

Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:
31210-SC, 32210-SC, 35210-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	201	151	101
34,000	196	147	98
33,000	190	142	95
32,000	184	138	92
31,000	178	134	89
30,000	173	129	86
29,000	167	125	83
28,000	161	121	81
27,000	155	116	78
26,000	150	112	75
25,000	144	108	72
24,000	138	104	69
23,000	132	99	66
22,000	127	95	63
21,000	121	91	60
20,000	115	86	58
19,000	109	82	55
18,000	104	78	52
17,000	98	73	49
16,000	92	69	46
15,000	86	65	43
14,000	81	60	40
13,000	75	56	37
12,000	69	52	35
11,000	63	47	32
10,000	58	43	29
9,000	52	39	26
8,000	46	35	23
7,000	40	30	20
6,000	35	26	17
5,000	29	22	14

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	289	217	144
34,000	281	210	140
33,000	272	204	136
32,000	264	198	132
31,000	256	192	128
30,000	248	186	124
29,000	239	179	120
28,000	231	173	116
27,000	223	167	111
26,000	215	161	107
25,000	206	155	103
24,000	198	149	99
23,000	190	142	95
22,000	182	136	91
21,000	173	130	87
20,000	165	124	83
19,000	157	118	78
18,000	149	111	74
17,000	140	105	70
16,000	132	99	66
15,000	124	93	62
14,000	116	87	58
13,000	107	80	54
12,000	99	74	50
11,000	91	68	45
10,000	83	62	41
9,000	74	56	37
8,000	66	50	33
7,000	58	43	29
6,000	50	37	25
5,000	41	31	21

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	219	164	109
34,000	213	159	106
33,000	206	155	103
32,000	200	150	100
31,000	194	145	97
30,000	188	141	94
29,000	181	136	91
28,000	175	131	88
27,000	169	127	84
26,000	163	122	81
25,000	156	117	78
24,000	150	113	75
23,000	144	108	72
22,000	138	103	69
21,000	131	98	66
20,000	125	94	63
19,000	119	89	59
18,000	113	84	56
17,000	106	80	53
16,000	100	75	50
15,000	94	70	47
14,000	88	66	44
13,000	81	61	41
12,000	75	56	38
11,000	69	52	34
10,000	63	47	31
9,000	56	42	28
8,000	50	38	25
7,000	44	33	22
6,000	38	28	19
5,000	31	23	16

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	280	210	140
34,000	272	204	136
33,000	264	198	132
32,000	256	192	128
31,000	248	186	124
30,000	240	180	120
29,000	232	174	116
28,000	224	168	112
27,000	216	162	108
26,000	208	156	104
25,000	200	150	100
24,000	192	144	96
23,000	184	138	92
22,000	176	132	88
21,000	168	126	84
20,000	160	120	80
19,000	152	114	76
18,000	144	108	72
17,000	136	102	68
16,000	128	96	64
15,000	120	90	60
14,000	112	84	56
13,000	104	78	52
12,000	96	72	48
11,000	88	66	44
10,000	80	60	40
9,000	72	54	36
8,000	64	48	32
7,000	56	42	28
6,000	48	36	24
5,000	40	30	20

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

**Endmill Data Sheet for Yonico bit Numbers:
31211-SC**

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	252	189	126
34,000	244	183	122
33,000	237	178	119
32,000	230	173	115
31,000	223	167	111
30,000	216	162	108
29,000	209	156	104
28,000	201	151	101
27,000	194	146	97
26,000	187	140	93
25,000	180	135	90
24,000	173	129	86
23,000	165	124	83
22,000	158	119	79
21,000	151	113	75
20,000	144	108	72
19,000	137	102	68
18,000	129	97	65
17,000	122	92	61
16,000	115	86	58
15,000	108	81	54
14,000	101	75	50
13,000	93	70	47
12,000	86	65	43
11,000	79	59	40
10,000	72	54	36
9,000	65	49	32
8,000	58	43	29
7,000	50	38	25
6,000	43	32	22
5,000	36	27	18

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	361	271	181
34,000	351	263	175
33,000	340	255	170
32,000	330	248	165
31,000	320	240	160
30,000	309	232	155
29,000	299	224	150
28,000	289	217	144
27,000	279	209	139
26,000	268	201	134
25,000	258	193	129
24,000	248	186	124
23,000	237	178	119
22,000	227	170	113
21,000	217	162	108
20,000	206	155	103
19,000	196	147	98
18,000	186	139	93
17,000	175	132	88
16,000	165	124	83
15,000	155	116	77
14,000	144	108	72
13,000	134	101	67
12,000	124	93	62
11,000	113	85	57
10,000	103	77	52
9,000	93	70	46
8,000	83	62	41
7,000	72	54	36
6,000	62	46	31
5,000	52	39	26

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	274	205	137
34,000	266	199	133
33,000	258	193	129
32,000	250	188	125
31,000	242	182	121
30,000	234	176	117
29,000	227	170	113
28,000	219	164	109
27,000	211	158	106
26,000	203	152	102
25,000	195	147	98
24,000	188	141	94
23,000	180	135	90
22,000	172	129	86
21,000	164	123	82
20,000	156	117	78
19,000	148	111	74
18,000	141	106	70
17,000	133	100	66
16,000	125	94	63
15,000	117	88	59
14,000	109	82	55
13,000	102	76	51
12,000	94	70	47
11,000	86	64	43
10,000	78	59	39
9,000	70	53	35
8,000	63	47	31
7,000	55	41	27
6,000	47	35	23
5,000	39	29	20

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	350	263	175
34,000	340	255	170
33,000	330	248	165
32,000	320	240	160
31,000	310	233	155
30,000	300	225	150
29,000	290	218	145
28,000	280	210	140
27,000	270	203	135
26,000	260	195	130
25,000	250	188	125
24,000	240	180	120
23,000	230	173	115
22,000	220	165	110
21,000	210	158	105
20,000	200	150	100
19,000	190	143	95
18,000	180	135	90
17,000	170	128	85
16,000	160	120	80
15,000	150	113	75
14,000	140	105	70
13,000	130	98	65
12,000	120	90	60
11,000	110	83	55
10,000	100	75	50
9,000	90	68	45
8,000	80	60	40
7,000	70	53	35
6,000	60	45	30
5,000	50	38	25

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:
31212-SC, 35212-SC, 36212-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	302	226	151
34,000	293	220	147
33,000	285	213	142
32,000	276	207	138
31,000	267	201	134
30,000	259	194	129
29,000	250	188	125
28,000	242	181	121
27,000	233	175	116
26,000	224	168	112
25,000	216	162	108
24,000	207	155	104
23,000	198	149	99
22,000	190	142	95
21,000	181	136	91
20,000	173	129	86
19,000	164	123	82
18,000	155	116	78
17,000	147	110	73
16,000	138	104	69
15,000	129	97	65
14,000	121	91	60
13,000	112	84	56
12,000	104	78	52
11,000	95	71	47
10,000	86	65	43
9,000	78	58	39
8,000	69	52	35
7,000	60	45	30
6,000	52	39	26
5,000	43	32	22

