



BANTAM TOOLS DESKTOP CNC 4TH AXIS ACCESSORY

Material	Tool Diameter	Type of End Mill	Spindle Speed (RPM)	Feed Rate (in/min)	Stepover (Percentage of Tool Diameter)	Depth of Cut	Plunge Rate (in/min)	Tips
Delrin	1/4"	Flat End Mill	26000	40	<75%	0.15	5	Delrin is a very forgiving material, allowing for aggressive cuts and smooth surface finishes. It's one of the best options for beginners and those experimenting with speeds and feeds recipes.
	1/8"	Flat end Mill	26000	30	<20%	0.15	5	
	80°	Engraving Bit	28000	20	<20%	0.01	5	
Aluminum	1/4"	Flat End Mill	28000	30	<40%	0.02	5	The Bantam Tools Desktop CNC 4th Axis Accessory can handle aluminum without a problem! But, it's important to use a conservative depth of cut to get the best surface finishes. Use deeper depth of cut and slower feedrates on contour to prevent edge lines and chatter.
	1/8"	Flat end Mill	28000	20	<5%	0.03	5	
	80°	Engraving Mill Bit	28000	15	<5%	0.005	0.656	
Hardwood	1/4"	Flat End Mill	24000	40	<75%	0.15	5	Wood particles and fine dust can cause damage to machine. It is important to optimize for your application to get larger chips without splintering your material.
	1/8"	Flat end Mill	24000	25	<10%	0.15	5	
	80°	Engraving Bit	28000	20	<10%	0.01	0.656	