

29-000	HONEYCOMB CORE	ALUMINUM		NOMEX		PAPER	
	Part #	RPM	Feed Rate	RPM	Feed Rate	RPM	Feed Rate
	29-003 (1/4")	500-4,000	100 IPM	500-10,000	120 IPM	500-10,000	120 IPM
	29-006 (3/8")	500-4,000	100 IPM	500-10,000	120 IPM	500-10,000	120 IPM
	29-009 (1/2")	500-4,000	100 IPM	500-10,000	120 IPM	500-10,000	120 IPM
	29-012 (5/8")	500-4,000	100 IPM	500-10,000	120 IPM	500-10,000	120 IPM
	29-015 (3/4")	500-4,000	100 IPM	500-10,000	120 IPM	500-10,000	120 IPM

29-050	SPINDLE SPEED		CORE TYPE	Max Feed Rate	SPINDLE SPEED		29-100
	DIA	Max RPM			Feed Rate	Max RPM	
	1/4	25,000	NR	Aluminum, less than 5#/cuft	100	25,000	1/4
	3/8	25,000	NR	Aluminum, more than 5#/cuft	100	25,000	3/8
	1/2	25,000	800	Paper based	400	25,000	1/2
	3/4	25,000	800	Paper based w/Fiber Reinforcement	800	25,000	3/4
	1	25,000	800	Fiberglass	600		
	1-1/2	18,000	800	Phenolic	600		
	1-3/4	18,000	NR	Carbon Fiber	800		
	2	16,500	100	Aramid, less than 5#/cuft	800		
	2-1/2	15,000	100	Aramid, more than 5#/cuft	800		
	3	14,000					
	4	12,000					

30-000/ 30-300 30-700 32-200	SPEEDS & FEEDS	FEED RATES				SPINDLE SPEED	
	Core Type	Solid Carbide	Solid Carbide w/Teeth	Diamond Saw	HSS	DIA	MAX RPM
	Aluminum, less than 5#/cuft	100	100	NR	150	1/4	25,000
	Aluminum, more than 5#/cuft	100	100	NR	100	3/8	25,000
	Paper based	400	400	NR	250	1/2	25,000
	Paper based with Fiber Reinforcement	800	800	400	150	3/4	25,000
	Fiberglass	600	600	600	NR	1	25,000
	Phenolic	200	200	400	NR	1-1/2	18,000
	Carbon Fiber	NR	NR	800	NR	1-3/4	18,000
	Aramid, less than 5#/cuft	800	800	400	150	2	16,500
	Aramid, more than 5#/cuft	800	800	400	NR	2-1/2	15,000
						3	14,000
						4	12,000

Note: 30-300 assembly requires one (1) hogger and one (1) blade

31-000/ 32-000	SPEEDS & FEEDS	FEED RATES						SPINDLE SPEED	
	Core Type	Solid Carbide	Diamond Carbide	HSS Saw	HSS Wavy	HSS (31-000)	HSS (31-100)	DIA	MAX RPM
	Aluminum, less than 5#/cuft	100	NR	150	100	100-140	90-140	3/8	25,000
	Aluminum, more than 5#/cuft	100	NR	100	100	70	70	1/2	25,000
	Paper based	300	NR	200	300	50	50	3/4	25,000
	Paper based w/Fiber Reinforcement	400	300	600	300	100-150	100-150	1	25,000
	Fiberglass	NR	600	NR	NR	NR	NR	1-1/2	25,000
	Phenolic	NR	600	NR	NR	NR	NR	1-3/4	25,000
	Carbon Fiber	NR	800	NR	NR	NR	NR	2	18,000
	Aramid, less than 5#/cuft	200	NR	150	200	100-150	100-150	2-1/2	18,000
	Aramid, more than 5#/cuft	200	400	NR	NR	NR	NR	3	18,000

34-000	CORE TYPE	CUTTER	RPM	FEED RATE	CUT DIRECTION
	Fiberglass panels with paper core (Nomex®)	Diamond Grit	18,000	220 lpm	Conventional
	Aluminum panels with aluminum core	HSS Saw	16,000	120 lpm	Conventional