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	433	325	217
34,000	421	316	210
33,000	408	306	204
32,000	396	297	198
31,000	384	288	192
30,000	371	278	186
29,000	359	269	179
28,000	347	260	173
27,000	334	251	167
26,000	322	241	161
25,000	309	232	155
24,000	297	223	149
23,000	285	213	142
22,000	272	204	136
21,000	260	195	130
20,000	248	186	124
19,000	235	176	118
18,000	223	167	111
17,000	210	158	105
16,000	198	149	99
15,000	186	139	93
14,000	173	130	87
13,000	161	121	80
12,000	149	111	74
11,000	136	102	68
10,000	124	93	62
9,000	111	84	56
8,000	99	74	50
7,000	87	65	43
6,000	74	56	37
5,000	62	46	31

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	328	246	164
34,000	319	239	159
33,000	309	232	155
32,000	300	225	150
31,000	291	218	145
30,000	281	211	141
29,000	272	204	136
28,000	263	197	131
27,000	253	190	127
26,000	244	183	122
25,000	234	176	117
24,000	225	169	113
23,000	216	162	108
22,000	206	155	103
21,000	197	148	98
20,000	188	141	94
19,000	178	134	89
18,000	169	127	84
17,000	159	120	80
16,000	150	113	75
15,000	141	105	70
14,000	131	98	66
13,000	122	91	61
12,000	113	84	56
11,000	103	77	52
10,000	94	70	47
9,000	84	63	42
8,000	75	56	38
7,000	66	49	33
6,000	56	42	28
5,000	47	35	23

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	420	315	210
34,000	408	306	204
33,000	396	297	198
32,000	384	288	192
31,000	372	279	186
30,000	360	270	180
29,000	348	261	174
28,000	336	252	168
27,000	324	243	162
26,000	312	234	156
25,000	300	225	150
24,000	288	216	144
23,000	276	207	138
22,000	264	198	132
21,000	252	189	126
20,000	240	180	120
19,000	228	171	114
18,000	216	162	108
17,000	204	153	102
16,000	192	144	96
15,000	180	135	90
14,000	168	126	84
13,000	156	117	78
12,000	144	108	72
11,000	132	99	66
10,000	120	90	60
9,000	108	81	54
8,000	96	72	48
7,000	84	63	42
6,000	72	54	36
5,000	60	45	30

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31213-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	352	264	176
34,000	342	257	171
33,000	332	249	166
32,000	322	242	161
31,000	312	234	156
30,000	302	226	151
29,000	292	219	146
28,000	282	211	141
27,000	272	204	136
26,000	262	196	131
25,000	252	189	126
24,000	242	181	121
23,000	231	174	116
22,000	221	166	111
21,000	211	159	106
20,000	201	151	101
19,000	191	143	96
18,000	181	136	91
17,000	171	128	86
16,000	161	121	81
15,000	151	113	75
14,000	141	106	70
13,000	131	98	65
12,000	121	91	60
11,000	111	83	55
10,000	101	75	50
9,000	91	68	45
8,000	81	60	40
7,000	70	53	35
6,000	60	45	30
5,000	50	38	25

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	505	379	253
34,000	491	368	245
33,000	477	357	238
32,000	462	347	231
31,000	448	336	224
30,000	433	325	217
29,000	419	314	209
28,000	404	303	202
27,000	390	292	195
26,000	375	282	188
25,000	361	271	181
24,000	347	260	173
23,000	332	249	166
22,000	318	238	159
21,000	303	227	152
20,000	289	217	144
19,000	274	206	137
18,000	260	195	130
17,000	245	184	123
16,000	231	173	116
15,000	217	162	108
14,000	202	152	101
13,000	188	141	94
12,000	173	130	87
11,000	159	119	79
10,000	144	108	72
9,000	130	97	65
8,000	116	87	58
7,000	101	76	51
6,000	87	65	43
5,000	72	54	36

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	383	287	191
34,000	372	279	186
33,000	361	271	181
32,000	350	263	175
31,000	339	254	170
30,000	328	246	164
29,000	317	238	159
28,000	306	230	153
27,000	295	222	148
26,000	284	213	142
25,000	274	205	137
24,000	263	197	131
23,000	252	189	126
22,000	241	181	120
21,000	230	172	115
20,000	219	164	109
19,000	208	156	104
18,000	197	148	98
17,000	186	139	93
16,000	175	131	88
15,000	164	123	82
14,000	153	115	77
13,000	142	107	71
12,000	131	98	66
11,000	120	90	60
10,000	109	82	55
9,000	98	74	49
8,000	88	66	44
7,000	77	57	38
6,000	66	49	33
5,000	55	41	27

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	490	368	245
34,000	476	357	238
33,000	462	347	231
32,000	448	336	224
31,000	434	326	217
30,000	420	315	210
29,000	406	305	203
28,000	392	294	196
27,000	378	284	189
26,000	364	273	182
25,000	350	263	175
24,000	336	252	168
23,000	322	242	161
22,000	308	231	154
21,000	294	221	147
20,000	280	210	140
19,000	266	200	133
18,000	252	189	126
17,000	238	179	119
16,000	224	168	112
15,000	210	158	105
14,000	196	147	98
13,000	182	137	91
12,000	168	126	84
11,000	154	116	77
10,000	140	105	70
9,000	126	95	63
8,000	112	84	56
7,000	98	74	49
6,000	84	63	42
5,000	70	53	35

*The shaded boxes are the recommended settings.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:

31010-SC, 31214-SC, 31215-SC, 32010-SC, 32211-SC, 32212-SC, 33210-SC, 34221-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	403	302	201
34,000	391	293	196
33,000	380	285	190
32,000	368	276	184
31,000	357	267	178
30,000	345	259	173
29,000	334	250	167
28,000	322	242	161
27,000	311	233	155
26,000	299	224	150
25,000	288	216	144
24,000	276	207	138
23,000	265	198	132
22,000	253	190	127
21,000	242	181	121
20,000	230	173	115
19,000	219	164	109
18,000	207	155	104
17,000	196	147	98
16,000	184	138	92
15,000	173	129	86
14,000	161	121	81
13,000	150	112	75
12,000	138	104	69
11,000	127	95	63
10,000	115	86	58
9,000	104	78	52
8,000	92	69	46
7,000	81	60	40
6,000	69	52	35
5,000	58	43	29

