

# 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.

# GERBER PLATINUM FEED SPEED CHART

ETCH CODE	Part Number	DIMENSIONS				Substrate	Feed IPM	RPM	Depth per Pass (x CED)	Substrate	Feed IPM	RPM	Depth per Pass (x CED)	
		Shank Dia.	Cutting Edge Dia. (CED)	Cutting Edge Length (CEL)	Overall Length (OAL)									
Soft Plastic & Foam	SPF	P80367A	1/4	1/16	1/4	2	Soft Plastic	20-35	18K	1x	Foam	35-60	18K	2x
		P80366A	1/4	1/8	1/2	2	Soft Plastic	80-120	18K	1.5x	Foam	100-150	18K	3x
		P80365A	1/4	3/16	5/8	2	Soft Plastic	90-150	18K	2.5x	Foam	100-200	18K	3x
		P80364A	1/4	1/4	3/4	2 1/2	Soft Plastic	125-200	18K	3x	Foam	100-200	18K	3x
		P80363A	1/4	1/8	1/4	2	Soft Plastic	80-120	18K	2x	Foam	120-160	18K	2x
		P80362A	1/4	3/16	3/8	2	Soft Plastic	90-150	18K	2x	Foam	120-160	18K	2x
		P80368A	1/4	1/4	1 1/2	3	Soft Plastic	80-150	18K	3x	Foam	100-180	18K	4x
Laminates & Veneers	LV	P80302A	1/4	1/8	3/8	2 1/2	Laminates & Veneers	80-140	18K	3x	Solid Woods	60-100	18K	2x
		P80303A	1/4	3/16	5/8	2 1/2	Laminates & Veneers	120-175	18K	3x	Solid Woods	100-140	18K	2x
		P80304A	1/4	1/4	7/8	2 1/2	Laminates & Veneers	120-225	18K	3x	Solid Woods	100-180	18K	2.5x
		P80305A	3/8	3/8	7/8	3	Laminates & Veneers	175-300	15K-18K	3x	Solid Woods	150-225	18K	2.5x
		P80306A	3/8	3/8	1 1/8	3	Laminates & Veneers	175-300	15K-18K	3x	Solid Woods	150-225	18K	2.5x
Foams	F	P80349A	1/4	1/4	1 1/4	3	Foams & Sintra	100-150	18K	4x	Soft Mechanical Plastics	60-120	18K	2x
		P80350A	1/4	1/4	2 1/4	4	Foams & Sintra	80-130	18K	3x	Soft Mechanical Plastics	Not recommended		
		P80351A	3/8	3/8	1 1/2	4	Foams & Sintra	130-200	18K	3x	Soft Mechanical Plastics	100-180	18K	2x
All Purpose Clean-Out	APC	P80358A	1/8	1/8	1/4	2	Plastics, Solid Woods & Surfaces	100-120	18K	1/2x	Aluminum & Brass	40-60	18K	1/4x
		P80359A	1/4	1/4	3/8	2	Plastics, Solid Woods & Surfaces	100-160	18K	1x	Aluminum & Brass	40-60	18K	1/4x
		P80360A	3/8	3/8	5/8	2 1/2	Plastics, Solid Woods & Surfaces	100-200	18K	1x	Aluminum & Brass	40-60	18K	1/6x
3D Modeling	3DM	P80352A	1/8	1/8	1/2	2	Woods, Plastics, Solid Surfaces	50-100	18K	1x	Aluminum	40-70	18K	1/4x
		P80353A	1/4	3/16	3/4	2	Woods, Plastics, Solid Surfaces	60-120	18K	1x	Aluminum	40-80	18K	1/2x
		P80354A	1/4	1/4	7/8	2 1/2	Woods, Plastics, Solid Surfaces	80-150	18K	1.5x	Aluminum	50-90	18K	1/2x
		P80355A	3/8	3/8	1 1/8	3	Woods, Plastics, Solid Surfaces	100-225	18K	2x	Aluminum	60-100	18K	1/2x
Folding Tool	FT	P80361A	1/4	1/2	3/8	2	Plastics	100-250	18K	1x	Alum Comp	70-100	18K	1x
All Purpose Straight	APS	P80336A	1/4	1/8	1/2	2	Most Materials	80-125	18K	2x				
		P80337A	1/4	3/16	5/8	2	Most Materials	100-150	18K	2.5x				
		P80338A	1/4	1/4	3/4	2 1/2	Most Materials	125-200	18K	3x				
		P80339A	1/4	1/4	1 1/4	4	Most Materials	100-150	18K	2x				

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## FRACTION - DECIMAL CONVERSION CHART

INCHES		MM	INCHES		MM
1/64	.015625	.3969	33/64	.515625	13.096
1/32	.03125	.7938	35/64	.53125	13.493
3/64	.046875	1.1906	37/64	.5625	14.287
1/16	.0625	1.5875	39/64	.59375	15.081
5/64	.078125	1.9844	41/64	.625	15.875
3/32	.09375	2.3813	43/64	.65625	16.668
7/64	.109375	2.7781	45/64	.6875	17.462
1/8	.125	3.1750	47/64	.71875	18.256
9/64	.140625	3.5719	49/64	.7500	19.050
5/32	.15625	3.9688	51/64	.78125	19.843
11/64	.171875	4.3656	53/64	.8125	20.637
3/16	.1875	4.7625	55/64	.84375	21.431
13/64	.203125	5.1594	57/64	.8750	22.225
7/32	.21875	5.5563	59/64	.90625	23.018
15/64	.234375	5.9531	61/64	.9375	23.812
1/4	.250	6.3500	63/64	.96875	24.606
17/64	.265625	6.7469	64/64	1.0000	25.400
9/32	.28125	7.1438			
19/64	.296875	7.5406			
5/16	.3125	7.9375			
21/64	.328125	8.3344			
11/32	.34375	8.7313			
23/64	.359375	9.1282			
3/8	.375	9.5250			
25/64	.390625	9.9219			
13/32	.40625	10.3188			
27/64	.421875	10.7157			
7/16	.4375	11.1125			
29/64	.453125	11.5094			
15/32	.46875	11.9063			
31/64	.484375	12.3032			
1/2	.500	12.7001			

