1 1/8	2 1/2		60-140	18K	2.5x		80-130	18K	4x									
		P80348A	1/4	1/8	1 1/8	2 1/2		40-100	18K	2.5x		60-110	18K	4x									
		P80370A	1/4	1/4	1 1/2	3		80-150	18K	3x		100-180	18K	4x									



C.E.L. - Cutting Edge Length. The distance from the cutting end of the bit to the furthest cutting edge of the bit, and the maximum cutting depth of the bit. Using a bit that is too long increases your chance of breaking the bit due to chatter or wobble.

C.E.D. - Cutting Edge Diameter. The width of the bit at the widest point of the cutting edge. This is used to determine the size of the hole that will be created by the bit.

O.A.L. - Overall Length. The total length of the bit from cutting edge to the end of the shank. If a bit is too long, it may not provide the proper clearance for hovering over your materials during non-cutting moves.

Shank Diameter - The width of the section of the bit that your collet holds onto. Make sure you have the correct collet or adapter sleeve for this dimension.

Shank Length - The length of the bit section that the collet holds onto.

Flute - The negative area where cut chips can collect and be channeled out of the cutting area. The shape and direction of the flute will determine the discharge direction of the chips during removal.

The feed speeds and depths per pass are recommended based on specific materials tested by Gerber. All materials and manufacturers vary and may require reduced feeds and speeds.