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	578	433	289
34,000	561	421	281
33,000	545	408	272
32,000	528	396	264
31,000	512	384	256
30,000	495	371	248
29,000	479	359	239
28,000	462	347	231
27,000	446	334	223
26,000	429	322	215
25,000	413	309	206
24,000	396	297	198
23,000	380	285	190
22,000	363	272	182
21,000	347	260	173
20,000	330	248	165
19,000	314	235	157
18,000	297	223	149
17,000	281	210	140
16,000	264	198	132
15,000	248	186	124
14,000	231	173	116
13,000	215	161	107
12,000	198	149	99
11,000	182	136	91
10,000	165	124	83
9,000	149	111	74
8,000	132	99	66
7,000	116	87	58
6,000	99	74	50
5,000	83	62	41

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	438	328	219
34,000	425	319	213
33,000	413	309	206
32,000	400	300	200
31,000	388	291	194
30,000	375	281	188
29,000	363	272	181
28,000	350	263	175
27,000	338	253	169
26,000	325	244	163
25,000	313	234	156
24,000	300	225	150
23,000	288	216	144
22,000	275	206	138
21,000	263	197	131
20,000	250	188	125
19,000	238	178	119
18,000	225	169	113
17,000	213	159	106
16,000	200	150	100
15,000	188	141	94
14,000	175	131	88
13,000	163	122	81
12,000	150	113	75
11,000	138	103	69
10,000	125	94	63
9,000	113	84	56
8,000	100	75	50
7,000	88	66	44
6,000	75	56	38
5,000	63	47	31

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	560	420	280
34,000	544	408	272
33,000	528	396	264
32,000	512	384	256
31,000	496	372	248
30,000	480	360	240
29,000	464	348	232
28,000	448	336	224
27,000	432	324	216
26,000	416	312	208
25,000	400	300	200
24,000	384	288	192
23,000	368	276	184
22,000	352	264	176
21,000	336	252	168
20,000	320	240	160
19,000	304	228	152
18,000	288	216	144
17,000	272	204	136
16,000	256	192	128
15,000	240	180	120
14,000	224	168	112
13,000	208	156	104
12,000	192	144	96
11,000	176	132	88
10,000	160	120	80
9,000	144	108	72
8,000	128	96	64
7,000	112	84	56
6,000	96	72	48
5,000	80	60	40

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:
31240-SC, 32220-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	503	377	252
34,000	489	367	244
33,000	474	356	237
32,000	460	345	230
31,000	446	334	223
30,000	431	323	216
29,000	417	313	208
28,000	403	302	201
27,000	388	291	194
26,000	374	280	187
25,000	359	270	180
24,000	345	259	173
23,000	331	248	165
22,000	316	237	158
21,000	302	226	151
20,000	288	216	144
19,000	273	205	137
18,000	259	194	129
17,000	244	183	122
16,000	230	173	115
15,000	216	162	108
14,000	201	151	101
13,000	187	140	93
12,000	173	129	86
11,000	158	119	79
10,000	144	108	72
9,000	129	97	65
8,000	115	86	58
7,000	101	75	50
6,000	86	65	43
5,000	72	54	36

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	722	541	361
34,000	701	526	351
33,000	681	510	340
32,000	660	495	330
31,000	639	480	320
30,000	619	464	309
29,000	598	449	299
28,000	578	433	289
27,000	557	418	278
26,000	536	402	268
25,000	516	387	258
24,000	495	371	248
23,000	474	356	237
22,000	454	340	227
21,000	433	325	217
20,000	413	309	206
19,000	392	294	196
18,000	371	278	186
17,000	351	263	175
16,000	330	248	165
15,000	309	232	155
14,000	289	217	144
13,000	268	201	134
12,000	248	186	124
11,000	227	170	113
10,000	206	155	103
9,000	186	139	93
8,000	165	124	83
7,000	144	108	72
6,000	124	93	62
5,000	103	77	52

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	547	410	273
34,000	531	398	266
33,000	516	387	258
32,000	500	375	250
31,000	484	363	242
30,000	469	352	234
29,000	453	340	227
28,000	438	328	219
27,000	422	316	211
26,000	406	305	203
25,000	391	293	195
24,000	375	281	188
23,000	359	270	180
22,000	344	258	172
21,000	328	246	164
20,000	313	234	156
19,000	297	223	148
18,000	281	211	141
17,000	266	199	133
16,000	250	188	125
15,000	234	176	117
14,000	219	164	109
13,000	203	152	102
12,000	188	141	94
11,000	172	129	86
10,000	156	117	78
9,000	141	105	70
8,000	125	94	63
7,000	109	82	55
6,000	94	70	47
5,000	78	59	39

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	700	525	350
34,000	680	510	340
33,000	660	495	330
32,000	640	480	320
31,000	620	465	310
30,000	600	450	300
29,000	580	435	290
28,000	560	420	280
27,000	540	405	270
26,000	520	390	260
25,000	500	375	250
24,000	480	360	240
23,000	460	345	230
22,000	440	330	220
21,000	420	315	210
20,000	400	300	200
19,000	380	285	190
18,000	360	270	180
17,000	340	255	170
16,000	320	240	160
15,000	300	225	150
14,000	280	210	140
13,000	260	195	130
12,000	240	180	120
11,000	220	165	110
10,000	200	150	100
9,000	180	135	90
8,000	160	120	80
7,000	140	105	70
6,000	120	90	60
5,000	100	75	50

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:

31250-SC, 31251-SC, 32230-SC, 33220-SC, 34230-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	604	453	302
34,000	587	440	293
33,000	569	427	285
32,000	552	414	276
31,000	535	401	267
30,000	518	388	259
29,000	500	375	250
28,000	483	362	242
27,000	466	349	233
26,000	449	336	224
25,000	431	323	216
24,000	414	311	207
23,000	397	298	198
22,000	380	285	190
21,000	362	272	181
20,000	345	259	173
19,000	328	246	164
18,000	311	233	155
17,000	293	220	147
16,000	276	207	138
15,000	259	194	129
14,000	242	181	121
13,000	224	168	112
12,000	207	155	104
11,000	190	142	95
10,000	173	129	86
9,000	155	116	78
8,000	138	104	69
7,000	121	91	60
6,000	104	78	52
5,000	86	65	43

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	866	650	433
34,000	842	631	421
33,000	817	613	408
32,000	792	594	396
31,000	767	575	384
30,000	743	557	371
29,000	718	538	359
28,000	693	520	347
27,000	668	501	334
26,000	644	483	322
25,000	619	464	309
24,000	594	446	297
23,000	569	427	285
22,000	545	408	272
21,000	520	390	260
20,000	495	371	248
19,000	470	353	235
18,000	446	334	223
17,000	421	316	210
16,000	396	297	198
15,000	371	278	186
14,000	347	260	173
13,000	322	241	161
12,000	297	223	149
11,000	272	204	136
10,000	248	186	124
9,000	223	167	111
8,000	198	149	99
7,000	173	130	87
6,000	149	111	74
5,000	124	93	62

