

# Nomad 883

#101 .125" Square

FEEDS  
&  
SPEEDS

#102 .125" Ball

MATERIAL	DOC	RPM	FEED	PLUNGE
<b>PLASTICS</b>				
ABS	.015"	9000	42	15
Acrylic	.019"	9000	44	14
Delrin	.02"	5900	65	18
HDPE	.02"	6250	80	21
Kydex	.03"	9000	55	13
Nylon	.018"	6250	75	8
Linoleum	.03"	3600	75	9
PEEK	.017"	7400	65	14
Polycarbonate	.013"	9000	55	18
Polypropylene	.02"	9100	90	15
PVC	.03"	6000	40	15
Styrene	.03"	6000	40	15
UHMW	.02"	7200	60	22
Sintra	.03"	6300	85	80
Resin	.02"	9000	60	50
<b>COMPOSITES</b>				
AL/PVC panel	.065"	9200	35	17
Carbon fiber ☠	.02"	6500	45	20 ☠
Garolite	.01"	9200	75	30
G10	.015"	7300	60	28
G10 XX	.015"	6500	55	25
Phenolic	.01"	8000	40	15
Foamcore	.1"	7500	75	35
Renshape	.04"	9000	35	15
<b>METALS</b>				
6061 AL	.01"	9200	8	1
360 Brass	.01"	9200	8	1
Lead	.013"	8000	15	3
Magnesium <small>Fire Hazard</small>	.015"	9200	8	1 <small>Fire Hazard</small>
Steel <small>Use Coolant</small>	.008"	8800	3	1 <small>Use Coolant</small>
Titanium	.01"	9000	3	1
<b>WOOD</b>				
Bamboo	.04"	9000	55	23
Pine	.03"	4500	72	32
Mahogany	.014"	9200	75	19
Plywood	.034"	7800	50	22
MDF	.017"	4000	75	18
<b>OTHER</b>				
Cork	.03"	9000	20	15
Graphite	.02"	6000	20	15
Limestone	.04"	9000	20	9
HD Wax	.04"	5000	80	40

## ROUTER RPM CHART

Dial #	1	2	3	4	5	6
Carbide/Makita	10K	12.5K	17.2K	22.3K	27.2K	30K
Dewalt DWP611	16.5K	18K	19.8K	21.5K	24.2K	27K

DESIGNED BY  CARBIDE 3D