


# 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.



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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		80-120	18K	1.5x		100-150	18K	3x
		P80365A	1/4	3/16	5/8	2		90-150	18K	2.5x		100-200	18K	3x
		P80364A	1/4	1/4	3/4	2 1/2		125-200	18K	3x		100-200	18K	3x
		P80363A	1/4	1/8	1/4	2		80-120	18K	2x		120-160	18K	2x
		P80362A	1/4	3/16	3/8	2		90-150	18K	2x		120-160	18K	2x
		P80368A	1/4	1/4	1 1/2	3		80-150	18K	3x		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		120-175	18K	3x		100-140	18K	2x
		P80304A	1/4	1/4	7/8	2 1/2		120-225	18K	3x		100-180	18K	2.5x
		P80305A	3/8	3/8	7/8	3		175-300	15K-18K	3x		150-225	18K	2.5x
		P80306A	3/8	3/8	1 1/8	3		175-300	15K-18K	3x		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		80-130	18K	3x		Not recommended		
		P80351A	3/8	3/8	1 1/2	4		130-200	18K	3x		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		100-160	18K	1x		40-60	18K	1/4x
		P80360A	3/8	3/8	5/8	2 1/2		100-200	18K	1x		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		60-120	18K	1x		40-80	18K	1/2x
		P80354A	1/4	1/4	7/8	2 1/2		80-150	18K	1.5x		50-90	18K	1/2x
		P80355A	3/8	3/8	1 1/8	3		100-225	18K	2x		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	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.			
		P80337A	1/4	3/16	5/8	2		100-150	18K	2.5x				
		P80338A	1/4	1/4	3/4	2 1/2		125-200	18K	3x				
		P80339A	1/4	1/4	1 1/4	4		100-150	18K	2x				

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## FRACTION - DECIMAL CONVERSION CHART

		INCHES	MM			INCHES	MM
1/32	1/64	.015625	.3969	17/32	33/64	.515625	13.096
1/16	3/64	.03125	.7938	9/16	35/64	.53125	13.493
1/8	5/64	.0625	1.5875	5/8	37/64	.546875	13.890
3/32	7/64	.078125	1.9844	19/32	39/64	.5625	14.287
1/4	9/64	.09375	2.3813	5/8	41/64	.578125	14.684
3/8	11/64	.109375	2.7781	11/16	43/64	.59375	15.081
1/2	13/64	.125	3.1750	23/32	45/64	.609375	15.478
5/8	15/64	.140625	3.5719	11/16	47/64	.625	15.875
3/4	17/64	.15625	3.9688	25/32	49/64	.640625	16.271
7/8	19/64	.171875	4.3656	13/16	51/64	.65625	16.668
1	21/64	.1875	4.7625	27/32	53/64	.671875	17.065
	23/64	.203125	5.1594	7/8	55/64	.6875	17.462
	25/64	.21875	5.5563	15/16	57/64	.703125	17.859
	27/64	.234375	5.9531	1	59/64	.71875	18.256
	29/64	.25	6.3500		61/64	.734375	18.653
	31/64	.265625	6.7469		63/64	.75	19.050
	33/64	.28125	7.1438		65/64	.765625	19.447
	35/64	.296875	7.5406		67/64	.78125	19.843
	37/64	.3125	7.9375		69/64	.796875	20.240
	39/64	.328125	8.3344		71/64	.8125	20.6375
	41/64	.34375	8.7313		73/64	.828125	21.0345
	43/64	.359375	9.1282		75/64	.84375	21.431
	45/64	.375	9.5250		77/64	.859375	21.8282
	47/64	.390625	9.9219		79/64	.875	22.2251
	49/64	.40625	10.3188		81/64	.890625	22.6220
	51/64	.421875	10.7157		83/64	.90625	23.0188
	53/64	.4375	11.1125		85/64	.921875	23.4157
	55/64	.453125	11.5094		87/64	.9375	23.8126
	57/64	.46875	11.9063		89/64	.953125	24.2095
	59/64	.484375	12.3032		91/64	.96875	24.6063
	61/64	.5	12.7001		93/64	.984375	25.0032
	63/64				95/64	1.000	25.4001