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	656	492	328
34,000	638	478	319
33,000	619	464	309
32,000	600	450	300
31,000	581	436	291
30,000	563	422	281
29,000	544	408	272
28,000	525	394	263
27,000	506	380	253
26,000	488	366	244
25,000	469	352	234
24,000	450	338	225
23,000	431	323	216
22,000	413	309	206
21,000	394	295	197
20,000	375	281	188
19,000	356	267	178
18,000	338	253	169
17,000	319	239	159
16,000	300	225	150
15,000	281	211	141
14,000	263	197	131
13,000	244	183	122
12,000	225	169	113
11,000	206	155	103
10,000	188	141	94
9,000	169	127	84
8,000	150	113	75
7,000	131	98	66
6,000	113	84	56
5,000	94	70	47

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	840	630	420
34,000	816	612	408
33,000	792	594	396
32,000	768	576	384
31,000	744	558	372
30,000	720	540	360
29,000	696	522	348
28,000	672	504	336
27,000	648	486	324
26,000	624	468	312
25,000	600	450	300
24,000	576	432	288
23,000	552	414	276
22,000	528	396	264
21,000	504	378	252
20,000	480	360	240
19,000	456	342	228
18,000	432	324	216
17,000	408	306	204
16,000	384	288	192
15,000	360	270	180
14,000	336	252	168
13,000	312	234	156
12,000	288	216	144
11,000	264	198	132
10,000	240	180	120
9,000	216	162	108
8,000	192	144	96
7,000	168	126	84
6,000	144	108	72
5,000	120	90	60

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31260-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	704	528	352
34,000	684	513	342
33,000	664	498	332
32,000	644	483	322
31,000	624	468	312
30,000	604	453	302
29,000	584	438	292
28,000	564	423	282
27,000	543	408	272
26,000	523	392	262
25,000	503	377	252
24,000	483	362	242
23,000	463	347	231
22,000	443	332	221
21,000	423	317	211
20,000	403	302	201
19,000	382	287	191
18,000	362	272	181
17,000	342	257	171
16,000	322	242	161
15,000	302	226	151
14,000	282	211	141
13,000	262	196	131
12,000	242	181	121
11,000	221	166	111
10,000	201	151	101
9,000	181	136	91
8,000	161	121	81
7,000	141	106	70
6,000	121	91	60
5,000	101	75	50

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	1011	758	505
34,000	982	736	491
33,000	953	715	476
32,000	924	693	462
31,000	895	671	448
30,000	866	650	433
29,000	837	628	419
28,000	809	606	404
27,000	780	585	390
26,000	751	563	375
25,000	722	541	361
24,000	693	520	347
23,000	664	498	332
22,000	635	476	318
21,000	606	455	303
20,000	578	433	289
19,000	549	411	274
18,000	520	390	260
17,000	491	368	245
16,000	462	347	231
15,000	433	325	217
14,000	404	303	202
13,000	375	282	188
12,000	347	260	173
11,000	318	238	159
10,000	289	217	144
9,000	260	195	130
8,000	231	173	116
7,000	202	152	101
6,000	173	130	87
5,000	144	108	72

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	766	574	383
34,000	744	558	372
33,000	722	541	361
32,000	700	525	350
31,000	678	509	339
30,000	656	492	328
29,000	634	476	317
28,000	613	459	306
27,000	591	443	295
26,000	569	427	284
25,000	547	410	273
24,000	525	394	263
23,000	503	377	252
22,000	481	361	241
21,000	459	345	230
20,000	438	328	219
19,000	416	312	208
18,000	394	295	197
17,000	372	279	186
16,000	350	263	175
15,000	328	246	164
14,000	306	230	153
13,000	284	213	142
12,000	263	197	131
11,000	241	180	120
10,000	219	164	109
9,000	197	148	98
8,000	175	131	88
7,000	153	115	77
6,000	131	98	66
5,000	109	82	55

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	980	735	490
34,000	952	714	476
33,000	924	693	462
32,000	896	672	448
31,000	868	651	434
30,000	840	630	420
29,000	812	609	406
28,000	784	588	392
27,000	756	567	378
26,000	728	546	364
25,000	700	525	350
24,000	672	504	336
23,000	644	483	322
22,000	616	462	308
21,000	588	441	294
20,000	560	420	280
19,000	532	399	266
18,000	504	378	252
17,000	476	357	238
16,000	448	336	224
15,000	420	315	210
14,000	392	294	196
13,000	364	273	182
12,000	336	252	168
11,000	308	231	154
10,000	280	210	140
9,000	252	189	126
8,000	224	168	112
7,000	196	147	98
6,000	168	126	84
5,000	140	105	70

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers:

31010-SC, 31214-SC, 31215-SC, 32010-SC, 32211-SC, 32212-SC, 33210-SC, 34221-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	805	604	403
34,000	782	587	391
33,000	759	569	380
32,000	736	552	368
31,000	713	535	357
30,000	690	518	345
29,000	667	500	334
28,000	644	483	322
27,000	621	466	311
26,000	598	449	299
25,000	575	431	288
24,000	552	414	276
23,000	529	397	265
22,000	506	380	253
21,000	483	362	242
20,000	460	345	230
19,000	437	328	219
18,000	414	311	207
17,000	391	293	196
16,000	368	276	184
15,000	345	259	173
14,000	322	242	161
13,000	299	224	150
12,000	276	207	138
11,000	253	190	127
10,000	230	173	115
9,000	207	155	104
8,000	184	138	92
7,000	161	121	81
6,000	138	104	69
5,000	115	86	58

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1155	866	578
34,000	1122	842	561
33,000	1089	817	545
32,000	1056	792	528
31,000	1023	767	512
30,000	990	743	495
29,000	957	718	479
28,000	924	693	462
27,000	891	668	446
26,000	858	644	429
25,000	825	619	413
24,000	792	594	396
23,000	759	569	380
22,000	726	545	363
21,000	693	520	347
20,000	660	495	330
19,000	627	470	314
18,000	594	446	297
17,000	561	421	281
16,000	528	396	264
15,000	495	371	248
14,000	462	347	231
13,000	429	322	215
12,000	396	297	198
11,000	363	272	182
10,000	330	248	165
9,000	297	223	149
8,000	264	198	132
7,000	231	173	116
6,000	198	149	99
5,000	165	124	83

