

# SHAPEOKO 3



#201 .25" Square

## FEEDS & SPEEDS



#202 .25" Ball

MATERIAL	DOC	RPM	Carbide Compact /Makita	Dewalt		
				FEED	PLUNGE	
<b>PLASTICS</b>						
ABS	.07"	17000	3	2	65	22
Acrylic	.06"	19000	3.5	3	65	25
Delrin	.08"	20115	3.75	3.5	65	32
HDPE	.125"	21280	4	4	80	40
Kydex	.08"	17000	3	2	55	22
Nylon	.08"	15820	2.75	1.5	75	40
Linoleum	.03"	17000	3	2	75	35
PEEK	.03"	17000	3	2	65	30
Polycarbonate	.08"	17000	3	2	55	25
Polypropylene	.08"	24200	4.5	5	90	15
PVC	.09"	17000	3	2	35	17
Styrene	.03"	17000	3	2	40	15
UHMW	.1"	16390	1.5	3	75	22
Sintra	.13"	17000	3	2	100	80
Resin	.09"	17500	3.25	2.25	60	50
<b>COMPOSITES</b>						
AL/PVC panel	.13"	17500	3.25	2.25	50	25
Carbon fiber ☠	.06"	17000	3	2	45	20 ☠
Garolite	.08"	18500	3.5	2.75	75	30
G10	.09"	18500	3.5	2.75	60	28
G10 XX	.08"	16390	3	1.5	55	25
Phenolic	.08"	17000	3	2	65	35
Foamcore	.1"	17000	3	2	65	35
Renshape	.18"	19000	3.5	3	75	35
<b>METALS</b>						
6061 AL	.03"	17500	3.25	2.25	30	10
360 Brass	.02"	17000	3	2	25	11
Lead	.065"	15820	2.75	1	50	20
Magnesium <small>Fire Hazard</small>	.04"	17500	3.25	2.25	40	15 <small>Fire Hazard</small>
Steel <small>Use Coolant</small>	.02"	17500	3.25	2.25	12	5 <small>Use Coolant</small>
<b>WOOD</b>						
Bamboo	.22"	19000	3.5	3	65	30
Pine	.4"	21000	3.75	3.5	75	40
Mahogany	.1"	18950	3.5	3	65	32
Plywood	.25"	18950	3.5	3	100	50
MDF	.3"	17000	3	2	80	30
<b>OTHER</b>						
Cork	.3"	24000	4.5	5	60	30
Graphite	.1"	19700	3.5	3	20	15
Limestone	.1"	17000	3	2	40	12
HD Wax	.3"	17000	3	2	100	50

### 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