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	875	656	438
34,000	850	638	425
33,000	825	619	413
32,000	800	600	400
31,000	775	581	388
30,000	750	563	375
29,000	725	544	363
28,000	700	525	350
27,000	675	506	338
26,000	650	488	325
25,000	625	469	313
24,000	600	450	300
23,000	575	431	288
22,000	550	413	275
21,000	525	394	263
20,000	500	375	250
19,000	475	356	238
18,000	450	338	225
17,000	425	319	213
16,000	400	300	200
15,000	375	281	188
14,000	350	263	175
13,000	325	244	163
12,000	300	225	150
11,000	275	206	138
10,000	250	188	125
9,000	225	169	113
8,000	200	150	100
7,000	175	131	88
6,000	150	113	75
5,000	125	94	63

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1120	840	560
34,000	1088	816	544
33,000	1056	792	528
32,000	1024	768	512
31,000	992	744	496
30,000	960	720	480
29,000	928	696	464
28,000	896	672	448
27,000	864	648	432
26,000	832	624	416
25,000	800	600	400
24,000	768	576	384
23,000	736	552	368
22,000	704	528	352
21,000	672	504	336
20,000	640	480	320
19,000	608	456	304
18,000	576	432	288
17,000	544	408	272
16,000	512	384	256
15,000	480	360	240
14,000	448	336	224
13,000	416	312	208
12,000	384	288	192
11,000	352	264	176
10,000	320	240	160
9,000	288	216	144
8,000	256	192	128
7,000	224	168	112
6,000	192	144	96
5,000	160	120	80

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31310-SC, 32310-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	302	226	151
34,000	293	220	147
33,000	285	213	142
32,000	276	207	138
31,000	267	201	134
30,000	259	194	129
29,000	250	188	125
28,000	242	181	121
27,000	233	175	116
26,000	224	168	112
25,000	216	162	108
24,000	207	155	104
23,000	198	149	99
22,000	190	142	95
21,000	181	136	91
20,000	173	129	86
19,000	164	123	82
18,000	155	116	78
17,000	147	110	73
16,000	138	104	69
15,000	129	97	65
14,000	121	91	60
13,000	112	84	56
12,000	104	78	52
11,000	95	71	47
10,000	86	65	43
9,000	78	58	39
8,000	69	52	35
7,000	60	45	30
6,000	52	39	26
5,000	43	32	22

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	433	325	217
34,000	421	316	210
33,000	408	306	204
32,000	396	297	198
31,000	384	288	192
30,000	371	278	186
29,000	359	269	179
28,000	347	260	173
27,000	334	251	167
26,000	322	241	161
25,000	309	232	155
24,000	297	223	149
23,000	285	213	142
22,000	272	204	136
21,000	260	195	130
20,000	248	186	124
19,000	235	176	118
18,000	223	167	111
17,000	210	158	105
16,000	198	149	99
15,000	186	139	93
14,000	173	130	87
13,000	161	121	80
12,000	149	111	74
11,000	136	102	68
10,000	124	93	62
9,000	111	84	56
8,000	99	74	50
7,000	87	65	43
6,000	74	56	37
5,000	62	46	31

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	328	246	164
34,000	319	239	159
33,000	309	232	155
32,000	300	225	150
31,000	291	218	145
30,000	281	211	141
29,000	272	204	136
28,000	263	197	131
27,000	253	190	127
26,000	244	183	122
25,000	234	176	117
24,000	225	169	113
23,000	216	162	108
22,000	206	155	103
21,000	197	148	98
20,000	188	141	94
19,000	178	134	89
18,000	169	127	84
17,000	159	120	80
16,000	150	113	75
15,000	141	105	70
14,000	131	98	66
13,000	122	91	61
12,000	113	84	56
11,000	103	77	52
10,000	94	70	47
9,000	84	63	42
8,000	75	56	38
7,000	66	49	33
6,000	56	42	28
5,000	47	35	23

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	420	315	210
34,000	408	306	204
33,000	396	297	198
32,000	384	288	192
31,000	372	279	186
30,000	360	270	180
29,000	348	261	174
28,000	336	252	168
27,000	324	243	162
26,000	312	234	156
25,000	300	225	150
24,000	288	216	144
23,000	276	207	138
22,000	264	198	132
21,000	252	189	126
20,000	240	180	120
19,000	228	171	114
18,000	216	162	108
17,000	204	153	102
16,000	192	144	96
15,000	180	135	90
14,000	168	126	84
13,000	156	117	78
12,000	144	108	72
11,000	132	99	66
10,000	120	90	60
9,000	108	81	54
8,000	96	72	48
7,000	84	63	42
6,000	72	54	36
5,000	60	45	30

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31311-SC, 32312-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	377	283	189
34,000	367	275	183
33,000	356	267	178
32,000	345	259	173
31,000	334	251	167
30,000	324	243	162
29,000	313	235	156
28,000	302	226	151
27,000	291	218	146
26,000	280	210	140
25,000	270	202	135
24,000	259	194	129
23,000	248	186	124
22,000	237	178	119
21,000	226	170	113
20,000	216	162	108
19,000	205	154	102
18,000	194	146	97
17,000	183	138	92
16,000	173	129	86
15,000	162	121	81
14,000	151	113	75
13,000	140	105	70
12,000	129	97	65
11,000	119	89	59
10,000	108	81	54
9,000	97	73	49
8,000	86	65	43
7,000	75	57	38
6,000	65	49	32
5,000	54	40	27

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	542	406	271
34,000	526	395	263
33,000	511	383	255
32,000	495	371	248
31,000	480	360	240
30,000	464	348	232
29,000	449	337	224
28,000	433	325	217
27,000	418	313	209
26,000	402	302	201
25,000	387	290	193
24,000	371	279	186
23,000	356	267	178
22,000	340	255	170
21,000	325	244	162
20,000	309	232	155
19,000	294	221	147
18,000	279	209	139
17,000	263	197	132
16,000	248	186	124
15,000	232	174	116
14,000	217	162	108
13,000	201	151	101
12,000	186	139	93
11,000	170	128	85
10,000	155	116	77
9,000	139	104	70
8,000	124	93	62
7,000	108	81	54
6,000	93	70	46
5,000	77	58	39

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	410	308	205
34,000	399	299	199
33,000	387	290	193
32,000	375	281	188
31,000	363	273	182
30,000	352	264	176
29,000	340	255	170
28,000	328	246	164
27,000	317	237	158
26,000	305	229	152
25,000	293	220	147
24,000	281	211	141
23,000	270	202	135
22,000	258	193	129
21,000	246	185	123
20,000	234	176	117
19,000	223	167	111
18,000	211	158	106
17,000	199	149	100
16,000	188	141	94
15,000	176	132	88
14,000	164	123	82
13,000	152	114	76
12,000	141	106	70
11,000	129	97	64
10,000	117	88	59
9,000	106	79	53
8,000	94	70	47
7,000	82	62	41
6,000	70	53	35
5,000	59	44	29

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	525	394	263
34,000	510	383	255
33,000	495	371	248
32,000	480	360	240
31,000	465	349	233
30,000	450	338	225
29,000	435	326	218
28,000	420	315	210
27,000	405	304	203
26,000	390	293	195
25,000	375	281	188
24,000	360	270	180
23,000	345	259	173
22,000	330	248	165
21,000	315	236	158
20,000	300	225	150
19,000	285	214	143
18,000	270	203	135
17,000	255	191	128
16,000	240	180	120
15,000	225	169	113
14,000	210	158	105
13,000	195	146	98
12,000	180	135	90
11,000	165	124	83
10,000	150	113	75
9,000	135	101	68
8,000	120	90	60
7,000	105	79	53
6,000	90	68	45
5,000	75	56	38

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

**Endmill Data Sheet for Yonico bit Numbers:
31312-SC, 32313-SC, 36312-SC**

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	453	340	226
34,000	440	330	220
33,000	427	320	213
32,000	414	311	207
31,000	401	301	201
30,000	388	291	194
29,000	375	281	188
28,000	362	272	181
27,000	349	262	175
26,000	336	252	168
25,000	323	243	162
24,000	311	233	155
23,000	298	223	149
22,000	285	213	142
21,000	272	204	136
20,000	259	194	129
19,000	246	184	123
18,000	233	175	116
17,000	220	165	110
16,000	207	155	104
15,000	194	146	97
14,000	181	136	91
13,000	168	126	84
12,000	155	116	78
11,000	142	107	71
10,000	129	97	65
9,000	116	87	58
8,000	104	78	52
7,000	91	68	45
6,000	78	58	39
5,000	65	49	32

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	650	487	325
34,000	631	473	316
33,000	613	459	306
32,000	594	446	297
31,000	575	432	288
30,000	557	418	278
29,000	538	404	269
28,000	520	390	260
27,000	501	376	251
26,000	483	362	241
25,000	464	348	232
24,000	446	334	223
23,000	427	320	213
22,000	408	306	204
21,000	390	292	195
20,000	371	278	186
19,000	353	265	176
18,000	334	251	167
17,000	316	237	158
16,000	297	223	149
15,000	278	209	139
14,000	260	195	130
13,000	241	181	121
12,000	223	167	111
11,000	204	153	102
10,000	186	139	93
9,000	167	125	84
8,000	149	111	74
7,000	130	97	65
6,000	111	84	56
5,000	93	70	46

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	492	369	246
34,000	478	359	239
33,000	464	348	232
32,000	450	338	225
31,000	436	327	218
30,000	422	316	211
29,000	408	306	204
28,000	394	295	197
27,000	380	285	190
26,000	366	274	183
25,000	352	264	176
24,000	338	253	169
23,000	323	243	162
22,000	309	232	155
21,000	295	221	148
20,000	281	211	141
19,000	267	200	134
18,000	253	190	127
17,000	239	179	120
16,000	225	169	113
15,000	211	158	105
14,000	197	148	98
13,000	183	137	91
12,000	169	127	84
11,000	155	116	77
10,000	141	105	70
9,000	127	95	63
8,000	113	84	56
7,000	98	74	49
6,000	84	63	42
5,000	70	53	35

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	630	473	315
34,000	612	459	306
33,000	594	446	297
32,000	576	432	288
31,000	558	419	279
30,000	540	405	270
29,000	522	392	261
28,000	504	378	252
27,000	486	365	243
26,000	468	351	234
25,000	450	338	225
24,000	432	324	216
23,000	414	311	207
22,000	396	297	198
21,000	378	284	189
20,000	360	270	180
19,000	342	257	171
18,000	324	243	162
17,000	306	230	153
16,000	288	216	144
15,000	270	203	135
14,000	252	189	126
13,000	234	176	117
12,000	216	162	108
11,000	198	149	99
10,000	180	135	90
9,000	162	122	81
8,000	144	108	72
7,000	126	95	63
6,000	108	81	54
5,000	90	68	45

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

**Endmill Data Sheet for Yonico bit Numbers:
31313-SC, 32314-SC**

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	528	396	264
34,000	513	385	257
33,000	498	374	249
32,000	483	362	242
31,000	468	351	234
30,000	453	340	226
29,000	438	328	219
28,000	423	317	211
27,000	408	306	204
26,000	393	294	196
25,000	377	283	189
24,000	362	272	181
23,000	347	260	174
22,000	332	249	166
21,000	317	238	159
20,000	302	226	151
19,000	287	215	143
18,000	272	204	136
17,000	257	192	128
16,000	242	181	121
15,000	226	170	113
14,000	211	159	106
13,000	196	147	98
12,000	181	136	91
11,000	166	125	83
10,000	151	113	75
9,000	136	102	68
8,000	121	91	60
7,000	106	79	53
6,000	91	68	45
5,000	75	57	38

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	758	569	379
34,000	736	552	368
33,000	715	536	357
32,000	693	520	347
31,000	671	504	336
30,000	650	487	325
29,000	628	471	314
28,000	607	455	303
27,000	585	439	292
26,000	563	422	282
25,000	542	406	271
24,000	520	390	260
23,000	498	374	249
22,000	477	357	238
21,000	455	341	227
20,000	433	325	217
19,000	412	309	206
18,000	390	292	195
17,000	368	276	184
16,000	347	260	173
15,000	325	244	162
14,000	303	227	152
13,000	282	211	141
12,000	260	195	130
11,000	238	179	119
10,000	217	162	108
9,000	195	146	97
8,000	173	130	87
7,000	152	114	76
6,000	130	97	65
5,000	108	81	54

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	574	431	287
34,000	558	418	279
33,000	542	406	271
32,000	525	394	263
31,000	509	382	254
30,000	492	369	246
29,000	476	357	238
28,000	459	345	230
27,000	443	332	222
26,000	427	320	213
25,000	410	308	205
24,000	394	295	197
23,000	377	283	189
22,000	361	271	181
21,000	345	258	172
20,000	328	246	164
19,000	312	234	156
18,000	295	222	148
17,000	279	209	139
16,000	263	197	131
15,000	246	185	123
14,000	230	172	115
13,000	213	160	107
12,000	197	148	98
11,000	181	135	90
10,000	164	123	82
9,000	148	111	74
8,000	131	98	66
7,000	115	86	57
6,000	98	74	49
5,000	82	62	41

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	735	551	368
34,000	714	536	357
33,000	693	520	347
32,000	672	504	336
31,000	651	488	326
30,000	630	473	315
29,000	609	457	305
28,000	588	441	294
27,000	567	425	284
26,000	546	410	273
25,000	525	394	263
24,000	504	378	252
23,000	483	362	242
22,000	462	347	231
21,000	441	331	221
20,000	420	315	210
19,000	399	299	200
18,000	378	284	189
17,000	357	268	179
16,000	336	252	168
15,000	315	236	158
14,000	294	221	147
13,000	273	205	137
12,000	252	189	126
11,000	231	173	116
10,000	210	158	105
9,000	189	142	95
8,000	168	126	84
7,000	147	110	74
6,000	126	95	63
5,000	105	79	53

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

**Endmill Data Sheet for Yonico bit Numbers:
31314-SC, 32311-SC, 35314-SC, 36314-SC**

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	604	453	302
34,000	587	440	293
33,000	569	427	285
32,000	552	414	276
31,000	535	401	267
30,000	518	388	259
29,000	500	375	250
28,000	483	362	242
27,000	466	349	233
26,000	449	336	224
25,000	431	323	216
24,000	414	311	207
23,000	397	298	198
22,000	380	285	190
21,000	362	272	181
20,000	345	259	173
19,000	328	246	164
18,000	311	233	155
17,000	293	220	147
16,000	276	207	138
15,000	259	194	129
14,000	242	181	121
13,000	224	168	112
12,000	207	155	104
11,000	190	142	95
10,000	173	129	86
9,000	155	116	78
8,000	138	104	69
7,000	121	91	60
6,000	104	78	52
5,000	86	65	43

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	866	650	433
34,000	842	631	421
33,000	817	613	408
32,000	792	594	396
31,000	767	575	384
30,000	743	557	371
29,000	718	538	359
28,000	693	520	347
27,000	668	501	334
26,000	644	483	322
25,000	619	464	309
24,000	594	446	297
23,000	569	427	285
22,000	545	408	272
21,000	520	390	260
20,000	495	371	248
19,000	470	353	235
18,000	446	334	223
17,000	421	316	210
16,000	396	297	198
15,000	371	278	186
14,000	347	260	173
13,000	322	241	161
12,000	297	223	149
11,000	272	204	136
10,000	248	186	124
9,000	223	167	111
8,000	198	149	99
7,000	173	130	87
6,000	149	111	74
5,000	124	93	62

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	656	492	328
34,000	638	478	319
33,000	619	464	309
32,000	600	450	300
31,000	581	436	291
30,000	563	422	281
29,000	544	408	272
28,000	525	394	263
27,000	506	380	253
26,000	488	366	244
25,000	469	352	234
24,000	450	338	225
23,000	431	323	216
22,000	413	309	206
21,000	394	295	197
20,000	375	281	188
19,000	356	267	178
18,000	338	253	169
17,000	319	239	159
16,000	300	225	150
15,000	281	211	141
14,000	263	197	131
13,000	244	183	122
12,000	225	169	113
11,000	206	155	103
10,000	188	141	94
9,000	169	127	84
8,000	150	113	75
7,000	131	98	66
6,000	113	84	56
5,000	94	70	47

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	840	630	420
34,000	816	612	408
33,000	792	594	396
32,000	768	576	384
31,000	744	558	372
30,000	720	540	360
29,000	696	522	348
28,000	672	504	336
27,000	648	486	324
26,000	624	468	312
25,000	600	450	300
24,000	576	432	288
23,000	552	414	276
22,000	528	396	264
21,000	504	378	252
20,000	480	360	240
19,000	456	342	228
18,000	432	324	216
17,000	408	306	204
16,000	384	288	192
15,000	360	270	180
14,000	336	252	168
13,000	312	234	156
12,000	288	216	144
11,000	264	198	132
10,000	240	180	120
9,000	216	162	108
8,000	192	144	96
7,000	168	126	84
6,000	144	108	72
5,000	120	90	60

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31340-SC, 32340-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	755	566	377
34,000	733	550	367
33,000	712	534	356
32,000	690	518	345
31,000	668	501	334
30,000	647	485	323
29,000	625	469	313
28,000	604	453	302
27,000	582	437	291
26,000	561	420	280
25,000	539	404	270
24,000	518	388	259
23,000	496	372	248
22,000	474	356	237
21,000	453	340	226
20,000	431	323	216
19,000	410	307	205
18,000	388	291	194
17,000	367	275	183
16,000	345	259	173
15,000	323	243	162
14,000	302	226	151
13,000	280	210	140
12,000	259	194	129
11,000	237	178	119
10,000	216	162	108
9,000	194	146	97
8,000	173	129	86
7,000	151	113	75
6,000	129	97	65
5,000	108	81	54

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1083	812	541
34,000	1052	789	526
33,000	1021	766	510
32,000	990	743	495
31,000	959	719	480
30,000	928	696	464
29,000	897	673	449
28,000	866	650	433
27,000	835	626	418
26,000	804	603	402
25,000	773	580	387
24,000	743	557	371
23,000	712	534	356
22,000	681	510	340
21,000	650	487	325
20,000	619	464	309
19,000	588	441	294
18,000	557	418	278
17,000	526	394	263
16,000	495	371	248
15,000	464	348	232
14,000	433	325	217
13,000	402	302	201
12,000	371	278	186
11,000	340	255	170
10,000	309	232	155
9,000	278	209	139
8,000	248	186	124
7,000	217	162	108
6,000	186	139	93
5,000	155	116	77

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	820	615	410
34,000	797	598	398
33,000	773	580	387
32,000	750	563	375
31,000	727	545	363
30,000	703	527	352
29,000	680	510	340
28,000	656	492	328
27,000	633	475	316
26,000	609	457	305
25,000	586	439	293
24,000	563	422	281
23,000	539	404	270
22,000	516	387	258
21,000	492	369	246
20,000	469	352	234
19,000	445	334	223
18,000	422	316	211
17,000	398	299	199
16,000	375	281	188
15,000	352	264	176
14,000	328	246	164
13,000	305	229	152
12,000	281	211	141
11,000	258	193	129
10,000	234	176	117
9,000	211	158	105
8,000	188	141	94
7,000	164	123	82
6,000	141	105	70
5,000	117	88	59

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1050	788	525
34,000	1020	765	510
33,000	990	743	495
32,000	960	720	480
31,000	930	698	465
30,000	900	675	450
29,000	870	653	435
28,000	840	630	420
27,000	810	608	405
26,000	780	585	390
25,000	750	563	375
24,000	720	540	360
23,000	690	518	345
22,000	660	495	330
21,000	630	473	315
20,000	600	450	300
19,000	570	428	285
18,000	540	405	270
17,000	510	383	255
16,000	480	360	240
15,000	450	338	225
14,000	420	315	210
13,000	390	293	195
12,000	360	270	180
11,000	330	248	165
10,000	300	225	150
9,000	270	203	135
8,000	240	180	120
7,000	210	158	105
6,000	180	135	90
5,000	150	113	75

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 31350-SC, 32350-SC, 35350-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	906	679	453
34,000	880	660	440
33,000	854	640	427
32,000	828	621	414
31,000	802	602	401
30,000	776	582	388
29,000	750	563	375
28,000	725	543	362
27,000	699	524	349
26,000	673	505	336
25,000	647	485	323
24,000	621	466	311
23,000	595	446	298
22,000	569	427	285
21,000	543	408	272
20,000	518	388	259
19,000	492	369	246
18,000	466	349	233
17,000	440	330	220
16,000	414	311	207
15,000	388	291	194
14,000	362	272	181
13,000	336	252	168
12,000	311	233	155
11,000	285	213	142
10,000	259	194	129
9,000	233	175	116
8,000	207	155	104
7,000	181	136	91
6,000	155	116	78
5,000	129	97	65

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1299	975	650
34,000	1262	947	631
33,000	1225	919	613
32,000	1188	891	594
31,000	1151	863	575
30,000	1114	835	557
29,000	1077	807	538
28,000	1040	780	520
27,000	1002	752	501
26,000	965	724	483
25,000	928	696	464
24,000	891	668	446
23,000	854	640	427
22,000	817	613	408
21,000	780	585	390
20,000	743	557	371
19,000	705	529	353
18,000	668	501	334
17,000	631	473	316
16,000	594	446	297
15,000	557	418	278
14,000	520	390	260
13,000	483	362	241
12,000	446	334	223
11,000	408	306	204
10,000	371	278	186
9,000	334	251	167
8,000	297	223	149
7,000	260	195	130
6,000	223	167	111
5,000	186	139	93

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	984	738	492
34,000	956	717	478
33,000	928	696	464
32,000	900	675	450
31,000	872	654	436
30,000	844	633	422
29,000	816	612	408
28,000	788	591	394
27,000	759	570	380
26,000	731	548	366
25,000	703	527	352
24,000	675	506	338
23,000	647	485	323
22,000	619	464	309
21,000	591	443	295
20,000	563	422	281
19,000	534	401	267
18,000	506	380	253
17,000	478	359	239
16,000	450	338	225
15,000	422	316	211
14,000	394	295	197
13,000	366	274	183
12,000	338	253	169
11,000	309	232	155
10,000	281	211	141
9,000	253	190	127
8,000	225	169	113
7,000	197	148	98
6,000	169	127	84
5,000	141	105	70

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
RPM			
35,000	1260	945	630
34,000	1224	918	612
33,000	1188	891	594
32,000	1152	864	576
31,000	1116	837	558
30,000	1080	810	540
29,000	1044	783	522
28,000	1008	756	504
27,000	972	729	486
26,000	936	702	468
25,000	900	675	450
24,000	864	648	432
23,000	828	621	414
22,000	792	594	396
21,000	756	567	378
20,000	720	540	360
19,000	684	513	342
18,000	648	486	324
17,000	612	459	306
16,000	576	432	288
15,000	540	405	270
14,000	504	378	252
13,000	468	351	234
12,000	432	324	216
11,000	396	297	198
10,000	360	270	180
9,000	324	243	162
8,000	288	216	144
7,000	252	189	126
6,000	216	162	108
5,000	180	135	90

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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Yonico End Mill Data Sheet

Endmill Data Sheet for Yonico bit Numbers: 33330-SC

Hard Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	1208	906	604
34,000	1173	880	587
33,000	1139	854	569
32,000	1104	828	552
31,000	1070	802	535
30,000	1035	776	518
29,000	1001	750	500
28,000	966	725	483
27,000	932	699	466
26,000	897	673	449
25,000	863	647	431
24,000	828	621	414
23,000	794	595	397
22,000	759	569	380
21,000	725	543	362
20,000	690	518	345
19,000	656	492	328
18,000	621	466	311
17,000	587	440	293
16,000	552	414	276
15,000	518	388	259
14,000	483	362	242
13,000	449	336	224
12,000	414	311	207
11,000	380	285	190
10,000	345	259	173
9,000	311	233	155
8,000	276	207	138
7,000	242	181	121
6,000	207	155	104
5,000	173	129	86

Soft Wood	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	1733	1299	866
34,000	1683	1262	842
33,000	1634	1225	817
32,000	1584	1188	792
31,000	1535	1151	767
30,000	1485	1114	743
29,000	1436	1077	718
28,000	1386	1040	693
27,000	1337	1002	668
26,000	1287	965	644
25,000	1238	928	619
24,000	1188	891	594
23,000	1139	854	569
22,000	1089	817	545
21,000	1040	780	520
20,000	990	743	495
19,000	941	705	470
18,000	891	668	446
17,000	842	631	421
16,000	792	594	396
15,000	743	557	371
14,000	693	520	347
13,000	644	483	322
12,000	594	446	297
11,000	545	408	272
10,000	495	371	248
9,000	446	334	223
8,000	396	297	198
7,000	347	260	173
6,000	297	223	149
5,000	248	186	124

Hard Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	1313	984	656
34,000	1275	956	638
33,000	1238	928	619
32,000	1200	900	600
31,000	1163	872	581
30,000	1125	844	563
29,000	1088	816	544
28,000	1050	788	525
27,000	1013	759	506
26,000	975	731	488
25,000	938	703	469
24,000	900	675	450
23,000	863	647	431
22,000	825	619	413
21,000	788	591	394
20,000	750	563	375
19,000	713	534	356
18,000	675	506	338
17,000	638	478	319
16,000	600	450	300
15,000	563	422	281
14,000	525	394	263
13,000	488	366	244
12,000	450	338	225
11,000	413	309	206
10,000	375	281	188
9,000	338	253	169
8,000	300	225	150
7,000	263	197	131
6,000	225	169	113
5,000	188	141	94

Soft Plastic	Depth = 1 X Bit Diameter	Depth = 2 X Bit Diameter	Depth = 3 X Bit Diameter
RPM	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)	Feed Rate (Inches Per Minute)
35,000	1680	1260	840
34,000	1632	1224	816
33,000	1584	1188	792
32,000	1536	1152	768
31,000	1488	1116	744
30,000	1440	1080	720
29,000	1392	1044	696
28,000	1344	1008	672
27,000	1296	972	648
26,000	1248	936	624
25,000	1200	900	600
24,000	1152	864	576
23,000	1104	828	552
22,000	1056	792	528
21,000	1008	756	504
20,000	960	720	480
19,000	912	684	456
18,000	864	648	432
17,000	816	612	408
16,000	768	576	384
15,000	720	540	360
14,000	672	504	336
13,000	624	468	312
12,000	576	432	288
11,000	528	396	264
10,000	480	360	240
9,000	432	324	216
8,000	384	288	192
7,000	336	252	168
6,000	288	216	144
5,000	240	180	120

*The shaded boxes are the recommended settings.

Instructions: Use these charts to determine the recommended starting numbers for your application. To fine tune your setup, raise the feed rate until the finish becomes unacceptable and then back down. Then, lower the RPM until the finish becomes unacceptable and then raise up a little. Now you have achieved the optimal setup for your bit and application.

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